GUIDELINES FOR
PEBAX® Tube Extrusion
PEBAX: 6333, 5533 & 4033 SN01

- **Extruder**
  - Screw profile
    - standard 3 zones PA (Compression ratio 2 à 3)
  - T° profile (to be adjusted as a function of output)
    - Tf at the entry
    - Tf + 20°C at the end of the screw
    - Tf + 10°C in the tools
    - Melt temperature
      - 6333: 190°C
      - 5533: 180°C
      - 4033: 180°C
  - Filtration
    - 40/40

- **Tools**
  - PA equipments
    - Die head
    - Pin & die

- **Calibrators**
  - Design with water lubrication at the entry and sleeve (like PA)
  - Bronze or brass
  - Low vacuum and high water level

- **Cooling**
  - Length of the line quite short
PEBAX: 3533 & 2533 SN01

- **Extruder**
  - Screw profile
    - standard 3 zones PA (Compression ratio 2 à 3)
  - $T^\circ$ profile (to be adjusted as a function of output)
    - Tf at the entry
    - Tf + 20°C at the end of the screw
    - Tf + 10°C in the tools
  - Filtration
    - 40/40

- **Tools**
  - PA equipments
    - Die head
    - Pin & die

- **Calibrators**
  - Sticking on PA sizing ring
  - Special design necessary

- **Cooling**
  - Length of the line quite short
Soft grade extrusion

- Special properties
  - High elasticity at the molten state
  - Sticking products

- Consequences: breaks of the melt
  - Elasticity leads to a less stable process
    - Necessity to shorten as much as possible the line length to strengthen the stability
  - Friction in the calibrator
    - Modify the calibrator design
    - Modifier the contact calibrator polymer: choice of another material