

Extrusion Processing Guidelines

PE 35- (Any Color)

Extruder Barrel Temperatures

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| • Barrel Zone 1 | 350-390 °F |
| • Barrel Zone 2 | 350-390 °F |
| • Barrel Zone 3 | 360-400 °F |
| • Barrel Zone 4 | 360-400 °F |

Material Drying is typically not required but for applications drying may be required. If needed dry at 160 – 190°F for 1-2 hours.

Die Temperatures

Zone 1	370-410°F
Zone 2	370-410°F
Screen Mesh	20-80
Screw Speeds	20-90 RPM
Sizers	When Applicable

Roll Temperatures

Top	220-260°F
Middle	190-230°F
Bottom	130-160°F

If you have any questions or require further processing information, please e-mail the Technical Service Group @ TechService@washpenn.com