

Extrusion Processing Guidelines

PEH2GF3.5- (Any Color)

Extruder Barrel Temperatures

- | | |
|-----------------|------------|
| • Barrel Zone 1 | 360-390 °F |
| • Barrel Zone 2 | 360-390 °F |
| • Barrel Zone 3 | 370-400 °F |
| • Barrel Zone 4 | 370-400 °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