

Extrusion Processing Guidelines

PPC1FR3- (Any Color)

Barrel Tempertures

- Barrel Zone 1 370-400 °F
- Barrel Zone 2 370-400 °F
- Barrel Zone 3 380-420 °F
- Barrel Zone 4 380-420 °F

Roll Temperature

- Top 150-250 °F
- Middle 160-220 °F
- Bottom 140-230 °F

Die Temperatures

- Barrel Zone 1 380-430 °F
- Barrel Zone 2 380-430 °F

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

Machine Information

Screen Mesh	60-150 Mesh
Sizers	When Applicable
Screw Speeds	20-90 RPM

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