

## Extrusion Processing Guidelines

### PPC1FR7- (Any Color)

#### Barrel Tempertures

- Barrel Zone 1 330-380 °F
- Barrel Zone 2 330-380 °F
- Barrel Zone 3 330-380 °F
- Barrel Zone 4 330-380 °F

#### Roll Temperature

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

#### Die Temperatures

- Barrel Zone 1 350-420 °F
- Barrel Zone 2 350-420 °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
Vacuum	Full (if equipped)

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