

Blow Molding Processing Guidelines

PPC1GF1.5- (Any Color)

Temperatures

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|-----------------|------------|
| • Barrel Zone 1 | 360-400 °F |
| • Barrel Zone 2 | 370-410 °F |
| • Barrel Zone 3 | 370-410 °F |
| • Barrel Zone 4 | 380-410 °F |
| • Nozzle | 380-410 °F |
| • Mandrel | 380-420 °F |
| • Die | 380-420 °F |
| • Mold Cooling | 100-190 °F |

Standard PP Drying times for PP resins is 160°F to 190°F for 1-2 hours, if drying times is less than 1 hour you can increase temperature to 210°F to accommodate a short drying cycle. Dryers should be equipped with a desiccant to extract moisture.

Machine/Shot Information

Screens	20-100 Mesh
Regrind	20-60%

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