

Extrusion Processing Guidelines

PPC1TF5 (Any Color)

Barrel Tempertures

- Barrel Zone 1 350-380 °F
- Barrel Zone 2 350-380 °F
- Barrel Zone 3 360-400 °F
- Barrel Zone 4 370-410 °F

Roll Temperature

- Top 210-250 °F
- Middle 180-230 °F
- Bottom 140-170 °F

Die Temperatures

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

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	00-120 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