

## Blow Molding Processing Guidelines

### WPP 311- (Any Color)

#### Temperatures

- |                 |            |
|-----------------|------------|
| • 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  | 075-190 °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](mailto:TechService@washpenn.com)