

## Extrusion Processing Guidelines

### PPH1GF6.5- (Any Color)

#### Extruder Barrel Temperatures

- |                 |            |
|-----------------|------------|
| • Barrel Zone 1 | 360-390 °F |
| • Barrel Zone 2 | 360-390 °F |
| • Barrel Zone 3 | 370-400 °F |
| • Barrel Zone 4 | 370-400 °F |

*Material Drying is typically not required but for applications drying may be required. If needed dry at 160 – 190°F for 1-2 hours.*

#### Die Temperatures

Zone 1	370-410°F
Zone 2	370-410°F
Screen Mesh	20-80
Screw Speeds	20-90 RPM
Sizers	When Applicable

#### Roll Temperatures

Top	220-260°F
Middle	190-230°F
Bottom	130-160°F

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