WASHINGTON PENN
An AUDIA® Company

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Extrusion Processing Guidelines

UC2I002 - (Any Color)

Barrel Temperatures

• Barrel Zone 1	370 - 400 °F	188 - 204 °C
• Barrel Zone 2	370 - 400 °F	188 - 204 °C
• Barrel Zone 3	380 - 420 °F	193 - 216 °C
• Barrel Zone 4	380 - 420 °F	193 - 216 °C

Roll Temperatures

Top	150 - 250 °F	66 - 121 °C
Middle	160 - 220 °F	71 - 104 °C
Bottom	140 - 230 °F	60 - 110 °C

Die Temperature

• Barrel Zone 1	380 - 430 °F	193 - 221 °C
• Barrel Zone 2	380 - 430 °F	193 - 221 °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	60 - 150 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 at wp.techservices@washpenn.com

These process conditions are typical processing parameters for injection molding. Use of these operating conditions, however, does not guarantee desired performance for all applications because of potential variability in a variety of factors including, but not limited to, gating, molding equipment, injection mold screw design, dispersion equipment, tooling, tool steel type, cooling capability, and part geometry. Washington Penn Plastic Co., Inc. makes no representations or warranties concerning product performance in any application.