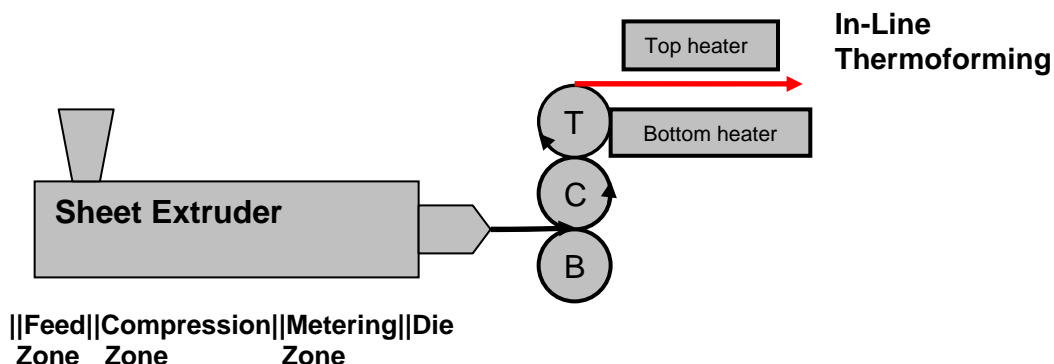




Processing Setup Sheet

Sheet Extrusion & In-Line Thermoforming Process



Processing Parameter	Units	Typical Setting
Barrel Temperature		
Feed Zone	°F*	400-420
Compression Zone	°F	410-430
Metering Zone	°F	430-450
Adapter and Screen Changer	°F	430-440
Die Temperature	°F	450-480
Melt Temperature	°F	440-475
Chill Rolls		
Top (T)	°F	150-160
Center (C)	°F	160-175
Bottom (B)	°F	140-150
Thermoforming		
Top Heater	°F	400-430
Bottom Heater	°F	400-435
Forming Temperature	°F	300-310

* To convert temperature from Fahrenheit to Celsius (Temp°F-32)/1.8 = Temp°C

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