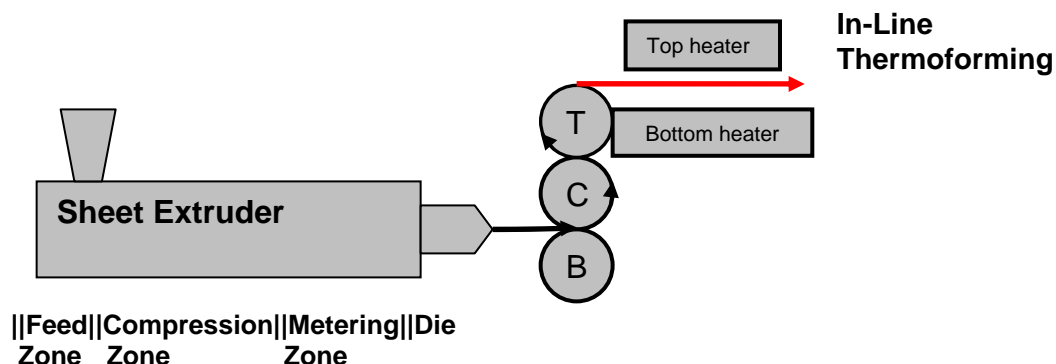




## Processing Setup Sheet

### Sheet Extrusion & In-Line Thermoforming Process



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