

Extrusion Guidelines for HDPE Pipe Grade Resins

INEOS Olefins & Polymers offers an exclusive line of HDPE grades that are successfully used for the commercial production of pipes around the world. These HDPE pipe grades run successfully on various types and designs of extruders to produce pipe over 63 inches (1600mm) in diameter.

INEOS Olefins & Polymers HDPE pipe grade materials extrude well at conditions similar to those traditionally used to process other PE pipe materials. We recommend the following extrusion parameters based on tests performed at our laboratory and at various third party testing sites.

Cylinder/Barrel Temperatures	355-400 °F (180-205 °C)
Head Temperature	375-410 °F (190-205 °C)
Die Temperature	375-410 °F (190-205 °C)
Melt Temperature	390-430 °F (200-220 °C)



Typical Pipe Extruder

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