

## Cardinal Rules to Successfully Evaluate Kostrate® EDGE for Profile Extrusion

1. Suggested materials for profile extrusion: **Kostrate® Edge High Rigidity** and **Kostrate® Edge High Rigidity Modified**. If toughness is of critical importance then we suggest **Kostrate® Edge Master Tough** or **Kostrate® Edge MAX E BM**. The Master Tough may be slightly more flexible as a rigid material but both the Master Tough and MAX E BM will be **tougher** than High Rigidity and High Rigidity Modified. For **maximum rigidity** with **excellent toughness** we would recommend our newest grade, Kostrate® Edge ME-X. Please note, most of our extrusion grades can be slightly modified both for toughness and improved rigidity by adding modifiers at the machine.
2. Complete purging of the material ahead to ensure that you obtain the clarity of the profile extruded part. Kostrate® Edge is a soft melt resin. We suggest in saving material that you consider purging first by the use of a low melt GPPS until the extrudate is clear. We have found purging can take more time than the actual Kostrate® evaluation.
3. Can be cut with a fly wheel knife that is **very** sharp, OR saw blade with tooth design for cutting e.g. ABS or Acrylic. IF a very thin gauge profile, a **heater** gun should be used **JUST** prior to cutting; this will cause the Kostrate® material to be more ductile.
4. Draw down 20 to 30 percent.
5. Screen packs as used for ABS, HIPS and/or impact acrylic, OR 20/60/100.
6. Measure the temperature of the profile extrudate, keeping it between 310 and 340 degrees F. Adjust as machine indicates.
7. Die must be 100% smooth/polished or even plated, i.e. no die lines.
8. IF the profile is thin, .040 or less wall thickness, running underwater especially if chilled, may not be needed. Kostrate® loses its heat very fast and you do not want to **shock** the material thus causing it to lose its "**toughness**".
9. Re grind must be kept clean and maybe reworked between 10 to 25 percent with virgin. A dedicated grinder is strongly suggested to ensure no foreign "thermoplastic dust or re grind" is introduced thus causing "gels".

10. Kostrate® has no die swell to negative 10 percent swell. Based on your die design you must determine draw down and swell performance as compared to your experience with other thermoplastics.
11. No drying is required.
12. For maximum clear UV protection please consider using Kostrate® Edge with UV. Please contact your PSG sales person for further advice.

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