

Grade: Kostrate® EDGE HE
Injection Molding Grade

Typical Material Properties

Physical	Nominal Values (English)	Test
Specific Gravity	1.02	ASTM D792
Melt Flow	10.0 g/10 min	ASTM D1238
Food Contact Acceptable	21 CFR 177.1640	FDA
	21 CFR 174.5	FDA
Mechanical		
Tensile Strength @ Break	5500 psi	ASTM D638
Flexural Modulus	270,000 psi	ASTM D790
Flexural Strength @ Yield	5500 psi	ASTM D790
Elongation	200%	
Hardness	70 Shore D	
Impact		
Dart Drop	35 (in-lbf)	
Impact on 0.125 x2.5" disk		
Unnotched IZOD Impact	N/B	
Thermal		
HDT @ 66 psi-unannealed (.125 in.)	185 °F	ASTM D648
Mold Shrinkage		
Linear Flow	.003 - .006 in/in	ASTM D955
Optical		
Haze	1.5%	D1003
Light Trans	90%	

Additional: Dishwasher safe, FDA compliant. Please note to allow your part to come to room temperature as parts become more water clear and harder surface after a dwell time of 72 hours.

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Recommended Processing Guidelines

INJECTION MOLDING:

	Nominal Values (English)
Drying Temperature	No Drying needed
Drying Time	NA
Suggested Max Moisture	NA
Rear Temperature	350 to 360 °F
Middle Temperature	360 to 375 °F
Front Temperature	370 to 380 °F
Nozzle Temperature	380 to 400 °F
Processing (Melt) Temp	360 to 410 °F
Mold Temperature	70 to 100 °F
Back Pressure	50 to 200 psi
Screw Speed	40 to 80 rpm

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