

Grade: Kostrate® EDGE MAX E
Injection Molding Grade

Typical Material Properties

Physical	Nominal Values (English)	Test
Specific Gravity	1.01	ASTM D792
Melt Flow	6 g/10 min	ASTM D1238
Food Contact Acceptable	21 CFR 177.1640	FDA
	21 CFR 174.5	FDA
Mechanical		
Tensile Strength @ Yield	4,000 psi	ASTM D638
Elongation @ Break	200%	ASTM D638
Flexural Strength @ Yield	6,000 psi	ASTM D790
Flexural Modulus	260,000 psi	ASTM D790
Hardness	67	Shore D
Impact		
Unnotched	No Break	ASTM D256
Thermal		
HDT @ 66 psi	192 °F	ASTM D648
Mold Shrinkage		
Linear Flow	.003 - .005 in/in	ASTM D955
Optical		
Haze	2 %	ASTM D1003
Light Trans	91 %	

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
Extruder Settings	
Rear Temperature	300 to 320 °F
Middle Temperature	310 to 330 °F
Front Temperature	320 to 330 °F
Processing (Melt) Temperature	310 to 330°F
Adapter	320 °F
Die Head Temperature	310 to 330 °F
Mold Temperature	70 °F

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