

Grade: Kostrate® EDGE LE
Injection Molding Grade

Typical Material Properties

Physical	Nominal Values (English)	Test
Specific Gravity	1.08	ASTM D792
Melt Flow (300 °C/1.2 kg.)	4.0 g/10 min	ASTM D1238
Food Contact Acceptable	21 CFR 177.1640	FDA
	21 CFR 174.5	FDA
Mechanical		
Tensile Strength @ Break	8000 psi	ASTM D638
Flexural Modulus	450,000 psi	ASTM D790
Flexural Strength @ Yield	16000 psi	ASTM D790
Elongation	8%	
Hardness 82 Shores D		
Impact		
Dart Drop	5 (in-lbf)	
Impact on 0.125 x2.5" disk		
Thermal		
HDT @ 66 psi-unannealed (.125 in.)	210 °F	ASTM D648
Mold Shrinkage		
Linear Flow	.003 - .006 in/in	ASTM D955
Optical		
Haze	.5%	ASTM D1003
Light Trans	93%	ASTMD1003

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	360 to 370 °F
Middle Temperature	370 to 390 °F
Front Temperature	380 to 400 °F
Nozzle Temperature	380 to 420 °F
Processing (Melt) Temp	390 to 440 °F
Mold Temperature	60 to 100 °F
Back Pressure	50 to 200 psi
Screw Speed	40 to 80 rpm

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