

PROPERTY Method/Cert	Test	Edge 8	Edge 8 IM
Physical			
Specific Gravity	ASTM D 792	1.06	1.05
Melt Flow (200°C/5kg)	ASTM D 1238	2.2 g/ 10 min.	3.75 g/ 10 min.
Mold Shrinkage	ASTM D 955	.003-.006 in/in	.003-.006 in/in
Food Contact Acceptable	FDA 21 CFR 177.1830 NSF/ ANSI 51	Compliant Certified	Compliant Certified
Mechanical			
Tensile Strength @ Yield	ASTM D 638	63 MPa (9200 psi)	(@ break) 4500 psi
Flex Modulus	ASTM D 790	3309 MPa (480,000 psi)	380,000 psi
Flex Strength @ Yield	ASTM D 790	110 MPa (16,000 psi)	9500 psi
Tensile Modulus	ASTM D 638	2894 MPa (420000 psi)	
Elongation	ASTM D 790	2%	10%
Rockwell Hardness	ASTM D 785	82 Shore D	80 Shore D
Izod Impact (1/8" bar @73°F)	ASTM D 265	0.6 ft-lbf/in (32 J/m)	
Thermal			
Deflection Temp [@ .0455 MPa (66psi)]	ASTM D 648	200°F(93°C)	210°F (99°C)
Vicat Softening Temp. [@ 1kg load]	ASTM D 1525	220°F (104°C)	
Flammability Classification [3.2 mm(.125 in)]	UL 94	90 HB	90 HB
Additional: Dishwasher Safe		YES- top rack	YES- top rack
Optical Properties			
Haze	ASTM D 1003	0.5%	1.0%
Light Transmission	ASTM D 1003	93%	90%
Recommended Processing			
Drying Temperature		No Drying Needed	No Drying Needed
Rear Temperature		400-430°F (204-221°C)	360-370 °F (182-188°C)
Middle Temperature		410-440°F (210-227°C)	370-390 °F (188-199°C)
Front Temperature		420-450°F (216-232°C)	380-400 °F (193-204°C)
Nozzle/Die Head Temp		400-440°F (204-227°C)	380-420 °F (193-215°C)
Processing (Melt) Temp		420-445°F (216-230°C)	390-440 °F (199-227°C)
Mold Temperature		80-100° F (27-38° C)	60-100 °F (16-38°C)
Back Pressure		50-200 psi (0.34-1.38 MPa)	50-200 psi
Screw Speed		40-80 rpm	40-80 rpm

First purge with GPPS at a high temperature, without degrading the GPPS. As it clears, lower the temperature in the Edge™ molding range of 400-430°F (204-211°C).

The information provided above is based upon typical values. Typical values are intended only as guides. Each customer is responsible for determining whether products and information in this document are appropriate for the customer's use. **NO GUARANTEES OR WARRANTIES ARE EXPRESSED OR IMPLIED.**