PROCESSING GUIDE

Edgetek[™] ET8900 CR SERIES



Edgetek[™] chemically resistant blends provide outstanding protection for consumer products that must maintain tensile strength integrity after repeated exposure to common disinfectants and cleaners.

Injection Molding Parameters

The barrel temperatures below should be used only as a reference point. Actual melt temperatures should be measured using a pyrometer to ensure consistent and accurate processing.

| BARREL TEMPERATURES | ENGLISH (°F) | | METRIC (°C) | | COMMENTS |
|------------------------|--------------|-------|-------------|-------|--|
| Zone 1 - Rear | 410°F | 450°F | 210°C | 230°C | |
| Zone 2 - Center | 420°F | 460°F | 215°C | 235°C | If smoking starts to occur, purge machine |
| Zone 3 - Front | 430°F | 470°F | 220°C | 240°C | immediately and reduce mold and barrel temperatures. |
| Nozzle | 440°F | 480°F | 225°C | 250°C | |

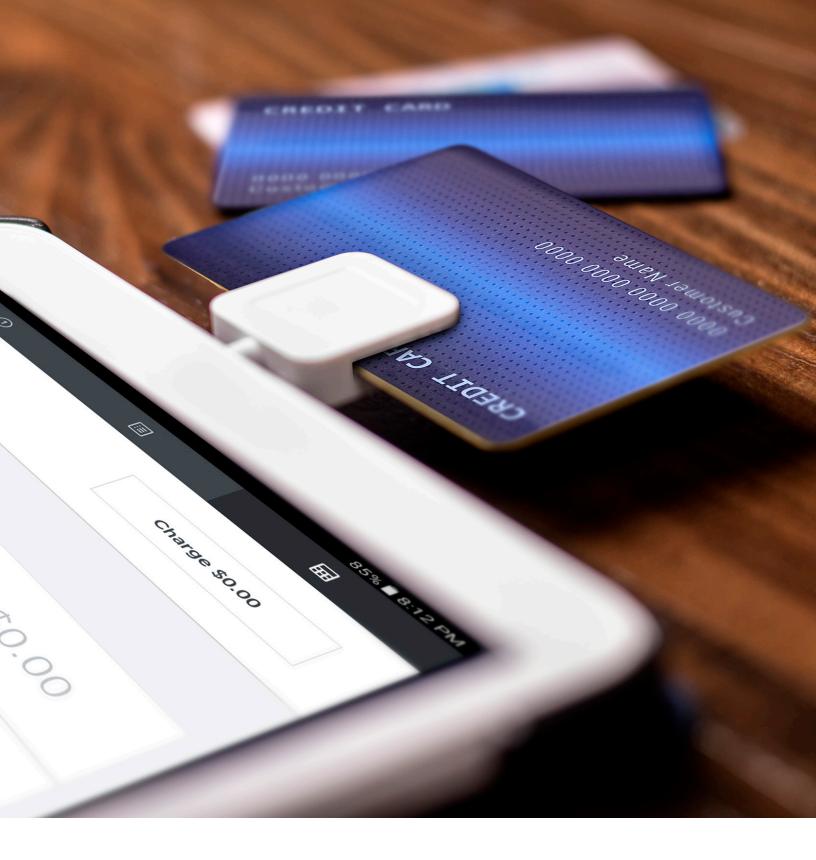
| MELT & MOLD TEMPERATURES | ENGLISH (°F) | | METRIC (°C) | | COMMENTS |
|-----------------------------|--------------|-------|-------------|-------|--|
| Melt Temperature | 440°F | 480°F | 225°C | 250°C | Wipe down mold surface after each production run. Strongly recommend immediate cleaning after injection. |
| Mold Temperature | 125°F | 200°F | 50°C | 90°C | Purge thoroughly before and after use of this product with a low flow (0.5–2.5 MFR) PE or PP. If contamination persists, purge with Dyna-purge D2. |

| DRYING CONDITIONS | ENGLISH (°F) | METRIC (°C) | | |
|-----------------------------|--------------|-------------|--|--|
| Temperature | 180°F | 80°C | | |
| Duration | 2–4 Hours | | | |
| Moisture Level Allowable | 0.05%-0.20% | | | |

| PROCESSING | | | |
|--------------------|--|--|--|
| Screw Speed | Typical screw speeds are recommended | | |
| Injection Velocity | 1–3 inch per second | | |
| Back Pressure | Lower back pressure is recommended | | |
| Pack Pressure | 60–80% of max injection pressure | | |
| Hold Pressure | 40–60% of max injection pressure | | |
| Cool Time | 10–30 seconds (depends on part geometry and dimensional stability) | | |
| Residence Time | Longer residence times are not advised | | |

Notes

These guidelines are based on lab results, and their values may not reflect actual processes using different machinery. Using these guidelines is not a guarantee that acceptable parts will be produced.



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