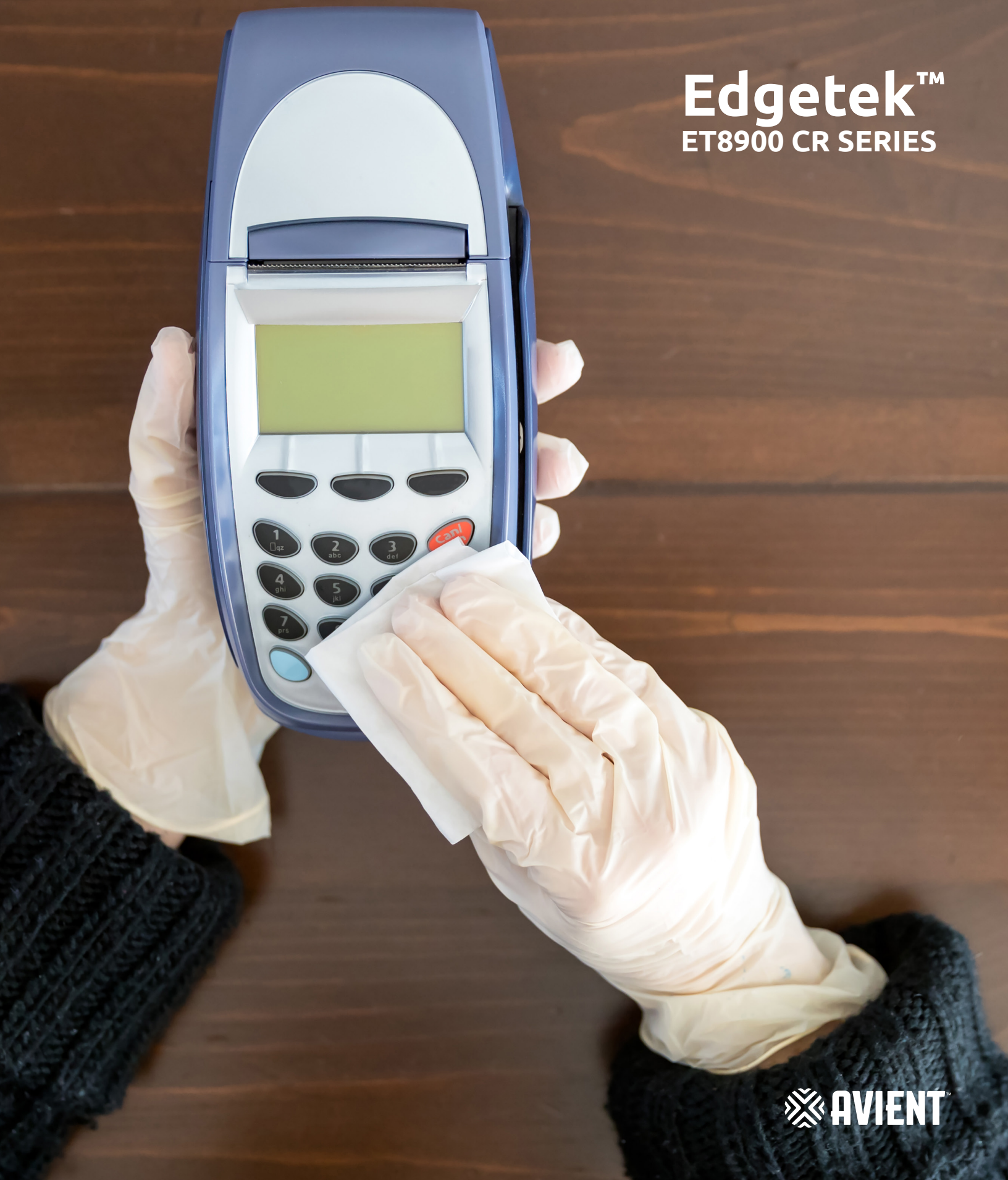
PROCESSING GUIDE

Edgetek™
ET8900 CR SERIES



AVIENT™

EDGETEK ET8900 CR THERMOPLASTICS

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	If smoking starts to occur, purge machine immediately and reduce mold and barrel temperatures.
Zone 2 - Center	420°F	460°F	215°C	235°C	
Zone 3 - Front	430°F	470°F	220°C	240°C	
Nozzle	440°F	480°F	225°C	250°C	

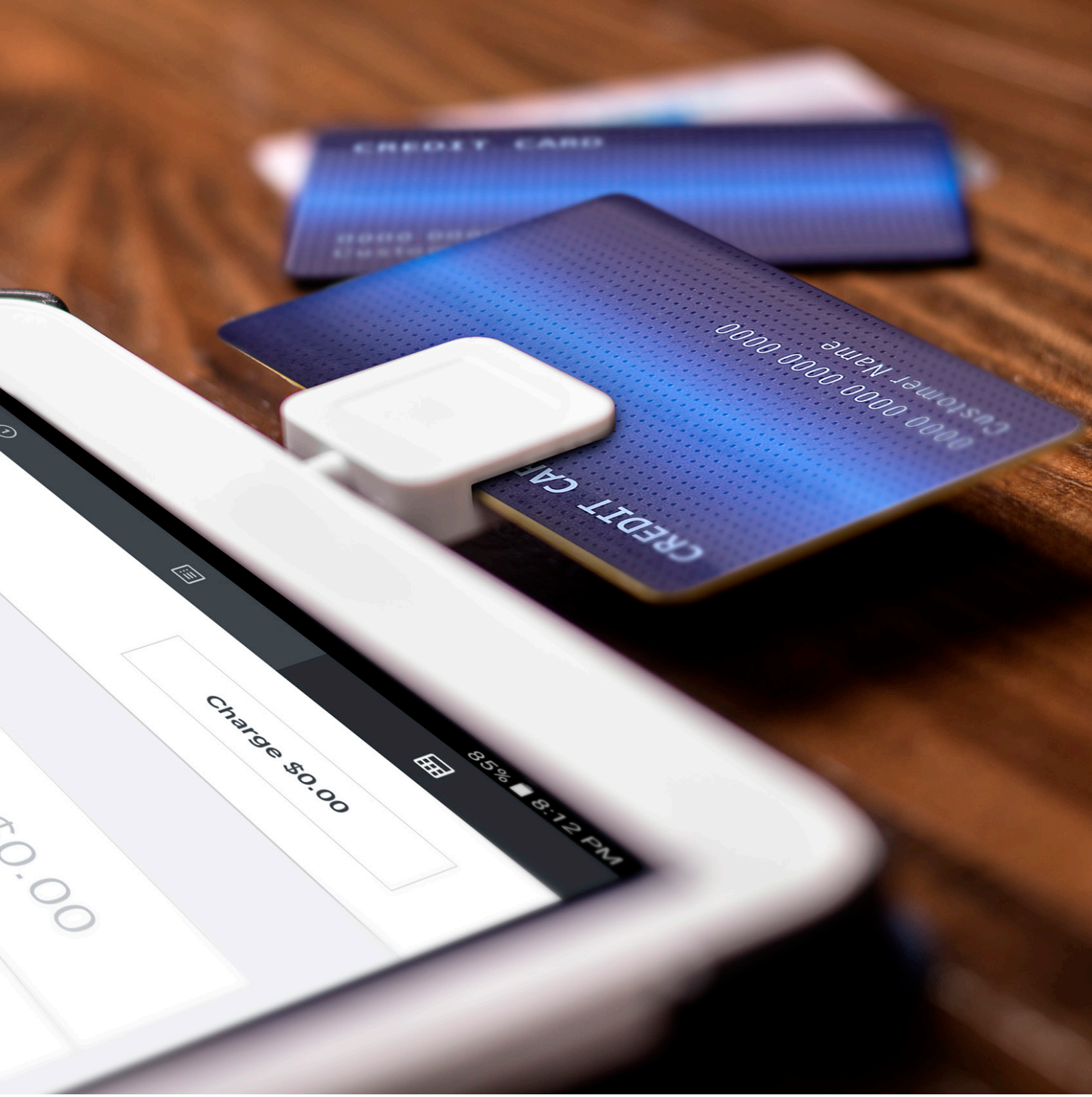
MELT & MOLD TEMPERATURES	ENGLISH (°F)		METRIC (°C)		COMMENTS
Melt Temperature	440°F	480°F	225°C	250°C	Wipe down mold surface after each production run. Strongly recommend immediate cleaning after injection. Purge thoroughly before and after use of this product with a low flow (0.5–2.5 MFR) PE or PP.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

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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