

# Edgetek™

ET8900 CR SERIES



## 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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