

Data sheet **NatureForm Yellu F**

Our compound, **NatureForm Yellu F** is a bio-based paper injection molding material. The unique formulation allows production on conventional injection molding machines as used in the plastics industry. The formulation consists of cellulose and chalk, among other ingredients, and gives the end product all the properties necessary for its application. This makes **NatureForm Yellu F** a first-class competitor to conventional plastics.

The material is suitable for food contact, especially developed for reuse. It is also dishwasher save.

Properties	Method	Unit	Value
MVR	ISO1133 (190°C/2,16kg)	cm ³ /10min	8
Density	ISO 1183-1	g/cm ³	1,00
Tensile modulus	ISO 527	MPa	1400
Tensile strength	ISO 527	MPa	25
Elongation at break	ISO 527	%	5,4
Charpy notched impact	ISO 179 1eA	kJ/m ²	2,8
HDT (B)	ISO 75	°C	70

Injection molding processing recommendations	
Predrying temperature	80°C
Predrying period	4 h
Maximum processing humidity	0,05%
Cylinder temperature	175 -190°C
Mold wall temperature	20°C