

Provisional data sheet **NatureForm HC04**

Our compound, **NatureForm HC04** is a bio-based garden compostable 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 HC04** a first-class competitor to conventional plastics.

Properties	Method	Unit	Value
MVR	ISO1133 (200°C/5kg)	cm ³ /10min	12,1
Density	ISO 1183-1	g/cm ³	1,34
Tensile modulus	ISO 527	MPa	515
Tensile strength	ISO 527	MPa	15,4
Impact strength	ISO 179 1eA	kJ/m ²	4,3
HDT (B)	ISO 75	°C	80
Bulk density	DIN EN 10204	g/cm ³	0,48
Shorehardness	ISO 868	Shore D	59

Injection molding processing recommendations	
Predrying temperature	70°C
Predrying period	4 h
Maximum processing humidity	0,05%
Cylinder temperature	175 -190°C
Mold wall temperature	20°C