

Technical data sheet **NatureForm Flex04**

Our compound, **NatureForm Flex04** is a biobased paper injection molding product. The unique formulation allows production on conventional injection molding machines used in the plastics industry. The formulation, which contains no fossil raw material, consists of cellulose and chalk, among other ingredients, and gives the final product all the properties necessary for its application. This makes **NatureForm Flex04** a first-class competitor to conventional plastics.

Properties	Method	Unit	Value
MVR	ISO1133 (190°C/2,16kg)	cm ³ /10min	12,0
Density	ISO 1183-1	g/cm ³	1,26
Tensile modulus	ISO 527-1	MPa	1500
Tensile strength	ISO 527-1	MPa	22
Charpy notched impact	ISO179 1eA	kJ/m ²	12
HDT (B)	ISO 75	°C	70
Bulk density	DIN EN 10204	g/cm ³	0,64
Shorehardness	ISO 868	Shore D	60

Injection molding processing recommendations	
Predrying temperature	55°C
Predrying period	4 h
Maximum processing humidity	0,05%
Cylinder temperature	175 -190°C
Mold wall temperature	20°C