

HERAFORM R350 NAT

Material code Colour code

DESCRIPTION

POM Acetal copolymer. Standard grade for extrusion and injection moulding of thick walled items.
Natural colour

ISO 1043 : POM

MATERIAL HANDLING AND PROCESSING

Drying is not normally required due to low water absorption of the resin. In case of water contact dry at 80°C for 3 - 5 h in air dryer.

Maximum recommended water content for best processing is 0,20%.

Special care must be taken to avoid moisture absorption and contamination with other polymers when adding regrind material. Colour variation and mechanical properties reduction may occur and should always be carefully monitored.

Processing Parameters

Melt Temperature:	Mold Temperature:	Injection Speed:
200 ÷ 220 °C	80 ÷ 100 °C	Medium

PRODUCT SAFETY AND APPROVALS

For safety instruction please refer to Material Safety Data Sheet



Underwriters Laboratories Inc. certified material. File number: E116324 www.ul.com



Technical data sheet

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PROPERTY		STANDARD	UNIT	VALUE
<i>Physical Properties</i>				
Density		ISO 1183	Kg/m ³	1410
Water absorption, immersion at 23°C	2mm thk	ISO 62	%	0.7
Melt Volume Rate	190°C / 2.16kg	ISO 1133	g/10'	2.2
<i>Mechanical Properties</i>				
Tensile Modulus	1mm/min	ISO 527-2/1A	MPa	2600
Stress at Yield	50mm/min	ISO 527-2/1A	MPa	62
Nominal Strain at Break	50mm/min	ISO 527-2/1A	%	>30
Charpy Notched Impact Strength	+23°C	ISO 179/1 eA	KJ/m ²	8.5
<i>Thermal Properties</i>				
Melting Temperature	10°C/min	ISO 11357-1-3	°C	165
Heat Deflection Temperature	1.8 MPa	ISO 75/2 A f	°C	101
Vicat Softening Temperature	50°C/h	ISO 306/B50 50N	°C	151
<i>Flammability Properties</i>				
Flammability	0.8mm	UL 94	class	HB
Automotive interior flammability	Burn rate	FMVSS302	mm/min	<50

