



Product Information



# HERAFORM R1300 NAT

Material code

Colour code

## DESCRIPTION

POM Acetal copolymer. Easy flowing grade for injection moulding of thin walled items with high mechanical requirement. 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](http://www.ul.com)





## Technical data sheet

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| PROPERTY                            |                | STANDARD        | UNIT              | VALUE |
|-------------------------------------|----------------|-----------------|-------------------|-------|
| <i>Physical Properties</i>          |                |                 |                   |       |
| Density                             |                | ISO 1183        | Kg/m <sup>3</sup> | 1410  |
| Water absorption, immersion at 23°C | 2mm thk        | ISO 62          | %                 | 0.7   |
| Melt Volume Rate                    | 190°C / 2.16kg | ISO 1133        | g/10'             | 12    |
| <i>Mechanical Properties</i>        |                |                 |                   |       |
| Tensile Modulus                     | 1mm/min        | ISO 527-2/1A    | MPa               | 2900  |
| Stress at Yield                     | 50mm/min       | ISO 527-2/1A    | MPa               | 65    |
| Nominal Strain at Break             | 50mm/min       | ISO 527-2/1A    | %                 | >25   |
| Charpy Notched Impact Strength      | +23°C          | ISO 179/1 eA    | KJ/m <sup>2</sup> | 6.5   |
| <i>Thermal Properties</i>           |                |                 |                   |       |
| Melting Temperature                 | 10°C/min       | ISO 11357-1-3   | °C                | 166   |
| Heat Deflection Temperature         | 1.8 MPa        | ISO 75/2 A f    | °C                | 106   |
| 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   |

