

Biomer® P304

Biodegradable Polymers

Biomer

Message:

Properties of the resins
can be processed as classic thermoplasts
biodegradable
waterproof
small tendency to creep
behaves similar to LPC's in the melt, for this:
finest surfaces
thin walls
microparts
free from even traces of catalysts!
highly crystalline (60 to 70%), for this:
excellent resistance to solvents
temperature of use: -30 to 120°C
shrinkage: 1,3 %

General Information			
Features	Biodegradable		
	Crystalline		
	Good Creep Resistance		
	Low to No Water Absorption		
	Pleasing Surface Appearance		
	Renewable Resource Content		
	Solvent Resistant		
Forms	Pellets		
Processing Method	Extrusion		
	Injection Molding		
Physical	Nominal Value	Unit	
Molding Shrinkage	1.3	%	
Crystallinity	60 to 70	%	
Flexural Strain at Break	2.5	%	
Temperature of Use	-30 to 120	°C	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹	1500	MPa	
Tensile Stress ² (Yield)	28.0	MPa	
Tensile Strain ³ (Break)	8.0	%	
Flexural Stress	31.0	MPa	
Impact	Nominal Value	Unit	Test Method
Charpy Unnotched Impact Strength (23°C)	60	kJ/m ²	ISO 179/1eU

Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	108	°C	ISO 75-2/A
Injection	Nominal Value	Unit	
Drying Temperature	60.0	°C	
Drying Time	> 2.0	hr	
Rear Temperature	185	°C	
Middle Temperature	165	°C	
Front Temperature	150 to 155	°C	
Nozzle Temperature	145	°C	
Processing (Melt) Temp	195	°C	
Mold Temperature	35.0 to 55.0	°C	
Extrusion	Nominal Value	Unit	
Drying Temperature	60.0	°C	
Drying Time	> 2.0	hr	
Cylinder Zone 1 Temp.	185	°C	
Cylinder Zone 2 Temp.	165	°C	
Cylinder Zone 3 Temp.	155	°C	
Cylinder Zone 4 Temp.	150	°C	
Adapter Temperature	145	°C	
Melt Temperature	> 195	°C	
Die Temperature	35.0 to 55.0	°C	
NOTE			
1.	1 mm/min		
2.	50 mm/min		
3.	50 mm/min		

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