

Technical Data Sheet



CELLIDOR B 500-15

Base Polymer	CelluloseAcetateButyrate
Filler/Additive System	15 % phthalate-free plasticiser
Special Features	low odour
Typical Applications	various

Pre-Drying Conditions	in an air circulating dryer 50-80 °C for 2-4 h dependant on moisture content 0,15 % max. moisture content
Processing Injection Moulding	melt temperature 180-230 °C mould temperature 40-80 °C
Storage	dry, protected from light

Properties	Value	Dimension	Test Norm
Mechanical Properties			
Flexural Modulus	1100	MPa	ISO 178
Flexural Stress (3.5% Strain)	30	MPa	ISO 178
Tensile Modulus	1200	MPa	ISO 527
Tensile Stress at Yield	27	MPa	ISO 527
Tensile Elongation at Yield	3.6	%	ISO 527
Tensile Elongation at Break	35	%	ISO 527
Impact Strength (Charpy, 23°C)	no break	kJ/m ²	ISO 179/1eU
Notched Impact Strength (Charpy, 23°C)	25	kJ/m ²	ISO 179/1eA
Ball Indentation Hardness H132/30	45	MPa	ISO 2039-1
Thermal Properties			
Vicat B50	74	°C	ISO 306
HDT / A (1,8 MPa)	69	°C	ISO 75-1/-2
Rheological Properties			
Melt Index (MVR)	17	cm ³ /10min	ISO 1133
MVR temperature	210	°C	-
MVR load	2.16	kg	-
Shrinkage (24h)	0.4 - 0.7	%	ISO 294-4
Physical Properties			
Density	1170	kg/m ³	ISO 1183