

Technical Data Sheet



CELLIDOR B 531-07

Base Polymer	CelluloseAcetateButyrate
Filler/Additive System	7 % phthalate-free plasticiser
Typical Applications	various

Pre-Drying Conditions	in an air circulating dryer 60-90 °C for 2-4 h dependant on moisture content 0,05 % max. moisture content
Processing Injection Moulding	melt temperature 180-230 °C mould temperature 40-80 °C extrusion melt temperature 180-230 °C die temperature 40-80 °C
Storage	dry, protected from light

Properties	Value	Dimension	Test Norm
Mechanical Properties			
Flexural Modulus	1900	MPa	ISO 178
Flexural Stress (3.5% Strain)	52	MPa	ISO 178
Tensile Modulus	1700	MPa	ISO 527
Tensile Stress at Yield	42	MPa	ISO 527
Tensile Elongation at Yield	4.9	%	ISO 527
Tensile Elongation at Break	13	%	ISO 527
Impact Strength (Charpy, 23°C)	145	kJ/m ²	ISO 179/1eU
Impact Strength (Charpy, -40°C)	120	kJ/m ²	ISO 179/1eU
Notched Impact Strength (Charpy, 23°C)	13	kJ/m ²	ISO 179/1eA
Notched Impact Strength (Charpy, -40°C)	6	kJ/m ²	ISO 179/1eA
Ball Indentation Hardness H132/30	75	MPa	ISO 2039-1
Thermal Properties			
Vicat B50	95	°C	ISO 306
HDT / A (1,8 MPa)	92	°C	ISO 75-1/-2
Rheological Properties			
Melt Index (MVR)	3.5	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	1200	kg/m ³	ISO 1183