

Technical Data Sheet



CELLIDOR B 531-10

Base Polymer	CelluloseAcetateButyrate
Filler/Additive System	10 % 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

Properties	Value	Dimension	Test Norm
Mechanical Properties			
Flexural Modulus	1600	MPa	ISO 178
Flexural Stress (3.5% Strain)	44	MPa	ISO 178
Tensile Modulus	1600	MPa	ISO 527
Tensile Stress at Yield	35	MPa	ISO 527
Tensile Elongation at Yield	4.1	%	ISO 527
Tensile Elongation at Break	13	%	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	77	MPa	ISO 2039-1
Thermal Properties			
Vicat B50	88	°C	ISO 306
HDT / A (1,8 MPa)	90	°C	ISO 75-1/-2
Rheological Properties			
Melt Index (MVR)	7	cm ³ /10min	ISO 1133
MVR temperature	210	°C	-
MVR load	2.16	kg	-
Shrinkage (24h)	0.7 - 0.9	%	ISO 294-4
Physical Properties			
Density	1190	kg/m ³	ISO 1183