

Technical Data Sheet



CELLIDOR B 631-10

Base Polymer	CelluloseAcetateButyrate
Filler/Additive System	phthalate-free plasticiser
Market Segment	sport and leisure,various
Application Area	extruded parts,profiles,various
Typical Applications	protection-strip,grease reservoir,various

Pre-Drying Conditions	in a dry air (dessiccant) dryer 50-70 °C for 1-2 h in an air circulating dryer 50-70 °C for 2-4 h max. moisture content <0,15 %
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	1600	MPa	ISO 178
Flexural Stress (3.5% Strain)	47	MPa	ISO 178
Tensile Modulus	1600	MPa	ISO 527
Tensile Stress at Yield	37	MPa	ISO 527
Tensile Strength at Break	33	MPa	ISO 527
Tensile Elongation at Yield	4	%	ISO 527
Impact Strength (Charpy, 23°C)	190	kJ/m ²	ISO 179/1eU
Notched Impact Strength (Charpy, 23°C)	22	kJ/m ²	ISO 179/1eA
Ball Indentation Hardness H132/30	65	MPa	ISO 2039-1
Thermal Properties			
Vicat B50	90	°C	ISO 306
HDT / A (1,8 MPa)	90	°C	ISO 75-1/-2
Rheological Properties			
Melt Index (MVR)	5	cm ³ /10min	ISO 1133
MVR temperature	210	°C	-
MVR load	2.16	kg	-
Shrinkage (24h)	0.45 - 0.75	%	ISO 294-4
Physical Properties			
Density	1190	kg/m ³	ISO 1183