

Technical Data Sheet



CELLIDOR CP 410-10

Base Polymer	CelluloseAcetatePropionate
Filler/Additive System	10 % phthalate-free plasticiser
Typical Applications	thick-walled parts

Pre-Drying Conditions	in an air circulating dryer 60-90 °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	1800	MPa	ISO 178
Flexural Stress (3.5% Strain)	45	MPa	ISO 178
Tensile Modulus	1800	MPa	ISO 527
Tensile Stress at Yield	43	MPa	ISO 527
Tensile Elongation at Yield	4.4	%	ISO 527
Tensile Elongation at Break	12	%	ISO 527
Impact Strength (Charpy, 23°C)	200	kJ/m ²	ISO 179/1eU
Notched Impact Strength (Charpy, 23°C)	20	kJ/m ²	ISO 179/1eA
Ball Indentation Hardness H132/30	95	MPa	ISO 2039-1
Thermal Properties			
Vicat B50	96	°C	ISO 306
HDT / A (1,8 MPa)	90	°C	ISO 75-1/-2
Rheological Properties			
Melt Index (MVR)	4.5	cm ³ /10min	ISO 1133
MVR temperature	210	°C	-
MVR load	2.16	kg	-
Shrinkage (24h)	0.7 - 1	%	ISO 294-4
Physical Properties			
Density	1210	kg/m ³	ISO 1183