

## Technical Data Sheet



### CELLIDOR B 500-20

Base Polymer	CelluloseAcetateButyrate
Filler/Additive System	20 % phthalate-free plasticiser
Special Features	low odour
Typical Applications	injection moulded parts

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
<b>Mechanical Properties</b>			
Flexural Modulus	900	MPa	ISO 178
Flexural Stress (3.5% Strain)	24	MPa	ISO 178
Tensile Modulus	900	MPa	ISO 527
Tensile Stress at Yield	19	MPa	ISO 527
Tensile Elongation at Yield	3.5	%	ISO 527
Tensile Elongation at Break	50	%	ISO 527
Impact Strength (Charpy, 23°C)	no break	kJ/m <sup>2</sup>	ISO 179/1eU
Notched Impact Strength (Charpy, 23°C)	35	kJ/m <sup>2</sup>	ISO 179/1eA
Ball Indentation Hardness H132/30	35	MPa	ISO 2039-1
<b>Thermal Properties</b>			
Vicat B50	60	°C	ISO 306
HDT / A (1,8 MPa)	60	°C	ISO 75-1/-2
<b>Rheological Properties</b>			
Melt Index (MVR)	30	cm <sup>3</sup> /10min	ISO 1133
MVR temperature	210	°C	-
MVR load	2.16	kg	-
Shrinkage (24h)	0.45 - 0.75	%	ISO 294-4
<b>Physical Properties</b>			
Density	1160	kg/m <sup>3</sup>	ISO 1183