

## Technical Data Sheet



### CELLIDOR CP 310-10

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

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
<b>Mechanical Properties</b>			
Flexural Modulus	1900	MPa	ISO 178
Flexural Stress (3.5% Strain)	50	MPa	ISO 178
Tensile Modulus	2100	MPa	ISO 527
Tensile Stress at Yield	40	MPa	ISO 527
Tensile Elongation at Break	15	%	ISO 527
Impact Strength (Charpy, 23°C)	no break	kJ/m <sup>2</sup>	ISO 179/1eU
Notched Impact Strength (Charpy, 23°C)	15	kJ/m <sup>2</sup>	ISO 179/1eA
Ball Indentation Hardness H132/30	85	MPa	ISO 2039-1
<b>Thermal Properties</b>			
Vicat B50	95	°C	ISO 306
HDT / A (1,8 MPa)	100	°C	ISO 75-1/-2
<b>Rheological Properties</b>			
Melt Index (MVR)	5	cm <sup>3</sup> /10min	ISO 1133
MVR temperature	210	°C	-
MVR load	2.16	kg	-
Shrinkage (24h)	0.7 - 0.9	%	ISO 294-4
<b>Physical Properties</b>			
Density	1210	kg/m <sup>3</sup>	ISO 1183