

Technical Data Sheet



CELLIDOR CP 410-18

Base Polymer	CelluloseAcetatePropionate
Filler/Additive System	phthalate-free plasticiser
Special Features	processing stabilised,high toughness,injection moulding grade
Typical Applications	various

Pre-Drying Conditions in an air circulating dryer 50-80 °C
for 2-4 h
dependant on 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	1250	MPa	ISO 178
Flexural Stress (3.5% Strain)	30	MPa	ISO 178
Tensile Modulus	1350	MPa	ISO 527
Tensile Stress at Yield	26	MPa	ISO 527
Tensile Elongation at Yield	3	%	ISO 527
Tensile Elongation at Break	30	%	ISO 527
Impact Strength (Charpy, 23°C)	no break	kJ/m ²	ISO 179/1eU
Impact Strength (Charpy, -40°C)	250	kJ/m ²	ISO 179/1eU
Notched Impact Strength (Charpy, 23°C)	35	kJ/m ²	ISO 179/1eA
Notched Impact Strength (Charpy, -40°C)	10	kJ/m ²	ISO 179/1eA
Ball Indentation Hardness H132/30	50	MPa	ISO 2039-1
Thermal Properties			
Vicat B50	70	°C	ISO 306
HDT / A (1,8 MPa)	60	°C	ISO 75-1/-2
Rheological Properties			
Melt Index (MVR)	20	cm ³ /10min	ISO 1133
MVR temperature	210	°C	-
MVR load	2.16	kg	-
Shrinkage (24h)	0.5 - 0.8	%	ISO 294-4
Physical Properties			
Density	1180	kg/m ³	ISO 1183