



CELLIDOR B 631-10

(Last update: 09.07.2019)



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



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Liability Exclusion

These are guide values and not a specification. The test values mentioned are representative values only and not binding minimum or maximum figures. These test values have been determined on standardised test specimens and can be affected by pigmentation, mould design and processing conditions.

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