

CELLIDOR B 631-12,5

(Last update: 03.06.2021)

MOCOM

Base Polymer	CelluloseAcetateButyrate
Filler/Additive System	phthalate-free plasticiser 12-13 %,light stabiliser
Special Features	high toughness,high surface quality,high surface gloss,good haptics,good weathering resistance
Typical Applications	extruded parts,profiles

Pre-Drying Conditions	in an air circulating dryer 60-90 °C for 2-4 h dependant on moisture content max. moisture content <0,05 %
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	1400	MPa	ISO 178
Flexural Stress (3.5% Strain)	37	MPa	ISO 178
Tensile Modulus	1400	MPa	ISO 527
Tensile Stress at Yield	33	MPa	ISO 527
Tensile Elongation at Yield	4	%	ISO 527
Tensile Elongation at Break	15	%	ISO 527
Impact Strength (Charpy, 23°C)	220	kJ/m²	ISO 179/1eU
Impact Strength (Charpy, -40°C)	165	kJ/m²	ISO 179/1eU
Notched Impact Strength (Charpy, 23°C)	25	kJ/m²	ISO 179/1eA
Notched Impact Strength (Charpy, -40°C)	7.5	kJ/m²	ISO 179/1eA
Ball Indentation Hardness H132/30	65	MPa	ISO 2039-1
Thermal Properties			
Vicat B50	85	°C	ISO 306
HDT / A (1,8 MPa)	82	°C	ISO 75-1/-2
Rheological Properties			
Melt Index (MVR)	9	cm³/10min	ISO 1133
MVR temperature	210	°C	-
MVR load	2.16	kg	-
Shrinkage (24h)	0.8 - 1.1	%	ISO 294-4

Technical Data Sheet



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Physical Properties

Density	1180	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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