

Technical Data Sheet



CELLIDOR B 631-12,5

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
Physical Properties			
Density	1180	kg/m³	ISO 1183