

Auracell® M

Cellulose Acetate
Rotuba Extruders, Inc.

Message:

Auracell® M is a Cellulose Acetate (CA) product. It can be processed by injection molding and is available in Europe or North America. Primary characteristic: eco-friendly/green.

General Information			
Features	Renewable Resource Content		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.27	g/cm ³	ASTM D792
Water Absorption (23°C, 24 hr)	2.3	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	55		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength			ASTM D638
Yield	23.4	MPa	
Break, 23°C	32.4	MPa	
Break, 70°C	13.4	MPa	
Tensile Elongation (Break)	47	%	ASTM D638
Flexural Modulus	1000	MPa	ASTM D790
Flexural Strength (Yield)	33.1	MPa	ASTM D790
Deformation Under Load			ASTM D621
50°C, 6.9 MPa	1.00	%	
50°C, 14 MPa	23.0	%	
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-40°C	64	J/m	
23°C	270	J/m	
Aging	Nominal Value	Unit	Test Method
Accelerated Aging - wt. lost, 72 hr (82°C)	3.6	wt%	ASTM D706
Flow Beginning Temperature	145	°C	ASTM D569
Soluble Matter Loss	0.60	%	ASTM D570
Injection	Nominal Value	Unit	
Drying Temperature	65.6	°C	
Drying Time	2.0	hr	
Dew Point	-40.0 to -28.9	°C	
Rear Temperature	182 to 193	°C	

Middle Temperature	182 to 193	°C
Front Temperature	182 to 193	°C
Nozzle Temperature	193 to 204	°C
Mold Temperature	37.8 to 82.2	°C
Injection Pressure	7.58 to 8.96	MPa
Back Pressure	0.00 to 0.345	MPa
Vent Depth	0.051 to 0.076	mm

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