

# Naturacell® General

Cellulose Acetate  
Rotuba Extruders, Inc.

Message:

Naturacell® General is a Cellulose Acetate (CA) product. It can be processed by extrusion or injection molding and is available in Europe or North America.

Characteristics include:

Eco-Friendly/Green

Plasticized

General Information			
Additive	Plasticizer (19 to 30%)		
Features	Renewable Resource Content		
Forms	Pellets		
Processing Method	Extrusion		
	Injection Molding		

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.29 to 1.31	g/cm <sup>3</sup>	ASTM D792
Melt Mass-Flow Rate (MFR)	0.25 to 5.3	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.070 to 0.30	%	ASTM D955
Water Absorption (23°C, 24 hr)	7.7 to 12	%	ASTM D570

Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	29 to 104		ASTM D785

Mechanical	Nominal Value	Unit	Test Method
Tensile Strength			ASTM D638
Yield	23.5 to 49.6	MPa	
Break	22.4 to 48.0	MPa	
Tensile Elongation (Break)	13 to 17	%	ASTM D638
Flexural Modulus	1030 to 2070	MPa	ASTM D790
Flexural Strength (Yield)	31.0 to 82.7	MPa	ASTM D790

Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-40°C	16 to 32	J/m	
23°C	110 to 200	J/m	

Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	63.9 to 87.8	°C	
1.8 MPa, Unannealed	53.9 to 82.2	°C	
Vicat Softening Temperature	87.2 to 103	°C	ASTM D1525

Optical	Nominal Value	Unit	Test Method
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Transmittance (1590 μm)	90.0 to 91.0	%	ASTM D1003
Haze (1590 μm)	0.88 to 1.3	%	ASTM D1003
Additional Information	Nominal Value	Unit	Test Method
Weight Loss on Heating - 72 hr @ 176°F (80°C)	0.87 to 4.0	%	ASTM D707

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#### Recommended distributors for this material

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