

# Rotuba CA H

Cellulose Acetate

Rotuba Extruders, Inc.

## Message:

Rotuba CA H is a cellulose acetate (CA) product. It can be processed by injection molding and is available in North America. Rotuba CA H's application areas include tools, consumer goods and medical/health care. The main features are: environmental protection/green.

| General Information         |                      |                   |             |
|-----------------------------|----------------------|-------------------|-------------|
| Features                    | Updatable resources  |                   |             |
|                             | Good stability       |                   |             |
|                             | Good color stability |                   |             |
| Uses                        | Mould                |                   |             |
|                             | Buttons              |                   |             |
|                             | Toys                 |                   |             |
|                             | Glasses              |                   |             |
| Forms                       | Particle             |                   |             |
| Processing Method           | Injection molding    |                   |             |
| Physical                    | Nominal Value        | Unit              | Test Method |
| Specific Gravity            | 1.28                 | g/cm <sup>3</sup> | ASTM D792   |
| Water Absorption (24 hr)    | 2.3                  | %                 | ASTM D570   |
| Hardness                    | Nominal Value        | Unit              | Test Method |
| Rockwell Hardness (R-Scale) | 76                   |                   | ASTM D785   |
| Mechanical                  | Nominal Value        | Unit              | Test Method |
| Tensile Strength            |                      |                   | ASTM D638   |
| Yield                       | 29.6                 | MPa               | ASTM D638   |
| Fracture                    | 40.0                 | MPa               | ASTM D638   |
| Tensile Elongation (Yield)  | 39                   | %                 | ASTM D638   |
| Flexural Modulus            | 1210                 | MPa               | ASTM D790   |
| Flexural Strength (Yield)   | 45.5                 | MPa               | ASTM D790   |
| Impact                      | Nominal Value        | Unit              | Test Method |
| Notched Izod Impact         |                      |                   | ASTM D256   |
| -40°C                       | 59                   | J/m               | ASTM D256   |
| 23°C                        | 210                  | J/m               | ASTM D256   |
| Injection                   | Nominal Value        | Unit              |             |
| Drying Temperature          | 66 - 77              | °C                |             |
| Drying Time                 | 2.0 - 4.0            | hr                |             |
| Rear Temperature            | 204 - 216            | °C                |             |
| Middle Temperature          | 204 - 216            | °C                |             |

|                    |              |     |
|--------------------|--------------|-----|
| Front Temperature  | 204 - 216    | °C  |
| Nozzle Temperature | 210 - 221    | °C  |
| Mold Temperature   | 43 - 54      | °C  |
| Injection Pressure | 8.27 - 10.3  | MPa |
| Back Pressure      | 0.00 - 0.345 | MPa |

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