



Designation: D707 – 15 (Reapproved 2023)

Standard Classification System and Basis for Specification for Cellulose Acetate Butyrate Molding and Extrusion Compounds (CAB)¹

This standard is issued under the fixed designation D707; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reapproval.

This standard has been approved for use by agencies of the U.S. Department of Defense.

1. Scope*

1.1 This classification system covers requirements for plasticized cellulose acetate butyrate thermoplastic compounds suitable for injection molding and extrusion. These compounds have a butyryl content less than 38 % and an acetyl content less than 15 % and can contain dyes and pigments. This classification system does not include special materials compounded for special applications. Cellulosic plastic materials, being thermoplastic, are reprocessible and recyclable. This classification system allows for the use of those cellulosic materials, provided that all specific requirements of this classification system are met.

1.2 The properties included in this classification system are those required to identify the compositions covered. Other requirements necessary to identify particular characteristics important to specialized applications are specified by using the suffixes as given in Section 5.

1.3 This classification system and subsequent line call out (specification) are intended to provide a means of calling out plastic materials used in the fabrication of end items or parts. It is not intended for the selection of materials. Material selection can be made by those having expertise in the plastic field only after careful consideration of the design and performance required of the part, environment to which it will be exposed, fabrication process to be employed, costs involved, and inherent properties of the material other than those covered by this classification system.

1.4 The values stated in SI units are to be regarded as standard.

1.5 The following safety hazards caveat pertains only to the test method portion, Section 12, of this classification system. *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility*

of the user of this standard to establish appropriate safety, health, and environmental practices and determine the applicability of regulatory limitations prior to use.

NOTE 1—There is no known ISO equivalent to this standard.

1.6 *This international standard was developed in accordance with internationally recognized principles on standardization established in the Decision on Principles for the Development of International Standards, Guides and Recommendations issued by the World Trade Organization Technical Barriers to Trade (TBT) Committee.*

2. Referenced Documents

2.1 ASTM Standards:²

- D149 Test Method for Dielectric Breakdown Voltage and Dielectric Strength of Solid Electrical Insulating Materials at Commercial Power Frequencies
- D256 Test Methods for Determining the Izod Pendulum Impact Resistance of Plastics
- D257 Test Methods for DC Resistance or Conductance of Insulating Materials
- D570 Test Method for Water Absorption of Plastics
- D618 Practice for Conditioning Plastics for Testing
- D635 Test Method for Rate of Burning and/or Extent and Time of Burning of Plastics in a Horizontal Position
- D638 Test Method for Tensile Properties of Plastics
- D790 Test Methods for Flexural Properties of Unreinforced and Reinforced Plastics and Electrical Insulating Materials
- D792 Test Methods for Density and Specific Gravity (Relative Density) of Plastics by Displacement
- D883 Terminology Relating to Plastics
- D1003 Test Method for Haze and Luminous Transmittance of Transparent Plastics
- D1600 Terminology for Abbreviated Terms Relating to Plastics

¹ This classification system is under the jurisdiction of ASTM Committee D20 on Plastics and is the direct responsibility of Subcommittee D20.15 on Thermoplastic Materials.

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² For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

*A Summary of Changes section appears at the end of this standard

- D1729** Practice for Visual Appraisal of Colors and Color Differences of Diffusely-Illuminated Opaque Materials
- D3641** Practice for Injection Molding Test Specimens of Thermoplastic Molding and Extrusion Materials
- D3892** Practice for Packaging/Packing of Plastics
- D4000** Classification System for Specifying Plastic Materials
- D5740** Guide for Writing Material Standards in the Classification Format
- D7209** Guide for Waste Reduction, Resource Recovery, and Use of Recycled Polymeric Materials and Products (Withdrawn 2015)³
- E308** Practice for Computing the Colors of Objects by Using the CIE System

- CAB = Table CAB property requirements.
- 01 = Group 01—high impact strength.
- 2 = Class 2—Plasticizer range from 12 to 23 % (see Table CAB, Footnote 1).
- 2 = Grade 2—Extrusion application.
- F053 = Flammability requirement from Classification System **D4000**—Burn rate maximum of 50 mm/min with 3 mm minimum thickness, when tested in accordance with Test Method **D635**.

NOTE 2—“CAB0122” corresponds to the following physical property requirements in Table CAB:

- Specific gravity: 1.15–1.19.
 Tensile stress at yield: 19 MPa min.
 Flexural modulus: 760 MPa min.
 Izod impact strength: 285 J/m min.
 Water absorption: 1.6 % max.
 Weight loss on heating: 2.7 % max.

3. Terminology

3.1 *Definitions*—The terminology used in this classification system is in accordance with Terminologies **D883** and **D1600**.

4. Classification

4.1 This classification system covers the following groups, classes, and grades (see Table CAB):

- 4.1.1 *Group 01*—High impact strength.
- 4.1.2 *Group 02*—High tensile strength.
- 4.1.3 *Class*—According to plasticizer content and properties specified in Table CAB.
- 4.1.4 *Grade 1*—For injection molding (general purpose).
- 4.1.5 *Grade 2*—For extrusion.

5. Suffixes

5.1 When requirements are needed that are not covered in Table CAB they shall be indicated through the use of suffixes.

5.2 A list of suffixes can be found in Classification System **D4000** (Table 3) and can be used for additional requirements as appropriate. Additional suffixes will be added to that classification system as test methods and requirements are developed and requested.

5.3 Color and opacity shall be within the limits defined in **6.3**.

5.4 Some of the more commonly used suffixes for cellulose acetate butyrate are shown as follows:

- E = electrical requirements as designated by the following digits:
- First Digit*
- 1 = volume resistivity—Test Methods **D257**.
 dielectric strength—Test Method **D149** (short-time/step-by-step).
- Second Digit*
- 1 = volume resistivity and dielectric strength meet property requirements as shown in Table 1.

- T = transmittance requirements as designated by the following digits:
- First Digit*
- 1 = total luminous transmittance determined in accordance with Procedure A of Test Method **D1003**.
- Second Digit*
- 1 = total luminous transmittance, 80 % min.

5.5 An example of this classification system for a high-impact cellulose acetate butyrate formulation would be as follows:

6. Materials and Manufacture

6.1 Materials supplied in these forms shall be as uniform in composition and size, and as free of contamination as can be achieved by good manufacturing practice.

6.2 If these materials contain colorants in the nominal amounts ordinarily employed, such additives shall not alter the ability of the materials to meet the specified properties.

6.3 The color of material supplied shall be comparable, within commercial match tolerances, to the color of standard samples prepared by the manufacturer.

7. Physical Requirements

7.1 Test specimens of the material shall conform to the requirements prescribed in Table CAB.

7.2 Molded specimens, for those tests requiring them, shall be prepared in accordance with Section **10**.

7.3 Conformance to the requirements of this classification system shall be determined in accordance with Section **11**.

8. Sampling

8.1 Sampling shall be statistically adequate to satisfy the requirements of **12.4**.

8.2 A batch or lot shall be constituted as a unit of manufacture as prepared for shipment and can consist of a blend of two or more “production runs.”

9. Number of Tests

9.1 Routine testing of each batch or lot shall be limited to properties designated in Table CAB of this classification system.

9.2 One set of samples for those tests that are designated (Section **12**) shall be considered sufficient for testing the batch or lot. The average results from those samples shall comply with the requirements prescribed in this classification system.

10. Specimen Preparation

10.1 Physical property requirements in Table CAB are based on injection-molded specimens 3.2 mm thick. Specimens

³ The last approved version of this historical standard is referenced on www.astm.org.

machined from compression-molded blanks or extruded strips can be used, provided it can be shown that the results are comparable.

10.2 Prior to molding cellulose acetate butyrate, dry the material to a moisture content of 0.2 % or less. The primary reason for drying the material is to eliminate visual defects such as surface imperfections and bubbles. Material spread in a tray to a maximum depth of 50 mm and exposed in a circulating-air oven at 75 to 90°C for 3 h is recommended. Formulations containing either very low or very high levels of plasticizer can require slightly higher or lower drying temperatures respectively. Control the injection molding cycles in accordance with Practice D3641, using a material temperature of 25 to 35°C above the “cold point.” (The “cold point” is the lowest material temperature at which it is possible to obtain a full shot when all other operating variables are held constant within the normal operating range.) Mold temperatures between 35 and 60°C have been found desirable. As a rule, thin-section moldings and higher hardness materials (lower plasticizer content) require higher mold temperatures.

10.3 Test specimens injection molded from cellulosic materials are subject to “overpacking” if the gate size is too large, and this can result in brittleness in the gate area as well as throughout the entire specimen. A gate size 1.5 mm square has been found to produce satisfactory test specimens.

11. Test Methods

11.1 Determine the properties defined by this classification system in accordance with the following test methods:

11.1.1 All tests shall be performed in the standard laboratory atmosphere as defined by Practice D618.

11.1.2 Test specimens shall be conditioned in accordance with Procedure A of Practice D618.

11.1.3 *Color-Visual*—Practice D1729

11.1.4 *Color-Quantitative*—Practice E308

11.1.5 *Plasticizer Content*—The test method for plasticizer content shall be specified.

11.1.6 *Specific Gravity*—Test Methods D792.

11.1.7 *Tensile Stress at Yield*—Test Method D638, Type I test specimen, 50-mm/min testing speed.

11.1.8 *Flexural Modulus*—Test Methods D790, 1.27-mm/min testing speed.

11.1.9 *Impact Strength (Izod)*—Test Method A of Test Method D256. Specimen size: 63.5 mm long by 12.7 mm wide by 3.2 mm thick.

11.1.10 *Water Absorption*—Test Method D570, 24-h immersion.

NOTE 3—The ungated “tab end” (75 mm long) of a Test Method D638, Type I tensile bar will give comparable results and can be used if the primary specimen type is not available. Condition in accordance with Test Method D570.

11.1.11 *Weight Loss on Heating*—Condition test specimens, 50.8 mm in diameter or 50.8 mm wide by 63.5 mm long by 3.2 mm thick, for 48 h over anhydrous calcium chloride at 23 ± 2°C or 4 h at 70 ± 2°C.

NOTE 4—The ungated “tab end” (75 mm long) of a Test Method D638, Type I tensile bar will give comparable results and can be used if the primary specimen type is not available. Weigh three specimens and place them in a circulating-air oven for 72 h at 82 ± 2°C. Support the specimens flatwise on a screen in the oven. Upon removal from the oven, cool the specimens in a desiccator over anhydrous calcium chloride to 23 ± 2°C. Weigh the specimens and calculate the weight loss on heating as a percentage of the conditioned weight as follows:

$$\text{weight loss on heating, \%} = \frac{(W_1 - W_2)}{W_1} \times 100 \quad (1)$$

where:

W_1 = original weight, g, after initial conditioning, and

W_2 = weight, g, after 72 h in oven at 82°C.

12. Inspection and Certification

12.1 Inspection and certification of the material supplied with reference to a specification based on this classification system shall be for conformance to the requirements specified herein.

12.2 Lot-acceptance inspection shall be the basis on which acceptance or rejection of the lot is made. The lot-acceptance inspection shall consist of plasticizer content determination (see Table CAB, Footnote 1) and color as specified in 6.3.

12.3 Periodic check inspection with reference to a specification based on this classification system shall consist of the tests for all requirements of the material under the specification. Inspection frequency shall be adequate to ensure that the material is certifiable in accordance with 12.4.

12.4 Certification shall be that the material was manufactured by a process in statistical control, sampled, tested, and inspected in accordance with this classification system and that the average values for the lot meet the requirements of the classification system (line call out).

12.5 A report of test results shall be furnished when requested. The report shall consist of results of the lot acceptance inspection for the shipment, the results of the most recent periodic-check inspection, and the percent by weight of recycled plastic, as defined in Guide D7209, if requested.

NOTE 5—The ASTM publication *Manual on Presentation of Data and Control Chart Analysis*, 8th Edition, stock number: MNL7-8TH-EB, provides detailed information about statistical process control.

13. Rejection

13.1 Material that fails to conform to the requirements of this classification system is not to be certified.

14. Packaging and Package Marking

14.1 The provisions of Practice D3892 apply to packaging, packing, and marking of containers for plastic materials.

15. Keywords

15.1 acetate; butyrate; cellulose; extrusion; molding; plasticized; recycled; specification