

Product description

Colour	Weight (mg)	Size (mm)	Bulk density (g/l)	Packaging	Food approved
Black	1.2	2.5 – 4.5	28.0 – 32.0	Bulk / Bag	Yes

Physical properties

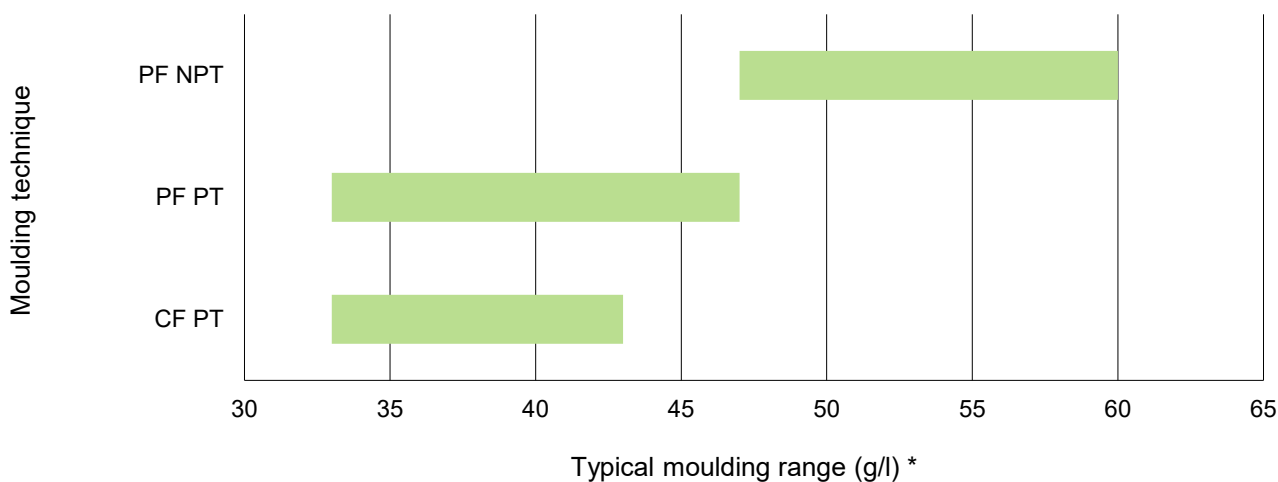
	Test method	40g/l	55g/l
Compressive strength	ISO 844		
25% strain (kPa)	5mm/min	210	310
50% strain (kPa)		300	420
75% strain (kPa)		600	900
Compression set	ISO 1856 (Method C)		
25% strain – 22 hours – 23°C (%)	Stabilising 24h	11.5	11.5
Burn rate (mm/min)	ISO 3795		
	12.5mm thick	60	45

Moulding

ARPRO 5130 can be moulded using Crack Fill (CF) and Pressure Fill (PF):

Crack fill: preferably applied to Pre-Treated (PT) ARPRO.

Pressure fill: applied to either Pre-Treated (PT) or Non-Pre-Treated (NPT) ARPRO.



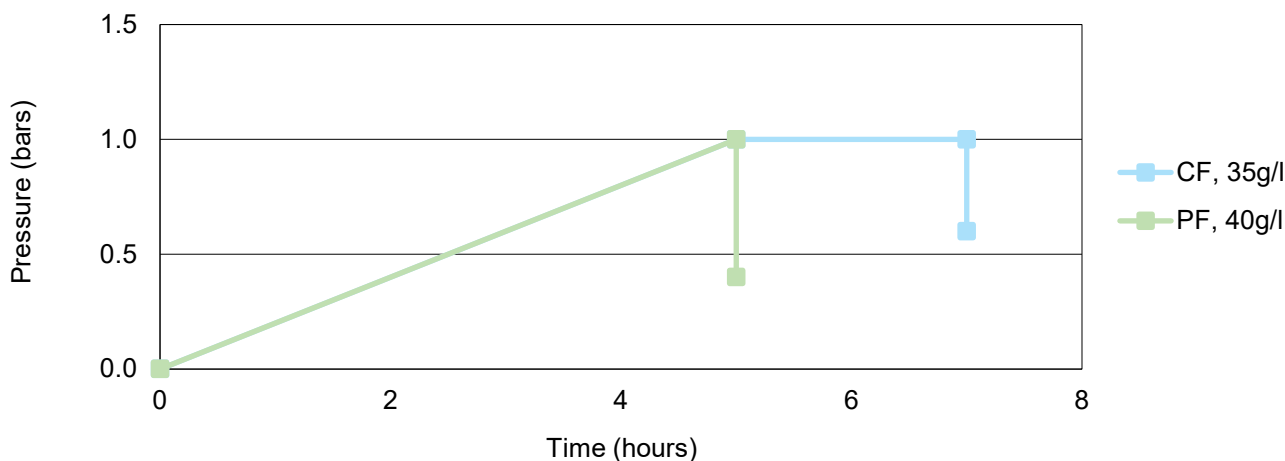
* Shrinkage, surface aspect and cycle time are influenced by process parameters, tool and equipment layout, and part geometry.

Pre-treatment

Recommended pre-treatment cycle with pressure tank environment and incoming compressed air both at 23°C:

Crack fill: 5 hours up to 1 bar, hold 2 hours at 1 bar, decrease and maintain at 0.6 bar throughout production.

Pressure fill: 5 hours up to 1 bar, decrease and maintain at 0.4 bar throughout production.



Pre-treatment cycles can be adapted according to moulding process, density and part geometry:

If internal cell pressure is too high, this may lead to fusion issues. In this case, decrease time, pressure or temperature to improve fusion.

Increase time, pressure or temperature to reduce moulded density and improve aspect.

Operating the pressure tank above ambient temperature, up to a maximum of 50°C, significantly shortens pre-treatment time.

Post-treatment

For moulded densities below 50g/l and depending on the parts dimensions, post-treatment at a temperature of 80°C is recommended for 3 to 8 hours. This helps to remove water content, as well as ensuring dimensional stability and a geometric shape.

Shrinkage

Typical values range from 1.8% to 2.2%. The higher the moulded density, typically the lower the shrinkage.

Storage

A storage temperature above 15°C is strongly recommended.

Indoor storage strongly recommended.

If stored outdoors, it is strongly recommended to keep the material indoors for 24 hours before moulding.