

## Product description

Colour	Weight (mg)	Size (mm)	Bulk density (g/l)	Packaging	Food approved
Black	1.2	1.5 – 3.0	88.0 – 102.0	Bag	Yes

## Physical properties

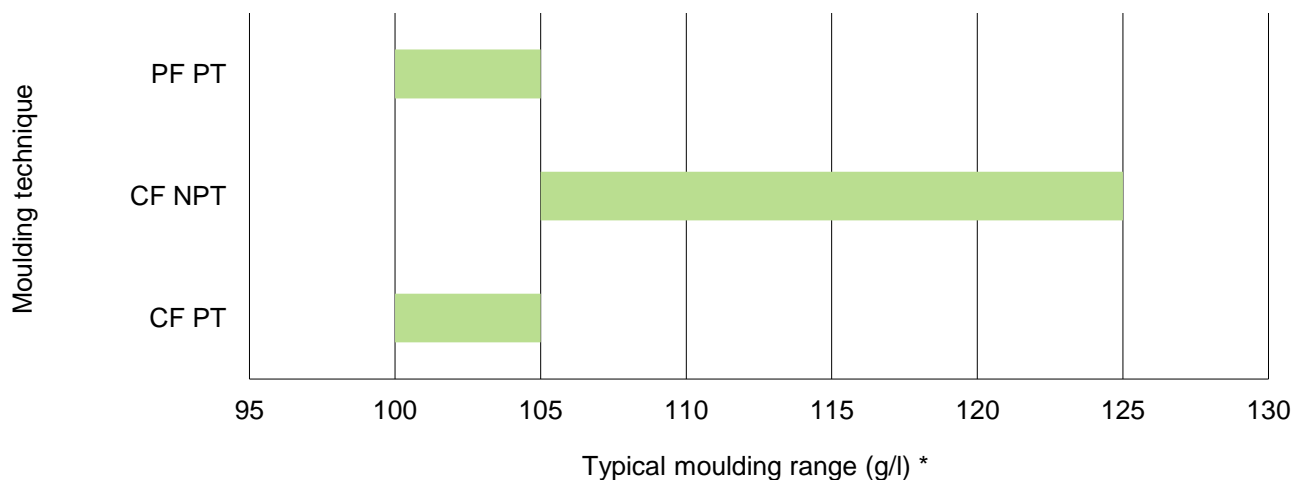
	Test method	105g/l	115g/l
Compressive strength	ISO 844		
25% strain (kPa)	5mm/min	760	860
50% strain (kPa)		1,040	1,190
75% strain (kPa)		2,500	2,950
Tensile strength (kPa)	ISO 1798	1,550	1,680
Tensile elongation (%)		18	17
Compression set	ISO 1856 (Method C)		
25% strain – 22 hours – 23°C (%)	Stabilising 24h	11.0	10.5
Burn rate (mm/min)	ISO 3795		
	12.5mm thick	25	20

## Moulding

ARPRO 5195 can be moulded using Crack Fill (CF) and Pressure Fill (PF):

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

Pressure fill: only applied to Pre-Treated (PT) ARPRO.

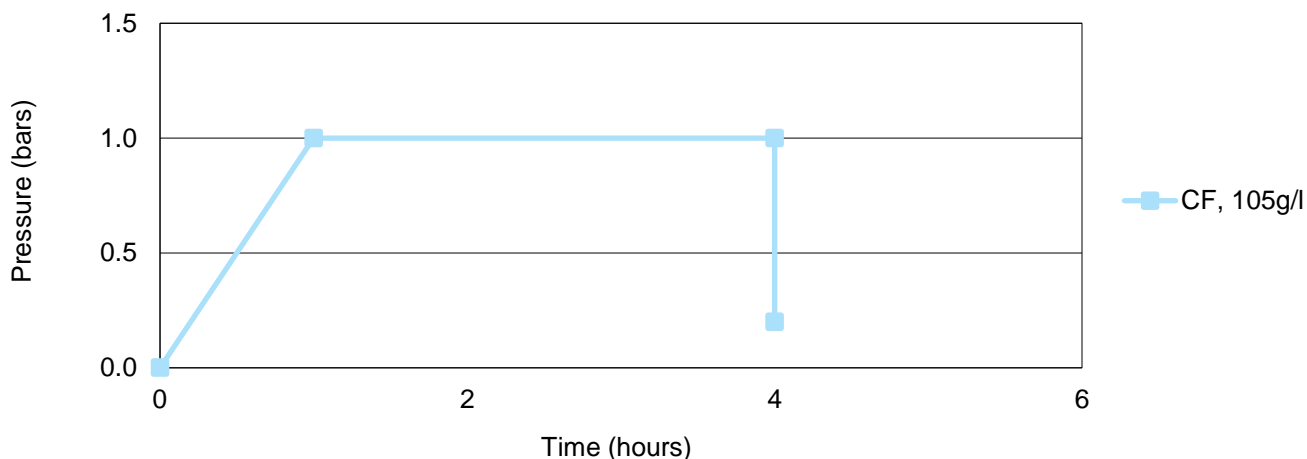


\* Shrinkage, surface aspect and cycle time are influenced by process parameters, tool and equipment layout, and part geometry.

**Pre-treatment**

Pressure tank environment and incoming compressed air should both be at 23°C:

1 hour up to 1 bar, hold for 3 hours at 1 bar, decrease and maintain at 0.2 bar throughout production.

**Processing**

Cycle 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**

No post-treatment is required. Stabilisation to ambient conditions for 4 hours before dimensional quality testing is recommended. For highly compressed parts, post-treatment is compulsory to obtain a nice surface aspect, for example 3 to 8 hours at a temperature of 80°C.

**Shrinkage**

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

**Storage**

Temperature: >15°C

Indoor storage strongly recommended.

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