35 Ocean

Product description

Colour	Weight (mg)	Size (mm)	Bulk density (g/l)	Packaging	Approved for direct food contact
Sea green shades[1]	1.2	2.5 – 4.5	32.0 – 38.0	Bag	No

Physical properties

	Test method	45g/l	60g/l
Compressive strength 25% strain (kPa) 50% strain (kPa) 75% strain (kPa)	 ISO 844 5mm/min	 260 355 755	 370 490 1,040
Tensile strength (kPa) Tensile elongation (%)	ISO 1798	615 24	830 20
Compression set 25% strain – 22 hours – 23°C (%)	ISO 1856 (Method C) Stabilising 24h	11.5	11.5
Burn rate (mm/min)	ISO 3795 12.5mm thick	55	40

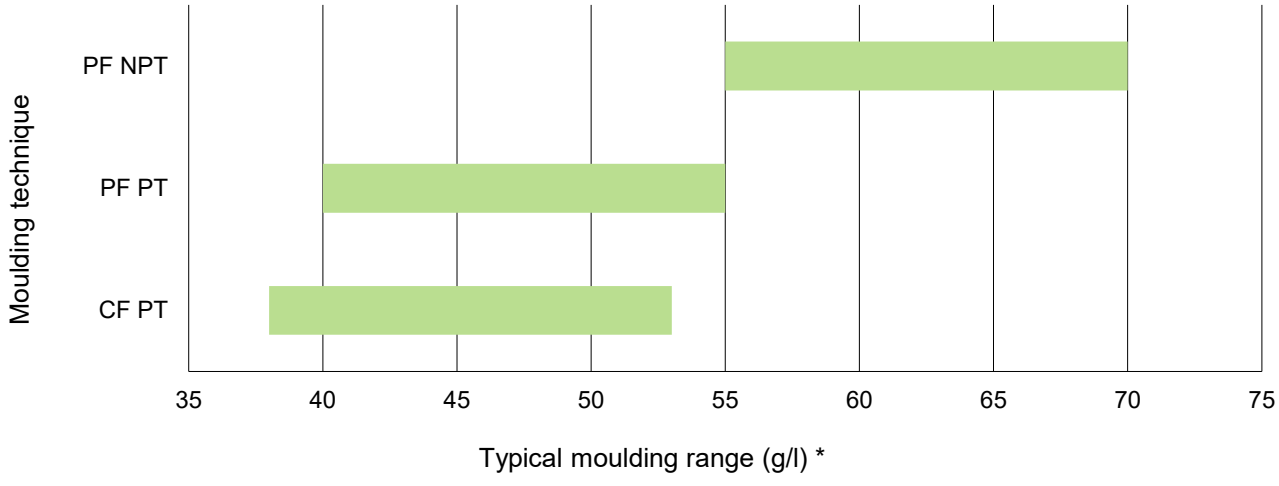
ARPRO 35 Ocean contains 15% of maritime industry waste and contributes to reduce CO_2 emissions by 6% compared to ARPRO Black!

Moulding

ARPRO 35 Ocean can be moulded using Crack Fill (CF) and Pressure Fill (PF):

Crack fill: 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.

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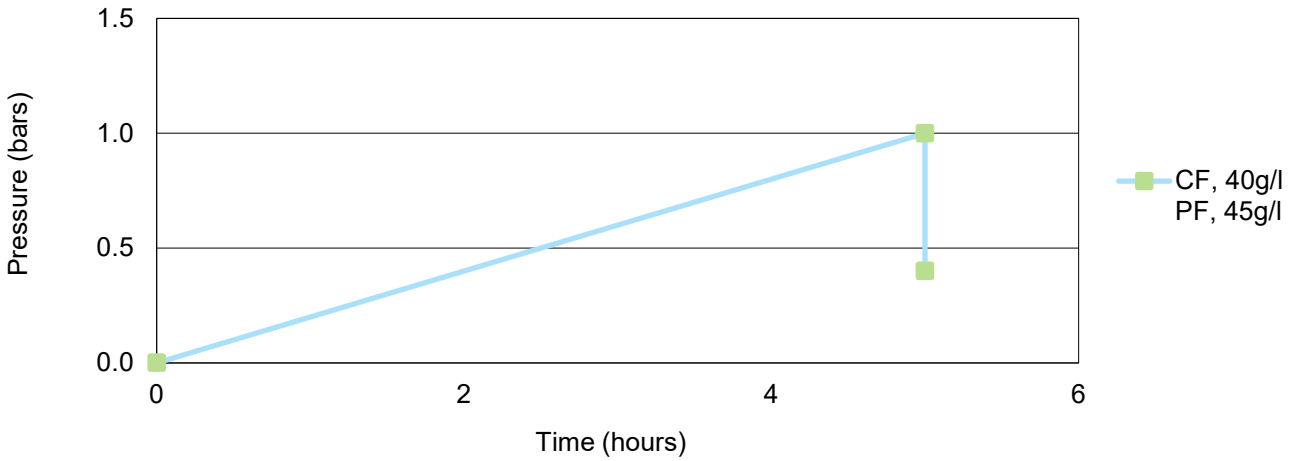
Pre-treatment

Recommended pre-treatment cycle with pressure tank environment and incoming compressed air both at 23°C:
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 50°C maximum, 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.

[1] ARPRO 35 Ocean once moulded may show a colour variation due to the unavoidable disparity in the colour mix of post-use maritime waste and the fact that no additional colouring pigments are added.

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