

Product description

Colour	Weight (mg)	Size (mm)	Bulk density (g/l)	Packaging	Food approved
Black	1.0	2.0 – 3.5	71.0 – 79.0	Bulk	No

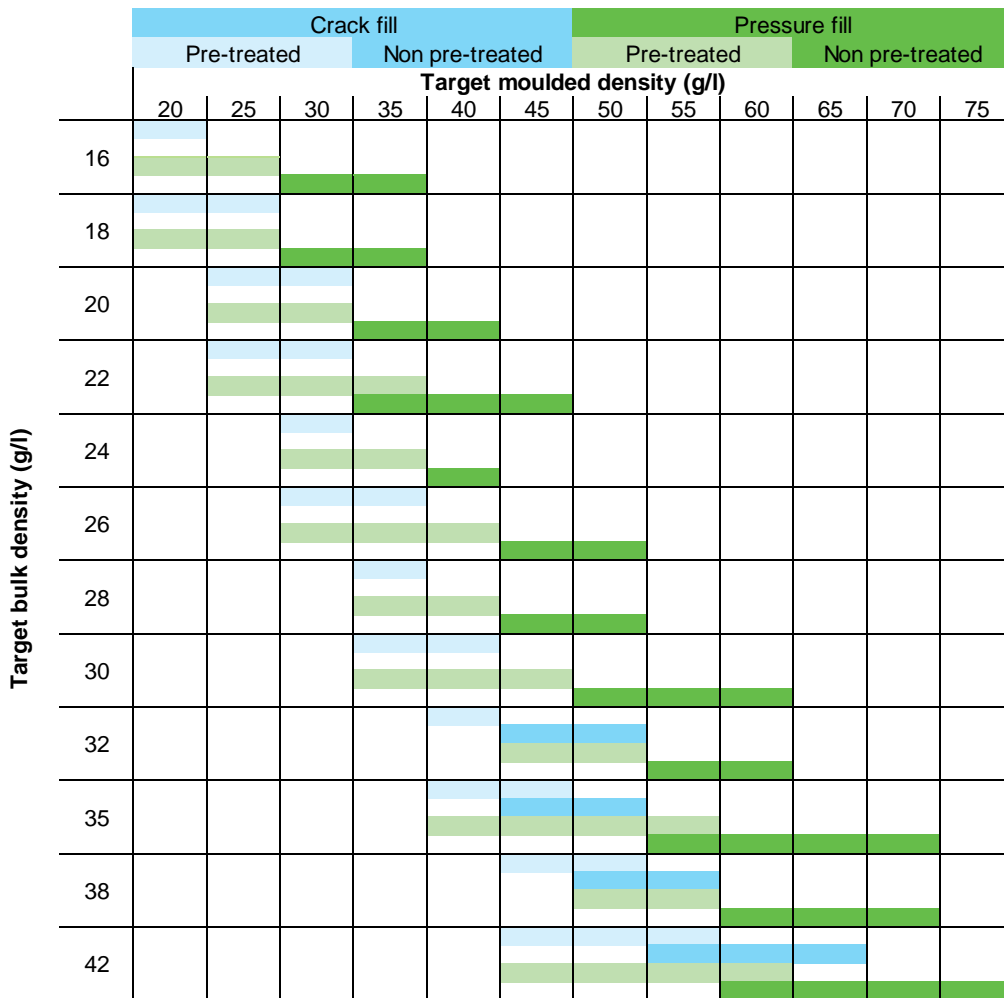
Physical properties

	Test method	20g/l	30g/l	40g/l	50g/l	60g/l	70g/l
Compressive strength	ISO 844						
25% strain (kPa)	5mm/min	80	150	210	275	340	425
50% strain (kPa)		150	220	300	370	475	580
75% strain (kPa)		370	460	600	800	1,000	1,250
Tensile strength (kPa)	ISO 1798	340	490	640	785	930	1,070
Tensile elongation (%)		32	30	28	26	25	23
Compression set	ISO 1856 (Method C)						
25% strain – 22 hours – 23°C (%)	Stabilising 24h	12.5	12.0	11.5	11.5	11.5	11.0
Burn rate (mm/min)	ISO 3795						
	12.5mm thick	115	80	60	50	40	35

ARPRO 5275 is for on-site expansion between 16g/l and 42g/l.

Moulding

ARPRO 5275 requires on-site expansion prior to moulding. The table below illustrates the bulk density range achievable through on-site expansion and the respective moulding process required to then achieve the target moulded density. For direct moulding of 5275 without expansion, please contact the ARPRO technical team for support.



Pre-treatment

Pre-treatment recommendations are available in the respective ARPRO black grade sheets at ARPRO.com.

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.

For moulded densities above 50g/l, post-treatment is not required. Stabilisation to ambient conditions for 4 hours before dimensional quality testing is recommended.

Shrinkage

Typical values range from 1.8% to 3.5%. 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.