

Product description

Colour	Weight (mg)	Size (mm)	Bulk density (g/l)	Packaging	Food approved
Grey	0.8	2.0 – 4.0	32.0 – 38.0	Bag	No

Physical properties

	Test method	40g/l	60g/l
Compressive strength	ISO 844		
25% strain (kPa)	5mm/min	210	340
50% strain (kPa)		300	475
75% strain (kPa)		600	1,000
Tensile strength (kPa)	ISO 1798	550	760
Tensile elongation (%)		19	17
Compression set	ISO 1856 C		
25% strain – 22 hours – 23°C (%)	Stabilising 24h	11.5	11.5
Burn rate (mm/min)	ISO 3795	0	0
	12.5mm thick	Self-extinguishing	Self-extinguishing
Burn classification*	UL 94	HF-1	HF-1
	3 – 13mm thick		

ARPRO 4135 FR is flame retardant and free of halogenated components**

* See UL website for classification.

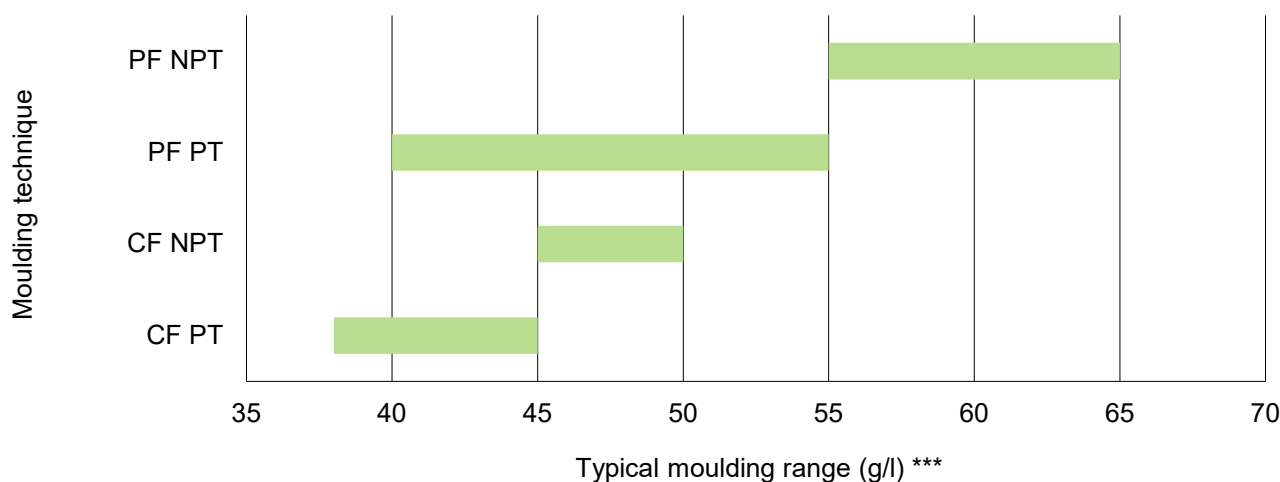
** Free of halogenated components according to UL 746 H. For moulded densities above 60g/l, the burn classification is not applicable.

Moulding

ARPRO 4135 FR 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: applied to either Pre-Treated (PT) or Non-Pre-Treated (NPT) ARPRO.



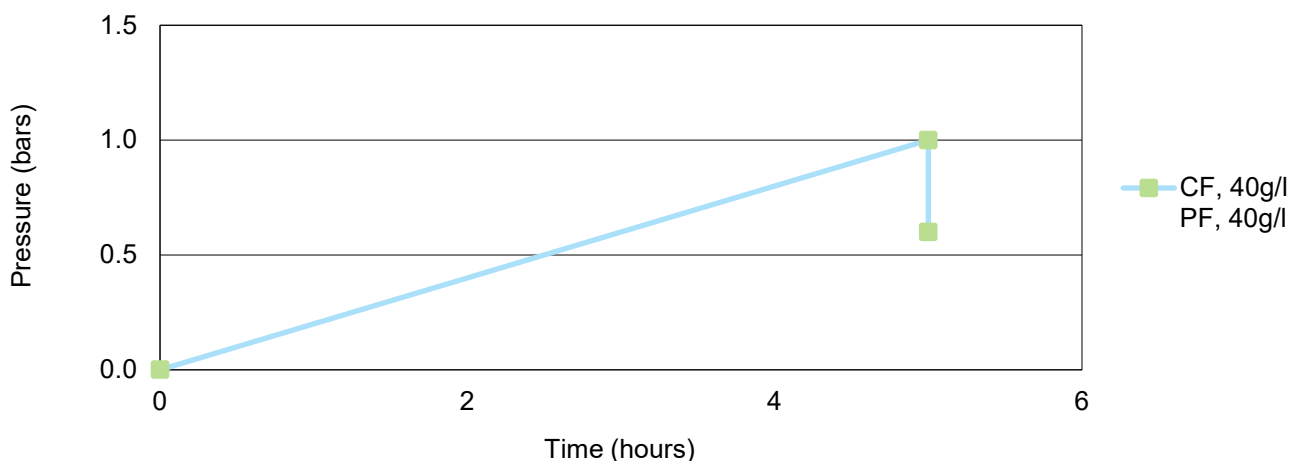
*** Shrinkage, surface aspect and cycle time are influenced by process parameters, tool and equipment layout, and part geometry.

Version 07

This information is provided as a convenience to customers and reflects the results of internal tests conducted on ARPRO samples. While all reasonable care has been taken to ensure that this information is accurate as of the date of issue, JSP does not represent, warrant or otherwise guarantee, expressly or impliedly, the suitability, accuracy, reliability or completeness of the information. ARPRO is a registered trade mark.

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 0.6 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%. Trials are recommended to determine the exact part shrinkage values. 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.