

Product description

Colour	Weight (mg)	Size (mm)	Bulk density (g/l)	Packaging	Approved for direct food contact
Grey	0.8	2.0 – 4.0	32.0 – 38.0	Bag	No

Physical properties

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

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

* See UL website for classification.

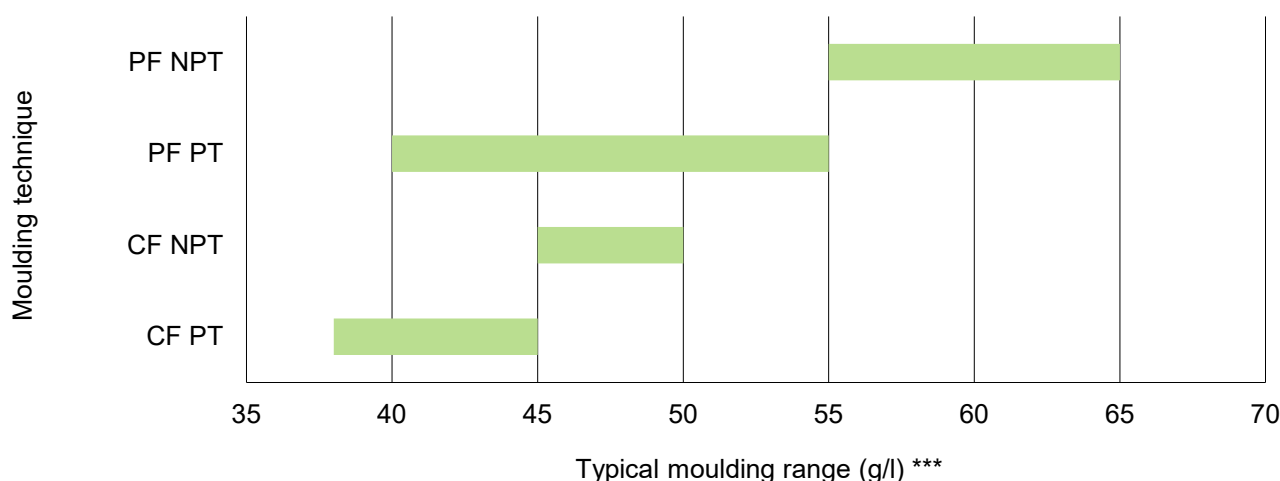
** Free of halogenated components according to UL 746 H. For moulded densities above 60g/l, the burn classification is not applicable.

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.



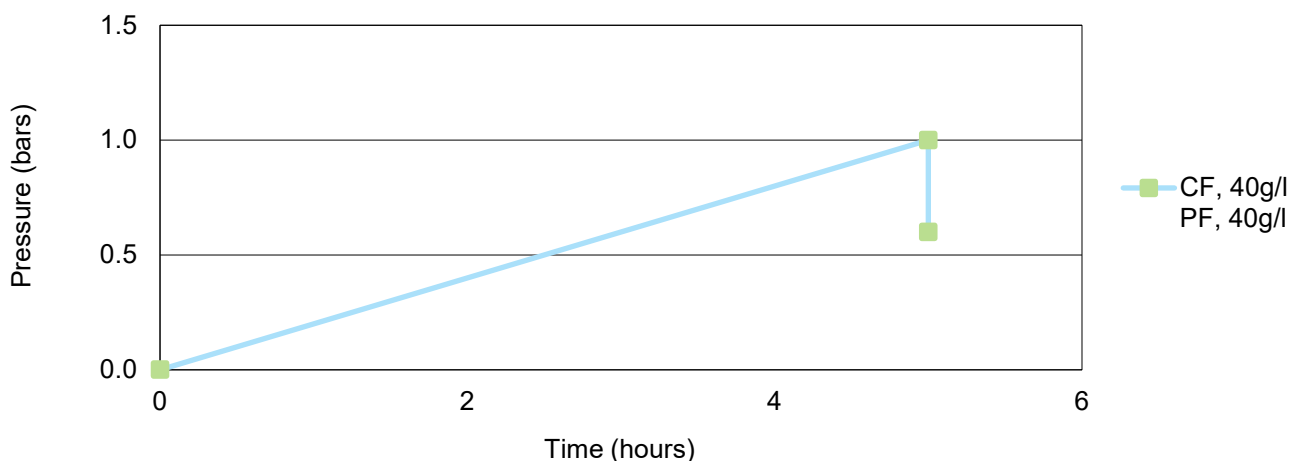
*** Shrinkage, surface aspect and cycle time are influenced by process parameters, tool and equipment layout, and part geometry.

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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 0.6 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.