

#### **Product description**

Colour	Weight (mg)	Size (mm)	Bulk density (g/l)	Packaging	Food approved
Black	1.0	2.0 - 3.5	49.0 - 57.0	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 25% strain – 22 hours – 23°C (%)	ISO 1856 (Method 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 5253 is for on-site expansion between 16g/l and 42g/l.

## Moulding

ARPRO 5253 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 5253 without expansion, please contact the ARPRO technical team for support.

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.

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# ARPRO

		Crack fill						Pressure Fill						
		Pre-treated Non pre-treated Target moulde				Pre-treated Non pre-treated								
Target bulk density (g/l)		20	25	30	35	40	45	50 50	55 55	) 60	65	70	75	
		20	20	00		10	10	00		00				
	16													
	18													
	20													
	22													
	24													
	26													
	28													
	30													
	32													
	35													

## **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

Temperature: >15°C Indoor storage strongly recommended. If stored outdoors, it is strongly recommended to keep the material indoors for 24 hours before moulding.

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