



Technical Guideline - Conversion Guide for Part Molding for ARPRO® Expanded Polypropylene (EPP)

Material Expansion Ratio (X)	Material Density (g/l)	Molded Part Density (g/l)			
		Non-Pretreat & Pressure Fill	Non-Pretreat & Crack Fill	Pretreat & Pressure Fill	Pretreat & Crack Fill
64.3	14	24.5	21.0	20.0	18.1
56.3	16	27.8	25.8	22.8	20.8
50.0	18	31.1	28.8	25.7	23.4
45.0	20	34.4	31.8	28.5	26.0
40.9	22	37.6	34.8	31.4	28.6
37.5	24	40.8	37.7	34.2	31.2
34.6	26	43.9	40.6	37.1	33.8
30.0	30	50.4	46.5	42.8	39.0
27.3	33	55.1	50.8	47.0	42.9
25.0	36	59.8	55.1	51.3	46.8
22.5	40	66.0	60.8	57.0	52.0
20.0	45	73.8	68.0	64.1	58.5
18.0	50	81.5	75.0	71.3	65.0
16.4	55	89.1	81.4	Not Recommended	71.5
15.0	60	96.6	87.6		Not Recommended (Not Necessary)
13.8	65	104.0	93.6		
12.9	70	111.3	99.4		
12.0	75	118.5	105.0		
11.3	80	Not Recommended	110.4		
10.6	85		115.6		
10.0	90		120.6		
9.0	100		132.0		
8.2	110		143.0		
7.5	120		155.2		
6.9	130		167.6		
6.4	140		180.0		
6.0	150		192.0		
5.6	160		203.4		
5.3	170		214.2		
5.0	180		225.0		
4.5	200		250.0		
4.1	220		275.0		
3.8	240		300.0		

Note: This technical guideline is intended as a reference only. Molding compression ratios are subject to change depending on part geometry, part volume, and molding equipment. Pre-treatment conditions such as ramp profile, ambient temperature, etc. will effect molding compression ratio and final molded part density. Consult your JSP Technical Representative for more details.

