

Product description

| Colour | Weight (mg) | Size (mm) | Bulk density (g/l) | Packaging | Food approved |
|--------|-------------|-----------|--------------------|------------|---------------|
| White | 1.2 | 3.0 – 5.0 | 20.5 – 23.5 | Bulk / Bag | Yes |

Physical properties

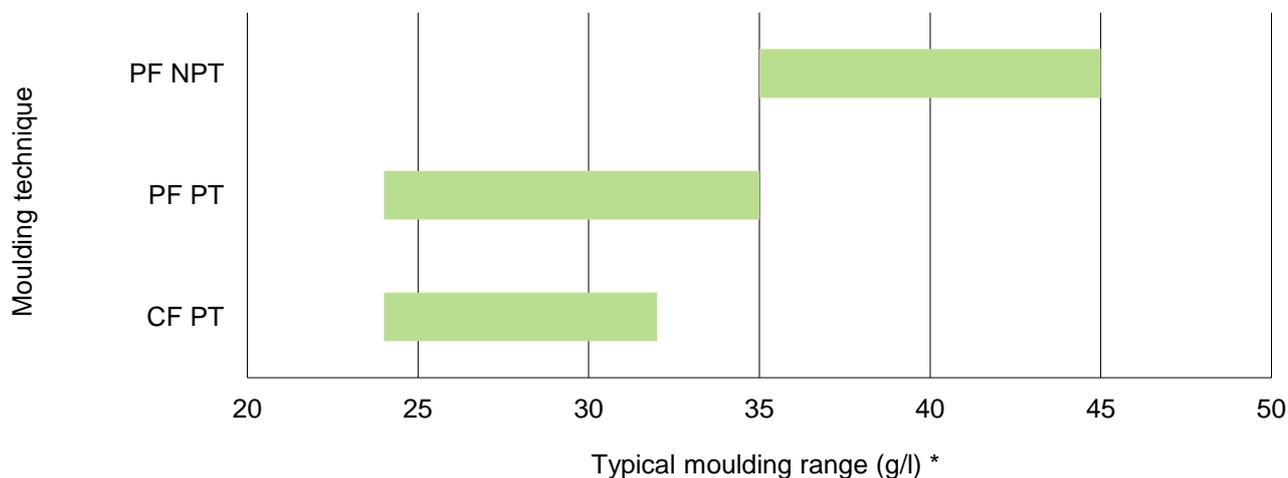
| | Test method | 30g/l | 40g/l |
|--|--|-------------------|-------------------|
| Compressive strength 25% strain (kPa) 50% strain (kPa) 75% strain (kPa) | ISO 844 5mm/min | 150 220 460 | 210 300 600 |
| Tensile strength (kPa) Tensile elongation (%) | ISO 1798 | 430 21 | 550 19 |
| Compression set 25% strain – 22 hours – 23°C (%) | ISO 1856 (Method C) Stabilising 24h | 12.0 | 11.5 |
| Burn rate (mm/min) | ISO 3795 12.5mm thick | 80 | 60 |

Moulding

ARPRO 3122 can be moulded using Crack Fill (CF) and Pressure Fill (PF):

Crack fill: preferably applied to Pre-Treated (PT) ARPRO.

Pressure fill: applied to either Pre-Treated (PT) or Non-Pre-Treated (NPT) ARPRO.



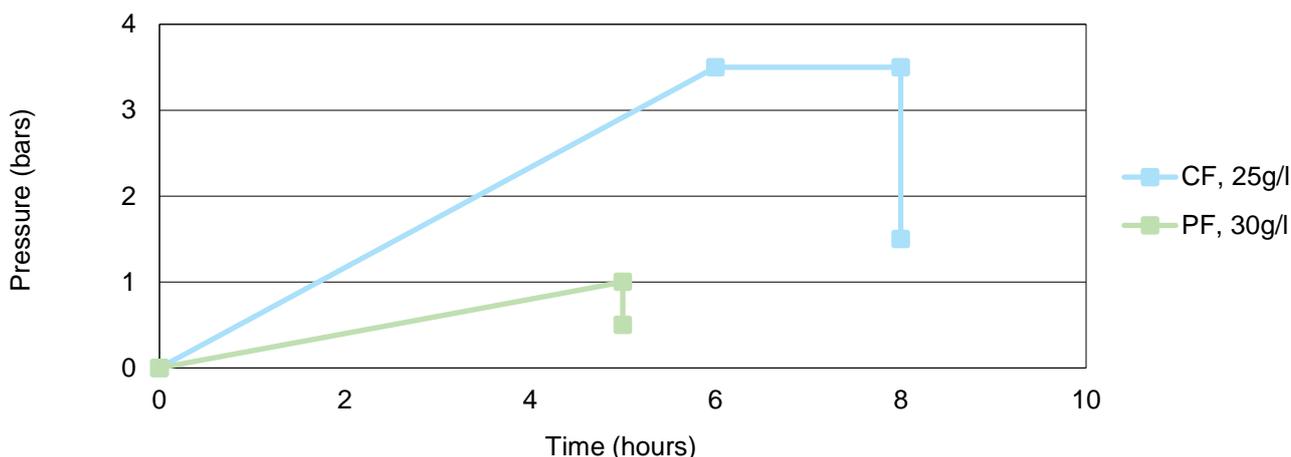
* Shrinkage, surface aspect and cycle time are influenced by process parameters, tool and equipment layout, and part geometry.

Pre-treatment

Pressure tank environment and incoming compressed air should both be at 23°C:

Crack fill: 6 hours up to 3.5 bar, hold at 3.5 bar for 2 hours, decrease and maintain at 1.5 bar throughout production.

Pressure fill: 5 hours up to 1 bar, decrease and maintain at 0.5 bar throughout production.



Processing

Cycle 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 2% to 2.6%. 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.