

Product description

Colour	Weight (mg)	Size (mm)	Bulk density (g/l)	Packaging	Food approved
White	1.2	3.5 – 6.0	13.5 – 16.5	Bulk / Bag	Yes

Physical properties

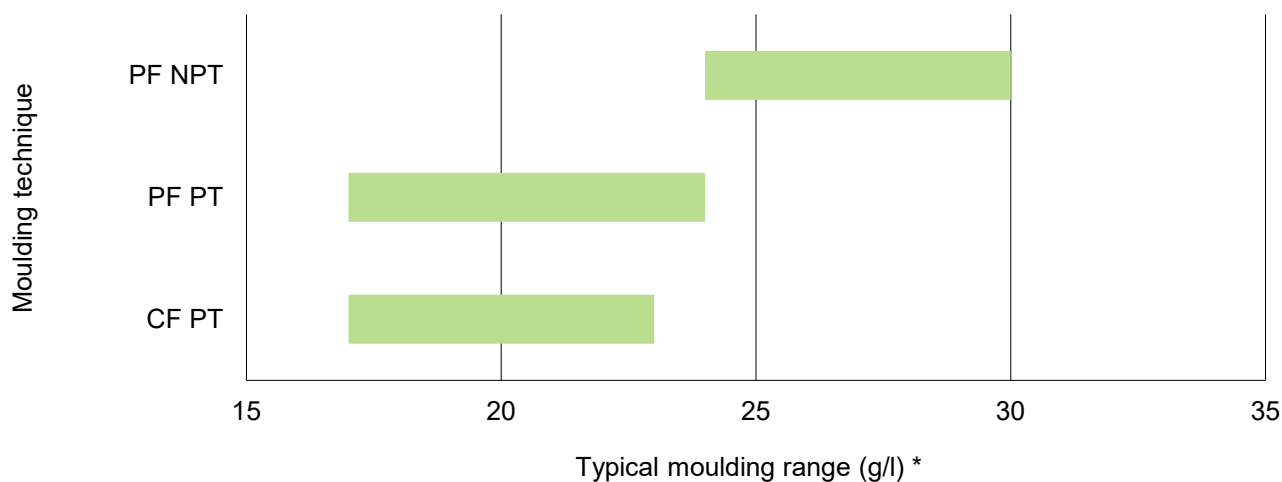
	Test method	20g/l	30g/l
Compressive strength 25% strain (kPa) 50% strain (kPa) 75% strain (kPa)	ISO 844 5mm/min	80 150 370	150 220 460
Compression set 25% strain – 22 hours – 23°C (%)	ISO 1856 (Method C) Stabilising 24h	12.5	12.0
Burn rate (mm/min)	ISO 3795 12.5mm thick	115	80

Moulding

ARPRO 3115 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.



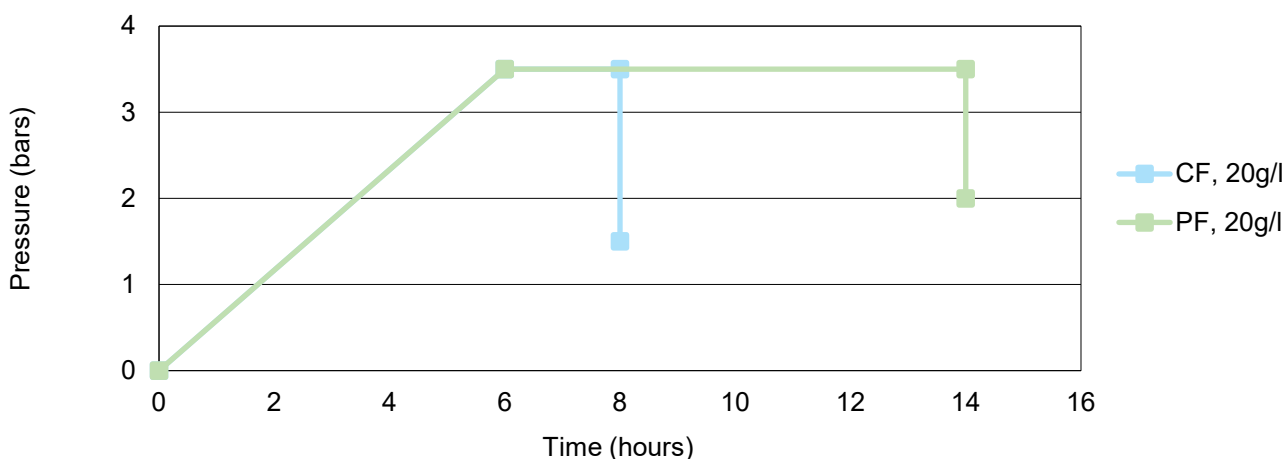
* Shrinkage, surface aspect and cycle time are influenced by process parameters, tool and equipment layout, and part geometry.

Pre-treatment

Recommended pre-treatment cycle with pressure tank environment and incoming compressed air both 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: 6 hours up to 3.5 bar, hold at 3.5 bar for 8 hours, decrease and maintain at 2 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 2% to 3.5%. 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.