

Product description

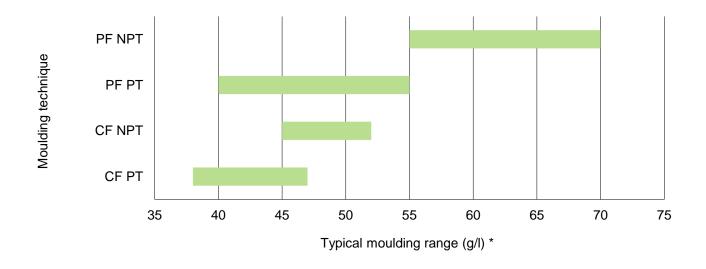
Colour	Weight (mg)	Size (mm)	Bulk density (g/l)	Packaging	Food approved
Black	1.2	2.5 – 4.5	33.0 – 37.0	Bulk / Bag	No

Physical properties

	Test method	45g/l	60g/l
Compressive strength	ISO 844		
25% strain (kPa) 50% strain (kPa) 75% strain (kPa)	5mm/min	240 340 720	340 475 1,000
Tensile strength (kPa) Tensile elongation (%)	ISO 1798	715 27	930 25
Compression set 25% strain – 22 hours – 23°C (%)	ISO 1856 (Method C) Stabilising 24h	11.5	11.5
Burn rate (mm/min)	ISO 3795 12.5mm thick	55	40

Moulding

ARPRO 5135 can be moulded using Crack Fill (CF) and Pressure Fill (PF) with Pre-Treated (PT) or Non-Pre-Treated (NPT) ARPRO in both processes.



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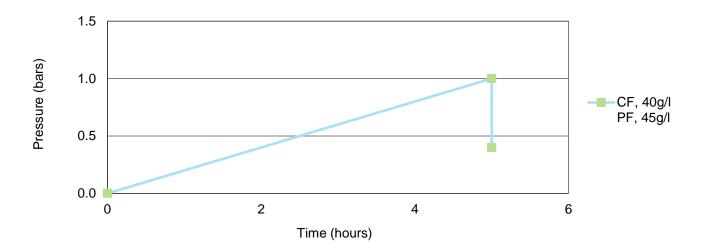
^{*} Shrinkage, surface aspect and cycle time are influenced by process parameters, tool and equipment layout, and part geometry.



Pre-treatment

Pressure tank environment and incoming compressed air should both be at 23 $^{\circ}\text{C}$:

5 hours up to 1 bar, decrease and maintain at 0.4 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 pretreatment 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%. 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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