

**Product description**

| Colour | Weight (mg) | Size (mm) | Bulk density (g/l) | Packaging  | Approved for direct food contact |
|--------|-------------|-----------|--------------------|------------|----------------------------------|
| Black  | 1.0         | 2.5 – 5.0 | 19.5 – 22.5        | Bulk / Bag | No                               |

**Physical properties**

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

**30%****RECYCLED  
PLASTIC**

Certified by RecyClass

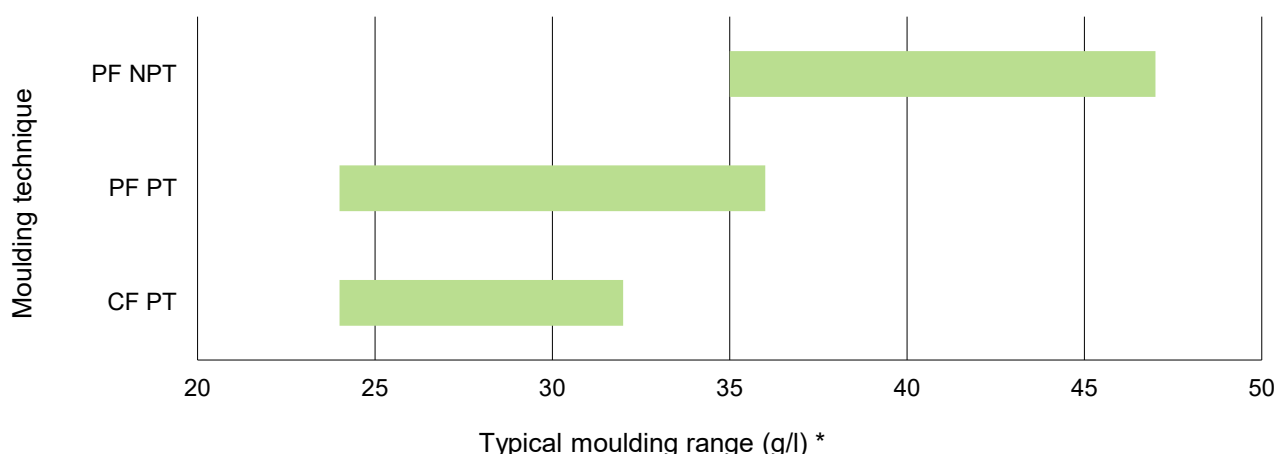
ARPRO 5121 RE is made of 30% plastics originated from post-consumer origin. The carbon footprint of this grade is 1.99 kg CO<sub>2</sub> eq. / kg ARPRO which is a 19% reduction in CO<sub>2</sub> emissions compared to ARPRO made from virgin raw materials. The RecyClass certificates and the LCA are available to download from ARPRO.com: <https://www.arpro.com/product/technical-resources/environmental-health-data>

**Moulding**

ARPRO 5121 RE 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.



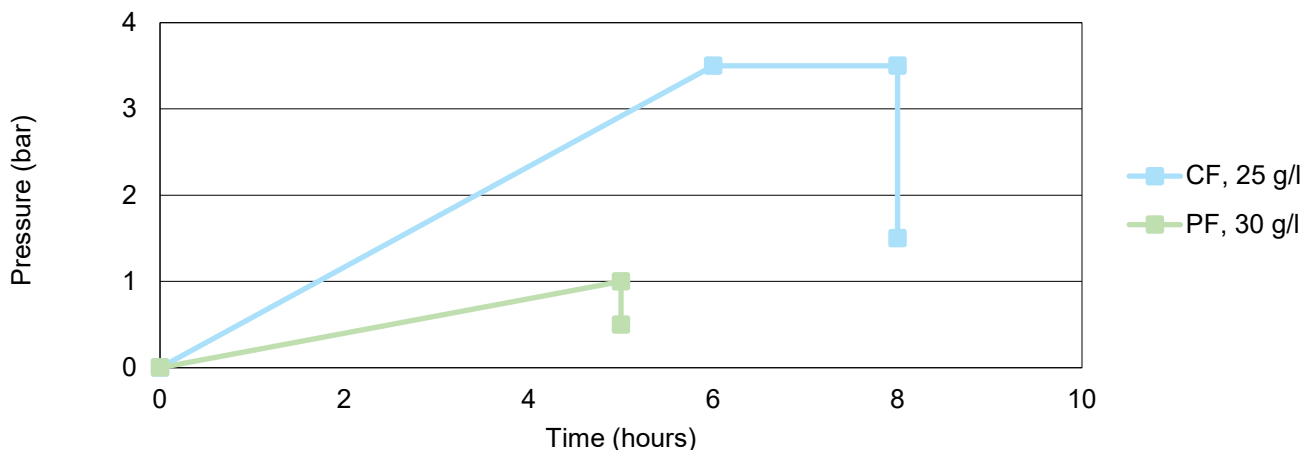
\* Shrinkage, surface aspect and cycle time are influenced by process parameters, tool and equipment layout, and part geometry.

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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.

### 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 2 hours at 3.5 bar, 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.



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 2.6%. 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.