

Product description

Colour	Weight (mg)	Size (mm)	Bulk density (g/l)	Packaging	Approved for direct food contact
Black	1.0	2.5 – 4.5	30.0 – 36.0	Bulk / Bag	No

Physical properties

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

30%**RECYCLED
PLASTIC**

Certified by RecyClass

ARPRO 5133 RE is made of 30% plastics originated from post-consumer origin. The carbon footprint of this grade is 1.99 kg CO₂ eq. / kg ARPRO which is a 19% reduction in CO₂ emissions compared to ARPRO made from virgin raw materials. The RecyClass certificates and the LCA are available to download from ARPRO.com:

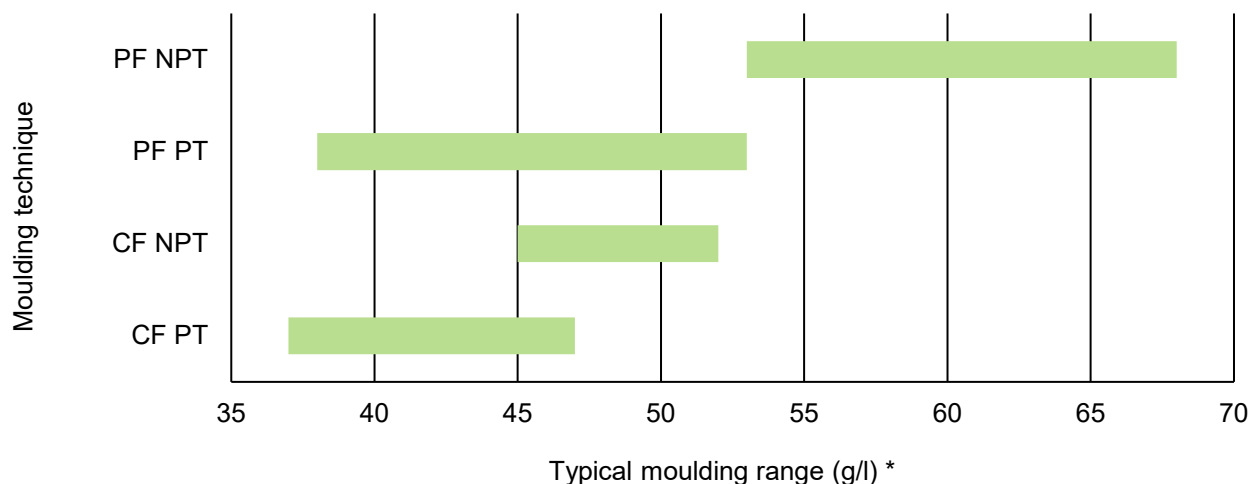
<https://www.arpro.com/product/technical-resources/environmental-health-data>

Moulding

ARPRO 5133 RE can be moulded using Crack Fill (CF) and Pressure Fill (PF):

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

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



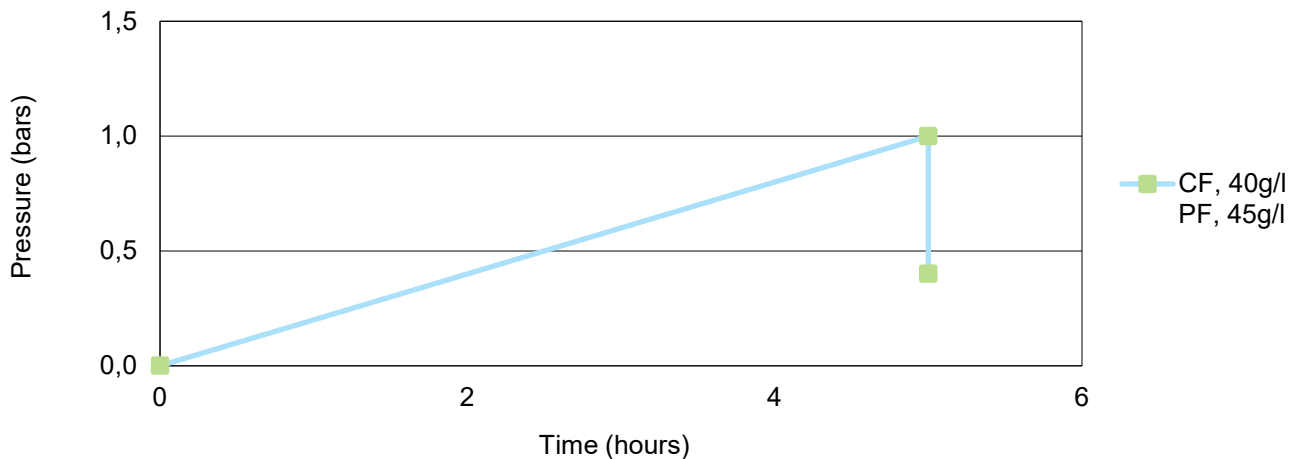
* Shrinkage, surface aspect and cycle time are influenced by process parameters, tool and equipment layout, and part geometry.

Version 06

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:
5 hours up to 1 bar, decrease and maintain at 0.4 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 1.8% to 2.2%. 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.