

CIRCULUM®

K-910w/R411

DESCRIPTION

K-910w/R411 is an expandable polystyrene grade containing pentane as a blowing agent. The products are delivered in the form of spherical beads with a bulk density of about 0.6 g/cm³. **K-910w/R411** is available in 1100 kg octabins.

APPLICATIONS

The properties of **K-910w/R411** make it suitable for the production of thick-walled shape-moulded products.

PROCESSING

The processing conditions of **K-910w/R411** depend on the combination of the product and processing equipment used. Optimal settings have to be adjusted for each combination. Some general processing conditions are given below:

Prefoaming The steam has to be saturated at a temperature of 100–110 °C. To reach higher densities (>30 kg/m³) it is recommended to mix the steam with air. Normal densities are from 20 to 40 kg/m³

Conditioning Depends on the density. The higher the density the longer the conditioning time. Generally 12–24 hours is recommended.

Moulding The machine should be fed with saturated steam with a maximum pressure of about 2 bar.

The steaming time depends on the equipment used as well as the size and required strength of the final product. Therefore, all machines have to be adjusted individually. Equipment using vacuum is recommended to reduce cycle times and to increase product strength.

Cutting Hot wire cutting (oscillating or stationary wires) is recommended. Temperature of the wires should be about 200–300 °C.

TECHNICAL INFORMATION

TYPICAL PHYSICAL PROPERTIES

Raw material	Value	Unit	Test method
Pentane content	> 6	%	Gas chromatography
Monomer level	< 0.1	%	Gas chromatography
Main bead size distribution	0.4-0.7	mm	Image analyser

FOOD CONTACT REGULATIONS

K-910w/R411 meets the food contact regulations in most countries. If required, contact your BEWI representative for a certificate.

STORAGE

K-910w/R411 should be stored at below 20 °C. Protect from direct sunlight and other weather conditions (rain, wind, frost etc.). Keep away from any source of ignition. The storage time should not exceed three months. After opening of the packaging, it should be used as soon as possible.

SAFETY

In transport **K-910w/R411** is classified according to European regulations for product transport: Substance number UN2211, Class 9.

In processing avoid generating dust. All equipment should be properly earthen. Releases pentane during processing which might form a flammable/explosive vapour-air mixture. Use proper ventilation and keep away from any source of ignition. A Safety Data Sheet is available on request.

RECYCLING

K-910w/R411 is suitable for recycling using modern methods of grinding, cleaning and regranulation. In-house production waste should be kept clean to facilitate direct recycling.

Please contact your BEWI representative for more details on various aspects of safety, recovery and disposal of the product.

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