

CIRCULUM® XK/RE

BEWI
RAW

EPS with recycled content (Etten-Leur, NL)

Version 1.0 (21/05/2026)

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General information

Circulum® XK is an innovative grade for expandable polystyrene (EPS), developed with sustainability in mind. Circulum® XK is produced using the extrusion process and offers the same mechanical properties as the standard grade Circulum® K. Pentane is used as a blowing agent. Due to the presence of recycled material, this product is not suitable for direct food contact applications.

Circulum® XK can contain up to 100% recycled polystyrene, sourced from mechanically post-consumer recycled EPS waste. This grade is REDcert²-certified, confirming its compliance with sustainability and traceability according to following standard:

- EN 15343, DIN CERTCO TÜV Rheinland, REDcert² -943-66600184

Technical information

Typical property	Unit	XK-710e	XK-510e
Beads size range (>95% between)	mm	1.0 (± 0.3)	1.2 (± 0.3)
Pentane content	%	4.5 – 5.5	
Residual styrene monomer	%	< 0.1	
Bulk density of raw material	kg/m ³	550 - 650	
Typical bulk density range (1 step pre-expansion)	kg/m ³	20 – 40	15 - 30

Typical applications

XK-710e	Shape moulding application. Due to its small bead size, it can be used for producing thin-walled products with a thickness < 10mm.
XK-510e	Shape and block moulding application. Suitable for non-FR application. It can be used for thick-walled, shape moulded products and insulating foam boards produced by block moulding.

Processing

Circulum® XK processing will depend on the grade type and the equipment used. Optimal settings exist for every combination. General guidelines are:

- **Pre-expansion:** Circulum® XK can be pre-expanded to the densities indicated above using standard continuous or batch pre-expanders. The minimum achievable density depends on the grade type, processing parameters, and pre-expansion equipment. Steam must be saturated and maintained at a temperature of 100–110 °C. Densities below the indicated range require a two-step pre-expansion process, either by using a continuous pre-expander or a batch pre-expander. For densities above the indicated range, it is recommended to mix the steam with air.
- **Silo storage (ageing):** Silo storage time will depend on the density of the pre-expanding beads and ambient conditions. The optimum time for ageing is mostly 10-48 hours for one-step pre-expanding and 2-4 hours between the first and second step in a two-step pre-expanding process.
- **Moulding:** Circulum® XK can be moulded with standard steam chest moulding machines. Steaming time and steam pressure will depend on the equipment used as well as on the size of the final product.

Packaging and storage

Circulum® XK is shipped in octabins on wooden pallets containing 1100 kg net of material. The octabins are not weather – or waterproof and need to be protected from direct sunlight and other weather conditions (rain, snow, frost, etc). It is not recommended to stack the octabins.

Circulum® XK should be stored at temperatures below 20°C, in a ventilated area and in the original and sealed packaging. Circulum® XK that is stored at these conditions should be processed within three months from the date of shipment. After opening or damaging the octabin the beads inside should be processed immediately.

Safety

Circulum® XK is classified as dangerous goods in transport according to the European regulations for product transport. UN-number: 2211, class 9, packing group: III ADR. During processing and handling, the release of pentane may lead to the formation of flammable atmospheres. Appropriate precautions must be taken to minimize ignition risks. The following actions are recommended:

- ensure adequate ventilation at all stages of processing;
- monitor pentane concentration (LEL) at critical locations (e.g. vessels and silo areas);
- avoid tilting or rotating octabins more than 145 ° during discharge;
- limit the number of octabins emptied simultaneously into one vessel;
- use appropriate anti-static clothing and footwear;
- ensure all equipment is properly grounded (earthed);
- apply additional precautions during low humidity conditions

Recycling

Circulum® XK is suitable for recycling using modern methods of grinding, cleaning and regranulation. In-house production should be kept clean to facilitate reuse of internal scrap. BEWI Circular can be contacted for further recycling options.

BEWI Circular

Website: <https://bewi.com/circular/>

Email address: circular@bewi.com