

CIRCULUM® KELP

BEW/
RAW

Extra low pentane EPS (Wismar, DE)

Version 1.0 (24/06/2026)

D.61.11.01-307

General information

Circulum® extra low pentane K is an expandable polystyrene (EPS) without any flame retardants that is suitable for packaging applications. Circulum® low pentane K is modified to achieve optimal cycle time.

Circulum® extra low pentane K is a white spherical bead made through suspension polymerisation and containing pentane as a blowing agent. The reduced pentane content makes this grade particularly suitable for high density applications.

Circulum® extra low pentane K complies with the compositional requirements of the major food contact regulatory in Europe. This ensures that the material is safe for food packaging and meets all necessary health and safety standards.

This grade is tested, confirming its compliance with EU food contact regulations/legislation proven by following statement:

- P60002-60124-01, Triskelion, Netherlands

Technical information

Typical property	Unit	K-740w	K-440w K-540w
Beads size range (>95% between)	mm	0.6 – 1.2	0.8 – 1.9
Pentane content	%	4.0 – 4.5	
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	25 - 40	

Typical applications

K-740w	Shape and block moulding application.
K-440w/ K-540w	Due to its small bead size, it can be used for producing thin-walled products with a thickness < 10 mm.

Processing

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

- **Pre-expansion:** Circulum® extra low pentane K 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® extra low pentane K 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® extra low pentane K 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® extra low pentane K should be stored at temperatures below 20°C, in a ventilated area and in the original and sealed packaging. Circulum® low pentane K 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® extra low pentane K 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® extra low pentane K 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

This information is not to be taken as a warranty or representation for which BEW RAW assumes legal responsibility nor as permission or recommendation to practice any patented invention without a license. It is offered solely for your consideration, investigation, verification and shall form no part of any contract with a customer.