



PLEXLINK CROSSLINKABLE HALOGEN FREE FLAME RETARDANT POLYOLEFIN COMPOUND

Grade	Plexlink 2135X			
Description	Crosslinkable, halogen free, low smoke flame retardant.			
Application	Insulation and sheathing compound for cables.			
Material Designation	BS 7655 : section 5.1			
Material Classification	EI5			
Properties	Test Method	Unit	Specification	Typical Value
Density	ASTM D 792	g/cm	1.43 +/- 0.05	1.43
Durometer Hardness	ASTM D 2240	Shore D	53 +/- 4	53
Tensile Strength (50 mm/min)	IEC 811-1-1	MPa	> 10	13.0
Elongation at Break (50 mm/min)	IEC 811-1-1	%	> 125	170
After 8 hrs steam cure	IEC 811-1-1			
Tensile Strength (50 mm/min)		MPa	> 10	13.5
Elongation at Break (50 mm/min)		%	> 125	160
After Ageing at 135°C, 168 hrs				
Tensile Strength (50 mm/min)	IEC 811-1-2	MPa	> 10	15.0
Max. Variation		%	+/- 30	+ 11.1
Elongation at Break (50 mm/min)	IEC 811-1-2	%	> 125	150
Max. variation		%	+/- 30	- 6.3
Hot Set Test (20 N/cm ² at 200°C)	IEC 811-2-1			
Permanent Elongation		%	< 25	≤ 15
Elongation under Load		%	< 100	35
Water Immersion Test, after 70°C, 168 hrs	BS 6469-99.1			
Max. variation of Tensile strength		%	+/- 30	-15.5
Max. variation of Elongation		%	+/- 30	-22.2
Pressure test at high temperature (100°C, 4 h)	IEC 811-3-1	%	< 50	23
Flame Retardant (Vertical Burning)	Test IEC 332-1			
Distance between:				
- Lower edge of top clamp & onset of charred portion		mm	> 50	200
- Lower edge of top clamp & downwards charred portion		mm	≤ 540	510
Oxygen Index	ASTM D 2863	%	> 30	32
Smoke Density	ASTM D2843	Dm	< 40	20
Acid Gas Emission	IEC 60754-2			
- pH		---	> 4.3	5.1
- conductivity		μS/mm	< 10	1.0

PLEXCHEM TECHNOLOGIES



RECOMMENDED PROCESSING CONDITION FOR PLEXLINK 2135X

TYPICAL TEMPERATURE SETTING, °C

Feed	Compression	Metering	Head	Die
105-115	110-120	120-130	155-175	170-180

- These conditions are indicative and may depend on the extruder and crosshead and tools design
- Maximum Melt Temperature is below 160 °C.
- Preferable low compression screw for extrusion.

CURING CONDITION

- Curing can be done by exposure to low pressure steam. In all cases, curing time depends on insulation thickness.
- In all cases, curing time depends on cable thickness; for ~ 2.0 mm wall thickness 8 hours steam cured are generally necessary.

MASTERBATCHES AND COLOURS

- Recommended masterbatches be thoroughly dried before use i.e. at 60 - 80 °C for 2-4 hours.

DELIVERY

Form : Granules
Package : 25 kg bags

MATERIALS HANDLING

The product should be stored under the following conditions:

- A clean, cool and dry storage area is recommended.
- Avoid direct exposure to sunlight and weathering.
- Closed and unbroken bags. Torn bags are to be sealed immediately.

NOTICE: The information and data contained herein serves only as a guide. No liability, warranty or guarantee of the product is created by this document. It is the user's responsibility to ascertain the appropriate operation conditions based on the user's own equipment and experiences.

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Do you have the safety data sheet for this product? Please contact you service representative for one or E-mail us at: plexchem@plexchem.com.sg

