AXELERON™ CX K-6923 NT A EXP1

High Density Polyethylene Cellular Insulation Compound

The Dow Chemical Company

Message:

Dow AXELERON™CX K-6923 NT A EXP1 is a high density polyethylene material used in physical foaming process, which requires a high foaming rate (60-80%). This material is used to provide excellent processing performance of high-speed production lines due to its low extrusion pressure, and smooth surface quality of insulating materials. In addition, because the material is a fully formulated premix material with all the necessary components, it can provide better dispersion of the nucleating agent, thereby achieving higher foaming rate and more stable processing performance (capacity and diameter). The product is stabilized to ensure its long-term performance and minimize the impact on signal attenuation.
processing suggestions:
DGDK-6923 NT A EXP1 can be processed by many commercial gas injection systems.
Under normal circumstances, the extrusion melting temperature is between 170-190°C. The typical barrel temperature depends on the extruder specification and material structure. a better starting point is:
feeding area: 140-150°C
transition area: 160-170°C
injection point: 180-190°C
metering area: 180-190°C
right angle head and die: 180-190°C
application field:
Typical applications include conventional 75 Ohm CATV cables and LAN cables.

General Information			
Uses	Coaxial Cable Insulation Wire and cable applications Insulating material Communication Equipment		
Forms	Particle		
Physical	**Nominal Value**	**Unit**	**Test Method**
Density [1]	0.948	g/cm³	ISO 1183
Melt Mass-Flow Rate (MFR) (140°C/5.0 kg)	5.6	g/10 min	ISO 1133
Hardness	**Nominal Value**	**Unit**	**Test Method**
Durometer Hardness [2] (Shore D)	64		ISO 868
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength [3]	20.0	MPa	IEC 60811-1-1
Tensile Elongation [4] (Break)	1100	%	IEC 60811-1-1
Thermal	**Nominal Value**	**Unit**	**Test Method**
Oxygen sensing time-Aluminum pan (200°C)	20	min	IEC 60811-4-2
Electrical	**Nominal Value**		**Test Method**
Dielectric Constant (2.47 GHz)	2.40		IEC 60250
Dissipation Factor (2.47 GHz)	1.2E-4		IEC 60250
Extrusion	**Nominal Value**	**Unit**	
Melt Temperature	170 - 190	°C	
Extrusion instructions			

DGDK-6923 NT A EXP1 can be processed using a range of commercial gas injection systems.It is normally extruded with a target melt temperature of 170 - 190 °C. Typical barrel temperatures required depend on extruder size and construction being made but a good starting point is:
Feed zone: 140 - 150 °C
Transition zone: 160 - 170 °C
Injection Point: 180 - 190 °C
Metering zone: 180 - 190 °C
Cross head and Die: 180 - 190 °C

NOTE	
1.	On unannealed material of the melt index extrudate
2.	Measured on compression moulded plaques
3.	Measured on extruded tape
4.	Measured on extruded tape

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