

TABOREX TA 1118 HD

High Density Polyethylene

SILON s.ro

Message:

A chemically-crosslinkable HDPE compound for the production of pipes for domestic hot and cold water, under floor heating and central heating application. It is specially designed to achieve an improved surface quality in co-extrusion or monolayer production processes.

TA 1118 HD is a crosslinkable compound made by Silane grafted ethylene polymer. This graft polymer constitutes together with a Masterbatch containing the crosslinking catalyst a "SIOPLAS-SYSTEM". Pipes produced with the SILON grade TA 1118 HD fulfil the requirements of ASTM F876-99a, ASTM F877-99a, CSA 137.5-99, DIN 16892 and all related standards.

This system allows the compound to be extruded as a normal thermoplastic polymer, which will attain a high level of crosslinking in the processed form. The final product has all the improved properties associated with crosslinked polyethylene.

General Information			
Features	Crosslinkable		
Uses	Piping system		
Forms	Sphere		
Processing Method	Co-extrusion molding		
	Extrusion		

Physical	Nominal Value	Unit	Test Method
Density	0.945	g/cm ³	DIN 53479, ASTM D1505
Apparent Density	0.56	g/cm ³	DIN 53466
Melt Mass-Flow Rate (MFR)			Internal method
190°C/2.16 kg	0.90	g/10 min	Internal method
190°C/5.0 kg	2.8	g/10 min	Internal method
Moisture Content		%	Internal method
Volatile Matter		%	Internal method
Gel Content ¹	69	%	

Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Break)	21.0	MPa	ISO 527-2
Tensile Strain (Break)	120	%	ISO 527-2

Extrusion	Nominal Value	Unit
Drying Temperature	80.0 - 90.0	°C
Drying Time	2.0	hr
Cylinder Zone 1 Temp.	160 - 170	°C
Cylinder Zone 2 Temp.	170 - 180	°C
Cylinder Zone 3 Temp.	170 - 190	°C
Cylinder Zone 4 Temp.	170 - 190	°C
Die Temperature	190 - 220	°C

Extrusion instructions
L/D: >25Compression ratio: 3:1 to 2.5 : 1Head: 200 to 210°CScrew: 70°C to 90 °C

NOTE

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Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

