

TABOREX TA 1135 HD

High Density Polyethylene

SILON s.ro

Message:

A chemically-crosslinkable HDPE compound for the production of multi-layer pipes for domestic hot and cold water, under floor heating and central heating application. It is designed to achieve best performance in single layer and co-extrusion products.

TA 1135 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 which are produced with the SILON grade TA 1135 HD fulfil the requirements of ASTM F876-04a, CSA 137.5-03, EN ISO 15875, BS 7291 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		
Agency Ratings	ASTM F 876		
	BS 7291		
	CSA 137.5-03		
	ISO 15875		
Forms	Sphere		
Processing Method	Extrusion		
Physical	Nominal Value	Unit	Test Method
Density	0.949	g/cm ³	DIN 53479, ASTM D1505
Apparent Density	0.56	g/cm ³	DIN 53466
Melt Mass-Flow Rate (MFR)			ASTM D1238, ISO 1133
190°C/2.16 kg	0.60	g/10 min	ASTM D1238, ISO 1133
190°C/5.0 kg	3.5	g/10 min	ASTM D1238, ISO 1133
Volatile Matter		%	Internal method
Gel Content	70	%	EN 579
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Break)	25.0	MPa	ISO 527-2
Tensile Strain (Break)	250	%	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: >25 Compression ratio: 3:1 to 2.5 : 1 Head: 200 to 210°C Screw: 70°C to 90 °C

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