

# PLEXLINKO 125-K

Crosslinked Polyethylene

Toler Chemical, Inc

## Message:

A chemically crosslinkable polyethylene compound curable by exposure to moisture, used in the manufacture of low voltage power cable insulation. This product has been specially designed for cables operating up to 6.6 KV, allowing extrudability at normal output rates. This product is less sensitive to precrosslinking or scorching. It is also designed to give low shrinkage properties even at high production speed. PLEXLINKÒ is manufactured using the Siloxan one-component system, a Silane crosslinking system developed by KABELMETAL ELECTRO GmbH. This process utilizes a special system that allows the additives and Silane to be homogeneously compounded with polyethylene pellets. The compound is a thermoplastic that can be made into the finished product which can then be cured in the presence of moisture.

General Information			
Features	Crosslinkable		
	Low shrinkage		
	Underwater curing		
Uses	Low voltage insulation		
Processing Method	Extrusion		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.920	g/cm <sup>3</sup>	ASTM D792
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	1.8	g/10 min	ASTM D1238
Molding Shrinkage - Flow	< 2.0	%	IEC 540
Moisture Content		ppm	Internal method
Thermoset <sup>1</sup>			IEC 540
Elongation : 200°C		%	IEC 540
Set : 200°C		%	IEC 540
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	> 15.0	MPa	IEC 540
Tensile Elongation (Break)	> 500	%	IEC 540
Aging	Nominal Value	Unit	Test Method
Change in Tensile Strength in Air (135°C, 168 hr)	8.0	%	IEC 540
Change in Ultimate Elongation in Air (135°C, 168 hr)	9.0	%	IEC 540
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity <sup>2</sup> (25°C)	> 1.0E+3	ohms·cm	ASTM D257
Dielectric Constant <sup>3</sup> (25°C)	2.31		ASTM D150
Thermoset	Nominal Value	Unit	
Shelf Life	52	wk	
Extrusion	Nominal Value	Unit	
Cylinder Zone 1 Temp.	160 - 180	°C	
Cylinder Zone 2 Temp.	170 - 190	°C	

Cylinder Zone 3 Temp.	180 - 200	°C
Cylinder Zone 4 Temp.	200 - 220	°C
Melt Temperature	180 - 200	°C
Die Temperature	220 - 240	°C

#### Extrusion instructions

L/D Ratio: 20:1 - 26:1Screw Compression Ratio: 3.0 - 3.5Die Head Design: Flat SurfaceDraw Down Ratio: 30°Ccure Time (Ambient - 80%RH 28°C): 15 daysCure Time (Steam - Low Pressure): 5 hoursCure Time (Hot Water - 60°C): 5 hours

#### NOTE

1.	20 N/cm <sup>2</sup>
2.	50% RH
3.	50% RH

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