

Borcell™ HE1346

High Density Polyethylene

Borealis AG

Message:

It is a fully formulated compound for chemical foamed telesingles. Borcell HE1346 is a high-density polyethylene compound containing chemical blowing agent.

Borcell HE1346 meets the applicable requirements as below when processed using sound extrusion practice and testing procedure:

BS 6234: Type H03

EN 50290-2-23

IEC 60708

NF C32-060

General Information			
Additive	Foaming agent		
Features	Lower die-out expansion		
	Foamable property		
	Workability, good		
	Good processing stability		
	Excellent appearance		
Uses	Cellular Insulation		
	Insulating material		
	Foam		
	Communication wire insulation material		
Agency Ratings	BS 6234 Type H03		
	EN 50290-2-23		
	IEC 60708		
	NF C 32-060		
Forms	Particles		
Processing Method	Extrusion		
Physical	Nominal Value	Unit	Test Method
Density			ISO 1183
-- ¹	0.945	g/cm ³	ISO 1183
-- ²	0.943	g/cm ³	ISO 1183
Apparent Density ³	0.50 - 0.60	g/cm ³	ISO 60
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress			
Yield	13.0	MPa	IEC 60811-1-1
Yield	23.0	MPa	ISO 527-2/50
Tensile Strain			

Fracture	500	%	IEC 60811-1-1
Fracture	600	%	ISO 527-2/50
Thermal	Nominal Value	Unit	Test Method
Oxidation Induction Time ⁴ (200°C)	50	min	IEC 60811-4-2/B
Resistance to Thermal Ageing ⁵ (105°C)	2.1	month	IEC 60811-4-2/A
Electrical	Nominal Value		Test Method
Dielectric Constant (1 MHz)	2.33		IEC 60250
Dissipation Factor (1 MHz)	4.0E-4		IEC 60250
Extrusion	Nominal Value	Unit	
Cylinder Zone 1 Temp.	155	°C	
Cylinder Zone 2 Temp.	170	°C	
Cylinder Zone 3 Temp.	185	°C	
Cylinder Zone 4 Temp.	195	°C	
Adapter Temperature	195	°C	
Die Temperature	195	°C	
Extrusion instructions			
Conductor preheating temperature: 110 to140 °CCooling water: 50 °C			
NOTE			
1.	Compound, ISO 1872-2, not expanded		
2.	Base resin, ISO 1872-2, not expanded		
3.	Range: 500 to 600 kg/m ³		
4.	expanded 35 % insulation		
5.	expanded 35 % insulation		

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