

# 4251Q

## QUICK EXTRUDING SILANE CROSS-LINKABLE PE COMPOUND

### FOR CABLE & WIRE WITH MONOSIL METHOD

#### Description

Grade 4251Q is silane XLPE compound with monosil method (one step) and is specially used for low voltage cable & wire. The product is composed by specific chosen LDPE material mixed with other additives. The product has outstanding performance and major characteristics are

- The product is suitable for the extrusion method of squeezing extrusion.
- Cables made from the product have excellent performance in smooth cable surface, high extrusion speed and production efficiency.
- Suitable for cable cross-sectional area less than 16mm<sup>2</sup>.

#### Standard

Performance test is in accordance with JB/T 10437-2004 standard. After crosslinked in the tepid water, the cable made from the product grade 4244Q can comply with the standard of IEC60502-2004, GB/T12706-2002.

#### Main Properties & Typical Values

Test items	Test method	Unit	Standard	Typical value
Tensile strength	GB/T1040.3	MPa	≥14.0	24.3
Elongation at break	GB/T1040.3	%	≥350	692
Heat ageing properties (Test temperature 135°C, 168hr)	GB/T8815			
Maximum tensile strength change		%	±20	13
Maximum elongation at break change		%	±20	7.4
Heat elongation (200±3)°C x 15min x 0.2MPa)	GB/T2951			
Maximum elongation change under load		%	≤100	80
Maximum permanent elongation change after cooled		%	≤5	-4
Dielectric strength	GB/T1408.1	MV/m	≥30	45*
Volume resistance (20°C)	GB/T1410	Ω.m	≥1.0×10 <sup>14</sup>	2.8×10 <sup>14</sup> *

Typical values were tested on the 1mm sample strip by squeezing film extrusion and be boiled in hot water at 90°C for four hours.

\*Especially, these typical values were tested by press moulding sample under the condition of 180±2 °C, 15min, and pressure over 15Mpa, then boiled in 90°C water for four hours.

## Recommended Processing Technique

### 1. Extrusion Equipment

Most extruders for PVC and PE suit for 4251Q

The recommended equipment and processing technique is as following.

Ratio of length and diameter	18—25:1
Diameter	45—120mm
Ratio of compressing	1.5—3.5
Ratio of elongation	1:1.0—1:1.5
Filtering mesh	40/60/40

### 2. Extruder processing temperature and other related settings

**Temperature Setting:** Specific processing temperature should be based on different equipment and pressing conditions, reference settings are as following:

Feeding Section (°C)	Compression Section (°C)	Measurement Section (°C)	Die head and Mould (°C)
150~160	160~180	180~200	200~210

**Die head setting:** Squeezing extrusion style is recommended

**Cooling water temperature:** Should not be less than 25°C, gradual cooling water tank is recommended.

### 3. Crosslink

After extrusion and cooling, the cable can be cross linked by immersed in hot water (90°C) or exposed in low pressure vapour. The time required for crosslink is based on the thickness of the insulation and the coil size, the thicker the insulation and the greater the coil size, the longer the crosslink time required. The crosslink time can be calculated according to the equation of 4hr/mm for 90°C.

Please contact our customer service for more technical service.