



Ddev Plastiks Industries Limited

An ISO 9001:2015 company

TECHNICAL DATA

Polyolefin Copolymer Halogen free Cable Compound:

KI-LSHF-3400 BD

DESCRIPTION :

KI-LSHF-3400 BD is a thermoplastic, halogen free, low smoke flame-retardant bedding compound for XLPE insulation and HFFR sheathing.

SPECIFICATION:

Cables manufactured with **KI-LSHF- 3400 BD** according to standard manufacturing practice meet the industrial cable specification as per BS 6724 for bedding materials.

TYPICAL PROPERTIES:

Property	Test Method	Unit	Typical Value
Density	ASTM-D-792	gm / cm ³	1.61
Hardness	ASTM-D-2240	Shore D	45
Tensile Strength at break	ASTM D-638	MPa	8
Elongation at break	ASTM D-638	%	150
Limiting Oxygen Index	ASTM-D-2863	%	>35
Smoke Density Rating	ASTM-D-2843	%	< 18
Halogen acid gas emission	IEC 60754-1	%	Nil

* Data is for information purpose only and should not be used for specification work.

PRE DRYING: Dehumidified hopper drying at 60-70°C for 2 – 3 hours prior to extrusion may be used to remove moisture.

RECOMMENDED PROCESSING CONDITIONS:

KI-LSHF-3400 BD can be processed using an 18-25 L/D extruder with proper control of the barrel temperature. A low compression screw (halogen free type) is recommended. PVC / PE screw are normally not suitable.

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Temperature Profile:

Name of the Zone	Zone 1	Zone 2	Zone 3	Zone 4	Zone 5	Zone 6	Zone 7
Temperature Range (°C)	130-140	140-145	140-145	140-145	145-150	150-160	160-165

These conditions are for guideline only and may vary depending on the extruder and crosshead type and size and tools design.

The use of breaker plate is advisable, in particular low compression screws.

A wide range of PE based colour master batches are applicable; it is suggested an addition of 1 -2 % (approx.) by weight.

STORAGE :

The compound must be stored in the following conditions.

- Closed and unopened bags.
- Ambient temperature generally not exceeding 30°C
- Avoid direct exposure to sunlight and weathering.

The compound can be negatively affected by long storage time. DPIL suggests its use within 12 months from the date of manufacturing.

PACKAGE :

30 kg packed in woven sack bags containing inner liner.

Customized packaging in Octabin box is also possible.

The information given in the document is believed to be reliable and is given in the good faith but without warranty. The user should test the product to ascertain the suitability for the intended use. Product specification or the whole document is subject to change without any prior notice.