



Ddev Plastiks Industries Limited

An ISO 9001:2015 company

TECHNICAL DATA

Polyolefin Copolymer Halogen free Cable Crack resistance Jacketing/Sheathing Compound:

KI-LSHF-3404

DESCRIPTION :

KI-LSHF-3404 is a Crack resistance halogen free, fire retardant, low smoke thermoplastic compound specially designed for jacketing/sheathing of armored and unarmored low and medium voltage power cables and control & signaling cables.

SPECIFICATION:

- VDE 0207 PART 24 HM 2 & VDE 0276 -604 : HM 4
- BS 7655 LTS 1 & LTS 4
- IEC 60092-359 SHF 1
- IEC 60332-1, IEC-332-2 & IEC 332-3
- IEC 60502-1 ST8

TYPICAL PROPERTIES :

Property	Test Method	Unit	Typical Value
Density	ASTM-D-792	gm / cm ³	1.49
Melt Flow Index, 150°C-21.6 kgs	ASTM D-1238	gm/ 10 min	6
Hardness	ASTM-D-2240	Shore D	53
Tensile Strength at break	ASTM D-638	MPa	12
Elongation at break	ASTM D-638	%	200
Variation in Tensile strength*	IEC 60811-401	%	±20
Variation in Elongation at break*	IEC 60811-401	%	±20
Limiting Oxygen Index	ASTM-D-2863	%	35
Temperature Index	ASTM-D-2863	°C	>275
Tear Strength @ 25°C	BS 6469-98.1	N/mm	8.5
Tear Strength @ 65°C	BS 6469-98.1	N/mm	5
Thermal Stress crack resistance @ 80°C	KIIL Internal	-	Pass
Smoke Density Rating	ASTM-D-2843	%	8
Halogen acid gas emission	IEC 60754-1	%	Nil
Corrosivity of gases	IEC 60754-2		
PH		-	6
Conductivity		µS/mm	1.6
Toxicity Index	NES 713	-	2.5
Pressure test at 90°C,4hrs	IEC 60811-3-1	%	24

* After Heat ageing at 100°C for 168 hours.

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

MKT: TDS – LSHF/3404 – 01/2024

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-3404 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.

Name of the Zone	Zone 1	Zone 2	Zone 3	Zone 4	Head	Die
Temperature Range (°C)	125-130	130-135	135-140	140-150	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 suggest its use within 12 months from the date of manufacturing.

PACKAGE :

25 kg packed in woven sack bags containing inner liner.

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.