

Horda E8413

Polyethylene
Horda Cable Compounds

Message:

Easy Strippable Semiconductive Shielding
E8413 is a crosslinkable easy-strippable semiconductive compound, designed for both XLPE and EPDM rubber insulated cables and use in both dry and steam curing processes.
Specifications:
E8413 meets the requirements as below, when optimal processing extrusion and end testing procedure are used:
AEIC-CS 5/94
BS 6622
HN 33-S-23 (EDF)
IEC 502
IEC 840
NF CS 32-223
SS 424 14 16, SS424 14 17 (HD 620 S1:1996)
VDE 0273 / 12.87

General Information			
Features	Semi Conductive		
	Strippable		
	Vapor Phase Curable		
Uses	Cable Jacketing		
	Insulation Shield		
Agency Ratings	AEIC CS5-94		
	BS 6622		
	EDF HN 33-S-23		
	HD 620 S1		
	IEC 60502		
	IEC 60840		
	NF C 33-223		
	SS 424, 14, 16		
	SS 424, 14, 17		
	VDE 0273/12.87		
Forms	Pellets		
Processing Method	Extrusion		
Physical	Nominal Value	Unit	Test Method
Density	1.25	g/cm ³	ASTM D1928
Mooney Viscosity (ML 1+4, 121°C)	21	MU	ISO 289
Moisture Content ¹	< 800	ppm	Internal Method
Hot Set (200°C) ²	65/10	%	IEC 60540

Stripping Angle	180	°	
Stripping Force ³			
EPR : 23°C	1.5 to 2.0	kN/m	
XLPE : 23°C	1.0 to 1.5	kN/m	
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore A)	85 to 90		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	11.0	MPa	ASTM D638
Tensile Elongation (Break)	260	%	ASTM D638
Aging	Nominal Value	Unit	Test Method
Change in Tensile Strength (135°C, 168 hr)	-5.0	%	ASTM D471
Change in Ultimate Elongation (135°C, 168 hr)	-50	%	ASTM D471
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity			ASTM D257
23°C	< 5.0E+2	ohms·cm	
90°C	< 1.0E+3	ohms·cm	
120°C	< 1.0E+3	ohms·cm	
Extrusion	Nominal Value	Unit	
Drying Temperature	< 40.0	°C	
Hopper Temperature	23.0	°C	
Cylinder Zone 1 Temp.	60.0 to 110	°C	
Cylinder Zone 2 Temp.	60.0 to 110	°C	
Cylinder Zone 3 Temp.	60.0 to 110	°C	
Cylinder Zone 4 Temp.	60.0 to 110	°C	
Cylinder Zone 5 Temp.	60.0 to 110	°C	
Adapter Temperature	100 to 130	°C	
Die Temperature	100 to 130	°C	
NOTE			
1.	QAHC-10420 (Karl Fischer method)		
2.	20 N/cm ²		
3.	50 mm/min		

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Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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