

Mecoline I RDX 1229 F

Thermoplastic
Melos GmbH

Message:
An e-beam radiation cross-linkable, halogen-free low smoke compound, offering good mechanical and electrical properties.

General Information			
Additive	Flame Retardant		
Features	Flame Retardant		
	Good Abrasion Resistance		
	Good Electrical Properties		
	Good Flexibility		
	Halogen Free		
	High Heat Resistance		
	Irradiation Crosslinkable		
	Low Smoke Emission		
	Low Temperature Flexibility		
	Oil Resistant		
Uses	Insulation		
	Wire & Cable Applications		
RoHS Compliance	RoHS Compliant		
Forms	Pellets		
Processing Method	Extrusion		
Physical	Nominal Value	Unit	Test Method
Density	1.37	g/cm ³	ISO 1183/A
Melt Mass-Flow Rate (MFR) (150°C/10.0 kg)	3.0	g/10 min	ISO 1133
pH	> 4.7		IEC 60754-2
Hot Set ¹			IEC 540
Elongation under load	20	%	
Residual elongation	10	%	
Conductivity	< 2.00	µS/mm	
Flame Test	< 15.0	sec	Internal Method
Halogen Content	0	%	IEC 754-1
Toxicity	< 3.00		NES 713
Thermal Shrinkage - 1hr @ 100°C	< 0.50	%	Internal Method
Head Temperature	170 to 180	°C	
Extruder Screw L/D Ratio	24.0:1.0 to 26.0:1.0		

Extruder Screw Compression Ratio	2.0:1.0 to 3.0:1.0		
Hardness	Nominal Value	Unit	Test Method
Shore Hardness (Shore D)	52		ISO 7619
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress			IEC 811-1-1
-- ²	15.0	MPa	
-- ³	> 10.0	MPa	
Tensile Strain			IEC 811-1-1
Break ⁴	200	%	
Break ⁵	> 230	%	
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity ⁶	1.0E+12	ohms·cm	Internal Method
Flammability	Nominal Value	Unit	Test Method
Oxygen Index	27	%	ASTM D2863
Extrusion	Nominal Value	Unit	
Cylinder Zone 1 Temp.	120 to 130	°C	
Cylinder Zone 2 Temp.	130 to 140	°C	
Cylinder Zone 3 Temp.	130 to 140	°C	
Cylinder Zone 4 Temp.	140 to 150	°C	
Cylinder Zone 5 Temp.	150 to 160	°C	
Adapter Temperature	150 to 160	°C	
Die Temperature	170 to 180	°C	
NOTE			
1.	at 200°C/15min/0.2 MPa		
2.	After crosslinking		
3.	Before crosslinking		
4.	After crosslinking		
5.	Before crosslinking		
6.	1h at 70°C		

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