

TABOREX TA 1135 HD

A chemically-crosslinkable HDPE compound for the production of multi-layer pipes for domestic hot and cold water, under floor heating and central heating application. It is designed to achieve best performance in single layer and co-extrusion products.

Description

TABOREX TA 1135 HD is a crosslinkable compound made by Silane grafted ethylene polymer. This graft polymer constitutes together with a Masterbatch containing the crosslinking catalyst a "SIOPLAS-SYSTEM". Pipes which are produced with the SILON grade TABOREX TA 1135 HD fulfil the requirements of ASTM F876-04a, CSA 137.5-03, EN ISO 15875, BS 7291 and all related standards.

This system allows the compound to be extruded as a normal thermoplastic polymer, which will attain a high level of crosslinking in the processed form. The final product provides all the superior properties associated with crosslinked polyethylene.

Physical Properties:

Properties	Test method	Units	Typical Value
Density	DIN 53479/ ASTM D 1505	g/cm ³	0.949
Bulk Density	DIN 53466	g/cm ³	0.56
Melt Flow Index	ISO 1133/ ASTM D 1238	g/10 min	0.60
Melt Flow Index	ISO 1133/ ASTM D 1238 (190/2)	g/10 min	3.50
Volatile total	ITN-ZP 300CH 3-5-5/d (190/5)	%	< 0.1
Tensile strength at break	ISO R 527	MPa	25
Elongation at break	ISO R 527	%	250
Gel Content	EN 579	%	70

Processing of TABOREX TA 1135 HD:

Extruder:

TABOREX TA 1135 HD can be processed on most modern thermoplastic extruders without problems. Particularly if the available screw is designed for Polyethylene excellent products can be expected.

Screw Parameters:

L/D: >25
Compression ratio: 3 - 2,5 : 1

Temperature Profile:

Zone 1	160°C - 170°C
Zone 2	170°C - 180°C
Zone 3	170°C - 190°C
Zone 4	170°C - 190°C
Head	200°C - 210°C
Die	190°C - 220°C
Screw*	70°C - 90 °C

* The thermostatic control of the screw improves processing results.

Recommendations for optimal extrusion conditions:

- Pre-drying of Catalyst Masterbatch and Colour Masterbatch about 2 hours at 80°C - 90°C, preferably with dried air.
- Material preconditioning to ambient temperature before the package opening is necessary, to avoid moisture condensation on the pellet surface.
- Use screw suitable for PE-HD (3-zone or barrier screw).
- Head and tools should be designated allowing streamlined flow avoiding stagnation of the material.
- In case of line stop longer than 10 - 15 minutes: Before restarting purge with standard HDPE (MFI: 0.3g/10 min.)

Crosslinking Cure:

The following methods are recommended:

- By immersion in hot water at 80°C - 95°C
- Exposure to low pressure steam

The period required to obtain the final gel content depends on the wall thickness and the temperature. The exposure times are in the range of 4 - 8 hours.

Storage:

TABOREX TA 1135 HD has a shelf life of nine months from the production date printed on the packaging. The packages should be opened only before processing; exposure to direct sun radiation must be avoided. After opening the bags the product must be used within 3 - 4 hours.

Packaging:

Graft Polymer:

- moisture resistant multilayer bags containing 25 kg
- boxes of 500 kg containing a moisture resistant multilayer lining sealed under vacuum

Catalyst Masterbatches:

- PE bags containing 25 kg