



PEXIDAN® X/T

Low density moisture curable polyethylene compound for low voltage building wire applications
(UL styles XHHW-2, RHW-2, RHH, SIS, USE-2).¹

DESCRIPTION

PEXIDAN® X/T is a low density flame-retardant XLPE system curable by moisture and consists of a silane pre-grafted base compound A-3001 and a flame retardant catalyst masterbatch CAT-005FR. Mixed and extruded in the proper proportions (80:20), the two components result in a material that is curable by exposure to 70-95°C hot water or even ambient moisture. In order to prevent pre-scorching the grafted compound and the catalyst masterbatch must be stored separately and mixed only when used. PEXIDAN® X/T is halogenated but is RoHS compliant.

¹ Also CSA listed for styles RW-90 and RWU-90 (-40°C rated)

Physical and Mechanical Properties	Typical Value	Unit	Test Method
- Specific gravity at 23°C	1.01		ASTM D792
- MFR, 190°C/2.16 kg	0.8	g/10 min	ASTM D1238
- Mechanical properties: Tensile strength at break Tensile strength at yield Elongation at break	2000 1800 375	psi psi %	UL 1581 / UL 2556
- Mechanical Properties: after thermal ageing (7d @121°C): Tensile strength at break Elongation at break After 60 day oil @75°C Tensile strength at break Elongation at break After 30 day gasoline @23°C Tensile strength at break Elongation at break	1950 350 1850 330 1825 350	psi % psi % psi %	UL 1581 / UL 2556
- Weather-o-meter testing (300hr. exposure) Original tensile strength After exposure Original elongation After exposure	2650 2870 440 430	psi psi % %	UL 1581 / UL 2556
- Deformation	1	%	UL 1581 / UL 2556
- Hot set test, 15 minutes @ 150°C, 0.2 N/mm ² load: Elongation under load	40	%	SACO AEI DWI-QA-4007 based on ICEA T-28-562
- Crushing Test	1400	lb	UL 1581 / UL 2556
- Relative Permittivity (SIC) @ 90°C, 60 Hz	2.5		UL 1581 / UL 2556
- Dielectric Constant , 1 MHz – 100 MHz range	2.34		
- Dissipation Factor @ 1 MHz @ 100 MHz	0.0012 0.0008		ASTM D150
- Dielectric Breakdown After glancing impact	35 33	kV	UL 1581 / UL 2556
- Insulation Resistance @ 23°C Initial @ 90°C After 12 weeks @ 90°C	560,000 21,000 50,000	MΩ-1000 ft.	UL 1581 / UL 2556
- Degree of Crosslinking	67	%	ASTM D2765
- Low Temperature Brittleness Point (LTBP)	Below -75	°C	ASTM D746
- Acid Gas Emission	3.68	% HBr	CSA C22.2 No. 0.3 Method 2
- Oxygen Index (LOI)	23.5	% Oxygen	ASTM D2863

Typical values reported above (except MFR) are obtained from a 14 AWG wire with 30-mil wall thickness, cured in hot water (6 hours @ 95°C). Weather-o-meter testing was performed on 6 AWG sample. Oxygen Index was performed on a 4mm thick compression-molded sample.

PROCESSING

The pre-grafted base PEXIDAN® A-3001 must be added with type CAT-005FR flame retardant catalyst masterbatch in the proportion 80:20 by weight. We strongly suggest dosing the two components directly in the throat of the extruder using a gravimetric or loss-in-weight feeder. In order to prevent scorching the grafted compound and the catalyst masterbatch must be stored separately and mixed just prior to consumption.

PEXIDAN® X/T can be processed with PE single screw extruders having proper temperature control and a good mixing screw (2.5:1 ratio at least).

The following temperature profile is suggested:

barrel zones:	from 310 to 340 °F
head:	365 °F
die:	365 °F
screw:	neutral

These conditions may depend on the equipment being used. It is recommended using conveyors and tools shaped in order to prevent stagnation in the head. In case of prolonged shutdown, purge the extruder with LDPE.

Curing can be done in the following ways:

- by immersion in hot water at 70-95 °C
- by exposure to low pressure steam
- ambient atmospheric moisture

In all cases curing time depends on wall thickness, temperature, relative humidity and quantity of wire on the reel.

A wide range of commonly used color masterbatches based on LDPE are available. A use level of 1.5% by weight should give an acceptable color but this will be dependent upon the concentrate itself. Levels of concentrates should be kept to a minimum because they can detract from performance. It is recommended that the catalyst and color masterbatches be dried prior to usage 4-6 hours at 60 °C (150 °F) using a desiccant dryer.

STORAGE

Due to the moisture sensitivity of PEXIDAN®, SACO AEI Polymers suggests that the following points should be considered when storing the materials:

- Ambient temperature generally not exceeding 30 °C
- Avoid direct exposure to sunlight and weathering
- Once the package has been opened it is suggested that the entire contents be used.

PACKAGING

The physical form of both PEXIDAN® A-3001 and CAT-005FR is free-flowing pellets, and are available in 1500-lb (680-kg) and 2000-lb (907-kg) gaylords respectively, or in 300-lb (136-kg) fibre drums.

Our technical team is at your disposal for further information and assistance.

The technical information contained herein is, to the best of our knowledge, believed to be accurate. However, SACO AEI Polymers makes no guarantee or warranty, and does not assume any liability, with respect to the accuracy or completeness of such information. Suitability of material for a specific final end use is the sole responsibility of the user. The data contained herein are typical properties only and are not to be used as specifications.

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