

XL07420B

Copolymer Compound
Wire and Cable Grade
Density 1.40

Applications

Petrothene XL07420B is especially formulated for use in flame retardant primary insulation for low voltage automotive thin wall wire and cable applications (ISO6722). XL07420B is a non-halogenated, flame retardant chemically crosslinkable compound.

Processing Techniques

XL07420B, like other crosslinkable polyolefin compounds, can be extruded as wire and cable insulation by means of a conventional extruder with a continuous vulcanization tube. Below are suggested extrusion and curing conditions for XL07420B. These conditions are intended as general guidelines only and not optimum values, since manufacturing variables such as extruder type and size, continuous vulcanization tube design and cable construction all have an effect on processing crosslinkable compounds. Contact your Equistar sales or technical service representative for more information.

Suggested General Extrusion Conditions

Extruder Zone	Temperature Range
Feed	225° - 235°F (107°-113°C)
Zone 2	225° - 235°F (107°-113°C)
Zone 3-X	225° - 235°F (107°-113°C)
Adapter	235° - 245°F / 113° - 118°C
Head	235° - 245°F / 113° - 118°C
Melt Temperature	240° - 260°F (116°-127°C)
Screw Cooling	180°F (82°C), if needed to control melt temperature
Die Cooling	90° - 120°F (32° - 49°C) to control die drool

Additional Suggestions

- Maximum screen pack of 40 mesh.
- Little or no die land.
- No pre-drying normally required.
- Compression ratio of 2:1 or 3:1.
- "Mixing" screws can be used if properly designed to prevent excessive heat build-up. Mixing screws are more useful on short (15/1) extruders than on longer (>20/1) extruders.
- Dies should be cleaned frequently to reduce compound build-up.
- On-size dies are recommended.
- Curing line steam temperature should be at least 400°F (204°C).

See Page 2 for Physical and Electrical Properties

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Physical and Electrical Properties

XL07420B is supplied as a natural compound. For information on other resins and compounds for Wire and Cable contact your Equistar sales or technical service representative.

Property*	Nominal Value	Units	Test Method
Density	1.40	g/cc	D 1505
Oxygen Index	27.5		D 2863
Hardness, Shore D	56		D 2240
Tensile Strength, Original	2,337 (16.1)	psi (MPa)	D 412
Aged 7 days @ 165°C	123	% retention	
Elongation, Original	215	%	D 412
Aged 7 days @ 165°C	90	% retention	

* All properties determined from compression-molded, press-cured plaques.

The values listed for physical and electrical properties are nominal values only and are subject to normal variations consistent with the test methods and/or variations found acceptable to the industry.

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Equistar Chemicals, LP
1221 McKinney, Suite 700
P. O. Box 2583
Houston, Texas 77252-2583
(800) 615-8999
www.lyondellbasell.com

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