



TABOREX TA 7400 LD

TABOREX TA 7400 LD is a crosslinkable LDPE compound for the production of tubes, bands and films providing good environmental stress crack resistance.

Description

TABOREX TA 7400 LD is a crosslinkable compound made by Silane grafted ethylene polymer. This graft polymer constitutes together with a TABOREX Masterbatch containing the crosslinking catalyst a „SIOPLAS SYSTEM“. This system allows the compound to be extruded as a normal thermoplastic polymer and will attain a high level of crosslinking in the processed form. The final product provides all the superior properties associated with crosslinked polyethylene.



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Properties

	Properties	Test method	Unit	Typical value
Physical	Density	ISO 1183-1	g/cm ³	0,925
	Melt Flow Index (190 °C/5 kg)	ISO 1133	g/10 min	9,0
	Bulk density	ISO 60	g/cm ³	0,5
	Moisture (water)	ISO 15512	%	< 0,25

Note: the above values are typical for this material, not standardized.



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Processing Guidelines

Extruder:

TABOREX TA 7400 LD can be processed on standard 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: 2,5–3 : 1

Temperature profile:

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

*The thermostatic control of the screw improves processing results

Recommendation for optimal extrusion conditions:

- Pre-drying of foreign masterbatches e.g. colour, PPA and others. Drying has to be done preferably with dried air. Residual moisture of the added masterbatches must not exceed 0,02 %.
- 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 designed 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: 0,3 g/10 min.)



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Crosslinking Cure

The following methods are recommended:

- Autoclave using saturated steam at 90–100 °C (optimal method)
- By immersion in hot water at 80–95 °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 2–4 hours.

Storage and handling

TABOREX TA 7400 LD has a shelf life of nine months from the production date printed on the packaging. The packages should be stored in dry conditions at ambient temperature below 30 °C and protected from UV light. The packages should be opened only before processing and after opening of the inliner the product must be used within 3–4 hours.

Packaging

- Boxes of 600 kg containing a moisture resistant multilayer lining.
- Moisture resistant multilayer bags containing 20 kg.



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