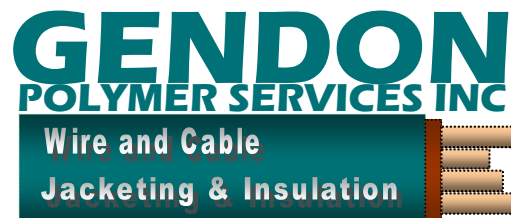


| | |
|---------------------------|-------------------------------------|
| Product | Genflam XL-R CPE General Purpose |
| Gendon Code | 2612 (Black) |
| | |
| Specification Date | 21 February, 2014 |



Key Features:

- Ease of Processing
- Excellent Flame Performance
- Oil Resistant
- Lead Free

| <u>Physical Properties:</u> | <u>Typical Value:</u> | <u>Test Method</u> |
|------------------------------------|------------------------------|---------------------------|
| Tensile at Break | 2300 psi | ASTM D412 |
| Elongation at Break | 330 % | ASTM D412 |
| Specific Gravity | 1.34 g/cc | ASTM D792 |
| Low Temperature Brittle Point | -35 C | ASTM D2137 |

(1) Samples extruded into tape with nominal thickness of 0.070 inches, then exposed to 12 MRad beam for crosslinkin

| <u>Combustion Properties:</u> | <u>Typical Value:</u> | <u>Test Method</u> |
|--------------------------------------|------------------------------|---------------------------|
| Limiting Oxygen Index | 32 | ASTM D2863 |

| <u>Accelerated Age Testing:</u> | <u>Typical Values:</u> | | <u>Test Method</u> |
|---|--------------------------------|-----------------------------------|---------------------------|
| | <u>Tensile Retained</u> | <u>Elongation Retained</u> | |
| Air Oven Age | | | |
| <ul style="list-style-type: none"> • 168 hrs at 100 °C • 168 hrs at 121 C | 106% 101% | 98% 98% | ASTM D573 |
| UV Resistance, 720 hour Exposure | NA | | |
| Fluid Immersion | | | |
| <ul style="list-style-type: none"> • IRM 902 Oil, 96 hrs at 100 °C | 52% | 67% | ASTM D471 |

Gendon Polymer Services, Inc. 5 Marconi Court Bolton, Ontario Canada L7E 1H3

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Suggested Running Conditions:

| | | |
|----------------------------|--|------------------|
| Extruder Length/Diameter | 20:1 to 24:1 | |
| Screw Type | Single flight metering, without mixing section | |
| Screw Compression Ratio | 1.25:1 preferred | |
| Extruder Zone Temperatures | | |
| • Feed | 200 °F | 95 °C |
| • Melt | 225 °F to 240 °F | 110 °C to 115 °C |
| • Metering | 250 °F | 121 °C |
| • Screw Cooling | 165 °F | 75 °C |
| Die Cooling | Not Recommended | |
| Gradient Cooling | Recommended | |
| Color Concentrate | Not Applicable | |

Processing Notes:

The Genflam XL-R CPE General Purpose Sheath compound has been designed to process easily on standard extruders used in the production of wire and cable products. These materials are designed to process similar to elastomeric compounds, attaining maximum output levels at relatively low shear rates. Care should be taken to ensure that screw compression ratio levels are below 1.5:1, and flow restrictions in the crosshead are kept to a minimum. Melt temperature values above 300 °F (150 °C) should be avoided.

The material can be extruded using either pressure or sleeving techniques. For generation of optimum physical properties, a draw down ratio of 1.25:1 is recommended. Gradient cooling is also recommended for maximization of physical properties.

The Genflam XL-R CPE General Purpose Sheath is supplied as a free flowing pellet, packaged in sealed foil lined boxes and does not need to be dried prior to use. It is recommended that the foil liners be resealed after use to prevent outside contamination or water absorption during storage. If the material has been exposed to a high humidity environment, or the foil liner has not been sealed, it is recommended the material be dried for a minimum of 4 hours at 140 °F (60 °C) in a standard desiccant style dryer prior to use.

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