HFFR CROSSLINKABLE
FOR CABLES
**Notes**

This is a range of polyolefin based HFFR compounds, crosslinkable by heat and moisture and by addition of a suitable catalyst before extrusion (SIOPLAS method). This solution is suitable for the production of crosslinked insulation or sheathing without the use of specific curing equipment (without a CCV line).

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**Processing**

The compound must be blended before extrusion with an exact amount of catalyst. Processing of silane grafted compounds with the catalyst is a reactive extrusion; the faster the material is extruded the better the results will be. Time at high temperature should be kept to a minimum to avoid processing issues such as pre-scorch. Processing is made within a range of 120°C-200°C. The extrudate must be cooled down into a water bath, which provides the moisture necessary for crosslinking. The reaction is fast but diffusion of moisture in the material is a limiting factor. For this reason a hot water bath or a low pressure sauna can be used to speed up crosslinking process after extrusion. Generally speaking curing time depends from wall thickness; for example 1 mm wall thickness may crosslink in 4-6 hours in extreme moisture conditions. In case of self curing, time depends on the specific ambient temperature and humidity in which the cable is stored after extrusion.

**Packaging**

All compounds are available in 25Kg. Bags, big bags or Oktabins on wooden pallet.

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**Storage**

All compounds must be stored at ambient temperature (not exceeding 30°C) in closed and unbroken moisture resistant bags, in order to avoid exposure to sunlight and water absorption. Long stocking time may negatively affect the quality of the material. Therefore they shall be used within 6 months from the compounding date and within a few hours if the bags are opened.

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**Catalysts**

- **CAT 115/1** High reactive catalyst 2-3%
- **CAT119LS** Low reactive catalyst 4-5%
- **CAT121LS** Med. reactivity catalyst 4-5%
- **CAT 113/UV** Catalyst for extreme ageing tests 6-7% (solar application)

Notes: All catalysts can be additivated with UV stabilizers for outdoor applications.

**** These properties are measured on crosslinked specimens.