



TP519C

Thermoplastic, low-smoke, halogen-free flame retardant compound for data and communication cable

This is a flame-retardant low-smoke thermoplastic compound, which has been specially developed to meet the requirements of limited toxic and corrosive fume emission. TP519C has been developed to offer good processability at high extrusion speeds and has very little die drool.

Test	Test method	Unit	Typical value	
Physical properties and mechanical properties				
Density	BS 2782 Pt. 6 Mtd 620A-D	g/cm ³	1.51	
Melt flow rate (21.16kgs at 150°C)	AEI Method	g/10min	12	
Tensile strength	IEC 60811-1-1	N/mm ²	13	
Elongation at break	IEC 60811-1-1	%	140	
Tear Strength	BS 6469	N/mm	5	
Hardness (N)	Shore A	-	90	
Hardness (N)	Shore D	-	40	
Typical ageing behaviour after 7 days at 135°C				
Tensile strength	IEC 60811-1-2	%Variation	+12	
Elongation at break	IEC 60811-1-2	% Variation	-10	
Thermo mechanical properties				
Hot pressure deformation at 80°C	IEC 60811-3-1	%	15	
Cold bend test at -30°C	IEC 60811-1-4	-	pass	
Elongation at break at -30°C	IEC 60811-1-4	%	50 (pass)	
Cold impact at -30°C	IEC 60811-1-4	-	pass	
Fire & smoke properties				
Oxygen Index	BS ISO 4589-2	%	31	
Temperature Index	BS ISO 4589-3	°C	270	
Toxicity index	NES 713	-	1.3	
Halogen Acid Gas Evolution	IEC 60754-2	%	<0.5	
Smoke emission 3m cube test	BS EN 61034-2:2005	-	pass	
Electrical properties				
Insulation Constant Ki at 20°C	IEC 60502	MΩ.km	95	
Insulation Constant Ki at 90°C	IEC 60502	MΩ.km	0.065	
Volume Resistivity at 20°C	IEC 60502	Ohm.cm	1.96 x 10 ¹⁴	
Dielectric Strength at 20°C	IEC 80243	kV/mm	19.4	
Permittivity at 50Hz at 23°C	IEC 60250	-	4.65	
Fluid resistance				
	Time (hrs)	Temperature °C	% Variation in TS	% Variation in EB
ASTM No2	4	70	18	7
1M NaOH	336	50	45	20
1M HCl	336	50	17	14

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TP519C

Recommended processing and handling conditions

Extruder

An extruder with an L/D ratio (length/diameter) of 15-24 and an extruder screw with a compression ratio 1.2:1 to 2.5:1 are recommended.

Extruder temperature conditions

It is important that the melt temperature is not allowed to rise above 170°C.

As a guide the following temperature profile is recommended:-

Zone 1	Zone 2	Zone 3	Zone 4	Head	Die
115°C	125°C	135°C	145°C	155°C	160°C

This profile will vary slightly depending on extruder type, head design and output.

Screw water temperature Depends upon screw design, but should be 30-50°C

Recommended screen pack 50 (mesh apertures per linear inch) or 300 micron

Head and tool design

The head and tools should be so designed as to allow streamlined flow. To obtain the optimum in physical properties in the case of tubing tools, the smallest possible draw down ratio is recommended to avoid internal stress.

Catalyst and colour masterbatches

Addition of approved colour masterbatches, including black, up to a maximum of 1%, has no detrimental effect on the properties.

It is recommended that all masterbatches should be thoroughly dried at 60°C for 8 hours or at 80°C for 4 hours.

Storage and shelf life

TP519C has an unlimited shelf life. However, the following precautions should be observed:-

- Packaging should remain sealed
- Avoid temperature above 25°C.
- Avoid storage outside and in direct sunlight.

Form and packaging

Form – pellets

Packaging – the following possibilities are available:-

- Moisture resistant sacks containing 25kg.
- Boxes with a moisture resistant heat sealed liner containing approximately 125kg, 500kg or 1000kg.

Additional grade information

TP519C is available in the following versions:-

TP519C (natural colour)	TP519CU (with a non-staining UV stabiliser added)
TP519CB (coloured black)	TP519CBU (carbon black added to give UV stability)

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