

POLIDAN[®] S/I 20

POLIDAN[®] PEX System

Crosslinkable polyethylene compound for Injection moulding applications

Description

POLIDAN[®] S/I 20 is a silane crosslinkable PE compound which is used together with a catalyst masterbatch to accelerate the crosslinking reaction. It is used for injection moulding.

Applications

POLIDAN[®] S/I 20 is used for the production of fittings for domestic hot and cold water supply for both monolayer and all plastic multilayer pipe solutions.

PHYSICAL AND MECHANICAL PROPERTIES	Typical Value	Unit	Test Method
Density at 23°C	0.956	g/cm ³	ASTM D 792
MFI, 190°C/2.16 Kg	2.8	g/10'	ISO 1133
Shrinkage:: before crosslinking	≤ 3.0	%	DIMENSIONAL MEASUREMENT
after crosslinking	≤ 0.5	%	
Vicat softening temperature	126	°C	ASTM D 1525
Gel content	> 65	%	EN 579
Specific Heat at 23°C	1.90	J/(g °K)	ISO 11357-4
Coefficient of linear expansion at 20°C	1.5 x 10 ⁻⁴	1/°K	ASTM D 696
Thermal conductivity at 23°C	0.47 ± 0.01	W.m ⁻¹ .K ⁻¹	HOT DISK METHOD

Above values are typical averages obtained from 18 x 2 mm mono layer pipe specimens which are extruded with 95 parts of POLIDAN[®] S/I 20 and 5 parts of CATALYST LV/1. These pipe specimens are cured by immersion in 95°C hot water for 24 hours.

Processing Guidelines

The silane crosslinkable compound POLIDAN[®] S/I 20 shall be used together with a Solvay Padanaplast catalyst masterbatch in the ratio of 95 to 5 parts respectively. Mixing shall be done just before moulding or during the production process with the use of automatic feeders. POLIDAN[®] S/I 20 can be processed with modern PE single screw extruders.

We suggest the following processing conditions:

Screw Profile		Temperature Profile	
L/D:	25 - 30	Cylinder:	from 160 to 200°C
Compression Rate:	>2.5 : 1		

This data is only indicative. Exact temperature settings depend on the available equipment. In case of prolonged stop purge the extruder with a low MFI HDPE.

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Curing

The final pipe properties are curing dependent.

Curing can be done in the following ways:

- by immersion in hot water at 90-95°C
- by exposure to steam

In all cases curing time depends on the fitting wall thickness, fitting structure and applied curing temperature.

Colouring

POLIDAN[®] compounds and catalyst masterbatches can be used together with good quality PE based colour masterbatches. Solvay Padanaplast suggests pre-drying all colour masterbatches prior use.

Storage and Handling

In order to avoid pre-mature crosslinking, the silane crosslinkable compound and the catalyst masterbatch shall be stored separately and mixed only when used. The silane crosslinkable compound shall be used within 10-12 hours after bags are opened.

The product shall be stored under the following conditions:

- Closed and unbroken bags
- Ambient temperature not exceeding 40°C
- Indoor in order to avoid direct exposure from sunlight

The product could undergo alterations due to extended period of storage. Solvay Padanaplast suggests the product use within six months from the production date printed on the packaging. Solvay Padanaplast accepts no liability of any kind in case the above mentioned conditions are not fulfilled.

Packaging

POLIDAN[®] S/I 20 is supplied in 500 kg octabins which contain a single moisture resistant bag or in 25 kg moisture resistant bags placed on 1375 kg pallets.

Technical Service

POLIDAN[®] S/I 20 is part of the Solvay Padanaplast POLIDAN[®] PEX System product range. Solvay Padanaplast Technical Service is available to assist customers with further information and advice including the start-up and also for any eventual necessity during the use of the product.

Disclaimer

The data and numerical results contained in this document are provided for the sake of general information and are given in good faith. They reflect the state of our knowledge at the time of publication. Because the possibilities and application conditions of our product are many and varied, and lie beyond our control, we can in no event be held responsible if all the necessary information on planned applications have not been formally brought to our attention. The information presented here cannot be considered as a suggestion to use our products without taking into account existing patents, or legal provisions or regulations, whether national or local. The purchaser is obliged to verify whether the possession, use or marketing of our products is subject within his territory to particular rules, especially with respect to public health, hygiene and worker and/or consumer safety. The purchaser alone assumes the duties of information and advice for the ultimate user. Specifications reported on this datasheet can not be used as reference values in a technical or sales contract. Solvay Padanaplast can in no event be held responsible for a possible failure on the part of the purchaser to respect these regulations, provisions and duties.

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