



PEX compound for Pipe – PEX-B Silane crosslinkable

• Description

ZARLNK™ XL4001 is a cross linkable natural polyethylene compound based on Supercure technology and a one-part Silane cross linkable insulation system, specially designed for PEX Pipe applications.

Polyethylene is used to manufactured compounds using the SILOXAN one-component system, a Silane crosslinking system developed by KABELMETAL ELECTRO GmbH. This process utilizes a special system that allows the additives and Silane to be homogeneously compounded with polyethylene pellets. Curing of the finished product is done in the presence of moisture.

• Applications

ZARLNK™ XL4001 is intended for is used for the production of fittings for domestic hot and cold water supply for both monolayer and all plastic multilayer pipe solutions

• Physical Properties

Data should not be used for specification work

Property	Typical Value	Test Method
Density (Base Resin)	0.95 gr/cm3	ISO 1183
Melt Flow Rate (190°C , 2.16 kg)	2 ~ 3 gr/10 min	ISO 1133
Elongation at Break (250 mm/min)	>300 %	IEC 60811-401
Tensile Strength (250 mm/min)	14 N/mm2	IEC 60811-401
Hot set test (200°C , 20N/cm2) Elongation under load	60 %	IEC 60811-507
Gel content	Min 65 %	ASTM D2765
Water content	< 0.1 %	ISO 15512
Hardness , Shore D (1s)	50	ISO 868

• Crosslinking

- by immersion in hot water at 60-95°C
- by circulation in hot water inside the pipe at 60-95°C
- by exposure to steam
- by exposure in ambient, crosslinking time depends on ambient temperature and relative humidity
- in all cases curing time depends on the thickness; for pipes 18*2 mm 4-6 hours in immersed hot water at 95°C are generally necessary.





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* Processing conditions and precaution

(1) Extrusion Equipment

- (a) L/D ratio 20/1-26/1. PVC or PE extruders are suitable with 2 – 2.7 compression ratio.
- (b) For tube extrusion, the recommended Draw Down ratio is <1.5:1.
- (c) Screen mesh: at most 40/60; Stainless steel screen is recommended.
- (d) Cooling water temperature to be > 30°C.

2) Typical temperature Setting °C

Feed	Compression	Metering	Neck	Die Head	Die
150-160	160 – 170	170 – 190	200	210	220

DO NOT LEAVE THE MELT IN THE EXTRUDER FOR MORE THAT 20 MINS!

• Packaging

- Package: Aluminum bags (25 kg)
- Small Bins (550 kg)

• Storage

ZARLNK™ XL4001 has a shelf life of 12 months from delivery date if stored in unopened original packages, under dry and clean conditions at temperatures between 10 - 30 °C.

Before use, material shall be conditioned indoors (production room) to reach ambient temperature. It is also recommended to ensure proper stock rotation by First In – First Out principle.

Avoid direct exposure to sunlight and weathering

