

Petrothene

# XL07425

Non-Halogenated Flame Retardant Polyolefin Compound  
Wire and Cable Grade  
Density **1.40**



**Description** Petrothene XL07425 is a colorable, non-halogenated, flame retardant compound crosslinkable via continuous vulcanization (C.V.).

**Applications** Petrothene XL07425 is used in 125°C automotive wire & cable applications (SAE J1128) and UL 125°C appliance and SIS wire.

Property*	Nominal Value	Units	ASTM Method
Density	1.40	g/cc	D 1505
Tensile Strength, Original	2,810 (19.4)	psi (MPa)	D 412
Aged 7 days @ 165°C	106	% retention	
Elongation, Original	220	%	D 412
Aged 7 days @ 165°C	98	% retention	

\*Properties determined from compression-molded, press-cured plaques.  
The values listed for physical and electrical properties are nominal values only and subject to normal variations consistent with the test methods and/or variations found acceptable to the industry.

**Material Handling** Pre-drying is typically not required. For additional handling information see the MSDS.

**Processing Techniques** Petrothene XL07425, like other cross-linkable polyolefin compounds, can be extruded as wire and cable insulation by means of a conventional extruder with a continuous vulcanization tube. Below are suggested extrusion and curing conditions for XL07425. These conditions are intended as general guidelines only, and not optimum values, since manufacturing variables such as extruder type and size, continuous vulcanization tube design and cable construction all have an effect on processing cross-linkable compounds. Users should determine the conditions necessary to obtain optimum product properties and suitability of product for the intended application.

Extruder Zone	Temperature Range	Extruder Zone	Temperature Range
Feed	225° - 235°F (107°-113°C)	Adapter	235° - 245°F (113°-118°C)
Zone 2	225° - 235°F (107°-113°C)	Head	235° - 245°F (113°-118°C)
Zone 3-X	225° - 235°F (107°-113°C)	Melt	240° - 260°F (116°-127°C)

### Additional Suggestions

- Single angle nominal or slightly undersize die with little or no land.
- Die Cooling of 90° - 120°F (32° - 49°C) to control die drool
- Curing line steam temperature should be at least 400°F (204°C).