



IKEBANA
ENGINEERING LTD.
 Heat shrinkable cable accessories

Heat Shrinkable Conductive End Caps Specification Sheet

Sr. No.	Characteristics	Requirement	Frequency	Control Method
	Product Control			
1	Visual	Good and free from defects	100% - daily	Internal
2	Dimensions	As per Engineering Drawing	5 samples - daily	Internal
3	Tensile strength	min 12 MPa (N/mm ²)	5 samples - daily	ASTM D 638
4	Ultimate elongation	min 300%	5 samples - daily	ASTM D 638
5	Hardness	min 38 shore D	Daily	ASTM D 2240
6	Tensile strength after thermal ageing (120 ⁰ C, 168 hrs)	min 10 MPa (N/mm ²)	Qualification	ISO - 188
7	Ultimate elongation after thermal ageing (120 ⁰ C, 168 hrs)	min 250%	Qualification	ISO - 188
8	Water absorption	max 1%	Qualification	ISO - 62
9	Volume resistivity	2 * 10 ⁴ ohm.cm	Qualification	IEC - 93
	Raw Material Control			
10	Tensile strength	min 12 MPa (N/mm ²)	Compounding	ASTM D 638
11	Ultimate elongation	min 300%	Compounding	ASTM D 638
12	Hardness	min 38 shore D	Compounding	ASTM D 2240
		Frequency	Agency	
	Daily	- Routine test during production	In-house	
	Qualification	- Whichever is earlier of the following	External and In-house	
		a. At the time of introduction of new product		
		b. After a significant change in formulation		
		c. Every three years		
	Compounding	- For compounding of every batch of material.	In-house	