



**IKEBANA**  
**ENGINEERING LTD.**  
 Heat shrinkable cable accessories

## Heat Shrinkable LV Breakouts 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 10 MPa (N/mm <sup>2</sup> )	5 samples - daily	ASTM D 638
4	Ultimate elongation	min 300%	5 samples - daily	ASTM D 638
5	Hardness	min 35 shore D	Daily	ASTM D 2240
6	Tensile strength after thermal ageing (120°C, 168 hrs)	min 9 MPa (N/mm <sup>2</sup> )	Qualification	ISO - 188
7	Ultimate elongation after thermal ageing (120°C, 168 hrs)	min 250%	Qualification	ISO - 188
8	Water absorption	max 1%	Qualification	ISO - 62
9	Dielectric strength	min 12 kV/mm	Qualification	IEC - 243
10	Dielectric constant	5 max	Qualification	ASTM D 150
11	Volume resistivity	min 10 <sup>12</sup> ohm.cm	Qualification	IEC - 93
	<b>Raw Material Control</b>			
12	Carbon black content	min 2.5%	Compounding	BS 2782 Meth.-452 B : 1978
13	Tensile strength	min 10 MPa (N/mm <sup>2</sup> )	Compounding	ASTM D 638
14	Ultimate elongation	min 300%	Compounding	ASTM D 638
15	Hardness	min 40 shore D	Compounding	ASTM D 2240
		<b>Frequency</b>	<b>Agency</b>	
	<b>Daily</b>	- Routine test during production	In-house	
	<b>Qualification</b>	- 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		
	<b>Compounding</b>	- For compounding of every batch of material.	In-house	