IKEBANA ENGINEERING LTD.
Heat shrinkable cable accessories

Heat Shrinkable MV 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 7 MPa (N/mm^2)	5 samples - daily	ASTM D 638
4	Ultimate elongation	min 300%	5 samples - daily	ASTM D 638
5	Hardness	min 32 shore D	Daily	ASTM D 2240
6	Tensile strength after thermal ageing (120^0C, 168 hrs)	min 6 MPa (N/mm^2)	Qualification	ISO - 188
7	Ultimate elongation after thermal ageing (120^0C, 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^{14} ohm.cm	Qualification	IEC - 93
12	Resistance to tracking	No failure by tracking after 1 hour at 2.5 kV 1 hour at 2.75 kV 1 hour at 3.00 kV and 20 mins at 3.25 kV	Qualification	IEC 587
13	Flame retardance	Non burning	Qualification	ESI 09-13
	Raw Material Control			
14	Tensile strength	min 7 MPa (N/mm^2)	Compounding	ASTM D 638
15	Ultimate elongation	min 300%	Compounding	ASTM D 638
16	Hardness	min 32 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	

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