

1 - CONSTRUCTION

- Made of : - BRAID = Continuous Polyester yarn.
- CORE = Electrifeutre in Polyester fiber REF. TFT 30.
- Variant : continuous polyester yarn in the core (see **)

We realized a cord which is entirely made of POLYESTER to eliminate itching problems.

TO BE IMPREGNATED BY USERS

Can be heat stabilized on request (1 hour at 180 °C). We add the letter T to the reference. This stabilization is recommended for diameters higher than 16 mm and eliminates a great part of the textile ensemage.

PRE-PREG

On request, we can make a stage B impregnation with a class F resin. The cord is heat stabilized before impregnation.

- The % of resin is $\geq 50\%$ for diameters < 10 mm and $\geq 60\%$ for diameters ≥ 10 mm of the weight of the cord.
- They are presented cut at length and packed in a waterproof aluminised bag and must be stored in a cool place (life time : 6 months).

Heat-setting :

The heat-setting temperature in general is the same on site or in workshop. In workshop the machine is put in an oven and on site it is put under the tarpaulin with one or two heat blowers.

The heat-setting time depends on each user but in general it takes 12 h for the temperature to increase (10°C / hour) and it takes 12 h at 130°C for the heat-setting.



2 - CHARACTERISTICS

DIAMETER mm	REFERENCE	WEIGHT g/m (average)			NUMBER OF BRAIDS	NUMBER of yarns per BRAID
		BRAID	CORE	TOTAL		
7	TT 73	10	10	20	1	3 x 16
9	TT 87	11	14	25	1	3 x 16
11	TT 74	12	18	30	1	3 x 16
11**	TT 65 - 1 fil R	22	57	79	1	3 x 32
13	TT 88	18	26	44	1	3 x 32
13**	TT 66 - 2 fils R	21	68	89	1	3 x 32
16	TT 75	25	30	55	1	3 x 56
16	TT 75 T	25	30	55	1	3 x 56
16**	TT 67 - 3 fils R	36	107	143	1	3 x 56
20	TT 58	50	45	95	2	3 x 56
20**	TT 68 - 4 fils R	36	149	185	1	3 x 56
25	TT 62	60	80	140	2	3 x 56
30	TT 49 T	65	125	190	2	3 x 56
35	TT 89 T	65	170	235	2	3 x 56
40	TT 53 T	70	225	295	2	3 x 72
50	TT 59 T	150	300	450	2	3 x 72
70	TT 86 T	240	630	870	2	3 x 96

HEAT RESISTANCE : class F = 155 °C

3 - TOLERANCES

Diameters : ($\leq 9 \text{ mm} \pm 1$) ($> 9 \text{ mm} \leq 20 \text{ mm} \pm 2$) ($> 20 \leq 40 \text{ mm} \pm 3$)

4 - CONTROL

- All our cords are controlled with a metal part detector.
- This control is made during the process of measuring .
- The detector can detect a sphere of a diameter of 0,9 mm in the center of the detection window and a sphere of 0,2 mm on the edge of the detection window.

5 - APPLICATION

- ELECTROTECHNICAL INDUSTRY.
Mainly as stuffing and filling of sections and parts after impregnation by the user.



6 - PRESENTATION

- The cords are conditioned on cardboard jaws bobbins.

DIMENSION	TYPE C1	TYPE C2	TYPE C3
- JAWS DIAMETER	220	300	580
- CENTRAL TUBE DIAMETER	60	60	120
- LENGTH BETWEEN JAWS in mm	200	200	220

DIAMETER mm	REFERENCE	TYPE of BOBBIN	LENGTH per BOBBIN
7	TT 73	C 1	150 M
9	TT 87	C 2	100 M
11	TT 74	C 2	100 M
11**	TT 65 - 1 fil R	C 2	100 M
13	TT 88	C 3	200 M
13**	TT 66 - 2 fils R	C 2	70 M
16	TT 75	C 3	200 M
16	TT 75 T	C 3	200 M
16**	TT 67 - 3 fils R	C 2	50 M
20	TT 58	C 3	150 M
20**	TT 68 - 4 fils R	C 2	50 M
25	TT 62	C 3	100 M
30	TT 49 T	C 3	70 M
35	TT 89 T	C 3	50 M
40	TT 53 T	C 3	40 M
50	TT 59 T	C 3	25 M
70	TT 86 T	C 3	20 M

R yarn = number of red yarns .

See photo

