

## 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 190 °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 ensimage.

### 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  $\geq 10$  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<br>mm | REFERENCE        | WEIGHT g/m (average) |      |       | NUMBER<br>OF<br>BRAIDS | NUMBER<br>of yarns<br>per<br>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<br>in mm | 200     | 200     | 220     |

| DIAMETER<br>mm | REFERENCE        | TYPE of BOBBIN | LENGTH<br>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

