Technical Data Sheet

Product Name
SCGC™ HDPE

Product Type
High Density Polyethylene

Product Grade
H6430BM

Product Description

SCGC HDPE H6430BM is a high density polyethylene resin suitable for producing beverage bottles by using extrusion blow molding machine.

Typical Application

- Drinking water bottles (Containing volume up to 20 liters)
- Milk bottles
- Fruit juice bottles
- Fish sauce gallons

Product Characteristics

- Excellent stiffness
- Odorless
- Good processability
- Good printability

International Compliance

- U.S FDA 21 CFR 177.1520
- Regulation (EU) No.10/2011
- Packaging and Packaging waste directive 94/62/EC/CONEG

Physical Properties

Properties	Test Method	Typical Value	Unit
Melt Flow Rate	ASTM D 1238 @ 190 °C, 2.16 kg	0.4	g/ 10 min
Density	ASTM D 1505	0.964	g/cm^3
Melting Point	ASTM D 2117	132	°C
Vicat Softening Point	ASTM D 1525	128	°C
Brittleness Temperature	ASTM D 746	< - 60	°C
Tensile Strength at Yield	ASTM D 638	300	kg/cm^2
Tensile Strength at Break	ASTM D 638	370	kg/cm^2
Elongation at Break	ASTM D 638	1200	%
Flexural Modulus	ASTM D 790	16000	kg/cm^2
Notched Izod Impact	ASTM D 256 @ 23 °C	245	J/m
ESCR	ASTM D 1693 @ 50 °C (Method B, Compression Molded, 25% Igepal)	24	Hrs, F_{50}

Note: The given values are typical value measured on the product. Values herein are not to be constructed as a product specification.

Thai Polyethylene Co., Ltd.
1 Siam Cement Road, Bangsue, Bangkok, 10800 Thailand
E-mail: general_plastics@scg.com

Published: March 2023

Manufacturer website: https://www.scgchemicals.com/en

SCGC	**Technical Data Sheet**	Product Name **SCGC™ HDPE**
	Product Type **High Density Polyethylene**	Product Grade **H6430BM**

Processing Guidelines

Recommended processing conditions:
The actual extrusion condition depends on type of using machine, size and wall thickness of product required. Generally, melt temperature should be 160-180 °C. 5-8 bar of blowing pressure is recommended. In some cases, enlargement of die and pin diameter (15-30%) may be suggested for increasing parison diameter.

Product Technical Assistance

For technical assistance or further information on this product or any other SCG Chemicals' products, contact your SCG Chemicals technical services at the address as specified below.

Product Available Form

- Block pellet

Product Packaging

- 25 kg loose bag
- 25 kg stretch wrap palletized
- 750 kg big bag
- Sea bulk container

Storage

- Store in original container in tidy according to the manual of Handling and Storage from Thai Polyethylene Company Limited.
- Product(s) should be stored in dry and dust free location at temperature below 50 °C and protected from direct sunlight and/or heat, well-ventilated area, away from incompatible materials and food and drink, as this may lead to quality deterioration, which results in odour generation and colour changes and can have negative effects on the physical properties of this product.
- Keep container tightly closed and sealed until ready for use. Containers that have been opened must be carefully resealed and kept upright to prevent leakage. Do not store in unlabelled containers. Use appropriate containment to avoid environmental contamination.
- The storage area should be stable and not be slopped.

Safety

- The product is not classified as a hazardous material.
- Please see our Material Safety Data Sheet for details on various aspects of safety, recovery, and disposal of the products; for more information, contact your SCG Chemicals technical services.

Thai Polyethylene Co., Ltd.
1 Siam Cement Road, Bangsue, Bangkok, 10800 Thailand
E-mail: general_plastics@scg.com

Manufacturer website: https://www.scgchemicals.com/en

SCGC	**Technical Data Sheet**	Product Name **SCGC™ HDPE**
	Product Type **High Density Polyethylene**	Product Grade **H6430BM**

Recycling

- The product is suitable for recycling using modern methods of shredding and cleaning. In-house production waste should be kept clean to facilitate direct recycling.
- Please see our Material Safety Datasheet for details on various aspects of safety, recovery and disposal of the products; for more information, contact your SCG Chemicals technical services.

Related Documents

- The latest version of this document will be available at our website, www.scgchemicals.com, or can be obtained from the SCG Chemicals technical services.
- The following related documents are available on request, and represent various aspects on the usability, safety, recovery and disposal of the product.
    - Safety Data Sheet.
    - Declaration of Compliance.

Disclaimer

- The applications specified herein is for reference only.
- It is customer's responsibilities to inspect and test the product for suitability of the customer's own use and purpose. The customer is responsible for appropriate, safe, legal use, processing and handling of the product.
- To the best of our knowledge, the information contained herein is accurate and reliable as of the date of publication. We however do not assume any liability whatsoever for the accuracy and completeness of the information contained herein.
- We make no warranties which extend beyond the description herein. Nothing herein shall constitute any implied warranty of merchantability or fitness for a particular purpose.
- No liability can be accepted in respect of the use of the product in conjunction with other materials. The information contained herein relates exclusively to the product when it is not used in conjunction with any third party's materials.

Thai Polyethylene Co., Ltd.
1 Siam Cement Road, Bangsue, Bangkok, 10800 Thailand
E-mail: general_plastics@scg.com

Manufacturer website: https://www.scgchemicals.com/en