# Technical Data Sheet

Product Name
**SCGC™ LLDPE**

Product Type
**Octene Copolymer PE for Rotational Moulding**

Product Grade
**M3504DXP**

## Product Description

SCGC M3504DXP is natural powder of DOWLEX™ NG 2429.01G which is a linear-low density polyethylene octene copolymer for rotational moulding applications. M3504DXP is specifically designed for applications requiring excellent environmental stress crack resistance and impact strength combined with low warpage and good processing. It is fully heat and UV stabilized resulting in a wide processing latitude, good color retention, and long life expectancy. These grades are recommended for large and thick tanks with a generous radius and curve.

## Typical Application

- Diesel fuel tanks
- Boat and tractor parts
- Chemical storage containers

## Product Characteristics

- Excellent ESCR
- Excellent chemical resistance
- High impact strength
- Enhanced outdoor performance with proven UV-protection recipe

## International Compliance

- Meet the requirements of U.S. Food and Drug Administration (FDA) 21 CFR Part 177.1520 (c), paragraph 3.1a, for food contact under conditions of use C-H (21 CFR 176.170 (c) Table 2), for all food types

## Physical Properties

| Properties | Test Method | Typical Value | Unit |
|---|---|---|---|
| Melt Flow Rate @ 190°C, 2.16 kg | ASTM D 1238 | 4.0 | g/10 min |
| Density | ASTM D 1505 | 0.935 | g/cm³ |
| Melting Point | ASTM D 2117 | 125 (257) | °C (°F) |
| Crystallization Point | ASTM D 2117 | 105 (221) | °C (°F) |
| Heat Deflection Temperature @ 0.455 MPa | ASTM D 648 | 60 (140) | °C |
| Heat Deflection Temperature @ 1.82 MPa | ASTM D 648 | 41 (106) | °C (°F) |
| Vicat Softening Temperature | ASTM D 1525 | 118 (224) | °C (°F) |
| **Mechanical Properties** | | | |
| Tensile Strength at Yield @ Speed 50 mm/min | ASTM D 638 | 17 (2460) | MPa (psi) |
| Tensile Strength at Break @ Speed 50 mm/min | ASTM D 638 | 30 (4350) | MPa (psi) |
| Elongation at Break @ Speed 50 mm/min | ASTM D 638 | 1000 | % |
| Flexural Modulus, 1% Secant | ASTM D 790 | 550 (80000) | MPa (psi) |
| Surface Hardness | ASTM D 2240 | 57 | Shore D |
| ARM Impact Strength @ -40°C (5.5 mm rotomolded sample) | ARM Method | 27 (110) | J/mm (lb-ft) |
| ESCR (100% Igepal, Condition A) | ASTM D 1693 | > 1,000 | hrs, F50 |

**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. / SCGC ICO Polymers Co., Ltd.**
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Manufacturer website: https://www.scgchemicals.com/en

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## Processing Guidelines

Moulding cycles depend on mould materials and its wall thickness, oven temperature, and shot size. Typical oven temperatures should be set between 250 and 300 °C. The recommended PIAT for M3504DXP is about 230 °C.

### Points of Concerns

- It is not recommended to flame the surfaces of molded parts with an open torch due to risk of thermal degradation and premature failure.
- Inclusion of fillers or recycled materials into the resins either by compounding or dry blending is not recommended due to risk of compromised impact strength.
- Use of pigments above 0.3% by dry blending into natural powder should be avoided due to risks of lower impact strength.
- Additional antioxidants, internal lubricants, or UV stabilizers into the virgin resins during the compounding process should be considered depending on the end applications.
- Not for cooking less than 10 min heating time.

### 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

- Natural powder

## Product Packaging

- 25 kg loose bag
- 25 kg stretch wrap palletized
- 750 kg big bag

## Storage

- Store in original container in tidy according to the manual of Handling and Storage from Thai Polyethylene Co., Ltd. / SCGC ICO Polymers Co., Ltd.
- 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.

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## 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.

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