



TECHNICAL DATA SHEET

Product Type

High Density Polyethylene for Blow Molding

Product Name

SCG HDPE

Product Grade

H6430BM

Product Description

SCG 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 liter)
- Milk bottles
- Fruit juice bottles
- Fish sauce gallons

Product Characteristics

- Excellent Stiffness
- Odorless
- Good processibility
- 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

Property	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	15000	kg/cm ²
Notched Izod Impact	ASTM D 256 @ 23 °C	245	J/m
ESCR	ASTM D 1693 @ 50 °C (Condition B, Compression Molded, 25% Igepal)	24	Hrs, F50

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

SCG Plastics Co., Ltd. / SCG Performance Chemicals Co., Ltd.





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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 service engineer at the address or telephone number as specified below.

Product Available Form

- Block pellet

Product Packaging

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

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