



TECHNICAL DATA SHEET

Product Type

High Density Polyethylene for Blown Film

Product Name

SCG HDPE

Product Grade

H5604F

Product Description

H5604F is a high density polyethylene product of bi-modal process which suitable for the high quality film application. It is recommended for general purpose film with high tensile strength.

Typical Application

- Shopping bag and T-shirt bag
- Garbage bag
- Liner bag

Product Characteristics

- High tensile strength with good dart impact strength
- High stiffness
- Low gel content
- Good moisture barrier
- Food contact applicable

International Compliance

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

Physical Properties

Property	Test Method	Typical Value	Unit
Melt Flow Rate	ASTM D 1238 @ 190 °C, 2.16 kg	0.04	g/10 min
Density	ASTM D 1505	0.954	g/cm ³
Melting Point	ASTM D 2117	131	°C
Vicat Softening Point	ASTM D 1525	124	°C
Brittleness Temperature	ASTM D 746	< -60	°C
ESCR	ASTM D 1693 @ 50 °C (Condition B, Compression Molded, 25% Igepal)	> 1000	hrs, F ₅₀
Film Properties			
Tensile Strength at Yield	ASTM D 882	MD: -, TD: 250*	kg/cm ²
Tensile Strength at Break	ASTM D 882	MD: 620*, TD: 310*	kg/cm ²
Tensile Modulus, 2% Secant	ASTM D 882	MD: 8200*, TD: 8000*	kg/cm ²
Elongation at Break	ASTM D 882	MD : 240*, TD : 450*	%
Elmendorf Tear Strength	ASTM D 1922	MD : 3*, TD : 80*	g
Dart Impact Strength	ASTM D 1709	139*	g

Note: (*) Properties obtained from film produced on a pilot line at TPE, 12 micron, BUR 5:1, MD = Machine Direction, TD = Transverse Direction. Conversion factor for changing unit from kg/cm² to MPa is divided by 10.2

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Processing Guidelines

The actual extrusion condition depends on type of using machine, size and film thickness of product required. Generally, melt temperature should be 180-200 °C with BUR = 3-5 times and frost line height (FLH) = 8-10 times of die 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 at the address or telephone number as specified below.

Product Available Form

- 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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