



TECHNICAL DATA SHEET

Product Type

High Density Polyethylene for Injection Application

Product Name

SCG HDPE

Product Grade

H6105JU Improvement

Product Description

SCG HDPE H6105JU Improvement is under development to improve stiffness and balanced impact property of high density polyethylene resin. This grade is added UV resistance suitable for industrial product produced from injection molding process.

Typical Application

- Large garbage bin, Fruit basket
- Pallet, Crate
- Industrial parts for outdoor uses

Product Characteristics

- Good stiffness, impact resistance
- Good processibility
- Wide service temperature range
- UV resistance

International Compliance

- Directive 2000/53/EC (End of life vehicle – ELV)
- Directive 94/62/EC (Packaging and Packaging waste)
- Directive 2002/95/EC (RoHS)

Physical Properties

Property	Test Method	Typical Value	Unit
Melt Flow Rate	ASTM D 1238 @ 190 °C, 2.16 kg	5.0	g/10 min
Density	ASTM D 1505	0.964	g/cm ³
Tensile Strength at Yield	ASTM D 638	250	kg/cm ²
Tensile Strength at Break	ASTM D 638	200	kg/cm ²
Flexural Modulus	ASTM D 790	15,500	kg/cm ²
Notched Izod Impact	ASTM D 256 @ 23°C	32	J/m
Hardness	ASTM D 2240	66	Shore D
Melting Point	ASTM D 2117	133	°C
Vicat Softening Point	ASTM D 1525	127	°C
Brittleness Temperature	ASTM D 746	< -60	°C
Heat Deflection Temperature (HDT)	ASTM D 648 @ 4.6 kg/cm ²	75	°C

Note:

- Conversion factor for changing unit from kg/cm² to MPa is divided by 10.20
- The given values are typical value measured on the product. Values herein are not to be constructed as a product specification.

Processing Techniques

The actual processing conditions depend on each machine type, product size, mold design and environment.

Recommended processing conditions:

Melt temperature: 200-250°C

Mold temperature: 20-60°C

Injection speed: Fast

Screw speed 40-70 rpm

Pressure: Injection 30-70%,

Packing and Holding 30-50%,

Back 10% of Max. Pressure

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H6105JU_{Improvement}

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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