

**Product Description**

EL-Lene H6430BM is a high density polyethylene resin suitable for producing beverage bottles by using Extrusion blow molding machine.

Typical Application

- Drinking water bottles, Water drums
(Containing volume up to 20 liter)
- Fruit juice bottles
- Milk bottles
- Fish sauce gallons

Product Characteristics

- Excellent stiffness
- Odorless
- Good processability
- Good printability
- Food contact applicable (Complies with U.S FDA 21 CFR 177.1520)

Physical Properties

Property	Test Method	Value	Unit
Melt Flow Rate	ASTM D 1238 @ 190°C, 2.16 kg	0.40	g/10 min
HLMI	ASTM D 1238 @ 190°C, 21.6 kg	30	g/10 min
Density	ASTM D 1505	0.966	g/cm ³
Tensile Strength at Yield	ASTM D 638 @ Crosshead speed 50 mm/min	300	kg/cm ²
Tensile Strength at Break	ASTM D 638 @ Crosshead speed 50 mm/min	370	kg/cm ²
Elongation at Break	ASTM D 638 @ Crosshead speed 50 mm/min	1200	%
Flexural Modulus	ASTM D 790	15000	kg/cm ²
Notched Izod Impact	ASTM D 256 @ 23°C	25	kg.cm/cm
Hardness	ASTM D 2240	70	Shore D
ESCR	ASTM D 1693 @ 50°C (Condition B, Compression Molded, 25% Igepal)	24	hrs, F ₅₀
Melting Point	ASTM D 2117	132	°C
Vicat Softening Point	ASTM D 1525	128	°C
Brittleness Temperature	ASTM D 746	< - 60	°C

Note : Conversion factor for changing unit from kg/cm² to MPa is divided by 10.20

Processing Techniques

The actual extrusion condition depends on type of using machine, size and wall thickness of product required. Generally, melt temperature should be 180-200°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 at the address or telephone number as specified below.

Product Available Form**Product Packaging**

- Pellet
- 25 kg loose bag
- Big bag with specified weight

SCG Plastics Company Limited / SCG Performance Chemicals Company Limited





Technical Datasheet

High Density Polyethylene for Blow Molding

EL-Lene™

H6430BM

Storage

- Store in original container in tidy according to the manual of Handling and Storage from Thai Polyethylene Company Limited/ Thai Polypropylene 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.

EL-Lene™ EL-Pro™ EL-Wax™



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