



# Technical Data Sheet

Product Name  
**SCGC™ HDPE**

Product Type  
**PE100 Black HDPE Compound for Injection Molding**

Product Grade  
**H1000PCI**

## Product Description

SCGC HDPE H1000PCI is a black, bimodal technology, high density polyethylene compound classified as MRS 10.0 material (PE100) providing superior mechanical properties and processability. In addition, it includes a good dispersion of carbon black pigment and anti-oxidant to ensure excellent long term UV resistance and thermal stability.

## Typical Application

- Injection molding fitting element for butt-fusion and electrofusion socket and saddle welding pipes

## Product Characteristics

- High productivity
- Easy flow and less energy consumption
- High thermal stability

## Physical Properties

Properties	Test Method	Typical Value	Unit
Melt Flow Rate	ISO 1133 @ 190 °C, 5.0 kg	0.24	g/ 10 min
Density (Compound)	ISO 1183	0.960	g/cm <sup>3</sup>
Tensile Strength at Yield	ISO 527 @ Crosshead speed 100 mm/ min	24	MPa
Tensile Strength at Break	ISO 527 @ Crosshead speed 100 mm/ min	> 30	MPa
Elongation at Break	ISO 527 @ Crosshead speed 100 mm/ min	> 600	%
Carbon Black Content	ISO 6964	2.25	% by mass
Carbon Black Dispersion	ISO 18553	< 3	-
Oxidative Induction Time	ISO 11357-6 @ 210 °C	≥ 40	Min
Flexural Modulus	ASTM D790	1,000	MPa
Melting Temperature	ASTM D 2117	130	°C
Vicat Softening Point	ASTM D 1525	124	°C
MRS Classification	ISO 12162/ISO 9080	10.0	MPa
Resistance to Slow Crack Growth	ISO 13479 @ 80 °C	> 500	Hrs

**Note:** - The given values are typical value measured on the product. Values herein are not to be constructed as a product specification.  
- Conversion factor for changing unit from kg/cm<sup>2</sup> to MPa is divided by 10.20.

Thai Polyethylene Co., Ltd.





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### Processing Guidelines

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

Recommend processing condition: Drying temperature at 80-90 °C for 1-2 hours, Melt temperature 190 – 250 °C, Medium injection speed, Screw speed 60 – 100 rpm, Mold or cooling temperature 50 – 70 °C.

### 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

- Black Pellet

### Product Packaging

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