



TECHNICAL DATA SHEET

Product Name

SCG LLDPE

Product Type

Octene Copolymer PE for Rotational Moulding

Product Grade

M50BKM1P

Product Description

SCG M50BKM1P is a black compound of DOWLEX™ NG 2429.01G which is a linear-low density polyethylene octene copolymer for rotational moulding applications. M50 is specifically designed for applications requiring excellent environmental stress crack resistance and impact strength combined with low warpage and good processing. It is fully heat and UV stabilized resulting in a wide processing latitude, good color retention, and long life expectancy. This grade is recommended for large and thick tanks with a generous radius and curve.

Typical Applications

- Diesel fuel tanks
- Boat and tractor parts
- Chemical storage containers

Product Characteristics

- Excellent ESCR
- Excellent chemical resistance
- High impact strength
- Enhanced outdoor performance with proven UV-protection recipe
- Contain 0.5% carbon black

International Compliance

- TUV certified material for diesel tanks
- Base resin of M50 meets the requirements of U.S. Food and Drug Administration (FDA) 21 CFR Part 177.1520 (c), paragraph 3.1a, for food contact under conditions of use C-H (21 CFR 176.170(c) Table 2), for all food types

Product Properties

Property	Test Method	Typical Value	Unit
Resin Properties			
Melt Flow Rate @ 190 °C, 2.16 kg	ASTM D 1238	4.0	g/10 min
Density	ASTM D 1505	0.935	g/cm ³
Melting Point	ASTM D 2117	125 (257)	°C (°F)
Crystallization Point	ASTM D 2117	105 (221)	°C (°F)
Heat Distortion Temperature	ASTM D 648 @ 0.455 MPa	60 (140)	°C (°F)
Heat Distortion Temperature	ASTM D 648 @ 1.82 MPa	41 (106)	°C (°F)
Vicat Softening Temperature	ASTM D 1525	118 (224)	°C (°F)
Mechanical Properties			
Tensile Strength-at-Yield	ASTM D 638 @ Speed 50 mm/min	17 (2460)	MPa (psi)
Tensile Strength-at-Break	ASTM D 638 @ Speed 50 mm/min	30 (4350)	MPa (psi)
Elongation-at-Break	ASTM D 638 @ Speed 50 mm/min	1000	%
Flexural Modulus, 1% Secant	ASTM D 790	550 (80000)	MPa (psi)
Surface Hardness	ASTM D 2240	57	Shore D
ARM Impact Strength @ -40 °C	ARM Method (5.5 mm rotomoulded sample)	27 (110)	J/mm (lb-ft)
ESCR (100% Igepal)	ASTM D 1693, Condition A	>1,000	hrs, F50

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

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Processing Guidelines

Moulding cycles depend on mould materials and its wall thickness, oven temperature, and shot size. Typical oven temperatures should be set between 250 and 300 °C. The recommended PIAT for M50BKM1P is about 235 °C. M50 requires 10% longer cooking time than normal butene grades.

Points of Concerns

- Finishing rotational parts by flaming, using scrap/filler in compound formulation, or dry blending pigment > 0.3% can decrease mechanical properties of rotational parts, which is not recommended.
- Not for cooking less than 10 min heating time.
- Use up the powder as quickly as possible after the package is opened due to a high moisture pick-up that will result to pinholing and poor impact strength.

Product Technical Assistance

For technical assistance or further information on this product or any other SCG Chemicals' products, please contact your SCG Chemicals technical service at the address or telephone number as specified below.

Product Available Forms

- Black compound powder

Product Packaging

- 25 kg loose bag
- 25 kg stretch wrap palletized

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 horizontal.

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