



TECHNICAL DATA SHEET

Product Name

SCG LLDPE

Product Type

Octene Copolymer PE for Rotational Moulding

Product Grade

M3504DXP / M50

Product Description

SCG M3504DXP is natural powder of DOWLEX™ NG 2429.01G which is a linear-low density polyethylene octene copolymer for rotational moulding applications, whereas M50 is the color compound version. M3504DXP 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. These grades are 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

International Compliance

- Meet 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
- For compliance of specific colors, please contact our technical service.

Product Properties

Property	Test Method	Typical Value	Unit
Resin Properties			
Melt Flow Rate	ASTM D 1238 @ 190 °C, 2.16 kg	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 M3504DXP is about 235 °C. However, the optimum PIAT of M50 color compound may vary with a color shade. These grades require 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.
- For black compound, 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

- Natural powder (M3504DXP)
- Color compound powder (M50)

Product Packaging

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

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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