



TECHNICAL DATA SHEET

Product Type

Polypropylene Impact Copolymer

Product Name

SCG PP

Product Grade

P640J

Product Description

SCG PP P640J is an impact copolymer polypropylene resin designed for injection molding process. This resin is recommended for product that requires high impact strength with good stiffness and processibility.

Typical Application

- Automotive parts
- Electrical appliance parts
- Industrial uses
- Toy, Furniture

Product Characteristics

- High impact strength
- Good stiffness
- Good processibility
- Food contact applicable

International

- U.S FDA 21 CFR 177.1520
- UL Yellow Card E202743
- RoHS Directive 2011/65/EU

Physical Properties

Property	Test Method	Typical Value	Unit
Melt Flow Rate	ASTM D 1238 @ 230°C, 2.16 kg	10	g/10 min
Density	ASTM D 1505	0.910	g/cm ³
Tensile Strength at Yield	ASTM D 638 @ Speed 50 mm/min	280	kg/cm ²
Tensile Strength at Break	ASTM D 638 @ Speed 50 mm/min	200	kg/cm ²
Flexural Modulus	ASTM D 790	12,000	kg/cm ²
Notched Izod Impact	ASTM D 256 @ 23°C	98	J/m
Notched Izod Impact	ASTM D 256 @ 0°C	59	J/m
Notched Izod Impact	ASTM D 256 @ -20°C	39	J/m
Rockwell Hardness	ASTM D 785	70	R-Scale
Melting Point	ASTM D 2117	163	°C
Vicat Softening Point	ASTM D 1525	150	°C
Heat Deflection Temperature (HDT)	ASTM D 648 @ 4.6 kg/cm ²	105	°C
% Shrinkage (2mmt) MD	TPE Method	1.3	%
TD	TPE Method	1.1	%
Flammability	UL - 94	HB	-

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.

SCG Plastics Co., Ltd. / SCG Performance Chemicals Co., Ltd.





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Processing Guidelines

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

Melt temperature: 210-250°C

Mold temperature: 25-70°C

Injection speed: Fast

Screw speed 40-70 rpm

Pressure: Injection 40-80%

Packing and Holding 30-60%

Back 10% of Max Pressure

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

- Block 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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