



Technical Datasheet		Product Name
		SCGC™ HDPE
Product Type	Product Grade	
Polyethylene for Rotational Moulding	3985	

Product Description

ICORENE® 3985 is a color compound high density polyethylene specifically developed for rotational moulding application which exhibits superior mechanical properties when compared to traditional high density grades.

This grade has been specifically developed for kayaks that require a balance of stiffness and toughness, fast cooking behavior and fully UV protection with a minimum UV8 rating,

Typical Application

- Kayaks
- Pallets
- Underground tanks
- Inspection pits

Product Characteristics

- Excellent stiffness
- Excellent impact strength
- Fast cycle time and excellent flow
- Excellent color fastness and UV protection (UV8) for outdoor use
- Wide variety of colors

Physical Properties

Property	Test Method	Typical Value	Unit
Resin Properties			
Melt Flow Rate	ASTM D 1238 @ 190 °C, 2.16 kg	5.0	g/10 min
Density	ASTM D 1505	0.950	g/cm ³
Melting Point	ASTM D 2117	128 (262)	°C (°F)
Crystallization Point	ASTM D 2117	117 (243)	°C (°F)
Heat Deflection Temperature	ASTM D 648 @ 0.455 MPa	66 (150)	°C (°F)
Vicat Softening Temperature	ASTM D 1525	120 (248)	°C (°F)
Mechanical Properties			
Tensile Strength-at-Yield	ASTM D 638 @ Speed 50 mm/min	22 (3200)	MPa (psi)
Tensile Strength-at-Break	ASTM D 638 @ Speed 50 mm/min	28 (4060)	MPa (psi)
Elongation-at-Break	ASTM D 638 @ Speed 50 mm/min	1160	%
Flexural Modulus	ASTM D 790	910 (132000)	MPa (psi)
Surface Hardness	ASTM D 2240	62	Shore D
ARM Impact Strength @ -40 °C	ARM Method (5.5 mm rotomoulded sample)	28 (114)	J/mm (lb-ft)

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

Thai Polyethylene Co., Ltd.

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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 3985 is about 200 °C which may vary with a color shade.

Points of Concerns

- It is not recommended to flame the surfaces of molded parts with an open torch due to risk of thermal degradation and premature failure.
- Inclusion of fillers or recycled materials into the resins either by compounding or dry blending is not recommended due to risk of compromised impact strength.
- Use of pigments above 0.3% by dry blending into natural powder should be avoided due to risks of lower impact strength.
- Additional antioxidants, internal lubricants, or UV stabilizers into the virgin resins during the compounding process should be considered depending on the end applications.
- 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 services at the address as specified below.

Product Available Forms

- Color compound powder
- 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/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.

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Safety

- The product is not classified as a hazardous material.
- Please see our Safety Data Sheet for details on various aspects of safety, recovery, and disposal of the products; for more information, contact your SCG Chemicals technical services.

Recycling

- The product is suitable for recycling using modern methods of shredding and cleaning. In-house production waste should be kept clean to facilitate direct recycling.
- Please see our Safety Data Sheet for details on various aspects of safety, recovery and disposal of the products; for more information, contact your SCG Chemicals technical services.

Related Documents

- The latest version of this document will be available at our website, www.scgchemicals.com, or can be obtained from the SCG Chemicals technical services.
- The following related documents are available on request, and represent various aspects on the usability, safety, recovery and disposal of the product.
 - Safety Data Sheet.
 - Declaration of Compliance.

Disclaimer

- The Applications specified herein is for reference only.
- It is customer's responsibilities to inspect and test the product for suitability of the customer's own use and purpose. The customer is responsible for appropriate, safe, legal use, processing and handling of the product.
- To the best of our knowledge, the information contained herein is accurate and reliable as of the date of publication. We however do not assume any liability whatsoever for the accuracy and completeness of the information contained herein.
- We make no warranties which extend beyond the description herein. Nothing herein shall constitute any implied warranty of merchantability or fitness for a particular purpose.
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