



Technical Datasheet		Product Name
Polyethylene for Rotational Moulding		SCGC™ LLDPE
Product Type	Product Grade	
	M30 / M40	

Product Description

SCGC M30 and M40 Series are color compound linear-low density polyethylene (LLDPE) for rotational moulding applications. These grades are suitable for containers and general applications which have thin wall less than 5 mm.

M30 and M40 Series includes the following grades:

M30: color compound designed for indoor and semi-indoor products with UV2 rating

M40: UV8-rating protection for outdoor use

Typical Application	Product Characteristics	International Compliance
- Cooler boxes - Portable containers - Material handling containers - General purpose moulding - Fish bins	- High impact strength - Low shrinkage and warpage - Consistent dimension	- Base resin of M30 and M40 series meets the requirements of U.S. Food and Drug Administration (FDA) 21 CFR Part 177.1520 Olefin polymers (c) 2.1 for food contact under conditions of use D-G (21 CFR 176.170(c) Table 2), for all food types. - For compliance of specific colors, please contact our technical

Physical 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	0.932	g/cm ³
Melting Point	ASTM D 2117	125 (257)	°C (°F)
Crystallization Point	ASTM D 2117	110 (230)	°C (°F)
Heat Deflection Temperature	ASTM D 648 @ 0.455 MPa	58 (136)	°C (°F)
Vicat Softening Temperature	ASTM D 1525	108 (226)	°C (°F)
Mechanical Properties			
Tensile Strength-at-Yield	ASTM D 638 @ Speed 50 mm/min	17 (2500)	MPa (psi)
Tensile Strength-at-Break	ASTM D 638 @ Speed 50 mm/min	25 (3600)	MPa (psi)
Elongation-at-Break	ASTM D 638 @ Speed 50 mm/min	1000	%
Flexural Modulus	ASTM D 790	570 (82700)	MPa (psi)
Surface Hardness	ASTM D 2240	55	Shore D
ARM Impact Strength @ -40 °C	ARM Method (5.5 mm rotomoulded sample)	28 (114)	J/mm (lb-ft)
Brittleness Temperature	ASTM D 746	< -60 (-76)	°C (°F)

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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Page | 1

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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 is about 210 °C for M30 and about 190 °C for M31 and M40. The optimum PIAT 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.

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

Product Packaging

- 25 kg loose bag
- 25 kg stretch wrap palletized

Storage

- Store in original container in tidy according to the manual of Polyethylene Company Limited/Thai Polypropylene Company
- Product(s) should be stored in dry and dust free location at from direct sunlight and/or heat, well-ventilated area, away from drink, as this may lead to quality deterioration, which results in and can have negative effects on the physical properties of this
- Keep container tightly closed and sealed until ready for use. be carefully resealed and kept upright to prevent leakage. Do not appropriate containment to avoid environmental contamination.
- The storage area should be stable and not be sloped.

Handling and Storage from Thai Limited.

temperature below 50 °C and protected incompatible materials and food and odour generation and colour changes product.

Containers that have been opened must store in unlabelled containers. Use

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Page | 2

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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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