



Technical Datasheet		Product Name
Polyethylene for Rotational Moulding		SCGC™ LLDPE
Product Type	Product Grade	
	M3204RU/RUP	

Product Description

SCGC M3204RU is a linear-low density polyethylene (LLDPE) for indoor/ semi-indoor rotational moulding applications. M3204RU and M3204RUP are the natural color PE resin available in a pellet and powder form, respectively. This grade is suitable for containers and general-purpose applications which are indoor/ semi-indoor or for thin wall (less than 5 mm) parts.

Typical Application	Product Characteristics	International Compliance
- Cooler boxes - Portable containers - Material handling containers - General purpose moulding - Fish bins - Small thin tanks (less than 1000 liters)	- High impact strength - Low shrinkage and warpage - Consistent dimension - UV-stabilized (UV2) for indoor/ semi-indoor	- Meet 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 - Meet Thai Industrial Standard TIS 816-2556 (PE resin)

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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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 M3204RU/RUP is about 180 °C.

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.
- M3204RU/RUP is not recommended for extrusion into color compound. If used, must add additional antioxidants during extrusion process.
- M3204RU/RUP is not recommended for parts which exceed 5 mm or 30 min heating.
- M3204RU/RUP is not recommended for products used under direct and intense sunlight.

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

- Natural pellet (M3204RU)
- Natural powder (M3204RUP)

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/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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