



TECHNICAL DATA SHEET

Product Name

SCG HDPE

Product Type

High Density Polyethylene for Injection Application

Product Grade

H5814J

Product Description

SCG HDPE H5814J is a general purpose high density polyethylene resin suitable for using in injection molding process. This good flow ability grade designed for high productivity with good toughness product.

Typical Application

- General injection parts
- Household product
- Bottle cap and closure
- Toy

Product Characteristics

- Good process ability
- Good impact resistance
- Food contact applicable

International Compliance

- U.S. FDA 21 CFR 177.1520
- Regulation(EU) No.10/2011
- Directive 94/62/EC
- Directive 2002/95/EC (RoHS)

Physical Properties

Property	Test Method	Typical Value	Unit
Melt Flow Rate	ASTM D 1238 @ 190°C, 2.16 kg	14	g/10 min
Density	ASTM D 1505	0.958	g/cm ³
Tensile Strength at Yield	ASTM D 638	280	kg/cm ²
Tensile Strength at Break	ASTM D 638	180	kg/cm ²
Elongation at Break	ASTM D 638	620	%
Flexural Modulus	ASTM D 790	12,500	kg/cm ²
Notched Izod Impact	ASTM D 256 @ 23°C	29.4	J/m
Hardness	ASTM D 2240	65	Shore D
ESCR	ASTM D 1693 @ 50°C (Condition B, Compression Molded, 25% Igepal)	2	hrs, F ₅₀
Melting Point	ASTM D 2117	131	°C
Vicat Softening Point	ASTM D 1525	122	°C
Heat Deflection Temperature (HDT)	ASTM D 648 @4.6 kg/cm ²	75	°C
% Shrinkage (2mmt) MD	TPE Method	1.60	%
TD	TPE Method	1.77	%
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.

1 Siam Cement Road, Bangsue, Bangkok, 10800 Thailand

Tel. +66 2586 4874

Fax +66 2586 5522

E-mail: general_plastics@scg.com



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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: 200-250°C

Mold temperature: 20-60 °C

Injection speed: Fast

Screw speed 40-70 rpm

Pressure: Injection 30-70%,

Packing and Holding 30-50%,

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

- 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.

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 Plastics/SCG Performance Chemicals technical service.

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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 Plastics/SCG Performance Chemicals technical service.

Related Documents

- The latest version of this document will be available at our website, www.scgchemicals.com, or can be obtained from the SCG Plastics/SCG Performance Chemicals technical service.
- 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
 - Statement on compliance to food contact regulations

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.
- No liability can be accepted in respect of the use of the product in conjunction with other materials. The information contained herein relates exclusively to the product when it is not used in conjunction with any third party's materials.

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