



## TECHNICAL DATA SHEET

Product Type

**High Density Polyethylene for Blown Film**

Product Name

**SCG HDPE**

Product Grade

**F15**

### Product Description

F15 is a high density polyethylene product of bi-modal process. It is recommended for film which is produced by high speed machine and wide lay flat. The key characteristics are high tensile strength and high productivity.

### Typical Application

- Shopping bag and T-shirt bag
- Garbage bag
- Liner bag

### Product Characteristics

- High productivity
- High tensile strength with good dart impact strength
- Low gel content
- Excellent printing
- Good moisture barrier
- Food contact applicable

### International Compliance

- U.S FDA 21 CFR 177.1520
- Regulation (EU) No.10/2011
- Packaging and Packaging waste Directive 94/62/EC/CONEG
- RoHS

### Physical Properties

| Property                   | Test Method                                                          | Typical Value        | Unit                 |
|----------------------------|----------------------------------------------------------------------|----------------------|----------------------|
| Melt Flow Rate             | ASTM D 1238 @ 190 °C, 2.16 kg                                        | 0.06                 | g/10 min             |
| Density                    | ASTM D 1505                                                          | 0.952                | g/cm <sup>3</sup>    |
| Melting Point              | ASTM D 2117                                                          | 130                  | °C                   |
| Vicat Softening Point      | ASTM D 1525                                                          | 123                  | °C                   |
| Brittleness Temperature    | ASTM D 746                                                           | < -60                | °C                   |
| ESCR                       | ASTM D 1693 @ 50 °C<br>(Condition B, Compression Molded, 25% Igepal) | > 1000               | hrs, F <sub>50</sub> |
| <b>Film Properties</b>     |                                                                      |                      |                      |
| Tensile Strength at Yield  | ASTM D 882                                                           | MD: -, TD: 320*      | kg/cm <sup>2</sup>   |
| Tensile Strength at Break  | ASTM D 882                                                           | MD: 910*, TD: 380*   | kg/cm <sup>2</sup>   |
| Tensile Modulus, 2% Secant | ASTM D 882                                                           | MD: 9900*, TD: 9800* | kg/cm <sup>2</sup>   |
| Elongation at Break        | ASTM D 882                                                           | MD : 350*, TD: 530*  | %                    |
| Elmendorf Tear Strength    | ASTM D 1922                                                          | MD : 3*, TD: 135*    | g                    |
| Dart Impact Strength       | ASTM D 1709                                                          | 142*                 | g                    |

**Note:** (\*) Properties obtained from film produced on a pilot line at TPE, 12 micron, BUR 5:1, MD = Machine Direction, TD = Transverse Direction. Conversion factor for changing unit from kg/cm<sup>2</sup> to MPa is divided by 10.2



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### Processing Guidelines

The actual extrusion condition depends on type of using machine, size and film thickness of product required. Generally, melt temperature should be 180-200 °C with BUR = 3-5 times and frost line height (FLH) = 8-10 times of die diameter.

### 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 Material 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.

### 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 Material Safety Datasheet 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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### Related Documents

- The latest version of this document will be available at our website, [www.scgchemicals.com](http://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.
  - Material Safety Datasheet
  - 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.
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