



## TECHNICAL DATA SHEET

Product Type

**Polyethylene for Rotational Moulding**

Product Name

**SCG LLDPE**

Product Grade

**M735RW / M70**

### Product Description

SCG M735RW is a linear-low density polyethylene (LLDPE) for rotational moulding applications. M735RW is a natural color PE resin available in a pellet and powder form, whereas M70 is the color compound version. With a high melt flow and a balance of impact strength, stiffness, and processability, this grade is suitable for rotational moulding of lawn and garden articles, decorative items, and small industrial parts.

### Typical Applications

- Lawn and garden articles
- Decorative items
- LED lamp covers
- Small industrial parts
- Intricate automotive articles

### Product Characteristics

- High melt flow suitable for complex shape
- Superior gloss and surface finish
- Smooth inside surface
- UV8 for outdoor use
- Good rigidity and toughness

### International Compliance

- 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
- UL 94 HB (flame retardancy)
- For compliance of specific colors, please contact our technical service.

### Product Properties

Property	Test Method	Typical Value	Unit
<b>Resin Properties</b>			
Melt Flow Rate	ASTM D 1238 @ 190 °C, 2.16 kg	6.0	g/10 min
Density	ASTM D 1505	0.932	g/cm <sup>3</sup>
Melting Point	ASTM D 2117	125 (257)	°C (°F)
Crystallization Point	ASTM D 2117	113 (235)	°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)
<b>Mechanical Properties</b>			
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	21 (3100)	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	57	Shore D
ARM Impact Strength @ -40 °C	ARM Method (5.5 mm rotomoulded sample)	25 (101)	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 M735RW/RWP is about 210 °C. However, the optimum PIAT of M70 color compound may vary with a color shade.

#### Points of Concerns

- Finishing rotational parts by flaming, using scrap/filler in compound formulation, or dry blending pigment > 0.3% can decrease mechanical properties of rotational parts, which is not recommended.
- Not for cooking less than 10 min heating time.
- 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 service at the address or telephone number as specified below.

### Product Available Forms

- Natural pellet (M735RW)
- Natural powder (M735RWP)
- Color compound pellet (M70)
- Color compound powder (M70)

### 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.
- 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 horizontal.



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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 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 Safety Data Sheet for details on various aspects of safety, recovery and disposal of the products; for more information, contact your SCG Chemicals technical service.

### 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 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.
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