

PRODUCT DATA SHEET

POLYETHYLENE

BorSafe™ HE3490-ELS-H

BLACK HIGH DENSITY BIMODAL PE100 POLYETHYLENE FOR PRESSURE PIPE

DESCRIPTION

BorSafe™ HE3490-ELS-H is a black compound, bimodal, high density polyethylene PE100-RC MRS 11.2 MPa material produced using the advanced Borstar® technology enabling the production of extra thick walled and very large diameter pipes. The compound contains well dispersed carbon black which gives outstanding UV resistance and an optimized stabilization package that provides long term stability. The product complies with ISO 4427 / ISO 4437 and EN 12201 / 1555 and is listed in PE100+ as a PE100-RC+ material.

APPLICATIONS

BorSafe™ HE3490-ELS-H is recommended for pressure pipe systems used in drinking water, sewage, relining, sea outfall and industrial applications. It is especially suited for the production of thick walled and large diameter pipes.

SPECIAL FEATURES

BorSafe™ HE3490-ELS-H is a high density Hexene copolymer compound specially designed to exhibit exceptional resistance to sagging lending to the production of thick walled and large diameter pipes.

PHYSICAL PROPERTIES

Property	Typical Value*	Test Method
Density (Compound)	960kg/m ³	ISO 1183
Melt Flow Rate (190°C/5.0kg)	0.17g/10min	ISO 1133
Tensile Modulus (1mm/min)	>1000MPa	ISO 527
Tensile Strain at Break (50mm/min)	>600%	ISO 527-2
Tensile Stress at Yield (50mm/min)	>24MPa	ISO 527-2
Carbon Black Content	≥2%	ISO 6964
Carbon Black Dispersion	≤3	ISO 18553
Oxidation Induction Time (210°C)	≥20mins	ISO 11357-6
Resistance to Rapid Crack Propagation, S4 test ⁺	>10bar	ISO 13477
Accelerated Notch Pipe test (ANPT)	≥300hr	ISO 13479
Accelerated FNCT test at 90°C/4MPa (AFNCT)	≥550hr	ISO 16770
Strain Hardening Test (SH)	≥50MPa	ISO 18488
Cracked Round Bar Test (CRB)	≥ 1,5 x 10 ⁶ cycles	ISO 18489

+Pc at 0°C, test pipe 250mm SDR11

*Data should not be used for specification work

PROCESSING GUIDELINES

Pre-drying

Due to the hygroscopic nature of carbon black, this compound is sensitive to moisture. Storage for a long time or under unfavorable conditions will increase the moisture content. For normal conditions and applications we suggest preheating and drying for minimum 1 hour with a maximum preheat temperature of 90°C.

Extrusion

The actual extrusion conditions will depend on the type of equipment used. They will also depend on size and wall thickness of the pipe produced. The following conditions may be used as a guide when starting up the extruder:

Cylinder	190 – 210°C
Head	200 – 210°C
Die	200 – 210°C,
Melt temperature	200 – 220°C

Specific recommendations for processing conditions can be determined only when the application and type of equipment are known. Please contact your local Borouge representative for such particulars.

STORAGE

BorSafe™ HE3490-ELS-H should be stored in dry conditions at temperatures below 50°C and protected from UV-light. Improper storage can initiate degradation, which results in odor generation and can have negative effects on the physical properties of the product.

Expected shelf life at proper storage conditions is 2 years from the date of production.

More information on storage can be found in Safety Information Sheet (SIS) for this product.

SAFETY

The product is not classified as a hazardous preparation.

Dust and fines from the product carry a risk of dust explosion. All equipment should be properly earthed. Inhalation of dust should be avoided as it may cause irritation of the respiratory system. Small amounts of fumes are generated during processing of the product. Proper ventilation is therefore required.

Please see our Safety Information Sheet (SIS) for details on various aspects of safety, recovery and disposal of the product, for more information contact your Borouge representative.

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.

RELATED DOCUMENTS

The following related documents are available on request, and represent various aspects on the usability, safety, recovery and disposal of the product.

Recovery and disposal of Polyolefin
Information on Emissions from Processing and Fires

Safety Information Sheet, SIS
Statement on Chemicals, Regulations and Standards.

DISCLAIMER

The product(s) mentioned herein are not intended to be used for medical, pharmaceutical or healthcare applications and we do not support their use for such applications.

To the best of our knowledge, the information contained herein is accurate and reliable as of the date of publication, however we do not assume any liability whatsoever for the accuracy and completeness of such information.

Borouge makes no warranties which extend beyond the description contained herein. Nothing herein shall constitute any warranty of merchantability or fitness for a particular purpose.

It is the customer's responsibility to inspect and test our products in order to satisfy itself as to the suitability of the products for the customer's particular purpose.

The customer is responsible for the appropriate, safe and legal use, processing and handling of our products.

No liability can be accepted in respect of the use of Borouge products in conjunction with other materials. The information contained herein relates exclusively to our products when not used in conjunction with any third party materials.

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