

	Product Data Sheet	Issue Date : 01.01.10
Product Name	Futura GreenWavePET- 20 Type 302	Old Type No. 990901P2

Recommended Applications

- ▶ Dual Ovenable Trays.
- ▶ Sheets and Thermoforming applications.

Product Features

- ▶ Futura GreenWavePET-20 is a PET based resin manufactured using 20% PCRPET by chemical glycolysis.
- ▶ Futura GreenWavePET-20 has fast crystallizing characteristics both during heating and cooling cycles and contains special additive for imparting thermal stability to obtain a good balance of rigidity and dimensional stability which is crucial for meeting the cyclic temperature needs involved in deep freezing and microwave heating of food trays.
- ▶ Futura GreenWavePET-20 is manufactured under Futura's patented technology for chemical recycling employing polymer filtration below 70 micron to deliver properties as good as virgin.
- ▶ Futura GreenWavePET-20 is in full compliance with USFDA regulations and EU norms.

Properties

Characteristic	Unit	Type 302			Test Method
		A	B	C	
Intrinsic Viscosity @ 30°C	dL/g	0.85 ± 0.02	0.95 ± 0.02	1.025 ± 0.025	FPL-QP-V-20-58
b* Color	CIE Lab	0 max.	1.0 max.	2.0 max.	FPL-QP-S-20-55-Part-B-XXI
Carboxyl Number	meq/kg	25 max.	25 max.	25 max.	FPL-QP-T-20-55-Part-B-VIII
Melting Point	°C	249 ± 3	249 ± 3	249 ± 3	FPL-QP-DSC-20-55-Part-B-XVIII #
Acetaldehyde	ppm	1.0 max.	1.0 max.	1.0 max.	FPL-QP-GC-20-55-Part-B-XII
Bulk Density	g/cc	0.85 ± 0.10	0.85 ± 0.10	0.85 ± 0.10	FPL-QP-P-20-55-Part-B-XX
Wt. of 20 Chips	mg	300 ± 50	300 ± 50	300 ± 50	FPL-QP-W-20-55-Part-A-I
Moisture (when packed)	wt. %	0.25 max.	0.25 max.	0.25 max.	FPL-QP-E-20-55-Part-B-VI

Determined using DSC second heating cycle.

Processing Parameters

a) Drying Condition

Granules must be thoroughly dried before processing to limit the occurrence of hydrolytic degradation.

Drying temperature	165 ± 5 °C
Drying time	4- 5 hours
Dew point	- 40 °C
Residual moisture content	≤ 25 ppm

b) Process Temperature** (Extrusion)

Zone Temperature	280 ± 5 °C
Die Zone	280 ± 5 °C

** The values quoted above are typical numbers for benchmarking. Individual machine parameters should be determined on a case-by-case depending on the design of the product(s).

Packing

Resin can be supplied in 1000 kg PP jumbo bags with LDPE liner at 20 bags per 20 ft FCL container as required.

Contact Address

Futura Polymers,
a division of Futura Polyesters Limited,
1-A Kamarajar Salai, Manali,
Chennai, India - 600 068.

Tel : + 91 44 25941313 – 17, 25941704 – 05
Fax : + 91 44 25941615, 1054, 1566
e-mail : futurach@futura polyesters.com
Web : www.futura polyesters.com

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