

	Product Data Sheet	Issue Date : 01.01.10
Product Name	Futura ImPET - Type 412	Old Type No. 940414H1

Recommended Application

- ▶ Injection molded parts with good Impact.

Product Features

- ▶ Futura ImPET is a PET based resin containing impact modifier.
- ▶ Futura ImPET is based polyester resin manufactured by mechanical recycling.

Properties

Characteristic	Unit	Type 412	Test Method
		D9	
Intrinsic Viscosity @ 30°C	dL/g	0.70 ± 0.02	FPL-QP-V-20-58
b* Color	CIELab	6 max.	FPL-QP-S-20-55-Part-B-XXI
Carboxyl Number	meq/kg	35 max.	FPL-QP-T-20-55-Part-B-VIII
Melting Point	°C	245 ± 3	FPL-QP-DSC-20-55-Part-B-XVIII #
DEG	wt%	2.5 max.	FPL-QP-GC-20-55-Part-B-XIII
Bulk Density	g/cc	0.85 ± 0.10	FPL-QP-P-20-55-Part-B-XX
Weight of 20 Chips	mg	275 ± 50	FPL-QP-W-20-55-Part-A-I
Moisture (when packed)	wt. %	0.20 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** (Injection Molding)

Barrel Temperature	285 ± 5 °C
Mold Temperature	285 ± 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.

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