

# TECHNICAL DATA SHEET

**OVALL**  
SUSTAINABLE SOLUTIONS

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Nº REF: MN-05-CLBC

## rPET - MIX CLEAR & LIGHT BLUE C (<30%)

### Specifications :

Properties	Value	Unit	Test Method
Color and odor	Clear and odorless	-	Visual Inspection
Delta b (after roast test)	< 4.0	-	Spectrophotometer
pH	6 - 8	-	pH meter
Bulk Density	250 - 400	g/L	Measuring Cylinder
Flakes Size ( $\leq 12.5$ mm)	$\geq 99.90$	%	Visual Inspection
Fines (< 1 mm)	< 1	%	Visual Inspection
Moisture	< 1	%	Moisture Analyzer
Melting Point	$250 \pm 10$	°C	DSC
Metal	< 50	ppm	Flake Scan
Wood, Paper, Cellulose	< 20	ppm	Flake Scan
Polyolefin	< 50	ppm	Flake Scan
PVC	< 50	ppm	Flake Scan
Other contamination	< 10	ppm	Flake Scan
Flakes with Glue	< 4.000	ppm	Visual Inspection
Yellow flakes	< 4.000	ppm	Visual Inspection
Silicone, rubber content	< 20	ppm	Flake Scan
Flakes Colored (Except Light Blue or Clear)	< 1.000	ppm	Flake Scan
Flakes Light Blue	< 30	%	Visual Inspection



# TECHNICAL DATA SHEET

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Nº REF: LB-04-CLBB

rPET -  
MIX  
CLEAR  
& LIGHT  
BLUE B  
(70/30)

## rPET- MIX CLEAR & LIGHT BLUE B (70/30)

### General Information

Material type:	Recycled PET
Color:	Mix of Clear and Light Blue (70% Clear and 30% Light Blue)
Source:	100% post-consumer plastic With at least over 95% from beverage bottles
Process:	Hotwash flake with optical bottle and flake sorter
Form:	Flake
Application:	Sheet, food grade bottles
Packaging:	PP Big Bag. Size: 500 kg /1.000 kg

### Physical parameters

Parameter	Value	Unit	Test Standard
Intrinsic Viscosity	0.74 ± 0.04	dl/g	ASTM D1238
Melting Temperature	249 ± 2	°C	ASTM D-3418
Bulk Density	300 ± 50	kg/m <sup>3</sup>	ISO 12418-2
Flake Size	<12	mm	
Bulk Moisture	<1	%	ASTM D6980-17
L	>62		ASTM-D6290-19
a	-1 ± 2		ASTM-D6290-19
b	-3 ± 3		ASTM-D6290-19
Washing Quality	Pass		Oven test

### Purity parameters

Parameter	Value	Unit	Test Standard
PVC	<30	ppm	ISO 12418
Non-PET Polymers	<20	PPm	ISO 12418
PH	7.5		-
Dust and Fines (<1mm)	1	%	Screen
Flakes with Glue	<4000	ppm	-
Yellow and Aged Flakes (after bake)	<3000	PPm	100g/220 °C/60mins
PA	<50	PPm	ISO 12418
HDPE/PP	<20	ppm	ISO 12418
Wood, Paper, Cellulose	<20	PPm	ISO 12418
Silicone, Ruber	<20	PPm	ISO 12418
Light Blue Flake	70:30 ± 5	%	Visual Observation
Metal	<20	ppm	ISO 12418-2



# TECHNICAL DATA SHEET

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Nº REF: PL-03-CLBA

## rPET - MIX CLEAR & LIGHT BLUE A (80/20)

rPET -  
MIX  
CLEAR  
& LIGHT  
BLUE A  
(80/20)

Tall Bag Packaging	1.000 / 1.100 kg
Short Bag Packaging	500 / 600 kg
HS Code	39076090

### Product Specification :

Physical Properties	Value		Unit	Test Method
	Min	Max		
Moisture Content (MC)	0.0	1.0	%	Moisture Analyzer
Intrinsic Viscosity (IV)	0.68	0.76	dl/g	ASTM D 4603
Bulk Density	20	-	Lbs/ft <sup>3</sup>	ISO 12418-2
	320	-	Kg/m <sup>3</sup>	
Size	10	12	mm	Internal measure
Fines < 2mm	0	5	%	Sieve shaker analysis
pH	7	8	pH	Internal measure
Melting Point	245	255	°C	ASTM D 3418
PVC	0	30	ppm	ISO 12418-2
Glue/ Adhesive	0	10	ppm	
Impurities (Wood, Paper, Rubber)	0	10	ppm	Manual Sorting
Polyolefin (PE, PP)	0	10	ppm	
Yellowish PET	0	100	ppm	
Metal Content	0	5	ppm	Metal separator
Comp; - Clear Flakes LB Flakes	60	80	%	Visual test
	40	20	%	
ColorTest				
L*	67	73	-	Colorimeter Hunterlab
a*	-2	2	-	
b*	0	6	-	
dE*	45	51	-	

