

	Product Data Sheet	Issue Date : 01.01.10
Product Name	Futura ClearPET – Type 101	Old Type No. 940400

Recommended Applications

- ▶ Aqua and Carbonated Soft Drink (CSD) Bottles.
- ▶ Sheets for Thermoforming / Vacuum forming.

Product Features

- ▶ Futura ClearPET is a PET based copolymer resin having IPA as comonomer without fast reheat additives.
- ▶ Futura ClearPET resin provides a good balance of clarity, rigidity to the preform and bottle.
- ▶ Futura ClearPET is in full compliance with USFDA regulations, EU and HBB Canada norms.
- ▶ Recyclable under SPI code no.1.

Properties

Characteristic	Unit	Type 101			Test Method
		A	B	C	
Intrinsic Viscosity @ 30°C	dL/g	0.76 ± 0.02	0.80 ± 0.02	0.84 ± 0.02	FPL-QP-V-20-58
b* Color	CIE Lab	-2 ± 1	-2 ± 1	-2 ± 1	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	246 ± 2	246 ± 2	246 ± 2	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
Weight 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** (Injection Stretch Blow Molding)

Barrel Temperature	285 ± 5 °C
Mold Temperature	285 ± 5 °C
Preform Temperature	110 ± 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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