

	Product Data Sheet	Issue Date : 01.01.10
Product Name	Futura WorldPET – Type 413	Old Type No.

Recommended Application

- ▶ Injection Molding components.

Product Features

- ▶ Futura WorldPET is a PET based copolyester resin.
- ▶ Futura WorldPET is manufactured using 100% PCRPET by mechanical recycling.
- ▶ Completely recyclable under SPI code no.1

Properties

Characteristic	Unit	Type 413	Test Method
		D9	
Intrinsic Viscosity @ 30°C	dL/g	0.72 ± 0.02	FPL-QP-V-20-58
b* Color	CIE Lab	3 max.	FPL-QP-S-20-55-Part-B-XXI
Carboxyl Number	meq/kg	40 max.	FPL-QP-T-20-55-Part-B-VIII
Melting Point	°C	249 ± 2	FPL-QP-DSC-20-55-Part-B-XVIII #
Bulk Density	g/cc	0.85 ± 0.10	FPL-QP-P-20-55-Part-B-XX
Weight of 20 Chips	mg	300 ± 50	FPL-QP-W-20-55-Part-A-I
Moisture (when packed)	wt. %	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 Molding & Stretch Blow 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.

Contact Address :

Futura Polymers,
a div. 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

All products are under continual improvement. Rights are reserved to modify product/process without prior notice subject to performance criteria as per product data sheet