

| <b>Technical Data Sheet</b>   |                           |             |   |
|---|---------------------------|-------------|---|
| <b>Clear rPET Flakes</b><br>Product Code 10-10-100  |                           |             |   |
| <b>Property</b>   | <b>Value</b>              | <b>Unit</b> | <b>Inspection method</b>                              |
| Origin of recycled PET  | post-consumer PET bottles | -           |   |
| Bulk density  | 300 - 450                 | g / L       | 1l uncompressed                                       |
| Fines content < 0.5mm   | < 0.1                     | %           | sieving 10min with 2.5 mm amplitude & 20 sec interval |
| Oversize flakes content > 10mm  | < 0.5                     | %           |   |
| Content of colored flakes   | < 1,000                   | ppm         | Sorting (visual)                                      |
| Content of light blue flakes  | < 4                       | %           | Sorting (visual)                                      |
| Intrinsic Viscosity IV  | 0.68 - 0.78               | dl/g        | Internal  |
| Moisture  | < 1                       | %           | 20 min at 160°C                                       |
| <b>Impurities</b>   |                           |             |   |
| - Polyvinyl Chloride  | < 100                     | ppm         | 30 min at 230°C                                       |
| - Polyolefins   | < 30                      | ppm         | 30 min at 230°C                                       |
| - Paper   | 0                         | ppm         | Sorting (visual)                                      |
| - Metals  | < 50                      | ppm         | Sorting (visual)                                      |
| - Flakes with glue residue  | < 1,000                   | ppm         | 30 min at 230°C                                       |
| Established by: KD      Date: 06.09.2013      Release: 5  |                           |             |   |
| Approved by: GK      Date: 12.09.2013   |                           |             |   |
| Authorized by: GK      Date: 12.09.2013   |                           |             |   |
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