

Type: **CumaFlex i90 (preliminary)**

Date: 20-12-2017

Product description

CumaFlex i90 is an impact modified medium viscous PET (Poly Ethylene Terephthalate) grade, with a high post-consumer recycled content. The material is supplied as crystallized pellets. This grade is especially developed for applications which require excellent mechanical properties.

Note: the given specifications are estimates of the final product specifications.

| Characteristics | Unit | Specification | Test Method |
|--|-------------|---------------|---------------------------|
| MVR @ 285°C/2.16 kg | (cc/10 min) | 28.0 ± 8.0 | DRM 1.02 (Melt viscosity) |
| Melting Temperature (T _m) | °C | 248 ± 3 | DRM 2.02 (DSC) |
| Glass Transition Temperature (T _g) | °C | 76 ± 3 | DRM 2.02 (DSC) |
| b* Color | - | -0.5 ± 3.0 | DRM 3.02 (Minolta CM-5) |

Packaging

Our standard packaging is bigbags, other packaging can be discussed. Further information is available upon request.

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Processing guidelines

| | |
|-----------------------------|---|
| Drying | Due to the fact that PET is a polycondensation polymer it is sensitive to degradation by moisture during processing. Therefore, it is essential to reduce the moisture level to below 0.005% (50ppm) prior to melting. This will reduce degradation to a minimum and eliminate fluctuations during processing. |
| Favorable drying conditions | Drying with a desiccant dryer using air with a dew point of below -30°C with a residence time of 10 to 12 hours at a temperature of max. 130°C will enable you to reach the required moisture level. To prevent moisture pick-up during transport to the extruder, dry air or nitrogen should be used for conveying the material. In case the extruder hopper is not moisture tight, it should be flushed with dry air or nitrogen. |
| Processing | The processing temperature settings can differ per machine characteristics and/or application requirements. The temperature can vary between 270°C and 300°C when combined with PET. |



This version replaces all previous product specific data sheets

Processing conditions should be considered as guidelines only and may vary with the type of equipment used, as well as with throughput. This information reflects our best knowledge at the time of issue. The typical properties as well as the recommendations are guidelines only. No liability can be assumed in connection with the usage of our products or information, including possible limitations because of patents.