

RAMAPET® R1

Polyethylene Terephthalate

Indorama Ventures PCL

Message:

RAMAPET R1 is a high intrinsic viscosity food grade PET copolymer specially designed for the CSD container market. It offers enhanced reheat ability that improves machine efficiency during blow molding.

General Information	
Features	Copolymer
	Food Contact Acceptable
	High Viscosity
Uses	Containers
Agency Ratings	EC 1935/2004
	EU 2002/72/EC
	EU 2004/1/EC
	EU 2004/19/EC
	EU 2005/79/EC
	EU 2007/19/EC
	EU 2008/39/EC
	EU 2023/2006
	EU 975/2009/EC
	FDA 21 CFR 174.5
	FDA 21 CFR 177.1630

Physical	Nominal Value	Unit	Test Method
Density	1.39 to 1.40	g/cm ³	ASTM D1505
Apparent Density			ASTM D1895
Poured	0.83	g/cm ³	
Vibrated	0.88	g/cm ³	
Acetaldehyde ¹	< 1.0	ppm	
Color a ²	-2.50 to -0.800		
Color b ³	-3.00 to 1.00		
Color L ⁴	77.5 to 82.5		
Crystallinity ⁵	> 50	%	
Intrinsic Viscosity ⁶	0.82 to 0.86	dl/g	
Moisture Content - When Packed ⁷	< 0.20	wt%	
Heat of Fusion	56.0	kJ/kg	ASTM E793
Chips/Gram ⁸	55.0 to 65.0	pieces	
Fines	< 0.1	wt%	

Pellet Shape	Cubical		
Pellet Size	2.50	mm	
Thermal	Nominal Value	Unit	Test Method
Glass Transition Temperature	76.0 to 80.0	°C	ASTM D3418
Melting Temperature			
--	245 to 249	°C	DSC
--	240 to 250	°C	ASTM D3418
Fill Analysis	Nominal Value	Unit	Test Method
Melt Density (285°C)	1.20	g/cm ³	ASTM D1238
Injection	Nominal Value	Unit	
Drying Temperature	150 to 170	°C	
Drying Time	6.0	hr	
NOTE			
1.	Gas Chromatograph		
2.	CIE Lab		
3.	CIE Lab		
4.	CIE Lab		
5.	Density Gradient Column		
6.	Ubbelohde Viscometer		
7.	Gravimetric Method		
8.	Weighment Method		

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