

RAMAPET® N180

Polyethylene Terephthalate

Indorama Ventures PCL

Message:

RAMAPET N180 is a general purpose, non-reheat PET resin for bottles, film, thermoformed containers and other transparent applications. It has good optical properties, the mechanical properties are representative for a PET resin with IV of 0.80. RAMAPET thermoplastic polyesters are condensation polymers produced by a continuous melt-phase polymerization process followed by a solid-state polymerization process.

General Information	
Features	Food Contact Acceptable
	General Purpose
	Opticals
Uses	Bottles
	Containers
	Food Packaging
	General Purpose
	Household Goods
	Medical/Healthcare Applications
	Pharmaceuticals
	Sheet
	Thermoformed Containers
Agency Ratings	EC 1935/2004
	EU 10/2011
	EU 2023/2006
	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	< 1.0	ppm	
Color a	-3.80 to -0.800		
Color b	-3.50 to 1.00		
Color L	> 78.0		
Crystallinity	45 to 55	%	
Intrinsic Viscosity	0.78 to 0.82	dl/g	
Moisture Content	< 0.30	wt%	

Heat of Fusion	56.0	kJ/kg	ASTM E793
Fines	< 0.1	wt%	
Pellet Shape	Cubical		
Pellet Size	2.50	mm	
Pellet Weight	55.0 to 65.0	pcs/g	
Thermal	Nominal Value	Unit	Test Method
Glass Transition Temperature	76.0 to 80.0	°C	ASTM D1238
Peak Melting Temperature	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	

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