



**4PET<sup>®</sup>** is the registered trade mark for Polyethylene Terephthalate (PET) compounds produced by 4PLAS.

### PROCESSING

For PET compounds, moisture content should be less than 0.02% before processing. Moisture causes immediate hydrolytic degradation during processing which causes molecular weight reduction and thus a reduction in process stability & product performance. Therefore **4PET<sup>®</sup>** grades should be dried at 120°C to 140°C for 4 hours in dehumidified dryers.

**4PET<sup>®</sup>** compounds can be processed on all commercial injection moulding machinery. Guide recommendations for processing parameters are detailed below:

Detailed processing conditions specific for each type of product are available upon request.

### RECYCLING

Regrind levels up to 25% can be used depending on the application and requirements. However, for flame retardant grades a maximum 10% addition rate is recommended. Regrind should be clean and free of contamination, should not be thermally degraded and must be dried prior to reuse.

### SAFETY

Under normal conditions **4PET<sup>®</sup>** is not a toxic and hazardous material. During processing preventive action should be taken to avoid direct contact with the polymer melt or the inhalation of any gases produced. Processing temperatures above 320°C should be avoided. Detailed safety information can be found in our material safety data sheets (MSDS).

	Processing Temperature (°C)	Mould Temperature (°C)	Hold Pressure (MPa)	Back Pressure
<b>4PET<sup>®</sup></b> PT (PET)	270 - 290	100 - 140	60 - 100	Low