



**Standard Specifications of Polyester Chips  
(Bottle Grade APE 84 – Prime)**

| S/N | Test  | Method                  | Unit    | Specification |
|-----|---|-------------------------|---------|---------------|
| 1   | I.V.—Phenol : 1,1,2,2, TCE (60:40 W/W) @<br>25.0 °C | ASTM D - 4603           | dl/ gm  | 0.840 ± 0.02  |
| 2   | Carboxyl End groups                                 | Titration Method        | Meq /Kg | 35 Max        |
| 3   | ASH   | Gravimetric Method      | ppm     | 280 Max       |
| 4   | Melting Point                                       | By DSC                  | °C      | 247 ± 2       |
| 5   | DEG   | By Gas Chromatograph    | %       | 1.40 ± 0.20   |
| 6   | Moisture  | KF Coulometer           | %       | < 0.10        |
| 7   | Chips / gm  | Number per Gram         | No.     | 55 - 60       |
| 8   | Colour Value (CIE Lab)<br>L*                        | CIE Lab D65/10°         | %       | 80.0 Min      |
|     | Colour Value (CIE Lab)<br>b*                        | CIE Lab D65/10°         | %       | 1.5 Max       |
| 9   | Acetaldehyde Content                                | By Gas Chromatograph    | ppm     | < 1.00        |
| 10  | Crystallinity                                       | Density Gradient Column | %       | 55 Max        |