



**SLOVENSKI STANDARD**  
**kSIST FprEN 15348:2014**

**01-september-2014**

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**Polimerni materiali - Reciklirani polimerni materiali - Karakterizacija reciklatov polietilen-tereftalata (PET)**

Plastics - Recycled plastics - Characterisation of poly(ethylene terephthalate) (PET) recyclates

Kunststoffe - Kunststoff-Rezyklate - Charakterisierung von Polyethylenterephthalat (PET) -Rezyklaten

Plastiques - Plastiques recyclés - Caractérisation des recyclats de poly(éthylène téréphthalate) (PET)

**Ta slovenski standard je istoveten z: FprEN 15348**

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**ICS:**

13.030.50	Recikliranje	Recycling
83.080.20	Plastomeri	Thermoplastic materials

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EUROPEAN STANDARD  
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**FINAL DRAFT**  
**FprEN 15348**

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ICS 13.030.50; 83.080.20

Will supersede EN 15348:2007

English Version

## Plastics - Recycled plastics - Characterisation of poly(ethylene terephthalate) (PET) recyclates

Plastiques - Plastiques recyclés - Caractérisation des recyclats de poly(éthylène téréphtalate) (PET)

Kunststoffe - Kunststoff-Rezyklate - Charakterisierung von Polyethylenterephthalat (PET)-Rezyklaten

This draft European Standard is submitted to CEN members for formal vote. It has been drawn up by the Technical Committee CEN/TC 249.

If this draft becomes a European Standard, CEN members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for giving this European Standard the status of a national standard without any alteration.

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Recipients of this draft are invited to submit, with their comments, notification of any relevant patent rights of which they are aware and to provide supporting documentation.

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EUROPEAN COMMITTEE FOR STANDARDIZATION  
COMITÉ EUROPÉEN DE NORMALISATION  
EUROPÄISCHES KOMITEE FÜR NORMUNG

**CEN-CENELEC Management Centre: Avenue Marnix 17, B-1000 Brussels**

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## Foreword

This document (FprEN 15348:2014) has been prepared by Technical Committee CEN/TC 249 "Plastics", the secretariat of which is held by NBN.

This document is currently submitted to the Formal Vote.

This document will supersede EN 15348:2007.

FprEN 15348:2014 includes the following significant technical changes with respect to EN 15348:2007:

- a) the deletion of former informative Annex B and replacement by a reference to EN ISO 1133-2 in Table 1;
- b) the use of a porcelain crucible instead of a crucible of platinum in B.5.

This European Standard is one part of a series of CEN publications on Plastics Recycling which is structured as follows:

- EN 15342, *Plastics — Recycled Plastics — Characterization of polystyrene (PS) recyclates*
- EN 15343, *Plastics — Recycled Plastics — Plastics recycling traceability and assessment of conformity and recycled content*
- EN 15344, *Plastics — Recycled Plastics — Characterization of Polyethylene (PE) recyclates*
- EN 15345, *Plastics — Recycled Plastics — Characterization of Polypropylene (PP) recyclates*
- EN 15346, *Plastics — Recycled plastics — Characterization of poly(vinyl chloride) (PVC) recyclates*
- EN 15347, *Plastics — Recycled Plastics — Characterization of plastics wastes*
- EN 15348, *Plastics — Recycled plastics — Characterization of poly(ethylene terephthalate) (PET) recyclates*
- CEN/TR 15353, *Plastics — Recycled plastics — Guidelines for the development of standards for recycled plastics*

## Introduction

Recycling of plastics waste is one type of material recovery process intended to save resources (virgin raw materials, water, and energy), while minimizing harmful emissions into air, water and soil as well as any impacts on human health. The environmental impact of recycling has to be assessed over the whole life cycle of the recycling system (from the waste generation point to the disposal of final residues). To ensure that recycling constitutes the best environmental option for treating the available waste, some prerequisites should preferably be met:

- recycling scheme being contemplated should generate lower environmental impacts than alternative recovery options;
- existing or potential market outlets should be identified that will secure a sustainable industrial recycling operation;
- collection and sorting schemes should be properly designed to deliver recyclable plastics waste fractions fitting reasonably well with the available recycling technologies and with the (changing) needs of the identified market outlets, preferably at minimum costs to society.

This European Standard has been produced in accordance with the guidance produced by CEN on Environmental Aspects and in accordance with CEN/TR 15353.

NOTE CEN/TR 15353 considers the general environmental aspects which are specific to the recycling process.

It is often impossible to trace back each individual product at the end user stage and to check whether the product has been used correctly through its life. Consequently products are out of industrial control for a period of time. It is possible that during this period contamination with other materials might occur that could affect the product's suitability for recycling into the intended application.

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## 1 Scope

This European Standard defines a method of specifying delivery conditions for poly(ethylene terephthalate) (PET) recyclates.

It gives the most important characteristics and associated test methods for assessing PET recyclates intended to be used for the production of semi-finished/finished products. It is intended for use by the supplier and purchaser of such materials, to assist them in agreeing on specifications.

This European Standard is applicable without prejudice to any existing legislation.

## 2 Normative references

The following documents, in whole or in part, are normatively referenced in this document and are indispensable for its application. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

CEN/TR 15353, *Plastics — Recycled plastics — Guidelines for the development of standards for recycled plastics*

EN ISO 472, *Plastics — Vocabulary (ISO 472)*

EN ISO 1133-2, *Plastics — Determination of the melt mass-flow rate (MFR) and melt volume-flow rate (MVR) of thermoplastics — Part 2: Method for materials sensitive to time-temperature history and/or moisture (ISO 1133-2)*

EN ISO 11664-4, *Colorimetry — Part 4: CIE 1976 L\*a\*b\* Colour space (ISO 11664-4)*

EN ISO 15512, *Plastics — Determination of water content (ISO 15512)*

ISO 565, *Test sieves — Metal wire cloth, perforated metal plate and electroformed sheet — Nominal sizes of openings*

ISO 1628-5, *Plastics — Determination of the viscosity of polymers in dilute solution using capillary viscometers — Part 5: Thermoplastic polyester (TP) homopolymers and copolymers*

ISO 3534-2, *Statistics — Vocabulary and symbols — Part 2: Applied statistics*

## 3 Terms and definitions

For the purposes of this document, the terms and definitions given in EN ISO 472 and CEN/TR 15353 and the following apply.

### 3.1

#### **sieve retention**

percentage-of the recycled test sample retained on a sieve at the end of the test

Note 1 to entry: The sieve retention is expressed in Per cent (mass fraction).

### 3.2

#### **container retention**

percentage of recycled matter retained in the container at the bottom of a stack of sieves, or under a single sieve, at the end of the test compared to the mass of the sample

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## 3.3

**average particulate dimension**

single value of size, representing the dominant particle size for the whole test sample

## 4 Characterization of PET recyclates

A single batch is the quantity of recyclate that has homogenous characteristics within the specified tolerances.

The characteristics of PET recyclates, which shall be met for every batch (see ISO 3534-2) of PET recyclate are shown in Table 1, and are divided into two types:

- required characteristics needed to characterize PET recyclates in general and required for all recyclates;
- optional characteristics needed to characterize PET recyclates according to customer specifications and applications.

These characteristics shall be assessed by using the test methods given in Table 1 and detailed below.

A Certificate of Analysis, providing the test results for each batch of recyclate shall be provided by the supplier to the purchaser upon request.

To secure the legal use of the recyclate, the supplier shall provide the necessary information about the material composition of the recyclates, as specified by the purchaser.

**Table 1 — Characterization of PET recyclates**

Characteristics	Unit	Test method	Comments
<b>Required</b>			
Shape		Visual	Flakes, pellets
Maximum particle size	mm		Given by the size of the screen of the grinder
Fine particle content	%	Annex A	Value in percentage of the particles passing the sieve of 1 mm.
Colour		Visual inspection	Unicolour, transparent, mixed
Water content	%	Annex B or EN ISO 15512	
PVC content	mg/kg	Annex C	
Polyolefin content	mg/kg	Annex C	
<b>Optional</b>			
Determination Melt Mass-Flow Rate (MFR)		EN ISO 1133-2	
Intrinsic viscosity (I.V.)	dl/g	ISO 1628-5	
Alkalinity	pH	Annex D	
Filterability	100 bar/h/cm <sup>2</sup>	Annex E	
Other residual content	mg/kg		Analysis according to the appropriate method e.g. FTIR, XRF, DSC...



Colour	L,a,b values	Colourimeter according to EN ISO 11664-4	Injection molded disks from Flakes, pellets
Other tests may be carried out by agreement between the purchaser and the supplier and results reported.			

## 5 Quality assurance

In order that the purchaser of the recyclate can have confidence in the quality of the product, the supplier shall maintain records of the quality control carried out, including incoming materials, processes and finished products.

NOTE A quality management system certified to EN ISO 9001 may be a suitable guarantee of consistent recyclate quality but not the recycled content.

The specification and the standard deviation or range of values within and between batches of material shall be agreed between the supplier and the purchaser.

Where a statement of recycled content, or the previous history of the material, is requested, documentary evidence shall be provided. These records should be available to the purchaser on request.

Where a recyclate has been produced via a melt process, the supplier may choose to state the level of filtration applied during that process. This will determine the maximum size of any non-melting contaminants present in the recyclate. The statement of filtration level shall include details of the filter. Recyclates that have not passed through a melt process cannot be quantified in the same way, and the supplier may state this.

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## Annex A (normative)

### Determination of size and distribution of PET-R flakes by sieving

#### A.1 General

This procedure specifies a method for determining the dimensional distribution (size) of PET-R flakes by measuring the quantities retained in a range of sieves having meshes of various sizes.

The results are to be expressed in terms of quantity retained on the various sieves or as the mean particulate dimension for the whole sample tested (That which has the greatest frequency).

#### A.2 Principles

A determined sample is filtered through a single sieve, or stack of sieves of various mesh opening sizes, helped by mechanical or manual vibrations. When several sieves are selected to form a stack, the sieves are assembled in ascending order of the mesh opening sizes so that the largest mesh opening is at the top.

#### A.3 Apparatus

**A.3.1 Weighing scale:** With a precision of  $\pm 0,1$  g.

**A.3.2 Sieve:** The nominal diameter of 200 mm, in accordance with ISO 565 supplemented by a lid and by a receiving container. Sieves are made of ring wire.

The sieves used have the following square mesh opening sizes of: 1 mm; 2 mm; 3,15 mm; 4 mm; 6,30 mm; 8 mm and 12,5 mm.

**A.3.3 Mechanical sieve shaker**

#### A.4 Procedure

**A.4.1** Examine the sieve, or the sieves, for the damage to the mesh or any deformation of the matrix of the meshes. Replace all defective meshes.

**A.4.2** Weigh the sieve, or each individual sieve, with a margin of 0,1 g.

**A.4.3** Weigh the container to the nearest 0,1 g.

**A.4.4** Assemble the sieve, or the sieves, and the container, one on top of the other. By assembling a stack of sieves, you ensure that they are gathered in the ascending order of the mesh opening sizes so that the largest opening is at the top.

**A.4.5** Weigh 100 g to 300 g with an accuracy of  $\pm 0,1$  g of flakes sample to be tested.

**A.4.6** Transfer the sample to the uncovered sieve, by avoiding overflow.