

CHI-C8-PPF-0

Basic Recycling Application Compatibility Test for PP-based Flex. Packaging

Version 3.0

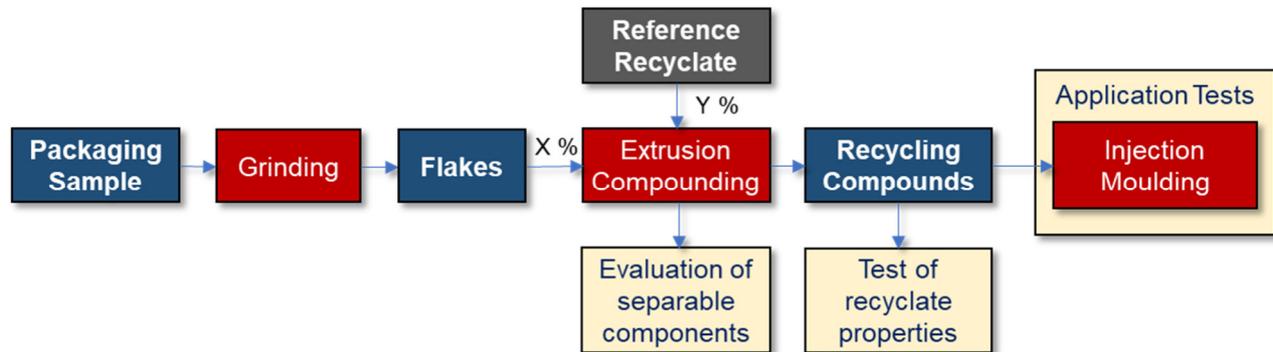
This CHI test method was developed by cyclos-HTP for PP-based flexible packaging and includes the following steps (Principle of the test method is shown in the flow chart on page 2):

1. **Materials** to be provided:
 - a. Flexible PP-based packaging/material structure containing a component with an unknown or suspect recycling compatibility, „PCK-S0“
 - b. Optional, reference packaging made of the same base PP grades, „PCK-R0“
 - c. Commercial recycle commonly used for the same target application in the recycling path („REF“)
2. **Grinding** of the respective samples to flakes on a granulator with a 10 mm sieve
3. **Extrusion/compounding** of materials combinations on a lab-scale extruder with mono or double screw to form various recycling compounds; melt temperature 220-240°C:
 - (A) **“CHI100”**: 100% PCK-S0
 - Optional:*
 - (B) **“PP100”**: 100% PCK-R0
4. **Melt Screen** (filter with 200 µm pore size) can be used to separate heterogeneous components and to examine them qualitatively. The quantitative assessment of inhomogeneity is performed by documenting the melt pressure increase within 30 minutes after start of extrusion. Where indicated, the filtrate can be qualitatively examined to assign it to a component in the starting material.
 - a. **Characterisation** of recycling compounds: Thermally (DSC), viscosity (MFR); density
5. **Test specimens for Injection moulding** are prepared from recycling blends (+ reference REF) according to DIN EN ISO 3167
 - a. **Characterisation** of test specimens: Morphologically (microscopy) and mechanically by tensile testing (DIN EN ISO 527) and Notched bar impact testing (DIN EN ISO 179).
6. **Evaluation** of all test results is carried out according to the following criteria, whereby the evaluation refers to the tested applications. The results of the samples CHI100 is compared with REF. Optional the samples PP100 and CHI100 are also compared.

An evaluation for the application in injection moulding is made in the following order:

 - a) A significant, negative deviation of the relevant test results between **CHI100** and **REF** leads to a classification of the assessed packaging structure as "not compatible for recycling" (CAT3 according to the CHI assessment and requirement catalogue). By demand a further testing is necessary according to the CHI standard method [CHI-C8-PPF-1](#).
 - b) If the relevant results between **CHI100** and **REF** are in a comparable range or CHI100 is even better, the assessed packaging structure can be stated as "recycling compatible" and - under suitable conditions - "valuable material"
 - c) In case of negative results of CHI100 in comparison to REF, an optional comparison of samples **CHI100** and **PP100** is used to prove whether the deviation originates from the PP base material in the sample or if the suspect component under investigation has a limited recyclability.

Principle of the test method:



Overview of test samples and evaluation parameters:

	Trial #	REF	CHI100	PP100
<i>Recyclate blends</i>	PCK-S0 (sample with suspect material)	0%	100%	0%
	REF (reference PCR recyclate)	100%	0%	0%
	PCK-R0 (reference packaging sample)	0%	0%	100%
<i>Recyclate blends characterisation</i>	DSC Tm peak [°C]			
	Fraction with low melting points (e.g. evaluation of PE contents)			
	Density [g/cm ³]			
	MFR (230°C/2.16kg) [g/10min]			
<i>Injection moulding application mechanical testing</i>	Tensile Modulus (E _t) [Mpa]			
	Tensile Strength (σ _m) [Mpa]			
	Tensile Stress at Yield (σ _y) [Mpa]			
	Elongation at Yield (ε _y) [%]			
	Charpy Impact strength (acU) [kJ/m ²]			

Version history:

Version No.	Date	Reason/Content of revision
1.0	Oct 2019	First version of test method
2.0	Mar 2020	Updated test program and parameters
3.0	Sep 2021	Updated evaluation criteria; improved scheme