

Contents

Preface — VII

Acknowledgements — IX

1	Introduction to polyethylene terephthalate recycling — 1
	References — 12
2	Overview of the world market for recycled polyethylene terephthalate — 15
2.1	Introduction — 15
2.2	Overview of the general plastics market and recycling markets — 16
2.2.1	Situation in the UK — 16
2.2.2	Situation in Europe — 21
2.2.3	Global situation — 24
2.3	Overview of the market for recycled polyethylene terephthalate — 26
2.3.1	Situation in Europe — 27
2.3.2	Global situation — 30
	References — 35
3	Brief history of the recycling of polyethylene terephthalate — 37
3.1	Introduction — 37
3.2	Situation in Europe — 38
3.3	Situation in the US and other parts of the world — 42
3.4	Use of recycled polyethylene terephthalate in food contact products — 44
3.5	Impact of bioplastics and oxobiodegradable additives — 46
3.6	The future — 50
	References — 51
4	Regulations and guidance documents from the european union and US food and drug administration — 53
4.1	Introduction — 53
4.1.1	General compositional requirements — 54
4.1.2	Tests to show compliance with migration and specific compositional requirements — 54
4.1.3	Good manufacturing practice — 54
4.2	Regulations and guidelines set by the European Union — 55
4.2.1	Introduction — 55

4.2.2	European Union regulations and policies for recycling —	56
4.2.3	Regulations that cover food contact materials set by the European Union —	57
4.2.3.1	Framework Regulation (EC) 1935/2004 —	58
4.2.3.2	The good manufacturing Practice Regulation (EC) 2023/2006 —	58
4.2.4	Regulations set by the European Union that apply to plastics —	59
4.2.4.1	European Union plastics regulation (EU) 10/2011 —	59
4.2.4.2	European Union recycled Plastics Regulation (EC) 282/2008 —	62
4.2.5	National regulations for food contact in the European Union —	63
4.2.6	Guidance documents for recycling food contact plastics in the European Union —	63
4.3	US regulations and guidelines —	66
4.3.1	Introduction —	66
4.3.2	Recycling regulations in the US —	67
4.3.3	Food contact regulations in the US —	68
4.3.4	Guidance documents for recycling food-grade plastics in the US —	70
	References —	72
5	Separation and sorting technologies —	75
5.1	Introduction —	75
5.2	Sorting and separation technologies for plastics —	79
5.2.1	Spectroscopic separation technologies —	79
5.2.2	Other types of sorting technologies —	81
5.2.2.1	Density-based techniques —	81
5.2.2.2	Electrostatic separation —	84
5.2.3	Removal of non-plastics from the recycling stream —	84
5.3	Separation of black and highly coloured plastic —	86
5.3.1	Introduction —	86
5.3.2	Developments in spectroscopic systems —	89
5.3.2.1	Mid-infrared spectroscopy —	90
5.3.2.2	Raman spectroscopy —	90
5.3.2.3	Laser-induced breakdown spectroscopy/laser- induced plasma spectroscopy —	91
5.3.2.4	Photoacoustic spectroscopy —	91
5.3.3	Novel black pigments that are near-infrared detectable —	92
5.3.4	Physical techniques that do not involve spectroscopy-based methods —	94
5.3.4.1	Triboelectric charging —	94
5.3.4.2	Tack separation —	94
5.3.5	Use of marker compounds —	95
5.3.5.1	Fluorescent additives —	95

5.3.5.2	Taggants — 95
5.3.5.3	Radio-frequency identification — 95
5.4	Other developments in detection and sorting systems — 96
	References — 97
6	Recycling technologies for polyethylene terephthalate — 101
6.1	Introduction — 101
6.2	Mechanical recycling processes — 103
6.3	Chemical recycling processes — 107
6.4	Removal of contamination from post-consumer polyethylene terephthalate — 112
6.4.1	Washing of polyethylene terephthalate — 113
6.4.2	Melt filtration — 114
6.5	Quality control of recycling processes — 115
6.5.1	Quality control of low-molecular weight contaminants — 116
6.5.2	Quality control of the recycled polyethylene terephthalate in the melt-state — 116
	References — 118
7	Testing and characterisation of recycled polyethylene terephthalate products — 121
7.1	Introduction — 121
7.2	General standards and characterisation tests for recycled materials and products — 121
7.3	Tests to characterise and assess the quality of recycled polyethylene terephthalate — 124
7.4	Tests on recycled polyethylene terephthalate material and products intended for food contact applications — 127
7.4.1	Decontamination of post-consumer polyethylene terephthalate by the recycling process — 127
7.4.2	Existing quality standards and test methods for food contact materials — 128
7.5	Contaminants and potential migrants in recycled polyethylene terephthalate — 128
7.5.1	Heavy metals — 128
7.5.2	Substances formed due to the decomposition of polyethylene terephthalate — 130
7.5.3	Substances absorbed by polyethylene terephthalate during use — 131
7.5.3.1	Flavour compounds and other species from foodstuffs — 131
7.5.3.2	Substances present as a result of the misuse of polyethylene terephthalate products — 131

7.5.4	Substances picked up by the polyethylene terephthalate during recycling operations —	131
7.5.5	General studies —	132
7.5.6	Migration studies —	133
7.5.7	Influence of contaminants on ageing of polyethylene terephthalate —	135
7.5.8	Summary of the contaminants detected in polyethylene terephthalate —	136
7.6	Development of new analytical methods for determining contaminants in recycled polyethylene terephthalate —	137
7.6.1	FSA research project FS241007 analytical method —	137
7.6.2	SuperCleanQ EU FP7 project analytical methods —	142
7.6.2.1	Method for determining contaminants in recycled polyethylene terephthalate materials and products —	142
7.6.2.2	Method for detecting contaminants in recycled polyethylene processing lines by inline monitoring —	144
	References —	145
8	Food-grade products made from recycled polyethylene terephthalate —	149
8.1	Introduction —	149
8.2	Bottles —	153
8.3	Large drinks containers —	156
8.4	Trays and bowls —	156
8.5	Film and sheet —	157
8.6	Use of non-food-grade recycled polyethylene terephthalate in food contact products —	158
8.7	Cosmetics and healthcare products —	159
	References —	159
9	Other products manufactured from recycled polyethylene terephthalate —	161
9.1	Introduction —	161
9.2	Use in construction products —	161
9.3	Wind turbines —	162
9.4	Automotive products —	163
9.5	Clothing products, fabrics and fibres —	163
9.6	Thermoset and thermoplastic polyester resins —	166
9.7	Coating products —	167
9.8	Printing paper —	168
9.9	Use in adhesives —	168
9.10	Medical and pharmaceutical products —	169

9.11	Use in plastic blends and composites —	169
9.12	Use in rubber products —	172
9.13	Low-molecular weight intermediate products —	173
9.14	Fuel products —	174
9.15	Miscellaneous products —	175
9.16	Modification of recycled polyethylene terephthalate to improve properties —	177
9.17	Recovery of metals, inorganic and organic compounds from functionalised polyethylene terephthalate products —	180
	References —	180

10 Conclusion — 183

Abbreviations — 185

Index — 189