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Advancing Possible

Advancing the Circular Economy with *Catalloy* produced grades

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Maximizing the value potential of PE-PP post-consumer recycling using *Catalloy* produced grades

- Do you want to use more recycled material and still achieve good product properties?
- *Catalloy* produced grades can expand the application options of recycled material that could contribute to closed loop recycling instead of cascaded recycling

Challenges with PP/PE post-consumer recycling

A major portion of polymer waste streams in the recycling industry is a combination of high-density polyethylene (HDPE), low-density polyethylene (LDPE) and polypropylene (PP)

Owing to their similar density, separation of these materials is complicated in the recycling stream

Besides the technical challenges, further segregation by resin type is economically impractical. Results are hence mix feed streams consisting of PP/PE blends

Depending upon the quality of the recycled feed and owing to the incompatibility between the two materials these blends of PP/PE may yield only limited mechanical properties or exhibit bad aesthetics

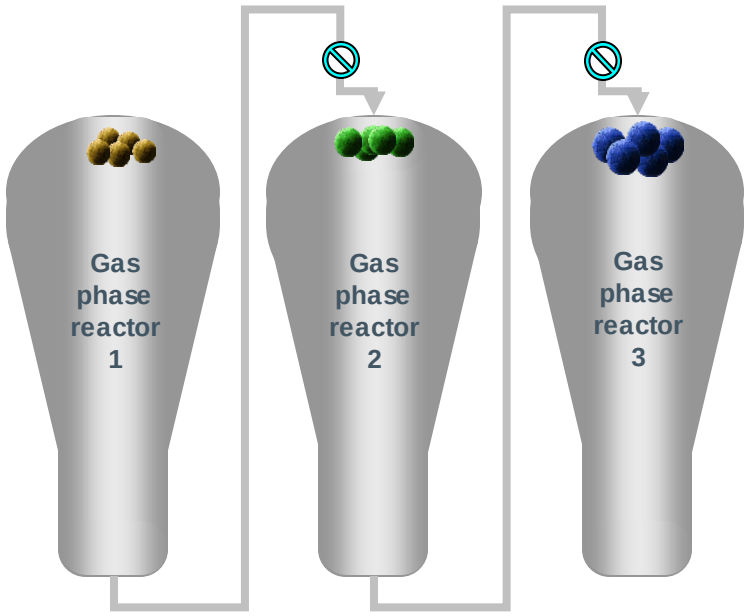
Advancing the circular economy with *Catalloy* produced grades

- Selected ***Catalloy*** produced grades enable to unlock waste potential by improving the mechanical properties and surface aesthetics of recycled materials
- ***Catalloy*** produced grades can expand the application options of recycled material

Catalloy technology for the production of thermoplastic polyolefins

- ***Catalloy* technology from LyondellBasell is a highly efficient closed-cycle process for the production of polypropylene based, thermoplastic polyolefins**

- ***Catalloy* produced grades main features**
  - Low density
  - Free flowing pellets/ easy handling
  - Natural color
  - No odor
  - Reduced emission
  - Low level of volatile (VOC) emission and fogging (FOG)
  - Free of plasticizers



***Catalloy* technology - an outstanding process to produce polypropylene based thermoplastic polyolefins**

Advancing the circular economy:
Upcycling by improved mechanical properties

The new *Hiflex* family as compatibilizer for improved impact strength

- ***Hiflex*** **CA 7700A**
- ***Hiflex*** **CA 7800A**

Hiflex range*:* Advanced *Catalloy* produced grades

The *Hiflex* product range comprises a new generation of *Catalloy* produced grades that offer:

- Easy handling and storage
- Good mechanical properties balance at high/low temperatures
- High compatibility with both PE and PP
- Available in natural color

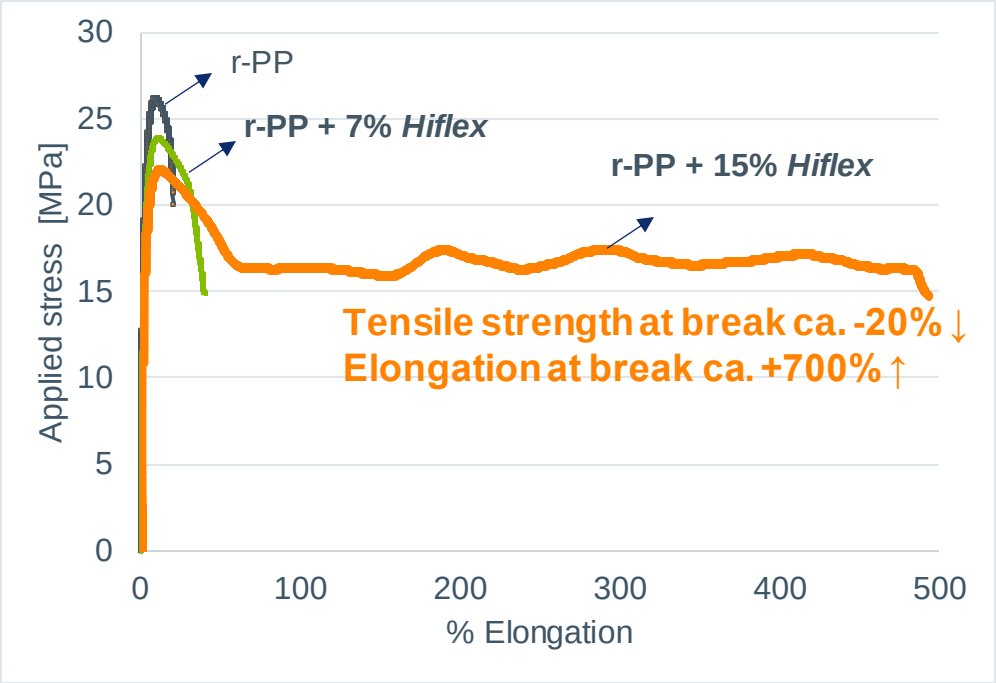
Hiflex	CA7800A	CA7700A	
Typical Properties	**Value**	**Value**	**Unit**
Density (ISO 1183)	0.88	0.88	g/cm³
MFR (ISO 1133 - 230°C/2.16 kg)	1.2	1.4	g/10 min
Flexural Modulus (ISO 527)	210	170	MPa
Notched Charpy Impact Strength – 20°C (ISO 179 1A)	85	NB	kJ/m²
DSC Melting temperature	161	143	°C

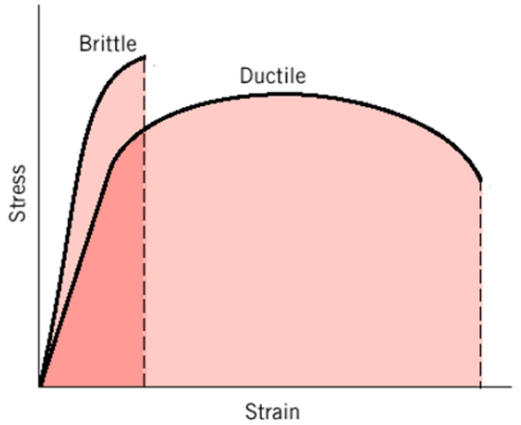
NB = No break
For TDS of LYB grades, please visit www.lyb.com

The new *Hiflex* product range combines high PP/PE compatibility with balanced mechanical properties

Effect of *Hiflex* grade on post-consumer recycled product: Improved impact strength

- **Tensile curves of post consumer recycled PP with different amounts of *Hiflex* grade**

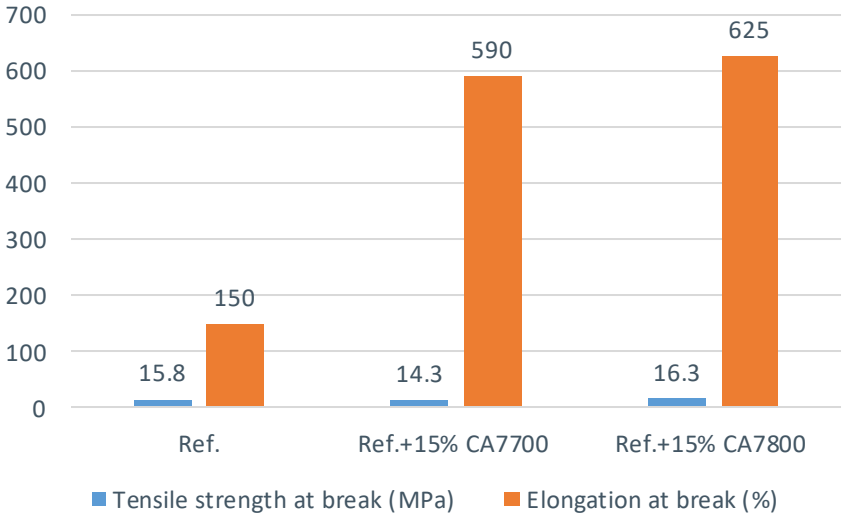


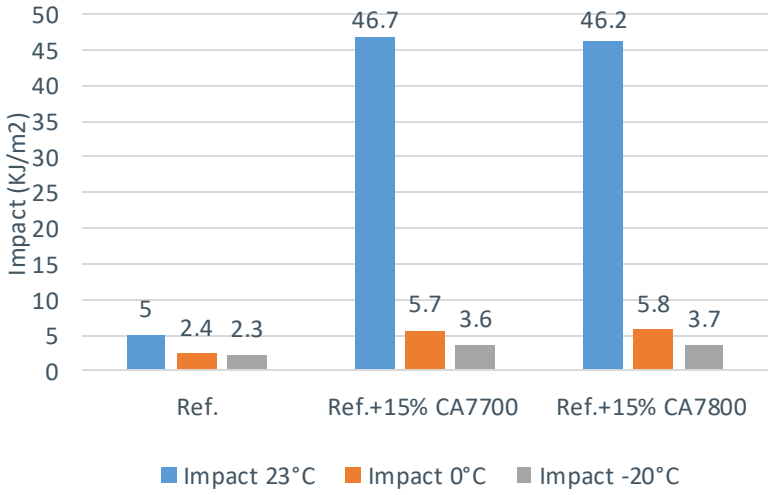


Courtesy of Revet S.p.a. (Pontedera - Italy)

- **Addition of *Hiflex* grade leads to a more ductile behavior**
- **Significant improvement in elongation at break observed upon adding 15% *Hiflex* grade**

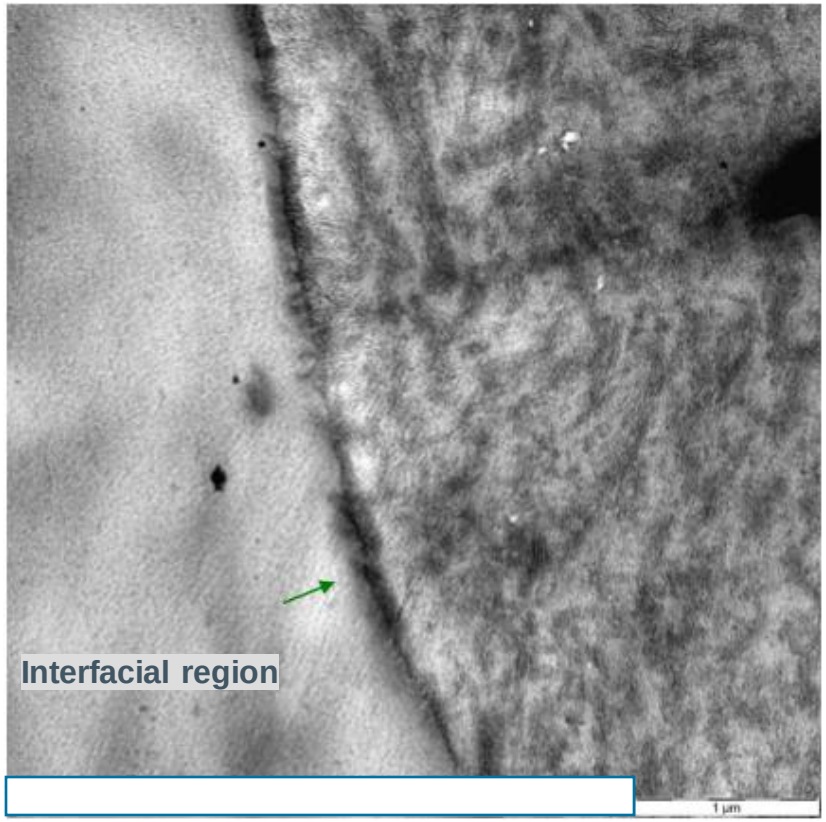
Hiflex grades as PP/PE compatibilizer : Improved impact strength



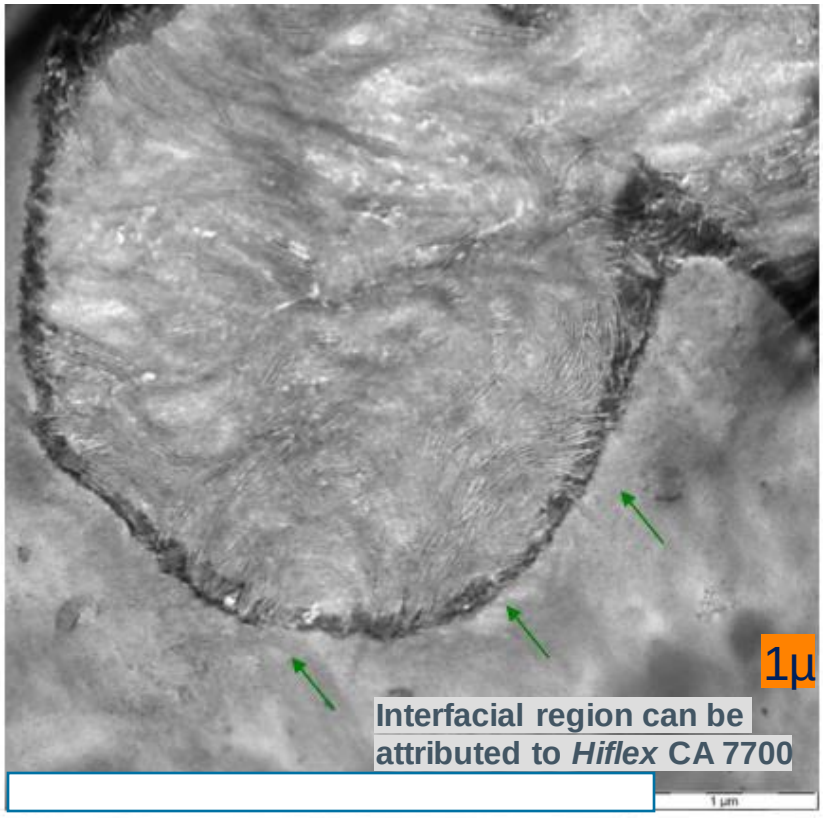


- **A 50/50 blend of PP Homopolymer and HDPE was taken as reference followed by the addition of 15% *Hiflex CA* 7700 A or *Hiflex* CA 7800 A**
- **Addition of *Hiflex* grades leads to a more ductile behavior with significant improvement in impact resistance especially at room temperature**

Hiflex CA 7700 A as compatibilizer: Transmission Electron Microscopy (TEM)



PP/PE Blend



PP/PE Blend + 15% *Hiflex* CA 7700

***Hiflex* CA 7700 A seems to be present in the interfacial region forming a bridge between PP and PE**

Advancing the circular economy: Upcycling by high flow

***Adflex* Z101H as high flow compatibilizer for improved mechanical properties**

Adflex Z101H: High flow compatibilizer

- ***Adflex* Z101H**
  - High flow for demanding injection molding processes
  - Good compatibility with both PE and PP
  - Very good impact resistance at low temperature
  - Excellent tensile properties
  - High filler loading for good color dispersions

***Adflex* Z101H**		
Typical Properties	**Value**	**Unit**
Density (ISO 1183)	0.88	g/cm³
MFR (ISO 1133 - 230°C/2.16 kg)	27	g/10 min
Flexural Modulus (ISO 527)	80	MPa
Notched Charpy Impact Strength – 20°C (ISO 179 1A)	100	kJ/m²
DSC Melting temperature	142	°C

For TDS of LYB grades, please visit www.lyb.com

These are typical property values not to be construed as specification limits

Advancing the circular economy: Upcycling by improved aesthetics

Hifax **X 1956 A grade for improved surface aesthetics**

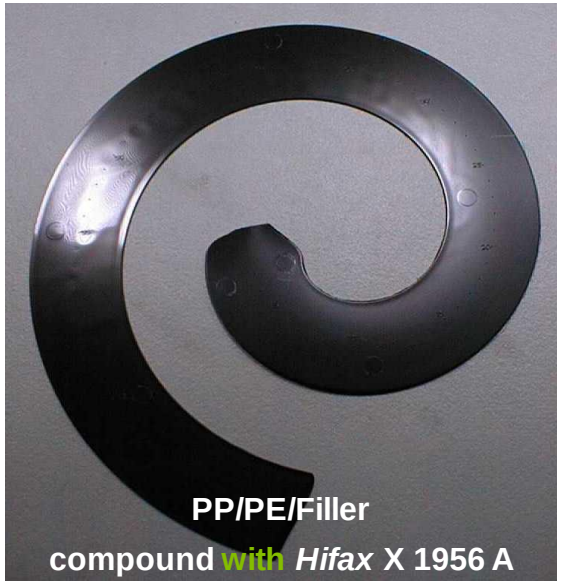
Hifax X 1956 A : Improved surface aesthetics of recycled products

- **Flow Marks**
  - Asynchronous “Tiger Stripes” is a known surface defect that appears during injection molding of large parts especially when different materials are compounded, as it happens with recycled feeds

***Hifax* X 1956 A: a functional modifier for improved surface aesthetics**

Hifax X 1956 A : Improved surface aesthetics of recycled products

- **The *Catalloy* produced grade *Hifax* X 1956 A**:
  - Maintains the impact/ stiffness balance of the compound
  - Drastically improves the surface aesthetics of the moulded part, allowing the access to high value applications
  - Improvement is already visible from 5% addition



***Hifax* X 1956 A**		
Typical Properties	**Value**	**Unit**
Density (ISO 1183)	0.88	g/cm³
MFR (ISO 1133 - 230°C/2.16 kg)	0.9	g/10 min
Flexural Modulus (ISO 527)	800	MPa
Notched Charpy Impact Strength – 20°C (ISO 179 1A)	10	kJ/m²
DSC Melting temperature	163	°C

For TDS of LYB grades, please visit www.lyb.com

These are typical property values not to be construed as specification limits

***Hifax* X 1956 A: a functional modifier for improved surface aesthetics**

Conclusions

- *Catalloy* produced grades are polypropylene based thermoplastic polyolefins and hence recyclable
- *Catalloy* produced grades *Hiflex* CA 7700 A and *Hiflex* CA 7800 A act as compatibilizer in recycled PP/PE blends, delivering a significant improvement in the impact resistance for the final item
- *Adflex* Z101H is an excellent alternative compatibilizer for good improved impact strength when high flow is requested by the injection molding process
- In value added applications when surface aesthetics of finished products is a key property, *Hifax* X 1956 A from *Catalloy* technology can be the product of choice
- Addition of grades from *Catalloy* technology in recycled PP/PE blends may improve circularity and upcycling of products and expand the application options

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