



Model Bale Specifications: HDPE Colored Bottles

This model specification provides industry-developed guidelines for recycling market acceptance of this baled commodity. It is not intended to replace the specifications of individual buyers that may allow or prohibit different contents or bale sizes. It provides a benchmark for sellers for producing quality recycled plastic baled commodities.

Any whole, blow-molded, high density polyethylene (HDPE) bottle containing the ASTM D7611 “#2, HDPE” resin identification code that is pigmented and opaque, and was generated from a curbside, drop-off, or other public or private recycling collection program. Bottles are defined as containers that have a neck or mouth that is smaller than the base.

All bottles should be free of contents or free flowing liquids and direction should be provided to consumers to empty and rinse containers. *While including closures (caps, lids, and rings) on bottles is acceptable, removal of closures is also acceptable.* Loose caps and closures should not be added to the bale.

CHECK WITH YOUR BUYER(S) as to their allowances for:

- HDPE cooking oil bottles
- HDPE motor oil or other automotive fluid bottles
- Non-bottle HDPE containers using fractional melt HDPE resin:
 - Blow molded HDPE jars or cannisters with a mouth similar to the base (e.g., coffee or cleaning wipes containers)
 - PE Squeeze Tubes
 - HDPE Thermoforms

Total contamination should not exceed 5% by weight. Contamination exceeding 5% may reduce bale value. The lower the % of contamination the higher the value of the bale; higher levels of contamination is potential for downgrade or rejection.

ALLOWABLE CONTAMINANTS AT LOW LEVELS: These contaminants are tolerable at low levels. None of the following individual contaminants should exceed 2%, by weight, unless noted otherwise. Excessive levels may reduce bale value.

- Injection molded HDPE (#2) containers
- Any non-HDPE rigid plastic bottle, container or packaging, including PET (#1), LDPE (#4), PP (#5), PS (#6), Other (#7) and compostable plastic, e.g., PLA and PHA (2% maximum of all combined)
- Loose paper or cardboard (OCC)
- Liquid residues
- Aluminum cans

CONTAMINANTS NOT ALLOWED: *If present, these contaminants may result in rejection.*

- Any item with degradable additives
- Containers which held hazardous materials, such as flammable, corrosive or reactive products, pesticides or herbicides



- Any bulky rigid plastic
- Any plastic bags or film
- Any plastic foam
- Other metal, wood, glass
- Batteries
- Electronics scrap, including items with circuit boards or battery packs
- Bio-Medical non-bottle waste/items (e.g., syringes, sharps, gloves, masks)
- Rocks, stones, mud, oils, grease

IMPORTANT: Any plastic container that previously contained any hazardous or potentially hazardous material, including needles, should be strictly avoided. Many purchasers will reject an entire load if any of the above materials are found and will return them at the seller's expense.

Bale Size/Minimum Shipping Weight/ Tare Weight: Bales should be a minimum of 30"x42"x 48". Bale sizes should allow a minimum of 35,000 pounds to be shipped on 48 foot trailer. Individual companies may apply price deductions for shipments that do not meet their minimum weight requirements. A tare weight of 8 pounds per bale may be taken from the gross weight for baling wire.

Bale Density: 15-20 lbs/ft³

Bale Integrity: Bale integrity must be maintained throughout loading, shipping, unloading and storage.

Bale Wire: Bales should be held together with 10-12 gauge, noncorrosive galvanized metal wire and with all bale wires wrapped in one direction (crisscrossing or double strapping should be preapproved by the buyer before shipping). A minimum number of bale wires should be used to maintain bale integrity. This number will vary with bale size and density.

Other Bale Wrap or Binding: Plastic wrap, cardboard headers, or other additional binding beyond bale wire should not be used.

Storage: Bales should be stored, with the bottom bale on a pallet, indoors or covered outdoors. Material must not be stored outdoors uncovered for a period exceeding four (4) weeks to prevent UV degradation from direct sunlight and moisture contamination.

DOCUMENT VERSION HISTORY

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