



Laser+[®] C
CUSTOM CONTAINER PET RESIN

Laser+[®] C (C60A)

polyethylene terephthalate resin

Product Information

Material Drying

Proper drying of polyethylene terephthalate (PET) is essential to produce a high quality part (container, film, etc.) with optimum physical properties. PET is hygroscopic, meaning that when it is exposed to humid atmospheres, it will absorb moisture. In PET the moisture is not only on the surface but diffuses slowly through the whole pellet and is firmly held by molecular attraction. Before processing the PET, this moisture must be removed. Carefully controlled drying of all PET is an essential requirement for optimum processing performance and final product properties. If drying is not carried out properly, to the known requirements of the type of PET in use, then deficiencies in process and product will result. The deficiencies will be impossible to remedy by later process changes. These defects arise in the injection molding or extrusion processes because at PET melt temperature (250°-280° C) any water present causes hydrolytic degradation of the PET, almost instantaneously, with the resultant loss in intrinsic viscosity (IV). Significant drops in IV cause loss of process control and reductions in end product properties.

Drying of PET polymer involves the diffusion of absorbed moisture from the interior of the polymer chip to its surroundings and, subsequently the removal of moisture from the bulk of polymer chips. Moisture removal can be achieved by heating the polymer chip under dry air or vacuum. In an air drying system, heated dehumidified air flows up through a chip bed and returns to the dehumidifier. The key requirements for a reliable drying process are:

Drying temperature: The ACTUAL chip temperature should achieve between 300° and 340° F measured at the dryer exit.

Dehumidified air temperature: Correctly designed equipment should operate at temperatures up to 340° F measured on entry to the dryer hopper, with an absolute maximum of 370° F to prevent possible discoloration.

Dehumidified air dew point: This should not be allowed to rise above -34° F and should preferably be -40° F or lower, measure after the desiccant bed. Always check the correct regeneration temperatures are being used.

Dehumidified air flow through the chip bed: Most dryers operate at around 1 cfm of airflow per 1lb/hr of PET chip as a minimum requirement, with the airflow at the correct temperature and dew point.

Chip residence time (drying time): DAK recommends a chip residence time for Laser+[®] PET of not less than four hours and preferably six hours. This is the theoretical drying time, which is calculated by dividing dryer capacity in lbs. by throughput in lb./hr. Extended periods of high temperature can adversely affect the polymer processing conditions. In the event of a stoppage for an extended period, dry polymer can be stored in the dryer-hopper by reducing the air temperature to 240° F (or even lower).



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PDS-C60A Rev 06/11



Laser+[®] C (C60A)

polyethylene terephthalate resin

Product Information

Product Description

Laser+[®] C (C60A) is a unique copolymer particularly suited for use in the custom PET container applications where clarity and neutral color are desired. It is a medium intrinsic viscosity (IV) product that gives the end user a strong clear bottle and offers excellent processing and consistency.

Typical Properties

Bi-orientation of Laser+[®] C (C60A) by injection/stretch blow molding provides optimal barrier and mechanical properties, including excellent vacuum performance. It performs well in both single- and two-stage processes used in the manufacturing of PET containers.

Laser+[®] C (C60A) offers excellent clarity and color, while maintaining good reheat characteristics for stretch blow molding. In addition, because it is a copolymer resin, it offers reduced crystallization rates and a wide processing window.

Certification

Laser+[®] C (C60A) is ideally suited for food packaging applications and is considered in compliance with the Food and Drug Administration (FDA) Food Contact Notification (FCN) 000635, covering PET polymers.

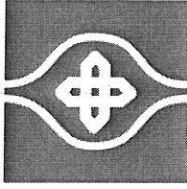
Sales Specifications

Property	Value	Unit	Test Method
Intrinsic Viscosity	0.83 ± 0.02	dL/g	DAK-QAR-SOP-0012
Color L*	87 ± 2.0	CIE	DAK-QAR-SOP-0011
Color b*	-3.0 ± 2.0	CIE	DAK-QAR-SOP-0011
Acetaldehyde	2 max	ppm	DAK-QAR-SOP-0010
Moisture Content (as packaged)	0.25 max	weight %	DAK-QAR-SOP-0013
Fines (as packaged, +24 Mesh Size)	0.10 max	weight %	DAK-QAR-SOP-0014
Chip Size, nominal	53 ± 5	chips / g	DAK-QAR-SOP-0015
Crystallinity	> 45	%	DAK-QAR-SOP-0016
Partical Size, Shape (Flat Cylinder)	3x3x2	mm	DAK-QAR-SOP-0017
Melting Point, nominal	246	°C	DAK-QAR-SOP-0016
Bulk Density	54.3	lb / ft ³	DAK-QAR-SOP-0018

These values represent the anticipated performance data for these polyester resins and intermediates; they are not intended to be used as design data. We believe this information is the best currently available on the subject. It is offered as a possible helpful suggestion in the experimentation you may care to undertake along these lines. It is subject to revision as additional knowledge and experience is gained. DAK Resins makes no guarantee of results and assumes no obligation or liability whatsoever in connection with this information. This publication is not a license to operate under, or intended to suggest infringement of, any existing patents.

CAUTION: Do not use in medical applications involving permanent implantation in the human body. For other medical applications, see "DAK Medical Caution Statement".





NAN YA PLASTICS CORPORATION, AMERICA SOUTH CAROLINA PLANT

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Tairilin Chip General Specifications

Specification: CNGFA080
Description: A-grade Bottle Resin
Lot No: AA20

Property	Unit	General Specification	Test Method
A. IV (Intrinsic Viscosity)	dL/g	0.800 ± 0.02	NALC-QC-104
B. Color			
1. L, Luminance		84.0 ± 3.0	NALC-QC-106
2. b, Yellowness		-2.0 ± 3.0	
C. Melting Point	°C	246 ± 3	NALC-QC-115
D. Acetaldehyde Content	ppm	< 1.00	NALC-QC-410

1. Nan Ya PET resin complies with the U.S. FDA Code of Federal Regulations Title 21 part 177.1630 and EC Directive 2002/72/EC with respect to its use for food contact applications.

2. Typical drying conditions:

 Maximum acceptable moisture level: 40ppm

 Drying air temp: 160-180°C

 Drying air dew point: < -40°C

 Drying residence time: 4 - 6hours

3. Typical molding conditions:

 Barrel temperatures: 275-285 °C

The conditions stated above are typical but not specific. Individual machine conditions will vary from machine to machine.

A solid black trapezoidal graphic is positioned in the upper right area of the page, above the "Technical Data Sheet" title.

Technical Data Sheet

COMPETE F 10018245 Amber - PET (CC00001133)

Color Masterbatch

Product Description

COMPETE F 10018245 Amber - PET (CC00001133)

General Key Characteristics

COMPETE F 10018245 Amber - PET (CC00001133) is a Universal based Flake-Small product.

Concentrate

Color - **Brown**
Carrier - **Universal**
Typical Addition Rate - **.25 %**

Regulatory Information

- Based upon the information provided to us by our suppliers, we certify that, to the best of our knowledge, the product identified on this data sheet, when used at the recommended use rates, alone should not cause the products manufactured to exceed the limits for heavy metals prescribed under the CONEG Model Toxics Legislation; namely that, except as exempted by that model legislation, the sum of the concentration levels of lead, cadmium, mercury and hexavalent chromium present in any such product or component is not to exceed 100 parts per million by weight (0.01%).

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Technical Data Sheet

COMPETE F 10018245 Amber - PET (CC00001133)

Physical

Product Form - Flake-Small

Packaging

COMPETE F 10018245 Amber - PET (CC00001133) is supplied in Flake-Small form and packed in 50 lb. boxes, 250 lb drums, or 1000 lb gaylords. The product should be stored in a dry place and kept free of contamination.

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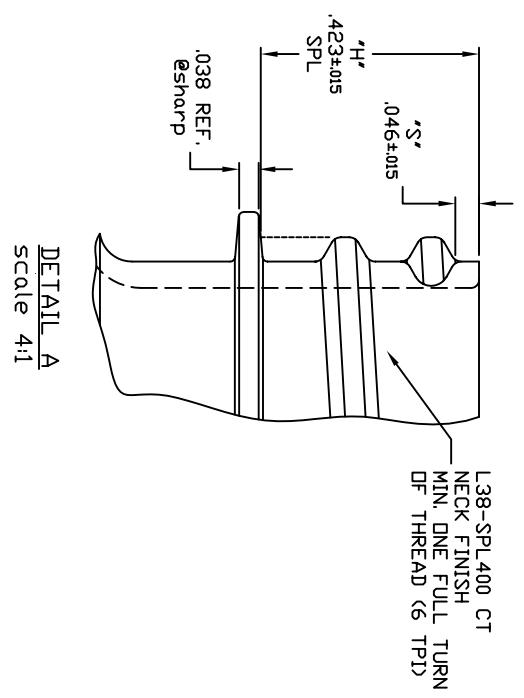
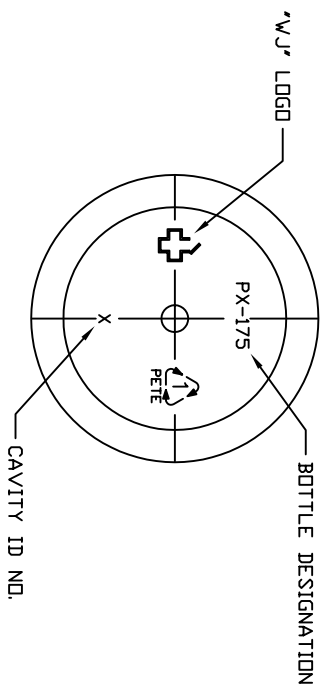
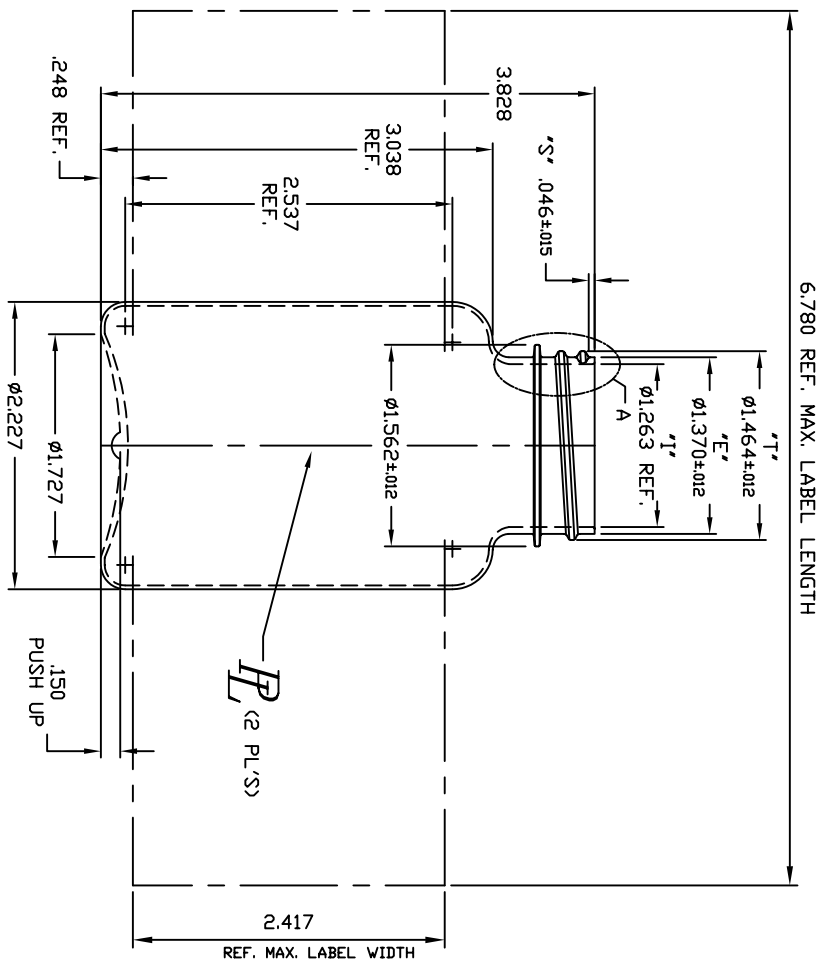
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2	12/14/00	ECN #1525; Weight: 22±1 was est'd 22±1; Overflow: 191±6 was est'd 191±6.	K.P.
REV.	DATE	DESCRIPTION	BY
Tolerances (except as noted) decimal fractional angular ±.050 ±1/16 ±1°			
 202 WASHINGTON AVENUE CARLSTADT, N.J. 07072 TELEPHONE: (201) 507-0900 * FAX: (201) 460-2059 Setting the Standard in Rigid Plastic Packaging			
weight (gr)	overflow (cc)	PX-175(175cc) WIDE MOUTH	
22±1	191±6	BOTTLE with 38mm SPL CT neck finish	
material: PETE	scale: FULL	BOTTLE with 38mm SPL CT neck finish	
min. wall thickness: .012"	drawn by: AZ	date: 11-12-98	rev: 2
	app'd by:	date:	drawing no: B-5470

②