



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".



DAK Americas LLC
Gateway Corporate Center, Suite 210
223 Wilmington W Chester Pike • Chadds Ford, PA 19317
1-888-738-2002 • fax: 610-558-7385 • www.dakamericas.com



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).



DAK Americas LLC
Gateway Corporate Center, Suite 210
223 Wilmington W Chester Pike • Chadds Ford, PA 19317
1-888-738-2002 • fax: 610-558-7385 • www.dakamericas.com

PDS-C60A Rev 06/11



***Color Concentrates for “Comar Products”
Technical Data Sheet
(Typical Properties)***

Date: Tuesday, May 3, 2016

Supplier: Penn Color, Inc.

Supplier Code: 66S854

Batch Number: RD85313

Color: Blue

Letdown Resin: PET

Mix Ratio / Letdown Ratio: 0.6%

Pellet Size: 3/32” x 1/16” Strand-Cut Pellet

FDA Status (21 CFR): Raw materials used in this formulation are listed in 21 CFR. See note*

Heavy Metals (CONEG): This product was not formulated with Heavy Metal ingredients.

*Note: A FDA Letter can be provided by Penn Color’s Regulatory Department upon request. However, be advised it is the responsibility of the user of this product to ensure compliance with all regulations that may impact their final product.

The performance of Penn Color’s dispersions may vary due to the composition and applications of the final products in which they are used. It is therefore essential that they be thoroughly tested in their intended application prior to commercialization. Penn Color does not make any warranties with the respect to the merchantability or fitness for a particular purpose of any samples provided. Fitness for use must be determined and verified by the finished product formulator and will not be the liability of Penn Color. The sample which you requested is proprietary to, and contains confidential information of, Penn Color, and should not be analyzed or given to a third party for evaluation.

400 Old Dublin Pike
Doylestown, PA 18901
215.345.6550

2755 Bergey Road
Hatfield, PA 19440
215.997.2221

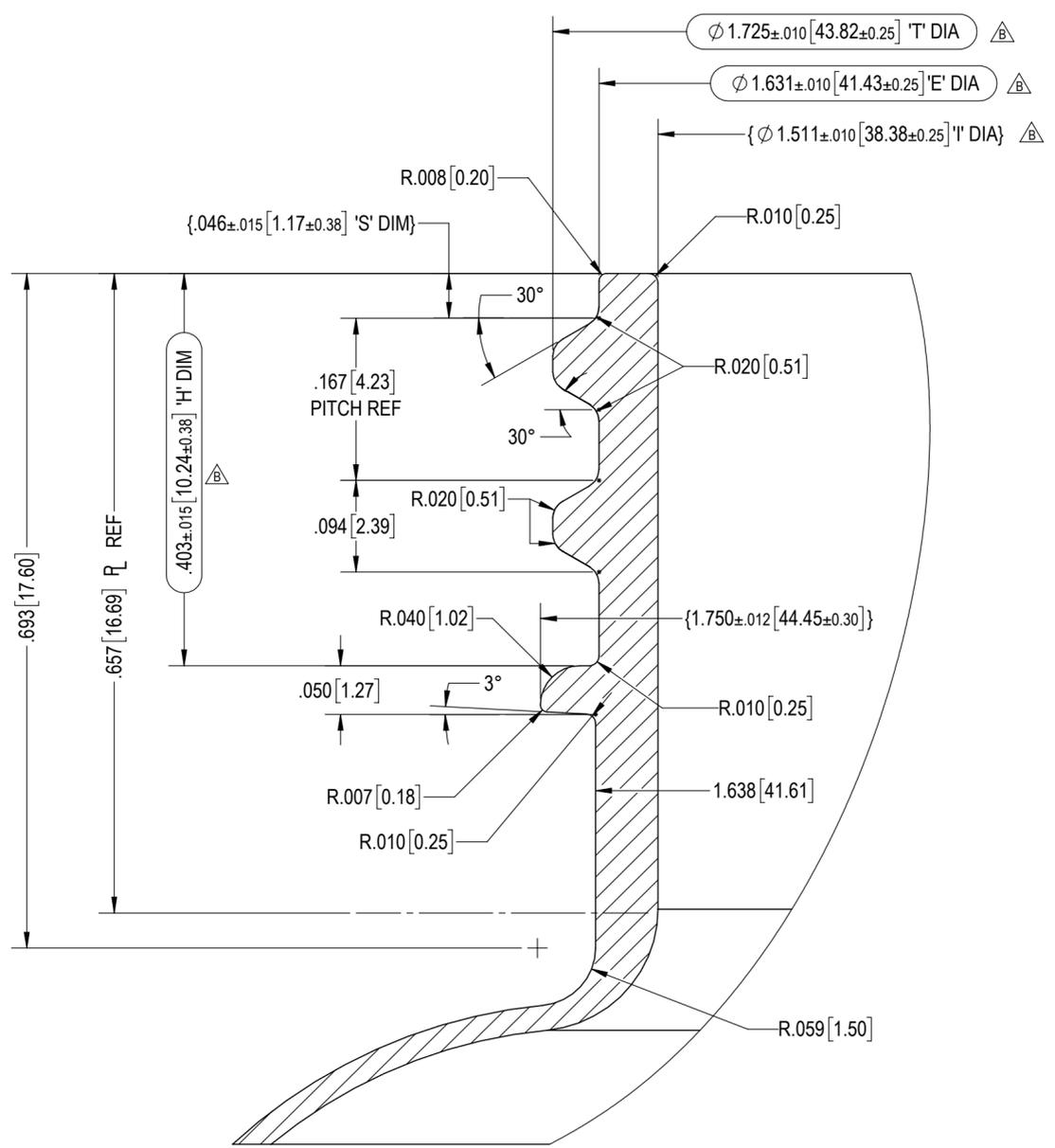
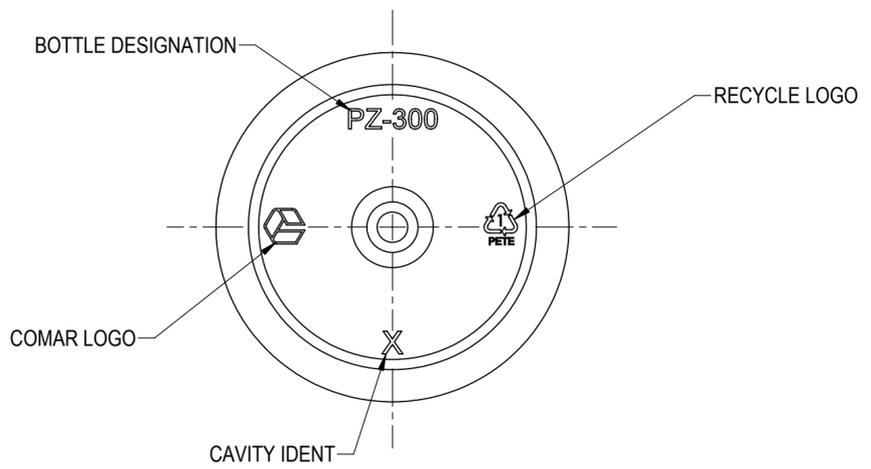
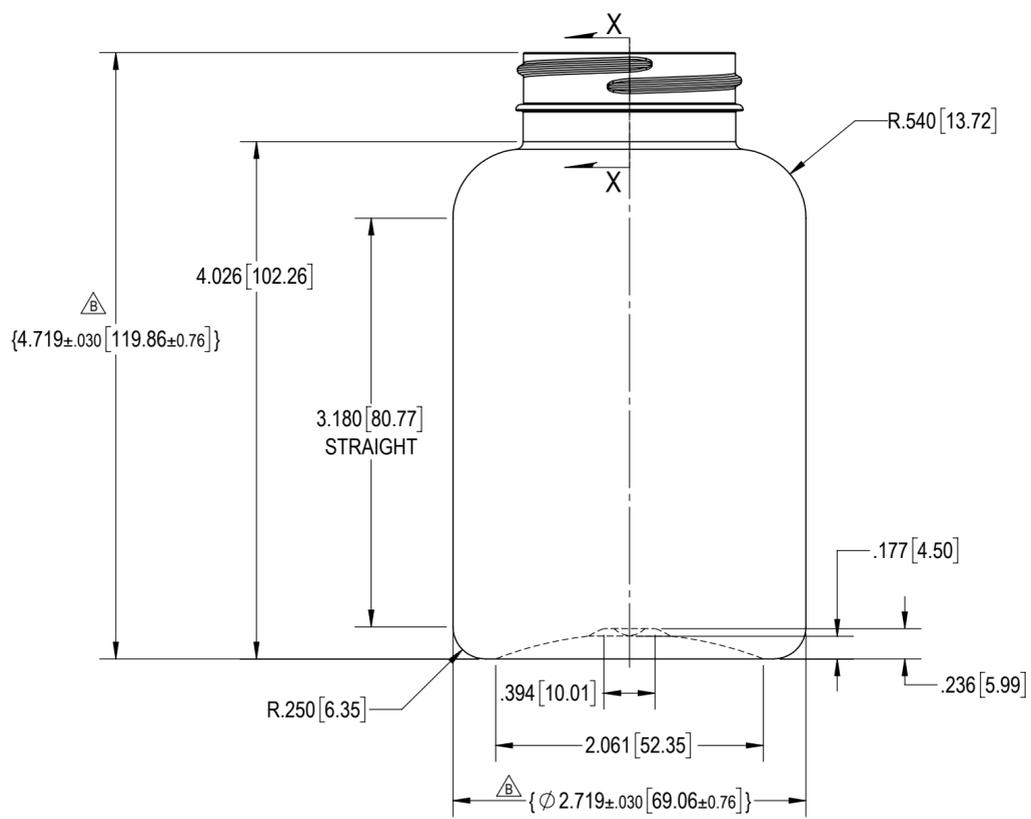
540 Hackett Mill Road
Ringgold, GA 30736
706.937.9200

30 Paul Kohner Place
Elmwood Park, NJ 07407
201.791.5100

1474 Putman Parkway
Milton, WI 53563

Smakterweg 31
5804 AE Venray
The Netherlands
+31.478.554000

Plot 808/C Dr. B.A. Road
Dadar, I.T.
Mumbai 400-014 India
+91.22.2414.0020



THREAD DETAIL
SCALE: 8x1
L45SP400 FINISH
6 TPI, .167 PTICH
1 FULL TURN MIN

- NOTES:**
- 1) GRAM WEIGHT: {30.0 GRAMS ± 1.5 GRAMS} $\triangle A, \triangle B, \triangle D$
 - 2) CAPACITY: 368 mL ± 9 mL TO O'FLOW $\triangle A, \triangle B$
 - 2) DIMENSIONS SHOWN IN [] ARE EXPRESSED IN MILLIMETERS
 - 3) FOR ALL UNSPECIFIED GEOMETRY, REFERENCE 3D MODEL FILE: 71-0027D PZ-300 300mL Round 45-400
 - 4) ALL SURFACES TO HAVE 'A2' FINISH UNLESS NOTED
 - 5) (BOXED) DIMENSIONS ARE CRITICAL TO PART FUNCTION
 - 6) (BRACKETED) DIMENSIONS ARE MAJOR INSPECTION DIMENSIONS
 - 7) WALL THICKNESS VARIATION IN LABEL PANEL NOT TO EXCEED .012 inch [0.3mm], VERTICALLY OR RADIALLY $\triangle C$
 - 8) MAX TAPER = .003 inch [0.08mm] / 1 inch [25.4mm]
 - 9) MAX PERPENDICULARITY = .005 inch [0.13mm] / 1 inch [25.4mm]
 - 10) TOP LOAD > = 400N [90 LBS]
 - 11) MIN WALL THICKNESS IN LABEL AREA = .016 inch [0.41mm]
 - 12) MIN HEEL WALL THICKNESS = .012 inch [0.3mm]

D	WEIGHT 30.0 G WAS 29.0 G	11/5/2019	BG	MMR
C	UPDATED TO CURRENT TITLEBLOCK CHANGED CUSTOMER TO STOCK ADDED PANEL VARIATION SPEC	10/26/2018	JB	BMG
B	2.719 ± .030 WAS 2.719 ± .040 4.719 ± .030 WAS 4.719 ± .060 1.725 ± .010 WAS 1.725 ± .012 1.631 ± .010 WAS 1.631 ± .012 1.511 ± .010 WAS 1.511 ± .012 WEIGHT 29.0 G WAS 30 G CAPACITY 368 mL WAS 364 mL CUST: PHARMAVITE WAS STOCK ADDED PHARMAVITE PART # REMOVED PANEL VARIATION SPEC	7/27/2018	BG	JDB
A	CAPACITY 364 mL WAS 368 mL GRAM WT 30g WAS 29g	6/6/2017	TKS	KAD
REV.	DESCRIPTION	DATE	APPROVED	DRN BY
	CONVERTED TO PRODUCTION ITEM FROM SK-6394 REV *	04/28/17	TKS	KAD
	CONVERSION DESCRIPTION	DATE	APPROVED	DRN BY

DRAWING IS IN INCHES AND [MILLIMETERS]	THIS DRAWING CONTAINS CONFIDENTIAL & PROPRIETARY INFORMATION AND MAY NOT BE REPRODUCED IN WHOLE OR PART WITHOUT WRITTEN AUTHORIZATION FROM COMAR LLC		TITLE	
	TOLERANCES UNLESS OTHERWISE SPECIFIED 3 PLACE DECIMAL ± .020 2 PLACE DECIMAL ± .04 1 PLACE METRIC ± .50 ANGLES ± °		PZ-300, 300mL ROUND L45SP400 NECK FINISH	
DO NOT SCALE DRAWING		NAME	DATE	PART NO
		KAD	12/08/16	71-0027
		CHECKED	DATE	SCALE
		RJH	12/08/16	1x1
		ENG APPR	DATE	COMMENTS
		TKS	10/26/18	N/A
		STATUS		MOLD NO
		STOCK		MB2371
		SIZE	SHEET	DWG NO
		C	1 OF 1	71-0027
		REV		D

