



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".



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ISO 9001:2008
#10004457

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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



Product Description

COMPETE F 10018245 Amber - PET (CC0000113325)

General Key Characteristics

COMPETE F 10018245 Amber - PET (CC0000113325) is a WAX CARRIER (EBS, CASTORWAX, E based Flake Small-W product.

Concentrate

Color - BROWN
Carrier - WAX CARRIER (EBS, CASTORWAX, E
Typical Addition Rate - 0.250%

Contact your PolyOne commercial or customer service representative with end use application for a full regulatory disclosure.

Physical

Product Form - Flake Small-W

Packaging

COMPETE F 10018245 Amber - PET (CC0000113325) is supplied in Flake Small-W form and can be packed in 50 lb. boxes, 100 lb. mini drums, PlanetPak(TM) boxes, 250 LB drums, 1000 lb gaylords or the most appropriate container based on order size and product type.

Contact Information

United States - Avon Lake, Ohio
+ 1 440 930 1000
Or visit www.avient.com

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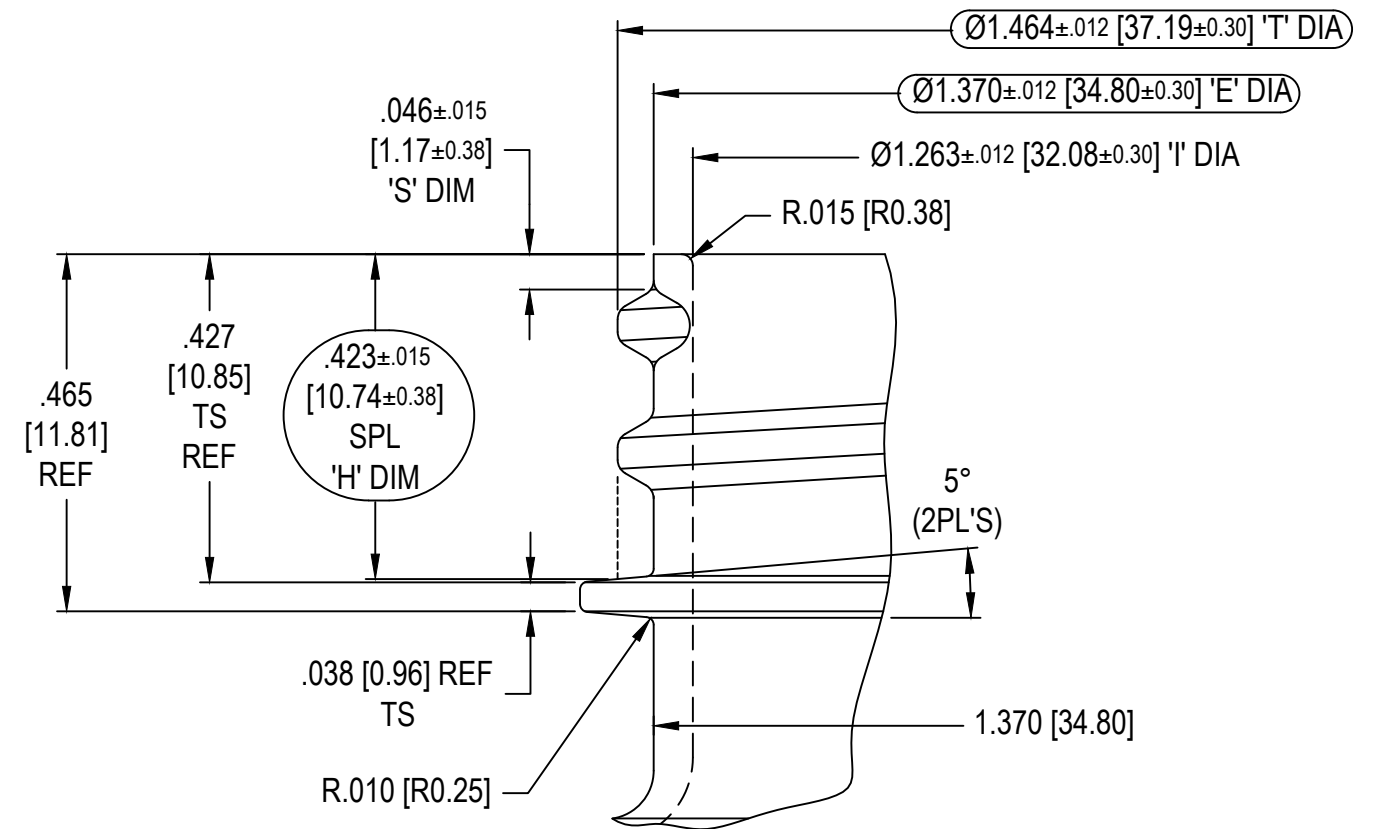
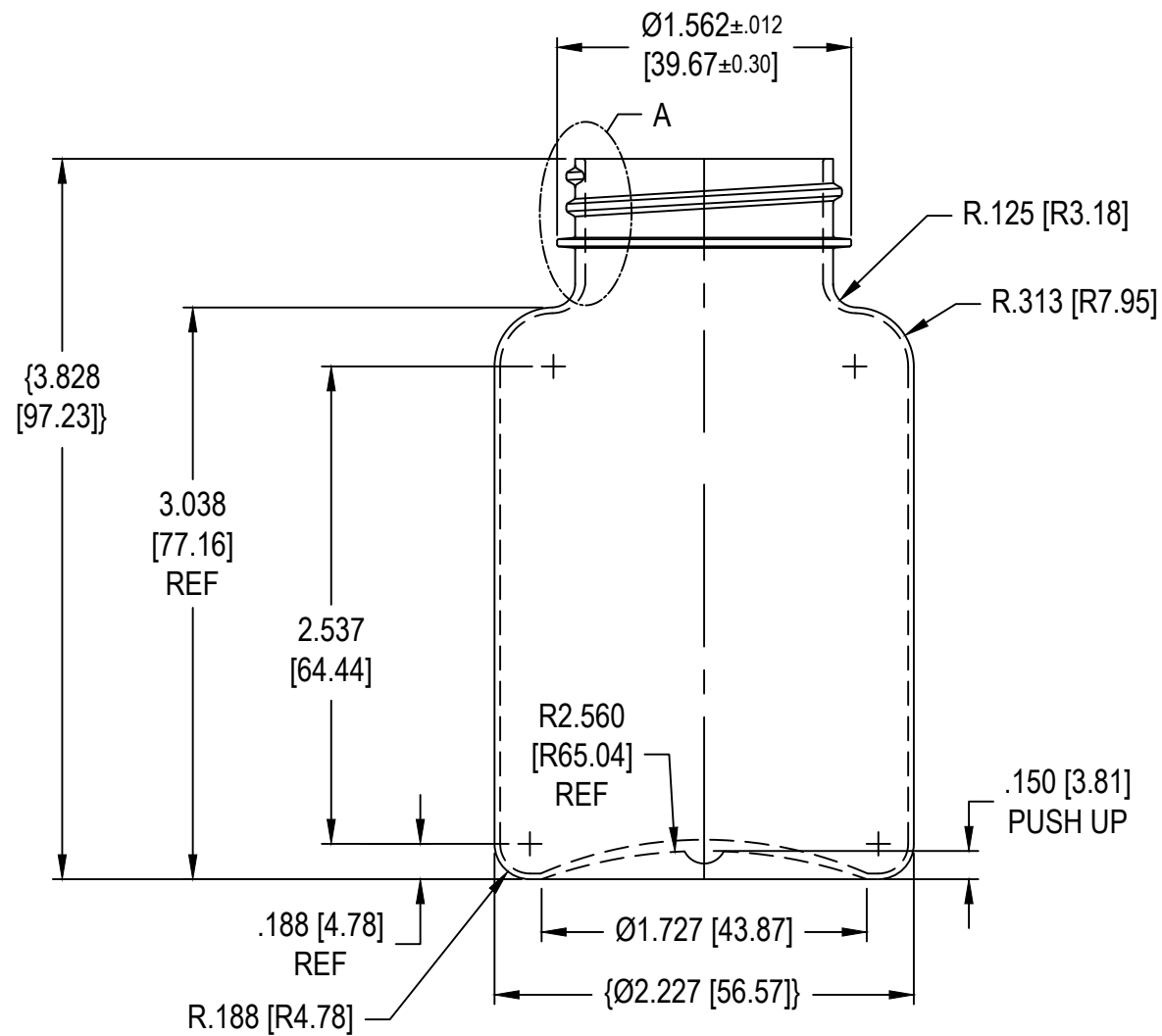
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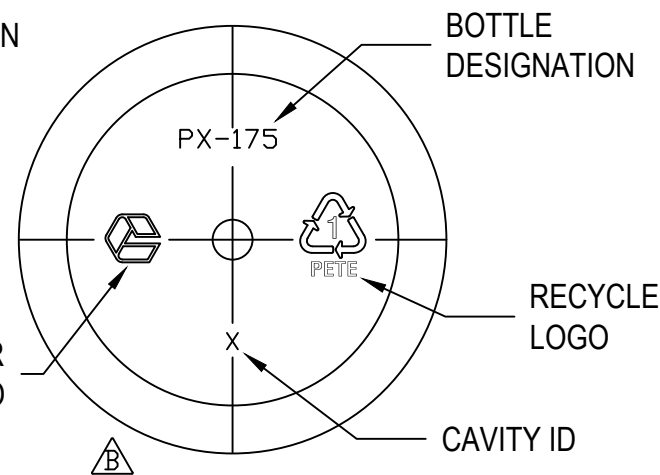
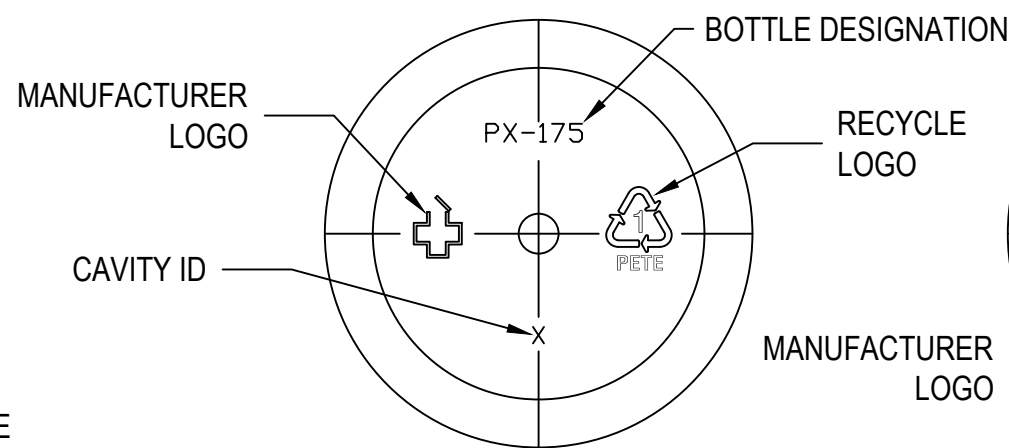
Contact Information

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patent owner.



NECK DETAIL
 SCALE 4X1
 SPECIAL L38SP400
 6 TPI, .167 PITCH
 ONE FULL TURN MIN



NOTES:

- 1) MATERIAL: PETE
- 2) GRAM WEIGHT: {23.7 GRAMS ± 2.0 GRAMS}
- 3) CAPACITY: 189mL ± 6mL TO OVERFLOW
- 4) LABEL PANEL WALL VARIATION NOT TO EXCEED .012 [0.30]
- 5) MINIMUM WALL IN LABEL PANEL = .016 [0.41]
- 6) MINIMUM HEEL WALL THICKNESS .012 [0.30]
- 7) MAXIMUM TAPER = .002/INCH [0.05]
- 8) MAXIMUM PERPENDICULARITY = .005 [0.13]
- 9) DIMENSIONS SHOWN IN [] ARE EXPRESSED IN MILLIMETERS
- 10) **BOXED** DIMENSIONS ARE CRITICAL TO PART FUNCTION
- 11) {BRACKETED} DIMENSIONS ARE MAJOR INSPECTION DIMENSIONS

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	
TOLERANCES UNLESS OTHERWISE SPECIFIED		NAME	DATE
3 PLACE DECIMAL ± .050		KD	02/19/11
2 PLACE DECIMAL ± .06			
2 PLACE METRIC ± 1.27		BG	05/06/19
1 PLACE METRIC ± 1.5			
ANGLES ± 1°		JB	01/30/20
DO NOT SCALE DRAWING	ENG APPR		

REV.	REVISION DESCRIPTION	CHECKED BY	DRN BY/DATE
B	ADDED ALTERNATE BOTTOM VIEW	BG	MMR 1/29/20
A	REDRAWN AND REVISED UPDATE TO CURRENT STANDARDS AND TITLE BLOCK	BG	MMR 03/27/19
TITLE		PART NO	
PX-175H (175cc) WIDE MOUTH BOTTLE WITH 38mm SPL CT NECK FINISH		VARIOUS	
COMMENTS		SCALE	
N/A		1x1	
STATUS		MOLD NO	
STOCK		MB2213, MB2179	
SIZE	SHEET	DWG NO	REV
B	1 OF 1	7574	B

