



Laser+ RF 9921 (F65R)

polyethylene terephthalate resin

Product Information

Product Description

Laser+® RF 9921 (F65R) is a unique copolymer particularly suited for use in the returnable carbonated soft-drinks PET container applications where transparency for thick wall bottles parts and high chemical resistance are needed. It is a medium intrinsic viscosity (IV) product that gives the end user a clear bottle and offers superior processing and consistency.

Typical Properties

Bi-orientation of Laser+® RF 9921 (F65R) by injection/stretch blow molding provides good barrier and mechanical properties, including excellent vacuum performance. It performs well in single-, two-stage and injection-blow processes used in the manufacturing of PET containers.

Laser+® RF 9921 (F65R) offers excellent clarity and color, while maintaining good reheat characteristics for stretch blow molding. In addition, because it is a CHDM copolymer resin, it offers significantly reduced crystallization rates and a wide processing window.

Certification

Laser+® RF 9921 (F65R) 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	0.80 ± 0.02	dL/g	DAK-QAR-SOP-0012
Color L*	77.5 min	CIE	DAK-QAR-SOP-0011
Color b*	0.3 ± 1.5	CIE	DAK-QAR-SOP-0011
Acetaldehyde	3 max	ppm	DAK-QAR-SOP-0010
Moisture Content (as packaged)	0.25 max	weight %	DAK-QAR-SOP-0013
Fines (as packaged, +24 Mesh Size)	0.05 max	weight %	DAK-QAR-SOP-0014
Chip Size, nominal	63 ± 10	chips / g	DAK-QAR-SOP-0015
Crystallinity	> 35	%	DAK-QAR-SOP-0016
Partical Size, Shape (Cubical)	3.27	mm	DAK-QAR-SOP-0017
Melting Point, nominal	238	°C	DAK-QAR-SOP-0016
Bulk Density	53	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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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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