


**UNITED NATIONS / DOT
PERFORMANCE CERTIFICATION**



4G DESIGN QUALIFICATION

**6 x 2.6 Liter Plastic Bottle Packaging with (2)
Designs**

TEST REPORT #: 20-CA20093

 4G / Y30.6 / S / **
USA / +CC7198

**Insert the year packaging is manufactured

TESTING PERFORMED FOR:

PUREPAK TECHNOLOGY CORPORATION

324 South Bracken Lane Suite 3
Chandler, AZ 85224

ATTN: Michael Dodd

TESTING PERFORMED BY:

TEN-E PACKAGING SERVICES, INC.

326 North Corona Avenue
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May 13, 2020

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NOTES AND COMMENTS

Tested as a design qualification due to decreasing the specific gravity to 1.9 from 2.0. The packaging will retain the +CC7198 Identification.

Testing 6 x 2.6 Liter Plastic Bottle Packaging with (2) Designs:

#1) 38-439 Closure & Shipper Taped Top & Bottom Flaps

#2) 38-439 Closure & Shipper Taped Top & Hot Melt Glued Bottom Flaps


PurePak Technology may use Identification +CC7198 for alternative plastic bottle designs provided they meet the requirements of 49 CFR; 178.601 (g)(1) Selective Testing Variation 1 and 49 CFR; 178.601 (g)(4) Selective Testing Variation 4.

SECTION I: CERTIFICATION

**Design Qualification of the PurePak Technology Corporation
 6 x 2.6 Liter Plastic Bottle Packaging with (2) Designs: #1) 38-439 Closure & Shipper Taped Top & Bottom Flaps & #2) 38-439 Closure & Shipper Taped Top & Hot Melt Glued Bottom Flaps**


TEN-E Packaging Services, Inc. is a current DOT UN Third-Party Certification Agency under §107.403 and certifies that the **PurePak Technology Corporation** packaging referenced above has passed the standards of the DEPARTMENT OF TRANSPORTATION'S TITLE 49 CFR; Performance Oriented Packaging Standards, Section 178. This package is also certified under IMDG, ICAO/IATA Regulations and the UN Recommendations on the Transport of Dangerous Goods. It is the responsibility of the end user to determine authorization for use under these regulations. The use of other packaging methods or components other than those documented in this report may render this certification invalid.

SUMMARY OF PERFORMANCE TESTS

UN / DOT TEST	CFR REFERENCE	TEST LEVEL	TEST CONTENTS	TEST COMPLETED	TEST RESULTS
Drop	178.603	1.9 m	Methanol/Water Solution	May 13, 2020	PASS
Stacking	178.606	272.1 Kg – 24 Hours	Empty	May 12, 2020	PASS
Pressure	173.27	300 kPa - 30 Minutes	Water	May 13, 2020	PASS
Vibration	178.608	3.3 Hz – 1 Hour	Water	May 11, 2020	PASS
Cobb	178.516	30 Minutes	---	May 13, 2020	PASS
TEST REPORT NUMBER:			20-CA20093		
UN MARKING: (CFR 49 – 178.503)			 4G / Y30.6 / S / ** USA / +CC7198		
PACKAGING IDENTIFICATION CODE:			4G - Fiberboard Box (178.516)		
PERFORMANCE STANDARD:			Y (Packaging meets Packing Group II and III tests)		
AUTHORIZED GROSS MASS:			30.6 Kg (67.4 Lbs.)		
"S" DESIGNATION:			Denotes Inner Packagings		
YEAR OF MANUFACTURE:			** Insert year the packaging is manufactured		
STATE AUTHORIZING THE MARK:			USA		
PACKAGING CERTIFICATION AGENCY:			(+CC) TEN-E Packaging Services, Inc. (Ontario, CA CAA #2006030021)		
THIRD PARTY PACKAGING IDENTIFICATION:			+CC7198		
PERIODIC RETEST DATE:			May 13, 2022		
SP NUMBER:			DOT-SP 14656		

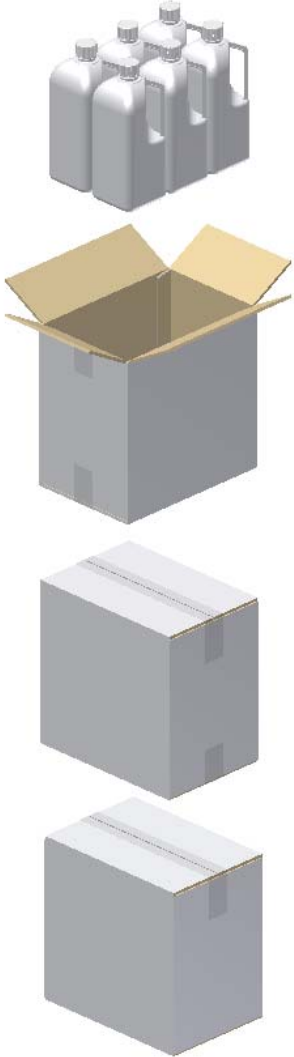
ALL OTHER WARRANTIES, EXPRESSED OR IMPLIED, INCLUDING ANY WARRANTY THAT THE PACKAGING TESTED IS MERCHANTABLE OR FIT FOR A PARTICULAR PURPOSE, ARE DISCLAIMED. In no event shall TEN-E Packaging Services, Inc. liability exceed the total amount paid by **PurePak Technology Corporation** for services rendered. In the event of future changes to the above referenced test standards, it is the responsibility of **Purepak Technology Corporation** to determine whether additional testing or updating of past testing is necessary to verify that the packaging we have tested remains in compliance with those standards.

MANUFACTURER:
Purepak Technology Corporation
 324 South Bracken Lane Suite 3
 Chandler, AZ 85224


 Matthew C. Anderson
 Project Manager
 TEN-E Packaging Services, Inc.
 326 North Corona Avenue

SECTIONS II & V: PACKAGING DESCRIPTIONS / COMPONENT DRAWINGS

6 x 2.6 Liter Plastic Bottles with 38-439 Closure Packaging with Two Case Sealing Mechanisms


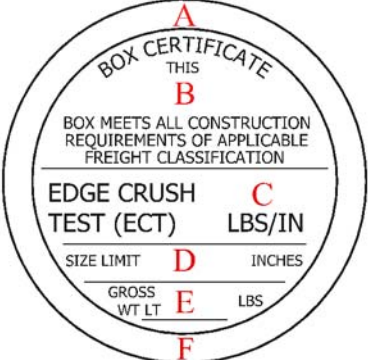
ASSEMBLY DRAWING	TEST LEVELS	
	Certification Type:	Design Qualification
	Packaging Code Designation:	4G
	Packing Group:	II
	Specific Gravity:	1.9
	Internal Pressure:	300 kPa
	TEST SAMPLE PREPARATION (Refer to Section IV)	
	Overall Packaging Tare Weight:	1,916.0 Grams
	Fill Capacity (98% Maximum Capacity):	
	Methanol/Water Solution	2,445.5 Grams
	Water	2,518.6 Grams
	Package Test Weight:	
	Methanol/Water Solution	16.5 Kg 36.3 Lbs.
	Water	17.0 Kg 37.4 Lbs.
	Authorized Package Gross Mass:	30.6 Kg 67.4 Lbs.
	CLOSING METHODS – INNER PACKAGING	
Application Torque:	50 In-Lbs	
Equipment:	Kaps All Electronic Torque Tester	
CLOSING METHODS – SHIPPER		
Top Flaps:		
Manufacturer:	3M, St. Paul, MN	
Type:	3M #34508 Scotch Tape	
Width:	48 mm (2")	
Overlap:	2" Minimum	
Tape Pattern:	Center Seam	
Bottom Flaps:		
Manufacturer:	3M, St. Paul, MN	
Type:	Option #1) 3M #34508 Scotch Tape Option #2) Hot Melt Glue (6 Parallel 1/4" x 3" Strips Per Bottom Inner Flap – Prepared by Client)	
Width:	48 mm (2")	
Overlap:	2" Minimum	
Tape Pattern:	Center Seam	

For Packagings with an Established Gross Mass:

If the gross mass calculation in this report exceeds the previously established gross mass, the manufacturer may elect to maintain the current gross mass marking (e.g. the gross mass rating of the UN marking on the packaging may be less than the calculated gross mass indicated in this report) or use the newly established gross mass. In no event shall the gross mass marking on the packaging exceed the gross mass to which the packaging was tested.

COMPONENT INFORMATION

CLOSURE (QIM-317-4937)		DRAWING
Manufacturer: Berry Plastics, Evansville, IN		
Description:	38mm Threaded Closure	
Quantity:	6	
Material:	Polypropylene	
Tare Weight:	10.3 Grams ± 3.0 Grams	
Overall Dimensions:		
• Height	1.016" ± 0.015"	
• Diameter	1.701" ± 0.015"	
Thread:		
• Type	38mm	
• Style	439	
Finish Dimensions:		
• T	1.481" ± 0.007"	
• E	1.389" ± 0.007"	
Markings (QC Audit):	71A	
Liner:		
Description:	P.E. Foam Liner	
Tare Weight:	0.73 Grams	
Thickness:	0.059"	
Diameter:	1.397"	
PLASTIC BOTTLE (Dwg #: D-459-45 A)		
Manufacturer: PurePak Technology, Chandler, AZ		
Description:	2.6 Liter Plastic Bottle with 38mm Threads	
Quantity:	6	
Material:	High Density Polyethylene	
Method of Manufacture:	Blow Molding	
Tare Weight:	208.0 Grams ± 8.0 Grams	
Capacity:		
• Rated	2.6 Liter	
• Overflow	2,600.0 Grams ± 30 mL	
Overall Dimensions:		
• Height	12.120" ± 0.080"	
• Width	5.302" ± 0.080"	
• Depth	5.302" ± 0.080"	
Thread Dimensions:		
• T	1.461" ± 0.012"	
• E	1.352"	
• Pitch	0.1636"	
Wall Thickness:		
• Minimum	0.040"	
Markings (QC Audit):	SPI "2" HDPE Recycling Symbol 4/20 DODD 1 M609 A042720 00:45 / 7000 MADE IN USA	







SHIPPER (P369-1311-2)		
Manufacturer: PCA, Phoenix, AZ		
Description:	Regular Slotted Container	
Material/Flute (Inner to Outer):	Double Wall Mottled White Corrugated Fiberboard; C/B-Flute	
Basis Weight (Outer to Inner) Lbs./MSF:		
• Specification	35 / 23 / 35 / 23 / 35	
Tare Weight:	576.0.0 Grams	
DIMENSIONS		
	Specification Dimensions (Inside)	Measured Dimensions (Outside)
• Length	13-3/4"	14-1/4"
• Width	9"	9-3/4"
• Height	12-3/8"	13-3/4"
Board Caliper (Nominal):	0.257"	
Manufacturer's Joint:	Inside Glued, 1-3/8" Lap	
Markings (QC Audit):	<div style="display: flex; justify-content: space-between;"> <div style="text-align: center;">  <p>4G/Y30.6/S/20 USA/+CC7198</p> </div> <div style="text-align: center;"> <p>DOT-SP 14656</p> </div> </div> <p>ART WORK DATE 12/23/19 13.75 X 9 X 12.375 ID 1394833</p>	
BOX CERTIFICATE		
(A) Corrugated Manufacturer:	-----	 <p>BOX CERTIFICATE THIS BOX MEETS ALL CONSTRUCTION REQUIREMENTS OF APPLICABLE FREIGHT CLASSIFICATION</p> <p>EDGE CRUSH TEST (ECT) LBS/IN</p> <p>SIZE LIMIT INCHES</p> <p>GROSS WT LT LBS</p>
(B) Structure:	Double Wall	
(C) ECT:	51 Lbs. Per Sq. Inch	
(D) Size Limit:	105"	
(E) Gross Wt. Lt:	120 Lbs.	
(F) Location:	-----	

SECTION III: TEST PROCEDURES AND RESULTS

DROP TESTS Design #1

TEST INFORMATION		TEST CRITERIA
TEST CONTENTS:	Methanol/Water Solution (0.971 SG)	<ul style="list-style-type: none"> For packaging containing liquid, each packaging does not leak. There can be no damage to the outer packaging likely to adversely affect safety during transport. Inner receptacles, inner packagings or articles must remain completely within the outer packaging and there must be no leakage of the filling substance from the inner packaging. Any discharge from a closure is slight and ceases immediately after impact with no further leakage. (§178.603)
SAMPLE PREPARATION:	Refer to Section II	
CONDITIONING:	-18°C (0°F) Freezer #W201	
CONTENTS TEMP.:	-18.4°C (-1.1°F)	
DROP HEIGHT:	1.9 Meters (75.0") (Refer to Section IV)	
TEST EQUIPMENT:	L.A.B. Accu Drop 160	

DROP ORIENTATIONS AND TEST RESULTS

Sample #1: Flat on Bottom	Sample #2: Flat on Top	*Sample #3: Flat on Long Side
		
PASS: No leakage or damage.	PASS: No leakage or damage.	PASS: No leakage or damage.
*Sample #4: Flat on Short Side	*Sample #5: Bottom Corner	**Sample #1: Top Corner
		
PASS: No leakage or damage.	PASS: No leakage. Deformation to shipper on impact corner.	PASS: No leakage. Deformation to shipper on impact corner.







*Side and corner drops were conducted to impact the manufacturer's joint.

**Flat on bottom drop sample was also used for the top corner drop.

DROP TESTS Design #2

TEST INFORMATION		TEST CRITERIA
TEST CONTENTS:	Methanol/Water Solution (0.971 SG)	<ul style="list-style-type: none"> For packaging containing liquid, each packaging does not leak. There can be no damage to the outer packaging likely to adversely affect safety during transport. Inner receptacles, inner packagings or articles must remain completely within the outer packaging and there must be no leakage of the filling substance from the inner packaging. Any discharge from a closure is slight and ceases immediately after impact with no further leakage. (§178.603)
SAMPLE PREPARATION:	Refer to Section II	
CONDITIONING:	-18°C (0°F) Freezer #W201	
CONTENTS TEMP.:	-18.4°C (-1.1°F)	
DROP HEIGHT:	1.9 Meters (75.0") (Refer to Section IV)	
TEST EQUIPMENT:	L.A.B. Accu Drop 160	

DROP ORIENTATIONS AND TEST RESULTS

Sample #12: Flat on Bottom	Sample #13: Flat on Top	*Sample #14: Flat on Long Side
		
PASS: No leakage or damage.	PASS: No leakage or damage.	PASS: No leakage or damage.
*Sample #15: Flat on Short Side	*Sample #16: Bottom Corner	**Sample 12: Top Corner
		
PASS: No leakage or damage.	PASS: No leakage. Deformation to shipper on impact corner.	PASS: No leakage. Deformation to shipper on impact corner.

*Side and corner drops were conducted to impact the manufacturer's joint.


**Flat on bottom drop sample was also used for the top corner drop.

STACKING TEST

Design #1

TEST INFORMATION		TEST CRITERIA
TEST CONTENTS:	Empty	<ul style="list-style-type: none"> There can be no deterioration that could adversely affect transport safety or any distortion liable to reduce the package's strength, cause instability in stacks of packages, or cause damage to inner packagings that is likely to reduce safety in transport. (§178.606)
SAMPLE PREPARATION:	Refer to Section II	
CONDITIONING:	73°F / 50% RH Quality Room #W202	
TEST LOAD APPLIED:	272.1 Kg (600.0 Lbs.) (Refer to Section IV)	
TEST DURATION:	24 Hours	
TEST EQUIPMENT:	Dead Load Weights	

STACKING TEST SET-UP & RESULTS

	Sample #	Maximum Deflection After 24 Hours	Results
	6	1/16"	PASS
7	1/16"	PASS	
8	1/16"	PASS	

Comments/Observations: Following the 24-hour stack test, there was no damage likely to affect the performance of the packaging.


Stacking Stability: Not conducted; required only for guided load tests.

STACKING TEST

Design #2

TEST INFORMATION		TEST CRITERIA
TEST CONTENTS:	Empty	<ul style="list-style-type: none"> There can be no deterioration that could adversely affect transport safety or any distortion liable to reduce the package's strength, cause instability in stacks of packages, or cause damage to inner packagings that is likely to reduce safety in transport. (§178.606)
SAMPLE PREPARATION:	Refer to Section II	
CONDITIONING:	73°F / 50% RH Quality Room #W202	
TEST LOAD APPLIED:	272.1 Kg (600.0 Lbs.) (Refer to Section IV)	
TEST DURATION:	24 Hours	
TEST EQUIPMENT:	Dead Load Weights	

STACKING TEST SET-UP & RESULTS

	Sample #	Maximum Deflection After 24 Hours	Results
	17	1/16"	PASS
	18	1/16"	PASS
	19	1/16"	PASS


Comments/Observations: Following the 24-hour stack test, there was no damage likely to affect the performance of the packaging.

Stacking Stability: Not conducted; required only for guided load tests.

PRESSURE DIFFERENTIAL TEST

TEST INFORMATION		TEST CRITERIA
TEST CONTENTS:	Water	<ul style="list-style-type: none"> Packaging for which retention of liquid is a basic function must be capable of withstanding the pressure requirements without leakage. (§173.27(c))
FILL CAPACITY:	Maximum Capacity	
CLOSURE APPLICATION:	Refer to Section II	
CONDITIONING:	Ambient	
TEST PRESSURE:	300 kPa	
TEST DURATION:	30 Minutes	
AREA OF PRESSURIZATION:	Through the Bottom	
TEST EQUIPMENT:	Regulated Water Source Digital Pressure Gauge #: 605	

HYDROSTATIC PRESSURE TEST SET-UP AND RESULTS


	Sample #	Results	Comments/Observations
	1	PASS	All three samples maintained the 300 kPa test pressure for 30 minutes without leakage.
	2	PASS	
	3	PASS	

VIBRATION TEST

Design #1

TEST INFORMATION		TEST CRITERIA
TEST CONTENTS:	Water	<ul style="list-style-type: none"> Immediately following the period of vibration, each package must be removed from the platform, turned on its side and observed for any evidence of leakage. A packaging passes the vibration test if there is no rupture or leakage from any of the packages. No test sample should show any deterioration which could adversely affect transportation safety or any distortion liable to reduce packaging strength. (§178.608)
SAMPLE PREPARATION:	Refer to Section II	
CONDITIONING:	73°F / 50% RH Quality Room #W202	
TABLE DISPLACEMENT:	1"	
TEST FREQUENCY:	3.3 Hz	
TEST DURATION:	1 Hour	
TEST EQUIPMENT:	Vertical motion using L.A.B. Palletizer Vibration System	

VIBRATION TEST SET-UP AND RESULTS


	Sample #	Results	Comments/Observations
	9	PASS	No leakage or damage.
	10	PASS	
	11	PASS	

VIBRATION TEST

Design #2

TEST INFORMATION		TEST CRITERIA
TEST CONTENTS:	Water	<ul style="list-style-type: none"> Immediately following the period of vibration, each package must be removed from the platform, turned on its side and observed for any evidence of leakage. A packaging passes the vibration test if there is no rupture or leakage from any of the packages. No test sample should show any deterioration which could adversely affect transportation safety or any distortion liable to reduce packaging strength. (§178.608)
SAMPLE PREPARATION:	Refer to Section II	
CONDITIONING:	73°F / 50% RH Quality Room #W202	
TABLE DISPLACEMENT:	1"	
TEST FREQUENCY:	3.3 Hz	
TEST DURATION:	1 Hour	
TEST EQUIPMENT:	Vertical motion using L.A.B. Palletizer Vibration System	

VIBRATION TEST SET-UP AND RESULTS

	Sample #	Results	Comments/Observations
	20	PASS	No leakage or damage.
	21	PASS	
	22	PASS	

COBB WATER ABSORPTION TEST

TEST INFORMATION	TEST CRITERIA
<p>NUMBER OF SAMPLES: 5</p> <p>SAMPLE SIZE: 5" x 5" (Minimum)</p> <p>CONDITIONING: 73°F / 50% RH Quality Room #W202</p> <p>WATER APPLIED: 100 mL / Sample</p> <p>TEST DURATION: 30 Minutes / Sample</p> <p>TEST EQUIPMENT: UWE Analytical Balance Gurley Cobb Water Absorption Fixtures</p>	<ul style="list-style-type: none"> An increase in mass greater than 155 g/m² over the 30 minute duration represents an unacceptable level of water resistance. (§178.516)

COBB WATER ABSORPTION TEST RESULTS	
Sample #	Water Absorbed
1	118.0 g/m ²
2	119.0 g/m ²
3	135.0 g/m ²
4	129.0 g/m ²
5	119.0 g/m ²
AVERAGE:	124.0 g/m²
RESULT	PASS

REGULATORY AND INDUSTRY STANDARD REFERENCES

REGULATORY REFERENCES

TEST	49 CFR ^①	UN ^②	IMDG ^③	ICAO ^④	IATA ^⑤
	October 2019 Edition	20 th Edition	2018 Edition	2019-2020 Edition	61st Edition
Drop:	178.603	6.1.5.3	6.1.5.3	6; 4.3	6.3.3
Stacking:	178.606	6.1.5.6	6.1.5.6	6; 4.6	6.3.6
Pressure:	173.27(c)	4.1.1.4.1	---	4; 1.1.6	5.0.2.9
Vibration:	178.608	---	---	4; 1.1.1 & 4; 1.1.4	5.0.2.7
Cobb:	178.516(b)(1)	6.1.4.12.1	6.1.4.12.1	6; 3.1.11.1	6.2.12.2

- ① United States Department of Transportation Code of Federal Regulations (CFR) Title 49, Transportation, Parts 100-185
 ② The United Nations Recommendations on the Transport of Dangerous Goods – Model Regulations (UN – Orange Book)
 ③ International Maritime Dangerous Goods Code (IMDG)
 ④ Technical Instructions for the Safe Transport of Dangerous Good by Air (ICAO)
 ⑤ International Air Transport Association (IATA) Dangerous Goods Regulations

INDUSTRY STANDARD REFERENCES

Drop:	ASTM ^⑥ D5276:	Standard Test Method for Drop Test of Loaded Containers by Free Fall
	ASTM ^⑥ D7790	Standard Test Method for the Preparation of Plastic Packagings Containing Liquids for United Nations (UN) Drop Testing
	ISO ^⑦ 2248:	Packaging – Complete, Filled Transport Packages – Vertical Impact Test by Dropping
Stacking:	ASTM ^⑥ D4577:	Standard Test Method for Compression Resistance of a Container Under Constant Load
	ISO ^⑦ 2234:	Packaging – Complete, Filled Transport Packages – Stacking Test using Static Load
Hydrostatic Pressure:	ASTM ^⑥ D7660:	Standard Guide for Conducting Internal Pressure Tests on United Nations (UN) Packagings
Vibration:	ASTM ^⑥ D999:	Standard Test Method for Vibration Testing of Shipping Containers
	ISO ^⑦ 2247:	Packaging – Complete, Filled Transport Packages – Vibration Test at Fixed Low Frequency
Cobb:	ISO ^⑦ 535:	Paper and Board – Determination of Water Absorption – Cobb Method

- ⑥ American Society for Testing and Materials (ASTM)
 ⑦ International Organization for Standardization (ISO)

EQUIPMENT

All inspection, measuring and test equipment that can affect product quality is calibrated and adjusted at prescribed intervals, or prior to use, and is traceable to NIST, using ANSI Z540 as an overall guide for calibration certification.

SECTION IV: MATHEMATICAL CALCULATIONS

INFORMATION USED FOR CALCULATIONS

Overall Packaging Tare Weight (PTW):	1,916.0 Grams	
Overflow Capacity (OFC):		<u>Methanol/Water</u>
Methanol/Water	2,495.4 Grams	SG: 0.971
Water	2,570.0 Grams	
Number of Inner Packagings (# IP):	6	
Packing Group	II	
Product Specific Gravity (PSG):	1.900	
Packing Group Multiplication Factor (MF):	1.00	
Overall Height of one Package (OH):	13.75 Inches	
Stack Test-# of Samples Tested Simultaneously:	1	

98% OF OVERFLOW

Overflow Capacity (OFC) x 98%

<u>OFC</u>	x	<u>98%</u>		
2,495.4	x	98% =	2,445.5 Grams	Methanol/Water
2,570.0	x	98% =	2,518.6 Grams	Water

PACKAGE TEST WEIGHTS

Overall Pkg Tare Weight (PTW) + (98% Overflow Capacity (OFC) x # of Inner Pkg (# IP))

<u>PTW</u>	+	<u>(98% OFC)</u>	x	<u># IP)</u>	
1,916.0	+	2,445.5	x	6	Methanol/Water
1,916.0	+	2,518.6	x	6	Water
Methanol/Water:		16.5	Kg	36.3	Lbs.
Water:		17.0	Kg	37.4	Lbs.

AUTHORIZED PACKAGE GROSS MASS CALCULATION (APGM)

Overall Pkg Tare Weight (PTW) + (Product SG (PSG) x 98% Overflow (OFC) x # of Inner Pkg (# IP))

<u>PTW</u>	+	<u>(PSG)</u>	x	<u>98% OFC</u>	x	<u># IP)</u>
1,916.0	+	1.9	x	2,518.6	x	6
		30.6	Kg	67.4	Lbs.	

