UNITED NATIONS / DOT PERFORMANCE CERTIFICATION

4G DESIGN QUALIFICATION

6 x 2.6 Liter Plastic Bottle With 45mm Neck Finish Packaging with Two Case Sealing Mechanisms

TEST REPORT #: 20-CA20163

(un) 4G / Y24.7 / S / **
USA / +CC10501

**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
Ontario, CA 91764
Phone: 909-937-1260
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September 28, 2020

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NOTES AND COMMENTS

Tested as a design qualification due to decreasing the specific gravity to 1.5 from 2.0. The packaging will be issued a new +CC10501 Identification.

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

#1) 45mm Neck Finish & Shipper Taped Top & Bottom Flaps

#2) 45mm Neck Finish & Shipper Taped Top & Hot Melt Glued Bottom Flaps

PurePak Technology may use Identification +CC10501 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 With 45mm Neck Finish Packaging with Two Case Sealing Mechanisms

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	1.5 m	Methanol/Water Soluti	September 18, 2020	PASS
*Stacking	178.606	272.1 Kg – 24 Hours	Empty	May 12, 2020	PASS
Pressure	173.27	300 kPa - 30 Minutes	Water	September 28, 2020	PASS
Vibration	178.608	3.4 Hz – 1 Hour	Water	September 24, 2020	PASS
*Cobb	178.516	30 Minutes	---	May 13, 2020	PASS

TEST REPORT NUMBER:	20-CA20163
UN MARKING: (CFR 49 – 178.503)	(un) 4G / Y24.7 / S / ** USA / +CC10501
PACKAGING IDENTIFICATION CODE:	4G - Fiberboard Box (178.516)
PERFORMANCE STANDARD:	Y (Packaging meets Packing Group II and III tests)
AUTHORIZED GROSS MASS:	24.7 Kg (54.4 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:	+CC10501
PERIODIC RETEST DATE:	September 28, 2020
SP NUMBER:	DOT-SP 14656

*Test results taken from test report 20-CA20093

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.

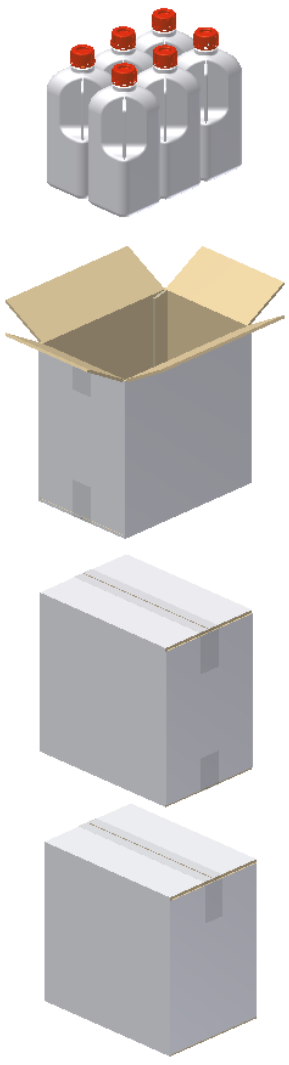
MANUFACTURER:
PurePak Technology Corporation
324 South Bracken Lane Suite 3
Chandler, AZ 85224

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 Bottle With 45mm Neck Finish Packaging with Two Case Sealing Mechanisms

ASSEMBLY DRAWING



TEST LEVELS		
Certification Type:	Design Qualification	
Packaging Code Designation:	4G	
Packing Group:	II	
Specific Gravity:	1.5	
Internal Pressure:	300kPa	
TEST SAMPLE PREPARATION (Refer to Section IV)		
Overall Packaging Tare Weight:	1,908.0 Grams	
Fill Capacity (98% Maximum Capacity):		
Methanol/Water Solution	2,447.0 Grams	
Water	2,541.2 Grams	
Package Test Weight:		
Methanol/Water Solution	16.5 Kg	36.3 Lbs.
Water	17.1 Kg	37.6 Lbs.
Authorized Package Gross Mass:	24.7 Kg	54.4 Lbs.
CLOSING METHODS – INNER PACKAGING		
Application Torque:	25 In-Lbs	
Equipment:	Kaps All Electronic Torque Tester	
CLOSING METHODS – SHIPPER		
Top Flaps:		
Manufacturer: 3M, St. Paul, MN		
Type:	3M #34508 Scotch Pressure Sensitive 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 ¼" 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:

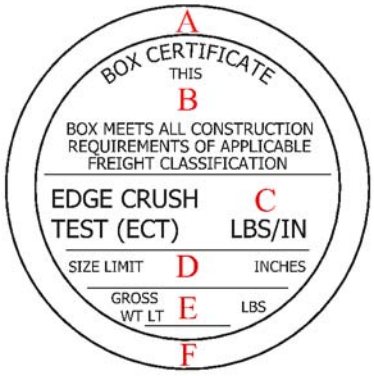
If the gross mass calculation in this report exceeds the previously established gross mass, the manufacturer may elect to maintain the current gross mass marking (e.g. the gross mass rating of the UN marking on the packaging may be less than the calculated gross mass indicated in this report) or use 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 (DIN 16901-150)	
Manufacturer: George MENSHEN Gmbh, Finnentrop, Germany	
Description:	45mm Threaded Closure Tamper Evident
Quantity:	6
Material:	High Density Polyethylene
Tare Weight:	11.07 Grams
Overall Dimensions:	
• **Height**	1.238”
• **Diameter**	1.992”
Thread:	
• **Type**	45mm
• **Style**	Buttress
Finish Dimensions:	
• **T**	1.766”
• **E**	1.682”
• **Pitch**	4mm
Markings (QC Audit):	2817.1 1
Liner:	
Description:	PTFE Liner
Tare Weight:	0.90 Grams
Thickness:	0.010”
Diameter:	1.767”
PLASTIC BOTTLE	
Manufacturer: PurePak Technology, Chandler, AZ	
Description:	2.6 Liter Plastic Bottle with 45mm Threads
Quantity:	6
Material/Pigment:	High Density Polyethylene / Natural
Method of Manufacture:	Blow Molded
Tare Weight:	208.0 Grams
Capacity:	
• **Rated**	2.6 Liter
• **Overflow**	2,593.0 Grams
Overall Dimensions:	
• **Height**	12.120” ± 0.080”
• **Width**	5.302” ± 0.080”
• **Depth**	5.302” ± 0.080”
Thread Dimensions:	
• **T**	1.772” ± 0.010”
• **E**	1.644” ± 0.010”
• **Pitch**	1.540”
Wall Thickness:	
• **Minimum**	0.032”
Markings (QC Audit):	SPI “2” HDPE Recycling Symbol 8/20 2 DODD

DRAWING

SHIPPER (Part #: 731195 and 1394833)		
Manufacturer: PCA, Arizona, CA		
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 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):	(u n) 4G/Y30.6/S/20 DOT-SP 14656 USA/+CC7198 ART WORK DATE 12/23/19 13.75 X 9 X 12.375 ID 1394833 957550	

BOX CERTIFICATE		
(A) Corrugated Manufacturer:	---------	
(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 (0.963 SG)	• 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.:	-18.7°C (-1.6°F)	
DROP HEIGHT:	1.5 Meters (60.0”) (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 (0.963 SG)	• 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.:	-18.7°C (-1.66°F)	
DROP HEIGHT:	1.5 Meters (60.0”) (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	• 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	• 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**

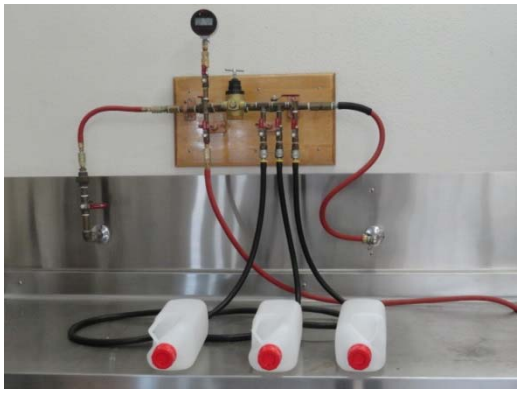
Comments/Observations: Following the 24-hour stack test, there was no damage likely to affect the performance of the packaging.

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

PRESSURE DIFFERENTIAL TEST

TEST INFORMATION		TEST CRITERIA
TEST CONTENTS:	Water	• 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	• 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:	Ambient	
TABLE DISPLACEMENT:	1”	
TEST FREQUENCY:	3.4 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	• 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:	Ambient	
TABLE DISPLACEMENT:	1”	
TEST FREQUENCY:	3.4 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
17	**PASS**	No leakage or damage.
18	**PASS**	
19	**PASS**	

COBB WATER ABSORPTION TEST

TEST INFORMATION		TEST CRITERIA
NUMBER OF SAMPLES:	5	• An increase in mass greater than 155 g/m² over the 30 minute duration represents an unacceptable level of water resistance. (§178.516)
SAMPLE SIZE:	5” x 5” (Minimum)	
CONDITIONING:	73°F / 50% RH Quality Room #W202	
WATER APPLIED:	100 mL / Sample	
TEST DURATION:	30 Minutes / Sample	
TEST EQUIPMENT:	UWE Analytical Balance Gurley Cobb Water Absorption Fixtures	

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

REGULATORY AND INDUSTRY STANDARD REFERENCES

REGULATORY REFERENCES					
TEST	**49 CFR①**	**UN②**	**IMDG③**	**ICAO④**	**IATA⑤**
	October 2019 Edition	**20th 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:	ASTM⑥ D5276:	Standard Test Method for Drop Test of Loaded Containers by Free Fall
	ASTM⑥ D7790	Standard Test Method for the Preparation of Plastic Packagings Containing Liquids for United Nations (UN) Drop Testing
	ISO⑦ 2248:	Packaging – Complete, Filled Transport Packages – Vertical Impact Test by Dropping
Stacking:	ASTM⑥ D4577:	Standard Test Method for Compression Resistance of a Container Under Constant Load
	ISO⑦ 2234:	Packaging – Complete, Filled Transport Packages – Stacking Test using Static Load
Hydrostatic Pressure:	ASTM⑥ D7660:	Standard Guide for Conducting Internal Pressure Tests on United Nations (UN) Packagings
Vibration:	ASTM⑥ D999:	Standard Test Method for Vibration Testing of Shipping Containers
	ISO⑦ 2247:	Packaging – Complete, Filled Transport Packages – Vibration Test at Fixed Low Frequency
Cobb:	ISO⑦ 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):	1,908.0	Grams	
Overflow Capacity (OFC):			Methanol/Water
Methanol/Water	2,497.0	Grams	SG: 0.963
Water	2,593.0	Grams	
Number of Inner Packagings (# IP):	6		
Packing Group	II		
Product Specific Gravity (PSG):	1.500		
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%

OFC	x	98%			
2,497.0	x	98%	=	2,447.1 Grams	Methanol/Water
2,593.0	x	98%	=	2,541.2 Grams	Water

PACKAGE TEST WEIGHTS

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

PTW	+	(98% OFC	x	# IP)	
1,908.0	+	2,447.1	x	6	Methanol/Water
1,908.0	+	2,541.2	x	6	Water

Methanol/Water:	16.5	Kg	36.3	Lbs.
Water:	17.1	Kg	37.6	Lbs.

AUTHORIZED PACKAGE GROSS MASS CALCULATION (APGM)

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

PTW	+	(PSG	x	98% OFC	x	# IP)
1,908.0	+	1.5	x	2,541.2	x	6

	24.7	Kg	54.4	Lbs.

DROP HEIGHT

Calculation For Product Specific Gravities Exceeding 1.2
Product Specific Gravity (PSG) x Packing Group Multiplication Factor (MF)

PSG	x	MF		Packing Group:	II
1.5	x	1.00		Required Drop Height	Actual Drop Height
		1.50	Meter	59.1 Inches	60 Inches

STACKING TEST MINIMUM LOAD CALCULATIONS

Number of Packages in a 3m High Stack (118.2 / Overall Pkg Height (OH) -1)

118.2 / Overall Height of one Pkg (OH) - 1

(118.2	/	OH)	-1	=	# 3m HS
118.2	/	13.75	-1	=	7.6

Stacking Test Load Calculation (Individual Package)

Authorized Pkg Gross Mass (APGM) x # of Pkg in a 3m High Stack (# 3m HS)

APGM	x	# 3m HS
24.7	x	7.6

187.8 Kg 414.0 Lbs.