



Normally we try to target the Leading Edge position to be at the support ring. By placing material above this point is of little value because this area already has improved transmission resistance because of the thick wall of the finish and the cap. In a similar manner barrier material located near the gate is not required because of the bottle base thickness.

Leading Edge axial variation around the preform circumference is dependent on the transition thickness just below the neck support ring. Consult Kortec for specific design recommendations to reduce range to +/- 7mm or less.

Range of Leading Edge within a cavity: +/- 4mm
 Range of Leading Edge cavity -to-cavity: +/- 3mm
 Maximum range (cavity-to-cavity & shot-to-shot): +/- 7mm

Trailing Edge barrier layer begins to taper approximately 10mm above the spherical radius and ends before the gate. Its thickness will be no greater than the "average volume" thickness and no less than 1% at the start of the spherical radius. The Trailing Edge will taper to zero before it reaches the gate to ensure no contamination on subsequent shots. The rate in which it tapers depends on the drying consistency/moisture content and the material combinations being used (PET type and IV, barrier resin type/grade).

The content of barrier resin depends on the customer's requirements

		Maßstab: 2:1		Benennung Preform 28gr. Multilayer	
		Datum 5.04.06		Name HR	
		gez.		gepr.	
Barriere-Gewichtstoleranz	±20%	PET-Verpackungen GmbH Deutschland		Zeichnungs Nr. SP10.V134 ML	
Vorformling-Durchm.	25.5	Gewerbegebiet 4 98701 Großbreitenbach			
Vorformling-Höhe	100.7 ±0.5	Tel.: +49 36781/480453			
Material	PET				
Gewinde	28 mm PCO	Diese Zeichnung bleibt unser Eigentum und ist nur für Sie persönlich bestimmt. Sie darf ohne unsere Genehmigung weder vervielfältigt noch dritten Personen zugänglich gemacht werden. Auf §§ 2 Ziffer 7 Urhebergesetz und §§ 18 UWG wird hingewiesen. Geringfügige, technisch bedingte Abweichungen behalten wir uns vor. Wir werden Ihnen diese gegebenenfalls rechtzeitig mitteilen.			
Vorformlingsgewicht	28 ± 0.5gr				