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(54) Title: A PACK FOR ANAEROBIC PRODUCTS

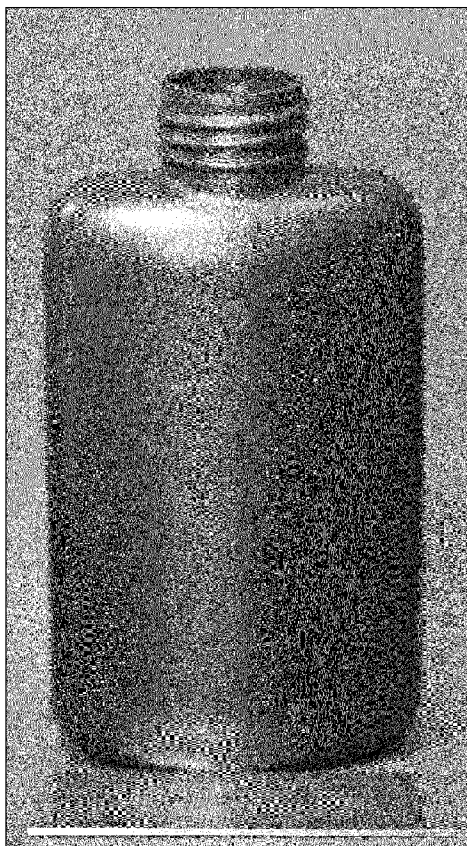


Figure 1 Image of (red) coloured 50 ml bottle of the type made and tested

(57) Abstract: A pack comprising: a container, the container having a container body, and the container body being sufficiently oxygen permeable to prevent an anaerobically curable composition held therein from curing due to absence of oxygen; and an anaerobically curable composition held within the container. The container body is constructed from a plastics material which is formed from a blend of a thermoplastic starch component and a polyethylene.

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Title

A Pack for Anaerobic Products

Field of the Invention

5 [0001] The present invention relates to a pack for anaerobic products such as anaerobic sealants and adhesives. Of particular interest are liquid anaerobic products. Anaerobic products cure, set-up or polymerise in the absence of oxygen (air).

Background to the Invention

10 [0002] The term anaerobic as used here is used to refer to formulations which cure, set-up or polymerise in the absence of air. Included are acrylic type systems including acrylate and methacrylate based compositions. This includes structural anaerobic materials.

[0003] Applications include those that require tensile bonding strength; torsional bonding strength (e.g. thread-locking formulations) etc.

15 [0004] Many types of container for anaerobic products have been produced. These include bottles, bag-in-box containers, etc.

[0005] One of the key considerations in packing an anaerobic adhesive is storage stability. Storage stability is compromised if there is not sufficient oxygen present through the mass of the composition to prevent curing occurring. Typically this means
20 that not all materials are suitable for use in the manufacture of containers for holding anaerobically curable products.

[0006] Furthermore, there may also be compatibility issues. For example, a component of an anaerobically curable composition and a component of the material of the container body may be incompatible with each other. For example, some materials may
25 cause deleterious effects on the chemical and/or physical properties of an anaerobically curable composition.

[0007] Accordingly, there is always a demand for alternative materials for use in the manufacture of containers for holding anaerobically curable products.

30 [0008] In particular there is a demand for alternative packs comprising a container and an anaerobically curable product held therein, which exhibit suitable storage stability.

Summary of the Invention

[0009] In one aspect, the present invention provides a pack comprising:

35 (i) a container, the container having a container body, and the container body being sufficiently oxygen permeable to prevent an

anaerobically curable composition held therein from curing due to absence of oxygen; and

(ii) an anaerobically curable composition held within the container;

wherein the container body is constructed from a plastics material which is formed from a blend of a thermoplastic starch component and a polyethylene.

5 [0010] This is desirable as an alternative material for forming the container body. It has desirable characteristics. Furthermore, the starch used in the thermoplastic starch component may be sourced from a renewable source.

[0011] The material has been found to be compatible with a wide range of formulations of anaerobically curable materials.

10 [0012] The material exhibits desirable characteristics for storing anaerobically curable products. In particular, it has been found that the performance of the material which forms the container body is comparable to that of more conventional materials.

[0013] Furthermore, the material is versatile. For example, it can be sufficiently rigid to form a container in the form of a bottle. A squeezable version of the container body can be formed. For example, the container body may be in the form of a squeezable container optionally fitted with a dispensing arrangement such as a dispensing nozzle. For example a dispensing assembly comprising a cap and a nozzle may be provided.

15 [0014] A pack of the invention has been found to demonstrate good storage stability properties which make it suitable for constructing different types of container.

[0015] Furthermore, a wide range of blends of material may be utilised.

[0016] For example, the starch in the thermoplastic starch component may be present in an amount from 6% to 33% of the weight of the blend used to form the container body.

25 [0017] The starch in the thermoplastic starch component may be present in an amount from 13% to 32% of the weight of the blend used to form the container body.

Optionally, the thermoplastic starch is present in an amount from 20% to 30% of the weight of the blend used to form the container body. For example, the starch in the thermoplastic starch component may be present in an amount from 23% to 30% of the weight of the blend used to form the container body.

30 [0018] The starch in the thermoplastic starch component may be present in an amount of about 26% of the weight of the blend used to form the container body.

[0019] The starch in the thermoplastic starch component may be utilised in the form of a thermoplastic starch component. That is it the starch may be utilised in conjunction with one or more other materials. For example the thermoplastic starch component may be a starch that is blended with a plasticiser. This may be desirable to make the

starch more easily blendable. For example, it is desirable that the thermoplastic starch component is blendable with non-starch materials such as (thermo)plastic materials. Desirably the starch is from a natural source.

5 [0020] Any suitable plasticiser may be used. For example a polyfunctional alcohol or combination of polyfunctional alcohols can be used. Suitable polyfunctional alcohols include glycerol and sorbitol and combinations thereof.

10 [0021] Within the thermoplastic starch component a compatibiliser may also be utilised to compatibilise the starch component with a polymer with which it is to be blended. For example the compatibiliser utilised may make the thermoplastic starch component compatible with polyethylene. For example the compatibiliser could be a polymer with groups that are compatible with the starch and groups that are compatible with the thermoplastic with which it is blended. Copolymers where one monomer is of a similar in nature to a polymer (with which the starch is) to be compatibilised and where a copolymerized co-monomer is compatible with the starch, for example reactive with the starch such as reactive with hydroxyl groups of the starch are desirable. In this respect grafted or random co-polymers may be used where the polymer backbone is of a monomer which is compatible with the polymer and the co-monomer is attached as pendant groups to the backbone.

20 [0022] For the present invention it is desirable that any compatibiliser has a backbone that is compatible with polyethylene. For example the backbone may be a polyethylene backbone. Any suitable pendant co-monomer can be used. Carboxylic acids, carboxylic acid anhydrides and esters of acrylic acid can be used as co-monomers. One suitable compatibiliser within the present invention is polyethylene-co-acrylic-acid.

25 [0023] For ease of blending the starch and optionally plasticiser may be pre-blended with an amount of polymer to which it is to be later blended. For example a thermoplastic starch component may be blended with polyethylene.

[0024] The process described and claimed in International Patent Publication WO 2011/020170 is suitable for preparing a thermoplastic starch of the invention.

30 [0025] To the extent, that in use, a thermoplastic starch component comprising components beyond the starch component is used the values given herein for the amount of starch refers to the starch only and does not include such other components.

35 [0026] For example, the polyethylene may be present in an amount from 66% to 94% of the weight of the blend used to form the container body. Optionally, the polyethylene is present in an amount from 67% to 87% of the weight of the blend used to form the container body. The polyethylene may be present in an amount from 70% to 80% of the weight of the blend used to form the container body. For example, the polyethylene

may be present in an amount of about 74% of the weight of the blend used to form the container body.

[0027] To the extent that polyethylene is utilised in the thermoplastic starch component the values given herein for the amount of polyethylene refers to the overall amount of polyethylene that is present in the container. (For the avoidance of doubt that amount does not include any copolymer of polyethylene that may be present for example as compatibiliser).

[0028] The oxygen permeability of the container body is at least 2.4 cm³ in 24 hours based on a wall thickness of 4 mm.

[0029] A pack of the invention can accommodate materials over a good range of viscosities. For example, the viscosity of the anaerobically curable composition may be from about 10 centipoise to about 8,000 centipoise.

[0030] Suitably the polyethylene is an LDPE-based material.

[0031] If desired, the blend from which the container body is formed may comprise a plasticiser.

[0032] As mentioned above, for some end-use applications, it is desirable that the container body is squeezable for dispensing the anaerobically curable composition. For example it may take the form of a squeezable bottle.

[0033] The container may further comprise a dispensing nozzle, optionally forming part of a closure for the container body, for dispensing anaerobic product from the container.

[0034] The container may further comprise a dispensing closure for dispensing anaerobic product from the container. Such a closure may incorporate a nozzle.

[0035] The container body may be coloured by a pigment. For example a pigment may be blended with the components forming the container body. This can be done without compromising the storage stability of the product contained therein.

[0036] The anaerobically curable material may comprise a monomer selected from the group consisting of (meth)acrylates, thiolenes, siloxanes, vinyls and, of course, combinations thereof.

[0037] The anaerobically curable monomer may be a (meth)acrylate monomer. (Meth)acrylate monomers suitable for use as a (meth)acrylate component in an anaerobically curable composition may be chosen from a wide variety of materials, such as these represented by H₂C=CGCO₂R₁, where G may be hydrogen, halogen or alkyl groups having from 1 to about 4 carbon atoms, and R₁ may be selected from alkyl, cycloalkyl, alkenyl, cycloalkenyl, alkaryl, aralkyl or aryl groups having from 1 to about 16 carbon atoms, any of which may be optionally substituted or interrupted as

the case may be with silane, silicon, oxygen, halogen, carbonyl, hydroxyl, ester, carboxylic acid, urea, urethane, carbonate, amine, amide, sulfur, sulfonate, sulfone and the like.

[0038] Additional (meth)acrylate monomers suitable for use in a pack of the invention include polyfunctional (meth)acrylate monomers, such as, but not limited to, di-or tri-functional (meth)acrylates like polyethylene glycol di(meth)acrylates, tetrahydrofuran (meth)acrylates and di(meth)acrylates, hydroxypropyl (meth)acrylate ("HPMA"), hexanediol di(meth)acrylate, trimethylol propane tri(meth)acrylate ("TMPTMA"), diethylene glycol dimethacrylate, triethylene glycol dimethacrylate ("TRIEGMA"), tetraethylene glycol dimethacrylate, dipropylene glycol dimethacrylate, di-(pentamethylene glycol) dimethacrylate, tetraethylene diglycol diacrylate, diglycerol tetramethacrylate, tetramethylene dimethacrylate, ethylene dimethacrylate, neopentyl glycol diacrylate, trimethylol propane triacrylate and bisphenol-A mono and di(meth)acrylates, such as ethoxylated bisphenol-A (meth)acrylate ("EBIPMA"), and bisphenol-F mono and di(meth)acrylates, such as ethoxylated bisphenol-F (meth)acrylate.

[0039] Still other (meth)acrylate monomers that may be used herein include silicone (meth)acrylate moieties ("SiMA"), such as those taught by and claimed in U.S. Patent No. 5,605,999 (Chu), the disclosure of which is hereby expressly incorporated herein by reference.

[0040] Of course, combinations of monomers, such as combinations of (meth)acrylate monomers, may also be used.

[0041] The (meth)acrylate component should comprise from about 10 to about 90 percent by weight of the composition, such as about 60 to about 90 percent by weight, based on the total weight of the composition.

Brief Description of the Drawings

[0042] Embodiments of the invention will be described, by way of example only, with reference to the accompanying drawings in which:

[0043] **Figure 1** is an image of (red) coloured 50 ml bottle made and tested in the experimental below; and

[0044] **Figure 2** is a graph showing the results of flexibility testing that was conducted on a bottle such as that shown in Figure 1 and as set out below.

Detailed Description of the Drawings

[0045] Figure 1 shows an image (photo) of a (red) coloured 50 ml bottle made and tested in the experimental below. A ruler is included in the image to give an indication of scale. (A similar bottle was made to hold 250 ml of product as set out below.)

5 [0046] A blend of polyethylene and a thermoplastic starch were utilised to form container bodies. Thereafter packs were formed utilising the container bodies and a closure for the container. Specifically anaerobically curable adhesive was placed in the container. The containers were found to demonstrate comparable storage stability to that demonstrated by a comparable container formed from PE alone.

10 [0047] All Loctite® products are available from Henkel Ireland, Tallaght Business Park, Whitestown, Tallaght, Dublin 24.

[0048] The following is a discussion of the creation of packs, tests carried out and the results of those tests:

Experimental

15 [0049] Packs which are in the form of bottles with anaerobic curable adhesive located therein are sold with what is often termed a “minimum” product fill volume - the containers are not filled to the top, rather a substantial headspace is left in the container. For example packs have been sold with respective fills of 50ml & 250ml of anaerobic product even though the containers themselves have a much greater
20 capacity for example internal volumes of approximately 106ml & 445ml respectively. The additional headspace is required in order to keep the products stable via access to oxygen.

[0050] Existing bottles in both sizes made from 100% LDPE and alternatives made up of 60% of the same LDPE and 40% Cardia BLF02 (Cardia BL-F02 is a commercially
25 available blend of thermoplastic starch and polyethylene – available from Cardia Bioplastics Unit 18/35 Dunlop Road Mulgrave, Victoria 3170, Australia) had 50 ml or 250 ml of product placed therein. The products for which specified tests were conducted are Loctite® products 270, 243, 242, 278, 290, 542, 549, 601,638, 648, 649, 2700, 2400, and 6300 as indicated in **Table 1** below.

30 [0051] Cardia BL-F02 is a thermoplastic starch material comprising starch; glycerol; sorbitol; polyethylene-co-acrylic-acid and polyethylene. Cardia BL-F02 is approximately (by weight) 66% starch, 30% polyethylene, and the remaining 4% is glycerol; sorbitol; and polyethylene-co-acrylic-acid.

[0052] The bottles were sealed with closures after filling.

[0053] Bottles were produced by a two cavity mould on a twin head extrusion blow moulding machine. The bottles made utilising the 40% Cardia BLF02 had the following dimensions and had 50 ml of anaerobic product placed inside:

50ml						
Cardia 40% trial	21.01.14			Cavity number	430.1	430.2
Overall Height		106.00 ± 1.00	mm		105.95	106.00
Overall Width		57.20 ± 1.00	mm		57.65	57.69
Overall Depth		28.00 ± 1.00	mm		28.26	28.30
Neck Height		13.70 ± 0.40	mm		13.75	13.76
"T" Dimension	Outside Threads	23.10 ± 0.20	mm		23.11	23.10
"T" Ovality		0.40 Max	mm		0.27	0.31
"E" Dimension	Inside Threads	21.10 ± 0.20	mm		21.11	21.23
"E" Ovality		0.40 Max	mm		0.21	0.19
"I" Dimension	Internal Neck	17.70 ± 0.20	mm		17.72	17.70
"I" Ovality		0.40 Max	mm		0.21	0.20
"S" Dimension	Thread Start	1.70 ± 0.40	mm		1.39	1.42
Thread Pitch		3.00 ± 0.10	mm		2.98	2.98
Thread Height		2.00 ± 0.10	mm		2.06	2.07
Wall Thickness(Min)		0.25			0.47	0.44
Leak Test		P / F			Pass	Pass
Brimfull Capacity		107.00 ± 6.00	ml		-	-
Bottle Weight		13.00 ± 1.50	gm		14.50	14.39
Dishing				Max top	28.37	28.50
				Min	28.08	28.18
				Max base	28.33	28.23
				D	0.14	0.09

- 5 [0054] The bottles made utilising the blend with 40% Cardia BLF02 had the following dimensions and had 250 ml of anaerobic product placed inside:

250ml						
Cardia 40% trial	21.01.14			Cavity number	429.10	
Overall Height		169.60 ± 2.50	mm		169.95	
Overall Width		91.50 ± 1.50	mm		91.86	
Overall Depth		45.00 ± 1.00	mm		45.39	
Neck Height		14.20 ± 0.40	mm		14.15	
"T" Dimension	Outside Threads	23.10 ± 0.20	mm		23.16	
"T" Ovality		0.40 Max	mm		0.10	
"E" Dimension	Inside Threads	21.10 ± 0.20	mm		21.24	
"E" Ovality		0.40 Max	mm		0.17	
"I" Dimension	Internal Neck	17.70 ± 0.20	mm		17.71	
"I" Ovality		0.40 Max	mm		0.07	
"S" Dimension	Thread Start	1.70 ± 0.40	mm		1.52	
Thread Pitch		3.00 ± 0.10	mm		2.98	
Thread Height		2.00 ± 0.05	mm		2.05	
Wall Thickness(Min)		0.25	mm		0.58	
Leak Test		P / F			Pass	
Brimfull Capacity		445.00 ± 10.00	ml		-	
Bottle Weight		36.00 ± 1.50	gm		36.47	
Dishing				Max top	45.08	
				Min	45.12	
				Max base	45.25	
				D	0.02	

[0055] Filled samples were then subjected to both accelerated (35°C & 45°C/98% relative humidity) and real time (22°C – often referred to generically as room

- 10 temperature, RT) ageing test programs as follows:

4wks @ 45°C/98%RH

- 8 wks @ 35°C
- 16 wks @ 35°C
- 6 mths @ 22°C
- 12mths @ 22°C
- 5 18mths @ 22°C
- 24mths @ 22°C

[0056] Length of real time ageing at 22°C is dependent on shelf life of product, which in most cases is 24mths.

10 [0057] The products and their specific test points are set out in **Table 1** below. (At the time of filing this application the 18 and 24 months testing were still ongoing, but performance to date is similar to that of conventional LDPE bottles.) The products and their test results are set out in **Table 2** below. A performance result equivalent to an LDPE bottle is considered to be a positive result.

15 [0058] Once test points are completed both sets of bottles are examined and visually compared for any evidence of gelling of product and/or deterioration of packaging and/or evidence of leakage.

[0059] Then samples were tested to ensure that required performance was being met. For this standard test methods STM-754, STM-8, STM-701 & STM-734 were used.

20 [0060] Unfilled bottles were subjected to Flexibility testing & Oxygen Transmission Rate measurements in comparison with LDPE & HDPE. They were also measured dimensionally to ensure they were within specification as indicated in the tabulated dimensions for each bottle.

25 [0061] Oxygen Transmission testing (OTR) was determined in accordance with ASTM F1307-02 using Mocon Oxtran 2/21 equipment with a coulometric sensor. The bottles were mounted such that the inside was purged for 12hrs by a stream of nitrogen while the outside was exposed to air (20.8% Oxygen) at 23°C, 50%RH. The bottles were tested using the converge mode. Equilibrium is established when the current transmission rate is less than 1% difference between the transmission rate obtained 5 cycles (30 minute/cycle) previous to the current transmission rate.

30 [0062] The result is quoted for 100% Oxygen. Four samples were tested for each bottle type. The integrity of the mounted bottles were checked prior to test using an Ai Leakmeter 120 electron-capture gas detector. The results are as follows.

	O2 transmission rate (cc/pack day to 100% O2)				Average
Purell LDPE	2.78	2.85	2.55	2.7	2.7
Marlex HDPE	1.34	1.64	1.45	1.63	1.5
Cardia BLF02 40%/Purell LDPE 60%	2.66	2.46	1.66	2.69	2.4

[0063] Purell is a brand name for product available from Lyondell Bassell, Houston, Texas, USA.

[0064] Marlex is a brand name for product available from Phillips Chemical International N.V., Overijse, Belgium.

5 [0065] Flexibility of bottles was determined on a TA-XT2i Stable Microsystems Texture Analyser using a P/2N stainless steel probe. Test speed was set at 0.5mm min and distance from central position was set at 6.5mm. Bottle was laid flat on the plate in horizontal position with the probe facing down in vertical orientation. Connected probe was set at a starting position where no load is being applied to the face of the bottle
10 wall. Unit was run at test speed until target distance was reached and graph produced of output values (Force/Kg) versus distance to compare the flexibility. Three samples of each bottle type was measured.

[0066] The results of this testing for a 50 ml bottle are set out in **Figure 2**. The 250ml bottle was assumed to have equivalent oxygen transmission.

Product	Test points
Loctite 270	All test points
Loctite 243	All test points
Loctite 242	6 & 12 mths @ 22°C only
Loctite 278	6 & 12 mths @ 22°C only
Loctite 290	All except 6mths @ 22°C
Loctite 542	6 & 12 mths @ 22°C only
Loctite 549	No 4wks @ 45°C/98%RH. Shelf life 12mths @ 22°C
Loctite 601	All test points
Loctite 638	All except 4wks @ 45°C/98%RH
Loctite 648	All except 4wks @ 45°C/98%RH
Loctite 649	All test points up to 12mths @22°C (shelf life)
Loctite 2700	All test points up to 18mths @ 22C (shelflife)
Loctite 2400	All test points up to 18mths @ 22C (shelflife)
Loctite 6300	All test points up to 12mths @22°C (shelflife)

Table 1

Test method	STM-754	STM-701	STM-734	STM-8	Result
Product	Shear strength	Break Torque	Fixture test	Stab test	Result
Loctite 270	Mild steel pins & collars	Mild & Stainless steel nuts & bolts	N/A	No	Results within specification and /or equivalent to LDPE bottles
Loctite 243	Mild steel pins & collars	Mild steel nuts & bolts	N/A	No	Results within specification and /or equivalent to LDPE bottles
Loctite 242	N/A	Mild steel nuts & bolts	N/A	No	Results within specification and /or equivalent to LDPE bottles
Loctite 278	Mild steel pins & collars	Zinc phosphate nuts & bolts	Brass nuts & bolts	No	Results within specification and /or equivalent to LDPE bottles
Loctite 290	Mild steel pins & collars	Mild steel nuts & bolts	N/A	No	Results within specification and /or equivalent to LDPE bottles
Loctite 542	Mild steel pins & collars	Mild steel nuts & bolts	N/A	No	Results within specification and /or equivalent to LDPE bottles
Loctite 549	N/A	Mild steel nuts & bolts	N/A	No	Results within specification and /or equivalent to LDPE bottles
Loctite 601	Mild steel pins & collars	Mild steel nuts & bolts	N/A	No	Results within specification and /or equivalent to LDPE bottles
Loctite 638	Mild & stainless steel pins & collars	Mild steel nuts & bolts	N/A	No	Results within specification and /or equivalent to LDPE bottles
Loctite 648	Mild steel pins & collars	N/A	N/A	Yes	Results within specification and /or equivalent to LDPE bottles
Loctite 649	Mild steel pins & collars	N/A	N/A	Yes	Results within specification and /or equivalent to LDPE bottles
Loctite 2700	Mild steel pins & collars	Mild steel nuts & bolts	N/A	No	Results within specification and /or equivalent to LDPE bottles
Loctite 2400	Mild steel pins & collars	Mild steel nuts & bolts	N/A	No	Results within specification and /or equivalent to LDPE bottles
Loctite 6300	Mild steel pins & collars	N/A	N/A	No	Results within specification and /or equivalent to LDPE bottles

Table 2

Conclusion

[0067] The bottles prepared according to the experimental above, clearly show that the pack of the invention provides an overall stability which is equivalent to existing packs
5 (such as LDPE). Furthermore, the bottles were shown to be compatible with the contents therein. No issues arose with premature curing/gelling of the product in the container. Furthermore, the containers were slightly easier to squeeze. And this was shown over a wide range of products of differing compositions.

[0068] Overall then, the bottles formed from the blending of the thermoplastic starch
10 with LDPE provided the same performance as equivalent 100% LDPE bottles in terms of product stability and compatibility, performance, oxygen transmission and are slightly easier to squeeze.

[0069] The words “comprises/comprising” and the words “having/including” when used
15 herein with reference to the present invention are used to specify the presence of stated features, integers, steps or components but do not preclude the presence or addition of one or more other features, integers, steps, components or groups thereof.

[0070] It is appreciated that certain features of the invention, which are, for clarity,
described in the context of separate embodiments, may also be provided in
combination in a single embodiment. Conversely, various features of the invention
20 which are, for brevity, described in the context of a single embodiment, may also be provided separately or in any suitable sub-combination.

Claims

1. A pack comprising:
 - 5 a. a container, the container having a container body, and the container body being sufficiently oxygen permeable to prevent an anaerobically curable composition held therein from curing due to absence of oxygen; and
 - b. an anaerobically curable composition held within the container;
- 10 wherein the container body is constructed from a plastics material which is formed from a blend of a thermoplastic starch component and a polyethylene.
2. A pack according to Claim 1 wherein the starch in the thermoplastic starch component is sourced from a renewable source.
3. A pack according to Claim 1 or Claim 2 wherein the starch in the thermoplastic
15 starch component is present in an amount from 6% to 33% of the weight of the blend used to form the container body.
4. A pack according to any preceding claim wherein the starch in the thermoplastic starch component is present in an amount from 13% to 32% of the weight of the blend used to form the container body.
- 20 5. A pack according to any preceding claim wherein the starch in the thermoplastic starch component is present in an amount from 20% to 30% of the weight of the blend used to form the container body.
6. A pack according to any preceding claim wherein the starch in the thermoplastic starch component is present in an amount from 23% to 30% of the weight of the
25 blend used to form the container body.
7. A pack according to any preceding claim wherein the starch in the thermoplastic starch component is present in an amount of about 26% of the weight of the blend used to form the container body.
8. A pack according to any preceding claim wherein the polyethylene is present in
30 an amount from 66% to 94% of the weight of the blend used to form the container body.
9. A pack according to any preceding claim wherein the polyethylene is present in an amount from 67% to 87% of the weight of the blend used to form the container body.

10. A pack according to any preceding claim wherein the polyethylene is present in an amount from 70% to 80% of the weight of the blend used to form the container body.
- 5 11. A pack according to any preceding claim wherein the polyethylene is present in an amount of about 74% of the weight of the blend used to form the container body.
12. A pack according to any preceding claim wherein the oxygen permeability of the container body is at least 2.4 cm^3 in 24 hours based on a wall thickness of 4 mm.
- 10 13. A pack according to any preceding claim wherein the viscosity of the anaerobically curable composition is from about 10 centipoise to about 8,000 centipoise.
14. A pack according to any preceding claim wherein the polyethylene is LDPE.
- 15 15. A pack according to any preceding claim wherein the blend from which the container body is formed comprises a plasticiser.
16. A pack according to any preceding claim wherein the container body is squeezable for dispensing the anaerobically curable composition.
17. A pack according to any preceding claim wherein the container body is a bottle.
- 20 18. A pack according to any preceding claim wherein the container further comprises a dispensing nozzle, optionally forming part of a closure for the container body, for dispensing anaerobic product from the container.
19. A pack according to any preceding claim wherein the container further comprises a dispensing closure for dispensing anaerobic product from the container.
- 25 20. A pack according to any preceding claim wherein the container body is coloured by a pigment.



Figure 1 Image of (red) coloured 50 ml bottle of the type made and tested

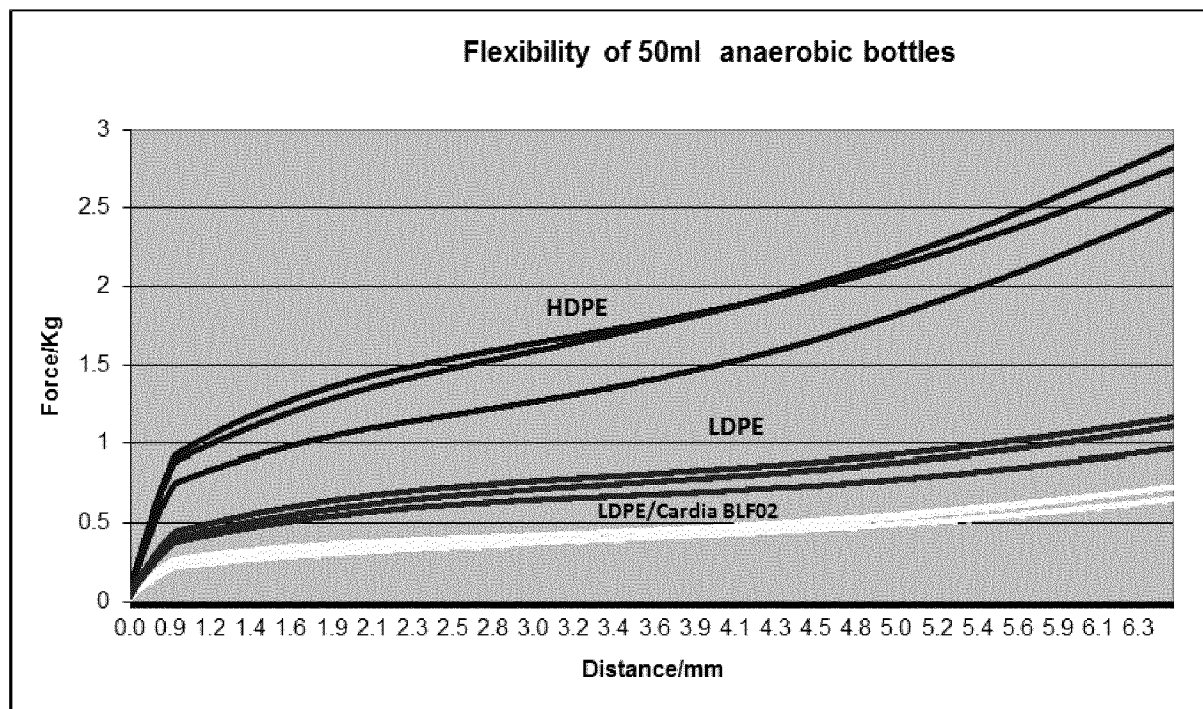


Figure 2

spec3499

INTERNATIONAL SEARCH REPORT

International application No
PCT/EP2014/066948

A. CLASSIFICATION OF SUBJECT MATTER
 INV. C08J5/00 B29D22/00 B65D35/00 B65D83/00 B65D85/00
 ADD.
 According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED
 Minimum documentation searched (classification system followed by classification symbols)
 C08J B29D B65D
 Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)
 EPO-Internal, WPI Data

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
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Further documents are listed in the continuation of Box C. See patent family annex.

* Special categories of cited documents :

<p>"A" document defining the general state of the art which is not considered to be of particular relevance</p> <p>"E" earlier application or patent but published on or after the international filing date</p> <p>"L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)</p> <p>"O" document referring to an oral disclosure, use, exhibition or other means</p> <p>"P" document published prior to the international filing date but later than the priority date claimed</p>	<p>"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention</p> <p>"X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone</p> <p>"Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art</p> <p>"&" document member of the same patent family</p>
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Date of the actual completion of the international search 1 April 2015	Date of mailing of the international search report 15/04/2015
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Name and mailing address of the ISA/ European Patent Office, P.B. 5818 Patentlaan 2 NL - 2280 HV Rijswijk Tel. (+31-70) 340-2040, Fax: (+31-70) 340-3016	Authorized officer Ansorge, Markus
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INTERNATIONAL SEARCH REPORT

International application No
PCT/EP2014/066948

C(Continuation). DOCUMENTS CONSIDERED TO BE RELEVANT		
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Y	page 1, line 1 - page 24, last line; claims 1-23	1-20
X	----- US 4 215 209 A (MEIER ERIC A [US] ET AL) 29 July 1980 (1980-07-29)	1-20
Y	claims 1-14; example 1	1-20
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	page 1, line 1 - page 16, last line; claims 1-13	
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