

USING CARBON DIOXIDE REGULATORS TO EXTEND THE SHELF LIFE OF PLASTIC PACKAGING

Cross-Reference to Related Applications

This application claims priority to provisional patent Appl. No. 60/548,286, filed
5 February 27, 2004, and to provisional patent Appl. No. 60/628,737, filed November
17, 2004, and to provisional patent application titled "Using Carbon Dioxide
Regulators to Extend the Shelf Life of Plastic Packaging" filed February 24, 2005.

Background of the Invention

Plastic and metal containers have been replacing glass in bottling beverages
10 where easy handling, low weight and non-breakability are needed. Plastic packaging,
especially polyethylene terephthalate (PET) bottles, are widely used for the
packaging of carbonated products such as beer, soft drinks, still waters and some
dairy products. For each of these products there is some optimum amount of
carbonation or carbon dioxide (sometimes referred to in this document as "CO₂")
15 pressure within the package to maintain its optimum quality. In conventional plastic
packaging, it is difficult to maintain the CO₂ pressure at this optimum level for an
extended period of time.

Plastic packaging is permeable to CO₂ and over time the pressure within the
bottle diminishes. Ultimately, after a defined amount of carbonation is lost, the
20 product is no longer suitable for use which is usually determined by a noticeable and
unacceptable change in flavor or taste. The point at which this occurs generally
defines the shelf-life of the package. The CO₂ loss rate is highly dependent on the
weight and dimensions of the package and on the temperature at which it is stored.
Lighter, thinner bottles lose carbonation more quickly, cannot withstand high internal
25 pressures, and have shorter shelf-lives. As plastic bottles become smaller, the
relative rate of carbonation loss becomes more rapid. Permeation is faster at higher

temperatures, reducing shelf-life, and making it difficult to store carbonated beverages in plastic containers in hot climates and still maintain a reasonable shelf-life. Longer shelf-life, lighter, less expensive plastic bottles, and the ability to store bottles longer in the absence of cooling have numerous economic advantages.

5 A variety of approaches have been applied to the problems described above. A simple method for extending the shelf-life of a carbonated beverage is to add additional carbon dioxide at the point of filling. This is currently used for carbonated soft drinks and for beer, but its effectiveness is hindered due to the effect of the over-carbonation on product quality and the negative effects that this can cause on the
10 bottle's physical performance. Small differences in internal pressure within the package cause significant differences in the effervescent qualities of the beverage. Dissolved CO₂ also effects taste. These precise requirements vary from product to product.

 Over-carbonation is also hindered by the pressure limitations of the package.
15 Making the bottle more pressure resistant is possible but requires use of additional material in the bottle construction or more exotic higher performing plastics.

 Carbonation can be maintained by reducing the CO₂ permeation rate. This typically involves application of a secondary barrier coating to a PET bottle, use of a more expensive, less permeable polymer than PET, fabrication of multilayer bottle
20 constructions, or combinations of these methods. These manufacturing approaches are invariably significantly more expensive than what is incurred in typical polyester bottle production and often these create new problems especially with recycling.

 Carbon dioxide generating materials have been used in the art to extend the shelf life of carbonated beverages. Molecular sieves treated with carbon dioxide

have been used to carbonate beverages by the reaction of the bound carbon dioxide with water.

U.S. Patent No. 6,852,783 issued to Hekal and U.S. Patent Application 2004/0242746 A1 to Freedman et al. describes a CO₂ releasing composition that can be incorporated or inserted into the packaging for carbonated beverages. The compositions in these references describe over twenty-five percent by weight of inorganic carbonate as the source of the carbon dioxide blended into the thermoplastic. A 32g PET bottle with a 25% loading of sodium bicarbonate has the potential to release 4.5 grams of carbon dioxide. This is approximately ten times higher than needed for application in a PET beer bottle and would likely cause an unsafe pressurization of the package. These structures also release their carbon dioxide too quickly to regulate pressure over a prolonged period especially if they were prepared in polyethylene terephthalate as opposed to polyethylene which has a far lower permeation rate for moisture. We have found such high loading levels to be unsuitable for our application since they have the potential to release far too much carbon dioxide into the package.

Summary of the Invention

This invention is directed to a method for replenishing carbon dioxide gas in a carbonated beverage container. The method comprises inserting a carbon dioxide regulator into the beverage container or into a closure of the container, and releasing carbon dioxide from said carbon dioxide regulator via a chemical reaction. The release of the carbon dioxide is regulated at a rate approximately equal to the rate of carbon dioxide loss from said container.

This invention is also directed to a method for replenishing carbon dioxide gas in a carbonated beverage container. The method comprises inserting a carbon

dioxide regulator into the container or into a closure of the container; and subsequently regulating the release of the carbon dioxide from the carbon dioxide regulator at a rate approximately equal to the rate of carbon dioxide loss from said container.

5 This invention is also directed to a packaging system for maintaining a consistent pressure of a carbonated beverage comprising a closure, a plastic container, and a carbon dioxide regulator.

 This invention is also directed to a method for making a packaging system for maintaining a consistent pressure in a carbonated beverage comprising overmolding
10 a preform around an assembly for a carbon dioxide regulator.

 This invention is also directed to a method for making a packaging system for maintaining a consistent pressure in a carbonated beverage comprising blending a carbon dioxide regulator into the plastic material used to form the body of a container for said carbonated beverage.

15 This invention is also directed to a carbon dioxide regulator composition for replenishing carbon dioxide gas in a carbonated beverage container comprising polymeric carbonates and organic carbonates, individually, or in combinations thereof.

 This invention is also directed to a carbon dioxide regulator composition for
20 replenishing carbon dioxide gas in a carbonated beverage container comprising materials that absorb and subsequently release carbon dioxide.

 A "carbonated beverage" as used herein is an aqueous solution in which carbon dioxide gas, in the range of about 2 to about 5 vol CO₂/vol H₂O, preferably about 3.3 to about 4.2 vol CO₂/vol H₂O for carbonated soft drinks, and about 2.7 to
25 about 3.3 vol. CO₂/vol H₂O for beer, has been dissolved.

“Carbon dioxide regulator,” as used herein, is a composition that acts to maintain a more constant carbon dioxide pressure within a package for a period of time by either slowly releasing CO₂ through a controlled chemical reaction process or by adsorbing and desorbing CO₂ through a physical process where the rate of this release is approximately equivalent to the CO₂ loss rate of the package.

Suitable CO₂ regulators include: polymeric carbonates, cyclic organic carbonates, organic carbonates such as alkyl carbonate, ethylene carbonate, propylene carbonate, polypropylene carbonate, vinyl carbonate, glycerine carbonate, butylene carbonate, diethyl carbonate, ethyl pyrocarbonate, methyl pyrocarbonate, dialkyl dicarbonate, or mixtures thereof; inorganic carbonates such as sodium bicarbonate, ferrous carbonate, calcium carbonate, lithium carbonate and mixtures thereof; molecular sieves, zeolites, activated carbon, silica gels and coordination polymers, metal organic frameworks (“MOF’s”), and isorecticular metal-organic frameworks (IRMOF’s). The amount of CO₂ regulator utilized is dependent upon the amount of carbon dioxide release desired which is dependent on the amount of carbon dioxide lost from the container over the shelf-life of the container.

Areas of the bottle in which the CO₂ regulator may be placed include, but are not limited to, the bottle closure, the bottle finish/neck, the bottle base, or blended into the plastic resin comprising the bottle.

Brief Description of the Drawings

Figure 1 is a depiction of the effect of a carbon dioxide regulator on the performance of a PET beer bottle.

Figure 2 is a depiction of the effect of a carbon dioxide regulator on the performance of a carbonated soft drink bottle.

Figure 3 is a depiction of a carbon dioxide regulator closure with disk insert and liner.

Figure 4 is a depiction of a carbon dioxide regulator assembly with disk and liner.

5 Figure 5 is a depiction of a carbon dioxide regulator closure with inset plug assembly.

Figure 6 is a depiction of a carbon dioxide regulator finish insert assembly.

Figure 7 is a depiction of carbon dioxide yield for an organic carbonate activated by water vapor.

10 Figure 8 is a depiction of the effect of bag sachet material on carbon dioxide release rate.

Figure 9 is a depiction of carbon dioxide loss on internal bottle pressure.

Figure 10 is a depiction of presaturation of carbon dioxide in 20 ounce bottles.

15 Detailed Description of the Invention

There are a wide variety of compositions that can serve as carbon dioxide regulators. These compositions fall into two categories. The first category is compositions that generate or release carbon dioxide via a controlled chemical reaction. Such compositions include: a) polymers such as aliphatic polyketones
20 which generate carbon dioxide as a degradation by-product of the polymer's reaction with oxygen or organic and inorganic carbonates groups that release carbon dioxide upon hydrolysis, especially in the presence of acids. Catalysts, binders, and other additives may be combined with these materials to help control the carbon dioxide release process; and b) organic carbonates such as alkyl carbonates, ethylene
25 carbonate, propylene carbonate, polypropylene carbonate, vinyl carbonate, glycerine carbonate, butylene carbonate, diethyl carbonate, ethyl pyrocarbonate, methyl

pyrocarbonate, cyclic carbonate acrylates such as trimethylol propane carbonate acrylate, and dialkyl dicarbonates which generate carbon dioxide upon hydrolysis that can be enhanced by reaction with an acid such as citric acid or phosphoric acid.

The second category is sorbent compositions that store carbon dioxide and then release it into the container as carbon dioxide is lost from the package. These include: absorbents such as silica gel; molecular sieves, zeolites, clays, activated alumina, activated carbon, and coordination polymers, metal organic frameworks or "MOF's" and isorecticular metal-organic frameworks or "IRMOF's" which are crystalline materials of metal oxide and organic acids analogous to zeolites. These materials may be engineered to have varying pore sizes and carbon dioxide storage capacity.

The various carbon dioxide generators described above may be blended into the polymer that makes up the container or the closure. They can also exist as layers in a multilayer closure, liner, or bottle design. Alternatively, they can be molded into an insert or disc that can be placed in the top of the bottle closure or in an insert which could be placed into the finish area of the container. Some designs are shown in Figures 3-6.

In systems where moisture is used to regulate the release rate of CO₂, the carbon dioxide regulator can be encapsulated or blended with a suitable polymer selected for its permeability to moisture and CO₂. By proper selection of the encapsulating or barrier polymer, the rate of moisture permeation can be used to control the rate of CO₂ release and match the CO₂ loss rate of the package thereby achieving a package which maintains a near constant internal CO₂ pressure for a period of time. This period of time is referred to as the regulation period.

In systems where oxygen is used to regulate the release rate of CO₂, the carbon dioxide regulator can be encapsulated or blended into a suitable polymer selected for its permeability to oxygen and CO₂. Again, by proper selection, the rate of CO₂ generation can be regulated to match the CO₂ loss rate of the package and
5 maintain a near constant internal CO₂ pressure for a period of time.

When the carbon dioxide regulator is prepared from a CO₂ adsorbing material, the additional CO₂ needed to extend shelf-life may be incorporated through over-carbonation at the point of filling. The package can be over-carbonated with the precise amount of CO₂ needed based upon the desired increase in shelf-life,
10 regulation period, and the CO₂ permeability of the package. The CO₂ regulating material must rapidly absorb this excess CO₂ before the package can deform due to excess CO₂. This adsorbance should occur within about six hours and preferably in about one hour. The CO₂ regulator should then release the adsorbed carbon dioxide at a rate less than or preferably approximately equivalent to the rate of carbon dioxide
15 loss from the package itself. This will ensure that a uniform and stable internal CO₂ pressure is maintained. Performance of specific regulator compositions may be optimized by proper drying, impregnating, and fabricating conditions that are well known to those skilled in the art. It is preferred to minimize the volume of the carbon dioxide regulator so that the space of the package is used efficiently.

20 Alternatively, the carbon dioxide regulator may be pre-charged with CO₂ by subjecting it to an environment of CO₂ gas so that it absorbs and holds enough CO₂ gas to replace CO₂ lost from the container during the normal use of the container.

The carbon dioxide regulator may be incorporated into the package in any number of ways. These include, but are not limited to, placing it inside the closure
25 either in a small cup or as a fabricated disk. These are illustrated in Figures 3-5.

These designs have several components, the body of the closure, the carbon dioxide regulator material, and a liner or cup material which supports the carbon dioxide regulator and can separates it from the package contents. The liner material can be designed to assist in controlling the CO₂ loss rate of the carbon dioxide regulator material either by acting to control the CO₂ permeation rate directly or by controlling the rate at which an activator can reach the carbon dioxide regulator. Water and water vapor can act as an activator in many systems. The amount of carbon dioxide regulator can vary depending on the requirements of the package. For smaller increases in shelf-life a thin insert may be placed inside the closure. For larger effects, where more carbon dioxide regulator would be required, the cup or plug-closure design would allow large amounts of carbon dioxide regulator to be used.

The carbon dioxide regulator may be placed into the bottle after it is fabricated by placing a formed piece into a suitable position in the bottle. This is illustrated in Figure 6. One approach would be a short tubular piece placed into a slot molded into the finish area of the bottle either during or after blow-molding. Another approach would be to over-mold a bottle preform around a carbon dioxide regulator assembly by placing the assembly on the core pin of a conventional injection mold and then over-molding a preform around this assembly using a polymer such as PET. The preform containing the carbon dioxide regulator assembly would then be blown into a bottle using conventional equipment. Another concept would be to use the stretch rod to position a regulator assembly into the bottle during blow-molding.

The carbon dioxide regulator can also be blended into the plastics used to form the body of the package or the closure. The preform containing the carbon dioxide regulator assembly would then be blown into a bottle using conventional

equipment. For such a system, it would be advantageous if the carbon dioxide regulator would not become active until the package was filled.

The carbon dioxide regulator can also be added as a layer in a multilayer fabrication either as a layer in the bottle, a layer in the closure, or a layer in the liner.

5 This layer may be made by any of the conventional multilayer extrusion and fabricating practices common in the industry including multilayer perform fabrication, multilayer film extrusion, coating, and laminating. The number of layers in the final package form may be from two to ten layers, and preferably three to five layers.

The release rate of carbonation from the carbon dioxide regulator can be
10 further controlled by either laminating with a film, coating the carbon dioxide regulator assembly, or by blending the carbon dioxide regulator into another material, especially a plastic. This may also facilitate the fabrication of the carbon dioxide regulator into a form suitable for this application. One approach would include blending the carbon dioxide regulator material into the polymer used to form the
15 closure liner or blending the carbon dioxide regulator material into the material used to produce the closure itself.

Molecular sieves are a preferred carbon dioxide regulator for this invention. Neat, uncompacted molecular sieves have the ability to absorb high levels of CO₂. The 13X molecular sieves absorb about 18% of their weight of CO₂ at bottle
20 pressure. Thus, for a 12 oz carbonated soft drink bottle that is carbonated to 4.0 vol., about 0.525 g of CO₂ gas is required to replace the CO₂ that lost from the package and double the shelf life. Molecular sieves appropriate to act as carbon dioxide regulators include, but are not limited to, aluminosilicate materials commonly known as 13X, 3A, 4A, and 5A sieves, faujasite, and borosilicate sieves. These materials

can be modified by ion exchange processes to modify their physical properties, and may be combined with fillers, binders, and other processing aids.

Another set of carbon dioxide regulators are coordination polymers, metal organic frameworks ("MOF's"), and isorecticular metal-organic frameworks (IRMOF's). These are polymeric structures made by the reaction of metal and organometal reagents with organic spacer molecules such than an open porous structure results. Any of the various related high porosity lattice systems prepared through such a reaction and that are capable of adsorbing and releasing carbon dioxide should be included.

Another set of carbon dioxide regulators include organic and inorganic carbonates. These materials react with water to form carbon dioxide especially in the presence of acid catalysts. Blending these materials into PET and activating them by filling the package with an acidic beverage is a preferred embodiment of our invention. Suitable inorganic carbonates would include sodium bicarbonate, calcium carbonate, and ferrous carbonate. Suitable polymeric carbonates would include cyclic carbonate copolymers such as poly(vinyl alcohol) cyclic carbonate and poly cyclic carbonate acrylate or linear aliphatic carbonate polymers. The poly(vinyl alcohol) cyclic carbonate is formed by the catalyzed reaction of poly vinyl alcohol with diethyl carbonate. A poly cyclic carbonate acrylate can be made by polymerizing the monomer, trimethylol propane carbonate acrylate, that is made from the catalyzed reaction between 2-ethyl-2-(hydroxylmethyl)-1,3-propanediol (trimethylpropane) and diethyl carbonate.

Another set of carbon dioxide regulators are polymers that oxidize to form carbon dioxide. One example of these would be aliphatic polyketones, example

would include polymers made by the reaction of ethylene and/or propylene with carbon monoxide.

One of the parameters important to optimizing the present invention is maximizing the density of CO₂ in the CO₂ source. The higher the density of the source with respect to moles of CO₂ per unit volume, the more CO₂ can be incorporated into the package to extend shelf life, while at the same time minimizing the volume occupied by the source. A variety of materials and their CO₂ densities are shown in Table 1 below.

TABLE 1**Density of Carbon Dioxide Sources**

		Effective Density	CO₂ Density	
		g/cc	g/cc	
Solid, CO₂				
Temp., C = -80		1.565	1.565	
Liquid, CO₂				
Temp., C = 0, Vap. Press. = 490 psig		0.929	0.929	
Temp., C = 25, Vap. Press. = 917 psig		0.713	0.713	
Gaseous, CO₂				
Temp. C = 0, Pressure = 44.07 psig		0.008	0.008	
Sorbent				
Sorption: 0.8 g/g for IRMOF-1 @ -77C		0.620	0.496	
Sorption: 0.18 g/g for 13X Mol Sieve Compacted @ 22 C		0.766	0.139	
Sorption: 0.022 g/g for Amorphous PET @ 22 C, 20 bar		1.335	0.030	
Stoichiometric Pairs				
Inorganic Carbonate	Acid			Ionization
sodium bicarbonate, NaHCO ₃	ascorbic acid, C ₆ H ₈ O ₆	1.797	0.304	mono
sodium bicarbonate, NaHCO ₃	benzoic acid, C ₇ H ₆ O ₂	1.578	0.337	mono
sodium bicarbonate, NaHCO ₃	citric acid, C ₆ H ₈ O ₇	1.696	0.270	mono
sodium bicarbonate, NaHCO ₃	fumaric acid, C ₄ H ₄ O ₄	1.833	0.403	mono
sodium bicarbonate, NaHCO ₃	maleic acid, C ₄ H ₄ O ₄	1.799	0.396	mono
sodium bicarbonate, NaHCO ₃	oxalic acid, C ₂ H ₂ O ₄	1.836	0.384	mono
sodium bicarbonate, NaHCO ₃	succinic acid, C ₄ H ₆ O ₄	1.693	0.369	mono
sodium bicarbonate, NaHCO ₃	terephthalic acid, C ₈ H ₆ O ₄	1.688	0.297	mono
Extra Strength Alka Seltzer, NaHCO ₃	Citric acid, non-stoichiometric	1.574	0.121	mono

Ferrous carbonate (iron(II)carbonate), CFeO_3	citric acid, $\text{C}_6\text{H}_8\text{O}_7$	2.040	0.275	mono
Ferrous carbonate (iron(II)carbonate), CFeO_3	fumaric acid, $\text{C}_4\text{H}_4\text{O}_4$	2.353	0.414	mono
lithium carbonate, Li_2CO_3	citric acid, $\text{C}_6\text{H}_8\text{O}_7$	1.667	0.276	mono
potassium bicarbonate, KHCO_3	citric acid, $\text{C}_6\text{H}_8\text{O}_7$	1.712	0.258	mono
sodium bicarbonate, NaHCO_3	citric acid, $\text{C}_6\text{H}_8\text{O}_7$	1.792	0.438	di
sodium bicarbonate, NaHCO_3	fumaric acid, $\text{C}_4\text{H}_4\text{O}_4$	1.928	0.597	di
calcium carbonate (calcite), CaCO_3	citric acid, $\text{C}_6\text{H}_8\text{O}_7$	1.714	0.301	di
calcium carbonate (calcite), CaCO_3	DL-malic acid	1.828	0.418	di
calcium carbonate (calcite), CaCO_3	dl-tartaric acid, $\text{C}_4\text{H}_6\text{O}_6$	1.886	0.398	di
calcium carbonate (calcite), CaCO_3	fumaric acid, $\text{C}_4\text{H}_4\text{O}_4$	1.885	0.476	di
dolomite, $\text{CaO} \cdot \text{MgO} \cdot 2\text{CO}_2$	citric acid, $\text{C}_6\text{H}_8\text{O}_7$	1.815	0.28	di
dolomite, $\text{CaO} \cdot \text{MgO} \cdot 2\text{CO}_2$	fumaric acid, $\text{C}_4\text{H}_4\text{O}_4$	2.020	0.427	di
Organic Carbonate				Hydration
ethylene carbonate, $\text{C}_3\text{H}_4\text{O}_3$		1.344	0.671	mono
propylene carbonate, $\text{C}_4\text{H}_6\text{O}_3$		1.204	0.519	mono
butylenes carbonate, $\text{C}_5\text{H}_8\text{O}_3$		1.146	0.434	mono
glycerine carbonate, $\text{C}_4\text{H}_6\text{O}_4$		1.390	0.518	mono
vinylene carbonate, $\text{C}_3\text{H}_2\text{O}_3$		1.353	0.692	mono
diethyl pyrocarbonate, $\text{C}_6\text{H}_{10}\text{O}_5$		1.122	0.304	mono
diethyl pyrocarbonate, $\text{C}_4\text{H}_6\text{O}_5$		1.122	0.609	di
dimethyl pyrocarbonate, $\text{C}_4\text{H}_6\text{O}_5$		1.250	0.410	mono
dimethyl pyrocarbonate, $\text{C}_4\text{H}_6\text{O}_5$		1.250	0.820	di
diethyl carbonate, $\text{C}_5\text{H}_{10}\text{O}_3$		0.976	0.364	mono

Another challenge is regulating the release of CO_2 from the source so that it generally corresponds to the rate of loss of CO_2 from the package. CO_2 release may be optimized through selection of the source itself, controlling activation of the CO_2 releasing reaction or by appropriate selection of membranes, coatings or films separating the CO_2 source from the beverage. Various methods are explained in the Example section below.

Another parameter important to optimizing the present invention is the volume, or thickness, of the carbon dioxide regulator required to produce sufficient amounts of CO_2 . In order to calculate the carbon dioxide regulator insert or thickness for a variety of reactant materials, a series of calculations are made assuming 100% conversion of the carbonate reactant to CO_2 . In the case of di- or tri- functional organic acids, one or more of the acid groups might react, but for purposes of the

calculations in the chart below, it is assumed that only one acid group reacts. The CaCO_3 and fumaric acid combination is included to demonstrate the effect of a more dense (higher yield of CO_2 per volume) reactant pair. Finally, ethylene carbonate is shown as an example of an organic source of carbonate, which decomposes upon reaction with water and does not require acidification. Table 2 below shows the effect of reactants on insert thickness.

TABLE 2

Effect of Reactants on Insert Thickness

Bottle	Type	Reactant	Calc. Insert Thkns.
12 oz.	CSD	1 mol NaHCO_3 + 1 mol Citric acid	0.2889"
12 oz.	CSD	1 mol CaCO_3 + 1 mol Fumaric acid	0.1602"
12 oz.	Beer	1 mol NaHCO_3 + 1 mol Citric acid	0.1134"
12 oz.	Beer	1 mol CaCO_3 + 1 mol Fumaric acid	0.0628"
12 oz.	Beer	ethylene carbonate	0.0423"
16 oz.	Beer	1 mol NaHCO_3 + 1 mol Citric acid	0.0758"
16 oz.	Beer	1 mol CaCO_3 + 1 mol Fumaric acid	0.0420"
16 oz.	Beer	ethylene carbonate	0.0283"

In the table above, mono-ionization is assumed and the total volume of the insert or disc is also increased by the addition of a non-reactive binding agent.

Some carbon dioxide regulators maybe pre-charged with CO_2 by subjecting it to an environment of CO_2 gas so that it absorbs and holds enough CO_2 gas to replace CO_2 lost from the container during the normal use of the container. Preferably, the CO_2 is released from the carbon dioxide regulator at a rate approximately equal to the rate of CO_2 permeation loss from the container.

One method of charging the carbon dioxide regulator with CO_2 is to place a disc or insert of the carbon dioxide regulator composition into the closure or finish of a carbonated drink bottle and then over-pressurizing the bottle with an amount CO_2 gas that is necessary to extend the container shelf life to the desired target. The excess

CO₂ is then quickly absorbed by the carbon dioxide regulator so that the bottle is not unduly stressed. The sorbed CO₂ is then released into the headspace of the carbonated beverage as the vapor pressure of the CO₂ decreases when product CO₂ is lost from the package. Another method is to pre-charge the disk or insert of the carbon dioxide regulator with CO₂ and to place the pre-charged disk into the closure or finish during the bottling and/or capping process.

Examples

Example 1

Various carbon dioxide regulators, specifically organic carbonates, were tested to determine whether they could be activated by water vapor alone and without an organic acid present. The results shown in Figure 7 illustrates that water vapor activates CO₂ production from organic carbonates by hydrolysis and an organic acid is not necessary.

Example 2

A variety of liner materials were tested to determine the effect of the permeability of the liner material on the rate of CO₂ production. A mixture of sodium bicarbonate and citric acid was sealed in a pouch suspended above 25 mL of water in a sealed bottle. The pouches were fabricated from three different materials with different permeabilities to moisture: a paper tea bag, polylactic acid and polyethylene. The results in Figure 8 demonstrates that a very low moisture barrier allows the most rapid rate of CO₂ generation and the higher moisture barrier provided by the polyethylene provides the slowest rate. Thus, a moisture barrier material

between the carbon dioxide regulator composition and the carbonated beverage can be used to control the rate of CO₂ production.

Example 3 – Sorbent CO₂ Saturation and Release

Various carbon dioxide generators, in particular sorbent materials, were tested to determine their capacity to store and release CO₂ under high pressure and to thereby extend the shelf-life of a carbonated beverage. The selected sorbent materials were first saturated under a high pressure CO₂ environment. The sorbent materials were then placed into 20 oz bottles and the bottles were rapidly carbonated with dry ice and capped. The molecular sieves were obtained from commercial sources and either used as received or dried by heating under vacuum. The 13X molecular sieve discussed below was obtained from the Aldrich Chemical Company and either used as received or dried under vacuum prior to use. The rate of CO₂ loss from the bottles was recorded over time. The results are shown below in Table 3:

TABLE 3

Summary of the CO₂ Saturation Experiments

Sample	% Shelf-Life Improvement
Control Bottles (no saturated additives)	-
Bottles w/8416 saturated film	32.6%
Bottles w/4A Molecular Sieves	104.2%
Bottles w/13X Molecular Sieves	61.4%
Bottles pre-saturated @300 psig CO ₂	0.2%

The results demonstrate that the shelf-life of a carbonated beverage can be extended by placing CO₂ saturated articles inside the bottles and that molecular sieves are particularly effective regulators.

Experiment 4 – Over-Pressurizing Bottles having molecular sieves with CO₂

An experiment was conducted to test the concept of over-pressurizing the bottle, storing the excess CO₂ in the molecular sieves and releasing the absorbed CO₂ back into the bottle head space. Four sets of 12 oz. bottles, each containing 15 cc of water and carbonated with dry ice, were tested. The first set was a control and was charged with 4.0 volumes of CO₂ only. The second set was charged with 4.75 volumes of CO₂ and about 3 grams of finely powered 13X molecular sieves dried under vacuum and contained in a test tube was also enclosed within the bottle. The third set was charged with 4.75 volumes of CO₂ and about 3 grams of un-dried finely powered 13X molecular sieves also contained in a test tube was enclosed within the bottle.

The results shown in Figure 9 shows that the control bottles lost CO₂ at a normal rate. However, the two sets that contained the molecular sieves showed an initial rapid drop in CO₂ pressure indicating that the CO₂ was absorbed by the molecular sieves. The CO₂ level in the headspace of the bottles then increased because the molecular sieves emitted the CO₂ back into the bottle. These two sets showed a theoretical increase of 11 weeks in shelf-life when compared to the control.

For the following examples, PET bottles were made by using conventional injection-blow molding procedures. They were made from a conventional PET bottle resin. The carbonated soft drink (CSD) bottles weighed 26.5 grams and had a volume of 12 ounces. The beer bottles used in the following examples had a weight of 37 grams, a volume of 500 mL, a champagne base, a 1716 finish, which is the neck and mouth of the bottle, and used a conventional CSD closure.

The effect of the carbon dioxide regulators on the internal pressure of PET bottles were conducted by placing a weighed amount of regulator sample into a test

tube and placing it into the PET bottle. Ten milliliters of water were added to the bottle in such a way that only water vapor was in contact with the adsorbent. The bottles were then carbonated according to the method taught in U.S. Patent No. 5,473,161. All test bottles were evaluated in triplicate.

5 The amount of carbon dioxide in the bottle was measured by FT-IR according to the method described by US patent 5,473,161 under license from The Coca-Cola Company. This directly corresponds to the internal CO₂ pressure in the bottles. Measurements were made periodically to track the amount of CO₂ remaining in the package. A conversion factor for the signal was used to convert the FT-IR result to
10 volumes of CO₂, a terminology commonly used in the packaging industry when describing the amount of carbonation in a carbonated beverage. One volume of CO₂ is the amount needed to give one atmosphere of pressure to the package at 20°C. The conversion constant was determined by placing a known amount of CO₂ into a bottle and measuring the CO₂ level within one hour of sealing. The conversion
15 constant was determined at several pressures and found to be constant within the precision of our test.

Shelf-life is determined by the amount of time it takes the CO₂ pressure in the package to fall to a minimum acceptable value. The requirement varies by the product packaged. For carbonated soft drinks, an initial carbonation level of about
20 4.0 volumes is used with a minimum acceptable level of about 3.3-3.4 volumes. This is a loss of 15-17.5%. For beer, a minimum carbonation level is typically 2.7 volumes with an initial level of 3.0 volumes. The initial carbonation level for each test was determined by measuring the CO₂ level within the package shortly after sealing. In cases where the shelf-life was not reached when our experiment was terminated, the

value was determined by extrapolation as shown in Figures 1 and 2. Most packages are used well before their ultimate shelf-life is reached.

Maintaining a very consistent carbonation level when the majority of the packages will be used is important for product quality. The period during which the internal CO₂ pressure stays relatively constant is defined as the regulation period. This is illustrated in Figures 1 and 2.

Comparative Example 5

A PET beer bottle with a 1716 finish and CSD closure was carbonated to a level of 3.3 volumes CO₂. This is a slightly higher initial carbonation level than typical of the industry. In beer, shelf-life is reached when the carbonation level reaches 2.7 volumes. Shelf-life and CO₂ loss rate results are shown in Table 4 and Figure 2.

Comparative Example 6

A 12 ounce CSD bottle with a CSD closure was carbonated to a level of 4.0 volumes of CO₂. For soft drinks shelf-life is reached at 3.3 - 3.4 volumes of CO₂. Results are shown in Table 4.

Example 5: Effect of 13X sieves on PET beer bottle shelf-life

One gram of dried 13X molecular sieve powder was placed in a test tube inside the same PET bottle-closure combination used in Comparative Example 5. CO₂ was added such that a carbonation level of 3.6 volumes of CO₂ would result in the absence of the adsorbent. Results are shown in Figure 1 and Table 4. Carbonation was monitored until the minimum requirement for beer, 2.7 volumes CO₂ was reached. Placing the adsorbent inside the package resulted in an immediate

reduction of measured CO₂ within the bottle and the shelf-life of the package was extended 36 days more than Comparative Example 5.

Example 6: Effect of 13X molecular sieves on 12 ounce CSD bottle shelf-life

5 This experiment was conducted as Example 5 except a 12 ounce CSD bottle and CSD closure was used. One gram of dried molecular sieve powder was placed in a test tube inside the same PET bottle. CO₂ was added such that a carbonation level of 4.35 volumes would result in the absence of the adsorbent. Carbonation level was monitored over time. Results are shown in Figure 2 and Table 4. Placing the
10 adsorbent inside the package resulted in an immediate reduction of free CO₂ and the shelf-life of the package was extended by 42 days when compared to Comparative Example 6.

TABLE 4
Effect of Adsorbent on Shelf Life and Internal CO₂
Pressure Loss

Example	Added Volume (Vol. CO ₂)	Initial Volume Measured (Vol CO ₂)	End Point (Vol CO ₂)	Regulation Period (Days)	Time to Shelf-life (Days)
Comp. 5	3.30	3.34	2.7	0	80
Comp 6	4.0	3.98	3.4	0	60
Example 5	3.60	3.38	2.7	30	116
Example 6	4.35	3.89	3.4	34	91

Comparison of Various Molecular Sieves

A variety of commercial molecular sieves (shown as individual letters in the
20 tables below) were tested according to the procedure described above using one gram of molecular sieve. These materials were obtained from various manufacturers (shown as "Mfr" in the Tables below) and used as received. One gram of each materials was tested in twelve ounce CSD bottles with PCO (plastic closure only)

finish at an added carbon dioxide volume of 4.5 volumes carbon dioxide. The initial carbon dioxide pressure was measured one hour after filling. Data on these molecular sieves are shown in Table 5.

5

TABLE 5

Shelf Life Extension with Various Molecular Sieves

Source	Sieve Type	Added volume (Vol. CO ₂)	Initial Pressure (Vol. CO ₂)	Regulation Period (Days)	Shelf Life (Days)
4.0 control	-	4.0	4.0	0	62
Aldrich	13X	4.5	4.1	44	102
Mfr 1	A	4.5	4.2	44	114
Mfr 1	B	4.5	4.2	44	110
Mfr 2	C	4.5	4.2	44	100
Mfr 2	D	4.5	4.3	44	100
Mfr 3	E	4.5	4.1	44	110
Mfr 3	F	4.5	4.2	44	110
Mfr 3	G	4.5	4.3	44	114

The effect of drying temperature on carbon dioxide retention performance was also measured. Drying molecular sieves often increases their capacity for adsorption.

10 Sieves were dried at 120°C for 15.5 hours and tested as described above. Results are shown in Table 6.

TABLE 6

Performance of Molecular Sieves After Drying at 120°C

Source	Sieve Type	Added volume (Vol. CO ₂)	Initial Pressure (Vol. CO ₂)	Regulation Period (Days)	Shelf Life (Days)
4.0 control	-	4.0	4.0	0	62
Aldrich	13X	4.5	4.2	46	105
Mfr 1	A	4.5	4.2	46	105

Mfr 1	B	4.5	4.2	46	110
Mfr 2	C	4.5	4.2	46	112
Mfr 2	D	4.5	4.3	46	99
Mfr 3	E	4.5	4.2	46	114
Mfr 3	F	4.5	4.1	46	105
Mfr 3	G	4.5	4.3	46	110

Sieves were dried at 240°C and tested as described above. Results are given in Table 7.

TABLE 7

Effect of Drying Sieve at 240°C

Regulator Material	Added volume (Vol. CO ₂)	Initial Pressure (Vol. CO ₂)	Regulation Period (Days)	Shelf Life (Days)
No Regulator	4.0	4.0	0	56
No Regulator	4.4	4.4	0	80
13X Sieve	4.4	4.2	14	71

Effect of Surface Area on Performance

A sample of 13X sieve powder was ground using a Spex Mill grinder to decrease its particle size and increase its surface area. The surface area and particle

size of the Aldrich 13X sieves before and after grinding is shown in Table 8.

TABLE 8

Surface Area and Particle Size of Aldrich 13X Sieves

Before and After Grinding

Measurement	Units	Original	Milled
Volume weighted mean diameter	microns	5.91	8.45
Surface weighted mean diameter	microns	3.41	3.17

Specific Surface Area	sq.m./g	1.7618	1.8919
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The performance of these materials was tested as described above using a twelve ounce CSD bottle with PCO finish and one gram of sieve. Results are shown in Table 9.

5

TABLE 9

Effect of Surface Area of Molecular Sieves on Carbonation Retention

Regulator Type	Specific Surface Area (sq. m/g)	Added volume (vol CO ₂)	Initial Pressure (Vol CO ₂)	Regulation Period (Days)	Shelf Life (Days)
No Regulator	-	4.0	4.0	0	56
13X Sieve	1.7618	4.5	4.3	44	140
13X Sieve	1.8919	4.5	4.1	44	140

Effect of Molecular Sieves in Tablet Form

Molecular sieves were pressed into pellets and tested either by exposing the tablet to the vapor space of the bottle or by immersing the tablet in water inside the container. Results are shown in Table 10.

10

TABLE 10

Comparison of Molecular Sieve Tablets and Powder

Regulator Type	Sieve Form	Added volume (vol CO ₂)	Initial Pressure (Vol CO ₂)	Regulation Period (Days)	Shelf Life (Days)
No Regulator	-	4.0	4.0	0	62
13X Sieve	Powder	4.5	4.1	46	102
13X Sieve	Tablet	4.5	4.1	46	104

15

Effect of Coatings to Modify Performance of Sieve Tablets

Molecular sieve tablets were prepared by compression and dried at 125°C. They were coated with a 2% solution of General Electric Silicone RTV615A 01P by mixing 10 parts of elastomer with 1 part curing agent, in heptane. Tablets were
 5 dipped in the coating and allowed to air dry at room temperature. The coated and uncoated tablets were placed in the headspace of a twelve ounce CSD bottle and tested as described above, and the results are shown in Table 11.

TABLE 11

Effect of Silicone Coating on Tablet Performance

Regulator Type	Sieve Form	Coating	Add CO ₂ (vol CO ₂)	Initial Pressure (Vol CO ₂)	Regulation Period (Days)	Shelf Life (Days)
No Regulator	-	-	4.0	4.0	0	62
13X Sieve	Tablet	Uncoated	4.5	4.0	46	102
13X Sieve	Tablet	Coated	4.5	4.1	40	-

Effect of Molecular Sieves in Closure Inserts

A small insert was prepared by injection molding a cup which would fit inside the closure and also act as the liner seal mechanism. This cup was designed to contain 1g of the molecular sieve material and fit inside of the finish of a twelve ounce CSD bottle. These cups were injection molded from polyethylene and polypropylene and the carbonation retention performance of molecular sieves placed into these
 20 cups was tested as described above. Data is shown in Table 12.

TABLE 12

Effect of Placing Molecular Sieves in Closure Inserts

Regulator Material	Cup Material	Add CO₂ (Vol. CO₂)	Initial Pressure (Vol. CO₂)	Regulation Period (Days)	Shelf Life (Days)
No Regulator	No Cup	4.0	4.0	0	62
No Regulator	No Cup	4.5	4.5	0	98
No Regulator	70-7931	4.5	4.5	0	100
No Regulator	955I	4.5	4.4	0	92
13X Sieve	70-7931	4.5	4.2	20	76
13X Sieve	955I	4.5	4.2	0	82

Note: 70-7931 is polypropylene obtained from BP
955I low density polyethylene obtained from Dow Chemical.

Comparison of Molecular Sieves with Ascarite

The performance of 13X molecular sieves and Ascarite, a carbon dioxide adsorbing mineral, are compared as described above using 1g of each material.

Results are shown in Table 13.

TABLE 13

Comparison of Carbonation Retention of Molecular Sieves and Ascarite

Regulator Form	Add CO₂ (vol. CO₂)	Initial Pressure (Vol. CO₂)	Regulation Period (Days)	Shelf Life (Days)
No Regulator	4.0	4.0	0	62
Ascarite	4.5	4.5	0	44
13X Sieve	4.5	4.5	44	108

Acid Activated Regulator Systems

A convenient method of regulating CO₂ release would be through contact of the package with the beverage. Many carbonated soft drinks are quite acidic, thus

making acidity a convenient trigger for CO₂ release from a carbon dioxide regulator incorporated into a PET bottle or closure. Common acids found in beverages include phosphoric acid and citric acid.

Suitable carbon dioxide regulators for this concept would include inorganic carbonates such as calcium carbonate, organic carbonate oligomers and polymers, such as shown in Table 14, and combinations thereof. The inorganic carbonates and organic carbonates oligomers were obtained from Aldrich Chemical Company. Cyclic carbonate polymers were obtained from Prof. Morton H. Litt of the Department of Macromolecular Science and Engineering at Case Western Reserve University.

PET was dry blended with various sources of carbon dioxide and compounded on a APV lab scale twin-screw extruder to form a water quenched strand. Approximately three grams of material was placed in a pH 2 solution of phosphoric acid in a 155 ml headspace vial and sealed with a crimp top silicone gasket. The generation of carbon dioxide was monitored by GC. The ml's of carbon dioxide generated per gram of regulator material per day is shown in Table 14. The approximate amount of regulator required to match the CO₂ release rate for a conventional 12 ounce carbonated soft drink container is also indicated.

TABLE 14

Rate of CO₂ Release From PET Blends

Sample	Carbonate Wt%	Molecular Sieve Wt%	PET Wt%	Temperature, C	CO ₂ Production, ml/g regulators/day	Amount to meet target, g
Filled PET						
13X Molecular Sieve Powder in PET	0	5	95	22	0.55	7.4
butylene	5	0	95	22	0.39	10.5

carbonate in PET						
butylene carbonate in PET with 13X	5	5	91	22	0.25	16.5
diethyl pyrocarbonate in PET	4	0	96	22	1.92	2.1
diethyl pyrocarbonate in PET with 13X	4	5	91	22	0.39	10.5
glycerine carbonate in PET	4	0	96	22	0.54	7.6
propylene carbonate in PET	5	0	95	22	0.52	7.9
propylene carbonate in PET with 13X	5	5	91	22	0.37	11.1
sodium bicarbonate, NaHCO ₃ in PET	5	0	95	22	8.13	0.5
sodium bicarbonate, NaHCO ₃ in PET with 13X	5	5	91	22	8.76	0.5
vinylene carbonate in PET	1	0	99	22	2.35	1.8
butylene carbonate in PET	5	0	95	52.2	0.69	6.0
diethyl carbonate in PET with 13X	5	5	91	52.2	0.72	5.7
vinylene carbonate in PET	1	0	99	52.2	7.60	0.5
Cyclic Carbonate polymer	5	0	95	23	0.13	30.9
Cyclic Carbonate polymer	5	0	95	22	0.15	27.4

Effect of Presaturation

- 5 Tablets of 4A extruded pellets with PET as a binder were prepared and saturated. 11.3 grams of 4A sieve was used with 4.8 grams of PET. The two

materials were blended together, and formed into a cylindrical compact in a pressure press at 10000 psig and approximately 100 to 120 C. The tablets were saturated in CO₂ at room temperature and 300 psig for 36 hours. The tablets adsorbed 1.47 grams of CO₂ on average. The tablets had been cut in half to allow them to be put
5 into the bottles. The bottles (6) were closed and monitored. The Figure 10 shows that the shelf life was extended with the 4A presaturated material. A maximum in the CO₂ level in the bottle occurred part way through the test that reveals the slow process of CO₂ evolution from the 4A material.

Tablets of 13X were prepared by a similar process. 3.2 grams of powdered
10 13X (Aldrich as for the 4A) and 4.8 grams of PET were formed into tablets, cut in half, and saturated with CO₂ at room temperature, 300 psig for 36 hours. The saturated pellets were placed in PET bottles and the CO₂ levels monitored. The shelf life was extended by the additional CO₂. The tablets had adsorbed 0.52 grams of CO₂ on average.

15 PET film, 5.25 inches square, 10 mil thick, and unstretched, were saturated at room temperature and 300 psig for 36 hours. 29 grams of film were allotted to each bottle. The PET film was saturated with CO₂ at room temperature for 36 hours at 300 psig. The film absorbed 0.99 grams of CO₂ on average. The film was placed in PET bottles (6) and the internal level of CO₂ monitored. The CO₂ that evolved from the
20 PET film extended the shelf life as shown in Figure 10.

Further discussion of Examples 5 and 6

Placing a suitable adsorbent inside a PET carbonated beverage bottle allows additional CO₂ to be added without causing an increase in the internal pressure of the
25 bottle. This is readily seen for Examples 5 and 6. For Example 5, CO₂ was added to

create a carbonation level of 3.6 volumes but after sealing only 3.38 volumes was measured. In Example 6, 4.35 volumes were added but only 3.89 volumes were measured within one hour after sealing. In each case, CO₂ was rapidly adsorbed preventing the over-carbonation from affecting the bottle.

5 The adsorbed CO₂ was then released into the bottle slowly over time resulting in a much more constant CO₂ pressure inside the package. The regulation period was thirty and thirty-four days for examples 5 and 6 respectively. This is well within the period of time in which most high volume carbonated beverages are packaged and sold.

10 The ultimate shelf-life for examples 5 and 6 is significantly longer than seen in the comparative examples. The shelf-life was extended by over thirty days in each case. A variety of different molecular sieves were evaluated as a basis for a carbon dioxide regulator. As illustrated in Table 5, we found a wide variety of materials to be effective.

15 We examined the effect of drying temperature on carbon dioxide regulator performance. We found that it was not necessary to dry molecular sieve based regulators to achieve excellent performance and that drying them to a temperature lower than conventionally used to dry these materials, 120 °C, gave some improvement in performance. Drying at higher temperature, 240 °C, resulted in a
20 significant decrease in the regulation period. Avoiding the need to dry the sieves prior to used would be very advantageous in a number of carbon dioxide regulator designs.

 Increasing the particle size and surface area of the adsorbent resulted in a significant increase in the amount of CO₂ which a carbon dioxide regulator could

adsorb as shown in Table 5. Optimizing particle size and surface area for a particular carbon dioxide regulator would be a matter of routine experimentation.

The physical form of the regulator will be important in developing an optimized carbon dioxide regulator design. We found that molecular sieves pressed into the
5 form of a tablet could be just as effective a regulator as molecular sieve powder. Optimization of the form and shape of the regulator is again a matter of routine experimentation.

Coating a molecular sieve tablet is expected to be a particularly effective method of producing a regulator. A critical feature of this coating would be to allow
10 the rapid adsorption of CO₂ during bottle filling to facilitate over-pressurization as a method for introducing additional carbon dioxide. We found silicone coatings to be effective as shown in Table 11.

An insert cup assembly represents one practical method for producing a carbon dioxide regulator system. We found that polyethylene based insert cups could
15 to be effective as illustrated in Table 12. Other polyolefins suitable for such assemblies would include thermoplastic polyolefin elastomers, ethylene copolymers, such as linear low density polyethylene, and ultralowdensity polyethylene, ethylene-propylene copolymers, propylene copolymers, and styrene thermoplastic elastomers. Softer polyolefins materials capable of forming a tight seal with the surface of the
20 package would be preferred. Determining the optimized dimensions and materials for an insert cup or other regulator form is a matter of routine experimentation.

Many materials which adsorb carbon dioxide do not readily form regulator systems as is illustrated in Table 13. Ascarite is a mineral which readily adsorbs large quantities of carbon dioxide but does not in its pure form produce a suitable

carbon dioxide regulator since the CO₂ is not released at a rate similar to the rate of CO₂ loss from the package.

There are a number of factors that one skilled in the art realizes would further enhance this invention. It is advantageous that the adsorbents have as high a capacity to adsorb carbon dioxide as possible. Capacity is the weight of carbon dioxide adsorbed per the weight of the adsorbent. Adsorbents with higher CO₂ adsorption capacity would be preferred since less would need to be added to the package to generate the desired shelf-life improvement.

The conditions under which these are handled can also be important. It is well known that heating molecular sieves can remove trapped species and create more capacity. Surprisingly, over-drying impairs the performance of these materials as a CO₂ regulator.

The molecular sieve may need to be combined with a binder material to facilitate its fabrication into parts suitable for this application. The type needed would depend on the properties of the sieve and the final properties needed in the final fabricated piece. They would include inorganic binders regularly used to improve the mechanical properties of molecular sieves, organic polymers in which the adsorbent may be blended and lower molecular weight resins and oligomers in which the adsorbent could be dispersed. These could be thermoset or thermoplastic in nature and can include materials such as silicone rubbers, polyolefins, epoxies, unsaturated polyesters, and polyester oligomers.

It is important to control the rate at which adsorbed CO₂ is released from the adsorbent and to prevent liquid water from causing a sudden release of adsorbed CO₂, to prevent the removal of sensory components of the beverage, or to permit components of the package to contact the regulator in a controlled way. This can be

done by either placing the adsorbent into a polymer with a low permeability for water or placing a thin film of such a polymer between the beverage and the adsorbent material. This material would need to allow CO₂ to readily adsorb the over-carbonation and could be comprised of a semi-permeable membrane, a permeable
5 membrane or a material with a high CO₂ permeability and their combinations. Suitable materials include polyolefins such as low density polyethylene, high density polyethylene, polypropylene, ethylene-propylene elastomers, ethylene-vinyl acetate copolymers, and silicone rubbers. Suitable membrane materials would include liquid impermeable/vapor permeable materials such as Gore-Tex or similar structures.
10 Especially preferred embodiments of our invention are blending the adsorbent into a suitable polymer and using this to fabricate the bottle closure itself, inserting a fabricated disk of adsorbent into the closure behind the closure liner, protecting a tubular insert with a thin film or coating of CO₂ permeable polymer or molding a tubular insert from a combination of adsorbent and CO₂ permeable polymer. The
15 preferred method of placing the adsorbent into the bottle and optimizing its performance is a matter of further experimentation.

Carbon dioxide regulators can also be formed by blending CO₂ releasing materials into PET as is shown in Table 14. For such a carbon dioxide regulator, it is critical that the CO₂ release not occur prior to filling of the package so that carbon
20 dioxide regulator performance is not lost in bottle storage. A variety of inorganic and organic carbonates can be blended into PET at concentration below 20% by weight and preferably under 10% by weight and achieve a rate of CO₂ release equivalent to the CO₂ loss rate of a conventional PET package. These are activated by exposing to water with a pH range similar to many carbonated soft drinks.

One aspect of this invention is to allow carbonated beverages to be stored for longer periods in hot locations without the need for more expensive coatings or cold storage conditions. In hot locations, storage temperature can be quite high and since the permeability of bottles for carbon dioxide is proportional to temperature, CO₂ loss rates are higher. Also, due to these temperatures the internal pressure inside the bottle can reach dangerous levels. Thus, a system which can maintain a stable and consistent internal pressure and increase shelf-life is particularly advantageous.

Another aspect of this invention is to allow for light-weighting of current carbonated beverage bottles and maintain their current shelf-life. The rate of permeation of a package is inversely proportional to the thickness of the package wall. It is economically advantageous to make packaging as light-weight as possible which results in wall thickness being reduced. A system which extends shelf-life of conventional packaging will be able to give thinner walled packaging a shelf-life equivalent to that of conventional packaging. Many of the bottles in applications that this technology is directed toward are in packages that cannot be lightweighted further without a further loss in shelf-life or through the use of more expensive bottle fabrication techniques.

Another aspect of this invention is to permit the maintaining of a more optimum and stable carbonation level for longer periods of time thus yielding a more consistent product taste and quality. The amount of dissolved carbon dioxide in a beverage is proportional to the carbon dioxide pressure in the container. Dissolved carbon dioxide concentration effects pH and other properties of the beverage. A stable amount of dissolved carbon dioxide will equate to a more consistent taste of the beverage product.

Another aspect of this invention is the control of the rate of release of carbon dioxide and that this release rate not materially exceed the permeation rate of the package. Over-pressurization of carbonated beverage bottles is a significant problem and can lead to rupture of the package, an economic and safety consideration. Any effective CO₂ regulating system for a carbonated beverage bottle must not release carbon dioxide at a rate significantly greater than the rate of CO₂ loss from the package. Ideally, the release rate should be equal to or slightly less than the permeation rate from the package and should not exceed a rate of 125% of the rate of permeation of the package. It must also be able to release the CO₂ consistently over a prolonged period of time ideally over a period of up to three months and for at least two weeks.

Another aspect of this invention is that it is self-regulating with respect to the thermal environment of the package such that in a warmer environment when the carbonation losses are higher, the regulators naturally release higher amounts of carbon dioxide that replenish the losses.

Another aspect of this invention is to provide a packaging system which can allow over-carbonation without increasing the pressure inside the package and allow lighter weight bottles to be acceptable for holding carbonated beverages. Adding extra carbonation at the point of filling is a very economical method for extending the shelf-life of carbonated beverages and is used today in the packaging of soft drinks and beer. It is limited by the ability of the package to maintain this higher initial pressure level. A system which adsorbs and re-releases this carbon dioxide will expand the amount of over-carbonation which can be done during filling and will facilitate the use of vessels with a lower pressure resistance.

Carbon dioxide regulation will also facilitate the use of containers which have lower modulus. Many plastics are not suitable for packaging carbonated beverages because they cannot contain the high internal pressures which can develop with carbonated soft drinks. An example are polyolefins such as polypropylene. The use
5 of a carbonation regulator with a lower modulus plastic such as polypropylene could allow it to be more generally useful for packaging of carbonated beverages.

This invention has been described for the purposes of illustration only in connection with certain embodiments. However, it is recognized that various changes, additions, improvements, and modifications to the illustrated embodiments
10 may be made by those persons skilled in the art, all falling within the scope and spirit of the invention.

15

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We claim:

1. A method for replenishing carbon dioxide gas in a carbonated beverage container comprising:
 - i. Inserting a carbon dioxide regulator into said container or into a closure of said container;
 - ii. Releasing carbon dioxide from said carbon dioxide regulator via a chemical reaction; and
 - iii. Regulating the release of carbon dioxide from said carbon dioxide regulator at a rate approximately equal to the rate of carbon dioxide loss from said container.
2. The method of claim 1 wherein said carbon dioxide regulator comprises polymeric carbonates and organic carbonates, individually, or in combinations thereof.
3. The method of claim 2 wherein said organic carbonates have a carbon dioxide density of between about 0.25 and about 0.9 grams per cubic centimeter.
4. The method of claim 1 wherein carbon dioxide released from said carbon dioxide regulator of step (iii) is regulated by water vapor.
5. The method of claim 4 wherein said carbon dioxide regulator is an organic carbonate comprising alkyl carbonates, dialkyl carbonates, ethylene carbonate, propylene carbonate, polypropylene carbonate, vinyl carbonate, glycerine carbonate, butylene carbonate, diethyl carbonate, ethyl pyrocarbonate, methyl pyrocarbonate, dialkyl dicarbonate, and cyclic carbonate acrylates.
6. The method of claim 1 wherein carbon dioxide released from said carbon dioxide regulator of step (iii) is regulated by liners, coatings, or films, individually, or in combinations thereof.

7. The method of claim 1 wherein said carbon dioxide regulator is housed in an insert which has a thickness of between about 0.01 inches to about 0.3 inches.

5 8. The method of claim 1 wherein said chemical reaction of step (ii) comprises an oxidation reaction.

9. The method of claim 1 wherein said chemical reaction of step (ii) comprises a hydrolysis reaction.

10

10. A method for replenishing carbon dioxide gas in a carbonated beverage container comprising

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i. Inserting a carbon dioxide regulator into said container or into a closure of said container; and

ii. Regulating the release of carbon dioxide from said carbon dioxide regulator at a rate approximately equal to the rate of carbon dioxide loss from said container.

20

11. The method of claim 10 wherein said carbon dioxide regulator is a sorbent that absorbs and subsequently releases carbon dioxide gas.

12. The method of claim 10 wherein said carbon dioxide regulator may optionally be pre-charged with carbon dioxide prior to inserting said carbon dioxide
25 regulator into said container.

30

13. The method of claim 10 wherein said carbon dioxide regulator may optionally be charged by placing an insert of said carbon dioxide regulator into a closure or finish of said container and subsequently overpressurizing said container with a suitable amount of carbon dioxide.

14. The method of claim 10 wherein said carbon dioxide regulator comprises materials that absorb and subsequently release carbon dioxide.

5 15. The method of claim 14 wherein said carbon dioxide regulator comprises molecular sieves.

10 16. The method of claim 14 wherein said carbon dioxide regulator comprises silica gels, molecular sieves, clays, activated alumina, zeolites, coordination polymers, metal organic frameworks, and isorecticular metal organic frameworks.

15 17. The method of claim 10 wherein the insertion of step (i) occurs so that said carbon dioxide regulator does not come into contact with said carbonated beverage.

18. The method of claim 10 wherein said carbon dioxide regulator may be blended directly into the material of said container or said closure.

20 19. A packaging system for maintaining a consistent pressure of a carbonated beverage comprising a closure, a plastic container, and a carbon dioxide regulator.

25 20. The packaging system of claim 19 wherein said closure comprises any materials used for sealing said plastic container, such as a plastic assembly of said closure and liner material therein.

30 21. The packaging system of claim 19 wherein said carbon dioxide regulator can be blended into any of the materials used to produce said plastic container, said closure, or said liner material.

22. The packaging system of claim 19 wherein said carbon dioxide regulator can be inserted into said plastic container or said closure in a form suitable for said plastic container.

23. The packaging system of claim 19 wherein said carbon dioxide regulator can be part of a regulator assembly by overmolding a preform around said regulator assembly using PET.

5

24. The packaging system of claim 23 wherein said preform is fabricated into a plastic container.

25. The packaging system of claim 19 wherein said carbon dioxide regulator can be added as a layer in said plastic container.

10

26. The packaging system of claim 19 wherein said carbon dioxide regulator can be added as a layer in said closure.

27. A method for making a packaging system for maintaining a consistent pressure in a carbonated beverage comprising overmolding a preform around an assembly for a carbon dioxide regulator.

15

28. The method of claim 27 wherein said overmolding occurs by placing said assembly on a core pin of a conventional injection mold and subsequently molding said preform around said assembly.

20

29. The method of claim 27 wherein said preform is fabricated into a plastic container.

25

30. A method for making a packaging system for maintaining a consistent pressure in a carbonated beverage comprising blending a carbon dioxide regulator into the thermoplastic material used to form the body of a container for said carbonated beverage.

30

31. A carbon dioxide regulator composition for replenishing carbon dioxide gas in a carbonated beverage container comprising polymeric carbonates and organic carbonates, individually, or in combinations thereof.

5 32. The composition of claim 31 wherein said polymeric carbonates comprise cyclic carbonate polymers and linear aliphatic carbonate polymers.

10 33. The composition of claim 31 wherein said organic carbonates comprise alkyl carbonates, dialkyl carbonates, ethylene carbonate, propylene carbonate, polypropylene carbonate, vinyl carbonate, glycerine carbonate, butylene carbonate, diethyl carbonate, ethyl pyrocarbonate, methyl pyrocarbonate, dialkyl dicarbonate, and cyclic carbonate acrylates.

15 34. A carbon dioxide regulator composition for replenishing carbon dioxide gas in a carbonated beverage container comprising materials that absorb and subsequently release carbon dioxide.

20 35. The composition of claim 34 wherein said material that absorb and subsequently release carbon dioxide comprise molecular sieves.

25 36. The composition of claim 34 wherein said materials that absorb and subsequently release carbon dioxide comprise silica gels, molecular sieves, clays, activated alumina, zeolites, coordination polymers, metal organic frameworks, and isorecticular metal organic frameworks.

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