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PACKAGING ASSEMBLY
INSTRUCTIONS
6 X 1 LITER Combination Packaging

Package: 1 LITER Issue Date: May 18, 2015 Revision: B UN Cert # +CC8458
With 38-439 or 45 mm Neck Finish

NO. / CASE	LIST OF COMPONENTS	Reference	SPEC / PART #
(6)	Berry 38-439A Acid Closure with Foam Liner OR	Figures Below	20038485
(6)	Menshen Tamper Evident 45 mm Closure DIN45E with PTFE Liner		21451022
(6)	1 Liter Bottle HDPE with 38-439 Neck Finish		1279825
(6)	1 Liter Bottle HDPE with 45 mm Neck Finish		1279746
(1)	Regular Slotted Corrugated Container, Pre-assembled	Figures Below	
(1) Roll	2" Clear Pressure Sensitive Tape (Scotch 3M Packaging Tape)	Figures Below	
PACKAGING CONFIGURATIONS:		Case Sealing Method	
Configuration : Six (6) 1 L Bottles/ Reshipper Carton		Top: 2" Clear Pressure Sensitive Tape Top and Bottom: Taped	

ASSEMBLY INSTRUCTIONS:

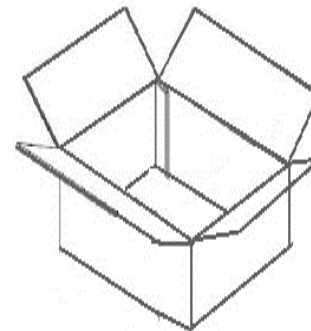
Note: Refer to component list above. Examine all parts for defects. Once you have determined that this packaging is free from defects then follow these instructions for package assembly.

1. Apply 38-439 threaded closure to bottle with an application torque of 35 to 50 in-lbs using an appropriate closing tool or,
2. Apply 45 mm threaded closure to bottle with an application torque of 23 to 28 in-lbs using an appropriate closing tool
5. For flat carton, fold in two opposite minor bottom flaps of carton. Then fold in remaining two major bottom flaps making sure that the exposed flaps display the Box Maker's Certificate or the Guarantee Stamp.
6. Tape the bottom flaps closed with 2" clear pressure sensitive tape. Center the tape over the middle seam formed by the flaps being folded together. The length of the tape should be such that there is a minimum 2" extension on each end.
7. Then place six (6) bottles in the carton with the bottle closures facing upward.
8. Tape the top flaps closed with 2" clear pressure sensitive tape. Center the tape over the middle seam formed by the flaps being folded together. The length of the tape should be such that there is a minimum 2" extension on each end.
9. Apply product labels and DOT hazard warning labels as required by customer work order instructions. Do not cover up any UN markings or DOT Hazard labels with tape.

1L/ 38-439



1 L/ 45 mm



4G/Y13.1/S/**
USA/ +CC8458