



**PurePak Technology Corporation**  
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**PACKAGING ASSEMBLY INSTRUCTIONS**

**2.6 Liter Combination Packaging**  
**1/carton, 4/carton and 6/carton**

**Package: 2.6 Liter**  
**With 38-439 or 45 mm Neck Finish**

**Issue Date: April 27, 2012**

**Revision: C**

**UN Cert # +CC7198**

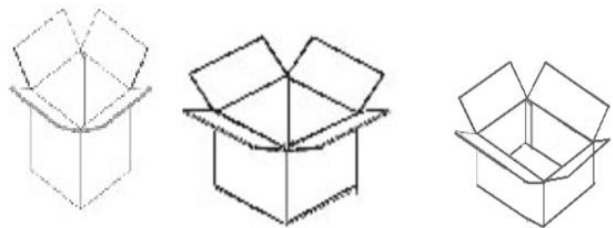
| NO. / CASE        | LIST OF COMPONENTS  | Reference     | SPEC / PART # |
|-------------------|---|---------------|---------------|
| (1) or (4) or (6) | Berry 38-439 A Stock Acid Closures with Foam Liner OR       | Figures Below | 20038485      |
| (1) or (4) or (6) | Menshen Tamper Evident 45 mm Closure DIN45E with PTFE Liner |               | 21451022      |
| (1) or (4) or (6) | 2.6 Liter Bottle with 38-439 Neck Finish                    |               | 971545        |
| (1) or (4) or (6) | 2.6 Liter Bottle with 45 mm Neck Finish                     |               | 971546        |
| (1)               | Regular Slotted Corrugated Container, Pre-assembled         | Figures Below |               |
| (1) Roll          | 2" Clear Pressure Sensitive Tape (Scotch 3M Packaging Tape) | Figures Below |               |
| Adhesive          | H.B Fuller Hot Melt Adhesive PHC-9256                       | Figures Below |               |

| PACKAGING CONFIGURATIONS:                                      | Case Sealing Method  |
|--|--|
| Configuration : One, Four or Six 2.6L Bottles/reshipper carton | Top: 2" Clear Pressure Sensitive Tape<br>Bottom: May be Glued or Taped |
| Configuration: One, Four or Six 2.6L Bottles/reshipper carton  | Top: 2" Clear Pressure Sensitive Tape                                  |
|  | Top: 2" Clear Pressure Sensitive Tape                                  |

**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.
2. Apply 45 mm threaded closure to bottle with an application torque of 23 to 28 in-lbs using an appropriate closing tool
3. For preassembled carton, place (1,4 or 6) bottles in carton with the bottle closures facing upward.
4. 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.
5. For flat carton, fold in two opposite bottom flaps of carton. Then fold in remaining two adjacent 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 (1, 4 or 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.



**4G/Y30.6/S/\*\***  
**USA/ +CC7198**

**\*\* (Year of Manufacture)**