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

<table>
<thead>
<tr>
<th>NO. / CASE</th>
<th>LIST OF COMPONENTS</th>
<th>Reference</th>
<th>SPEC / PART #</th>
</tr>
</thead>
<tbody>
<tr>
<td>(1) or (4) or (6)</td>
<td>Berry 38-439 A Stock Acid Closures with Foam Liner OR</td>
<td>Figures Below</td>
<td>20038485</td>
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<tr>
<td>(1) or (4) or (6)</td>
<td>Menshen Tamper Evident 45 mm Closure DIN45E with PTFE Liner</td>
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<td>21451022</td>
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<td>(1) or (4) or (6)</td>
<td>2.6 Liter Bottle with 38-439 Neck Finish</td>
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<td>971545</td>
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<td>(1) or (4) or (6)</td>
<td>2.6 Liter Bottle with 45 mm Neck Finish</td>
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<td>971546</td>
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<td>(1)Roll</td>
<td>2&quot; Clear Pressure Sensitive Tape (Scotch 3M Packaging Tape)</td>
<td>Figures Below</td>
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<td>Adhesive</td>
<td>H.B Fuller Hot Melt Adhesive PHC-9256</td>
<td>Figures Below</td>
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</table>

PACKAGING CONFIGURATIONS:

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

Configuration: One, Four or Six 2.6L Bottles/reshipper carton
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.