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# PACKAGING ASSEMBLY INSTRUCTIONS

2.5 Liter Combination Packaging  
1/carton, 4/carton and 6/carton

**Package: 2.5 Liter    Issue Date: August 12, 2011    Revision: C    UN Cert #+CC6166**  
**With 38-439 or 45 mm neck finish**

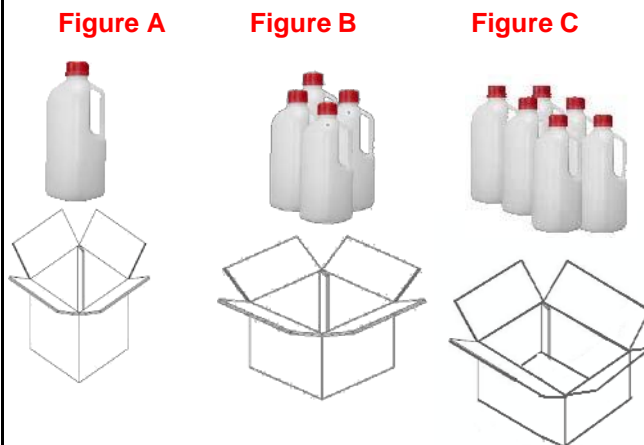
NO. / CASE	LIST OF COMPONENTS	Reference	SPEC / PART #
(1) or (4) or (6)	Berry 38-439 A Stock Acid Closures with Foam Liner OR	Figures Below	500093
(1) or (4) or (6)	Menshen Tamper Evident 45mm Closure DIN45E with PTFE Liner		500001
(1) or (4) or (6)	2.5 Liter Bottle with 38-439 Neck Finish		1222529
(1) or (4) or (6)	2.5 Liter Bottle with 45 mm Neck Finish		1906665
(1)	Regular Slotted Corrugated Container, Pre-assembled	Figures Below	731195
(1) Roll	2" Clear Pressure Sensitive Tape (Scotch 3M Packaging Tape)	Figures Below	
Adhesive	H.B. Fuller Hot Melt Adhesive PHC-9200	Figures Below	

PACKAGING CONFIGURATIONS:	Case Sealing Method
Configuration : One, Four or Six 2.5L Bottles/reshipper carton	Top: 2" Clear Pressure Sensitive Tape Bottom: Glued
Configuration: One, Four or Six 2.5L Bottles/reshipper carton	Top: 2" Clear Pressure Sensitive Tape Bottom: 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 23-28 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 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 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 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/5.3/S/\*\***  
**USA+CC6166**

**Figure A**  
**UN Marking**



**4G/19.3/S/\*\***  
**USA+CC6166**

**Figure B**  
**UN Marking**



**4G/29.1/S/\*\***  
**USA+CC6166**

**Figure C**  
**UN Marking**

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