



75 W. Baseline Road,
Suite D44
Gilbert, AZ 85233
(480) 926-0022

**PACKAGING ASSEMBLY
INSTRUCTIONS**
6 X 500 ML Combination Packaging

**Package: 500 ML
With 38-439 or 45 mm Neck Finish**

Issue Date: April 26,2012

Revision: C

UN Cert # +CC7197

NO. / CASE	LIST OF COMPONENTS	Reference	SPEC / PART #
(6)	Berry 38-439A Acid Closure with Foam Liner	Figures Below	500093
(6)	Menshen Tamper Evident 45 mm Closure DIN45E with PTFE Liner		500001
(6)	500 ml Bottle with 38-439 Neck Finish		1046059
(6)	500 ml Bottle with 45 mm Neck Finish		1046096
(1)	ECT 48 Doublewall, RSC Carton	Figures Below	
(1) Roll	2" Clear Pressure Sensitive Tape (Scotch 3M Packaging Tape)	Figures Below	

PACKAGING CONFIGURATIONS:

Configuration : Six (6) 500 ML Bottles/ Reshipper Carton

Case Sealing Method

Top: 2" Clear Pressure Sensitive Tape
Top and Bottom: Taped

ASSEMBLY INSTRUCTIONS:

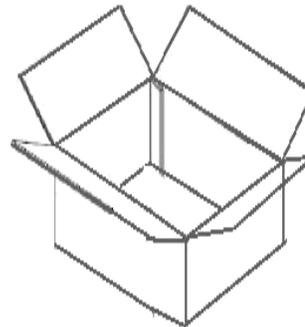
Note: Refer to component list above. Examine all parts for defects. Once you have determined that this packaging is free from defects then follow these instructions for package assembly.

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.

500 ML/ 38-439



500 ML/ 45 mm



4G/Y7.5/S/
USA/ +CC7197**