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**PACKAGING ASSEMBLY  
INSTRUCTIONS**  
One Gallon 150 gram bottle

Page 1 of 1

**Package: One Gallon 150 gram bottle Issue Date: July 13, 2015 Revision: D UN Cert # +CC7715  
4 x 150 gram Plastic Bottle Packaging**

NO. / CASE	LIST OF COMPONENTS	CONFIGURATION	SPEC / PART #
4	Berry 38-439 A Stock Acid Closures with Foam Liner	A & B	500093
4	150 gram Bottles with 38-439 Neck Finish	A & B	1779697 8086 0500 0145
(1)	Regular Slotted Corrugated Container, Pre-assembled	A & B	731197
(1) Roll	2" Clear Pressure Sensitive Tape (Scotch 3M Packaging Tape)	A & B	
Adhesive	H.B. Fuller Hot Melt Adhesive PHC-9200	A	

**PACKAGING CONFIGURATIONS:**

**Case Sealing Method**

Configuration A: 4 X 150 gram Bottles

Top: 2" Clear Pressure Sensitive Tape

Bottom: Glued

Configuration B: 4 X 150 gram Bottles

Top: 2" Clear Pressure Sensitive Tape

Bottom: 2" Clear Pressure Sensitive Tape

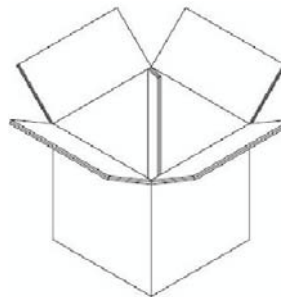
**ASSEMBLY INSTRUCTIONS:**

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 threaded closure to bottle with an application torque of 35 to 50 in/lbs using an appropriate closing tool.
2. For Configuration A, place four (4) bottles into a pre-assembled carton with the bottle closures facing upward.
3. Tape the tops closed with 2" 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.
4. For Configuration B, fold in two opposite bottoms flaps of carton. Then fold in the remaining two adjacent bottom flaps making sure that the exposed flaps display the Box Maker's Certificate or the Guarantee Stamp.
5. Tape the bottom flaps closed with 2" 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.
6. Then place four (4) bottles in the carton with the bottle closures facing upward.
7. 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.
8. Apply product labels and DOT hazard warning labels as required by work order instructions. Do not cover up any UN markings with labels or tape of any kind.

**Configuration**

A & B



**4G/Y23.5/S/\*\*  
USA+CC7715**

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

