

## IMPORTANT NOTE

This closure instruction includes the assembly procedures for this packaging design. Substitution of materials or a change to these closure instructions may cause non-compliance with regulations and void the test certification for the packaging.

## COMPONENTS

Included with the packaging

- 1 – Corrugated Box (KB4LFAPTR)
- \*1 – Polyethylene Liner Bag (K64464)
- 1 – Foam Inserts (KF4LF)
- \*1 – Secondary Closure Tape (KTAP112)
- 2 – Closure Tape (KTAP318)

May not be included with the packaging

- 1 – Phenolic Cap with Teflon liner (KC38PT)
- 1 – PVC Coated Bottle (KG4LAJ-CT)

## ASSEMBLY INSTRUCTIONS

1. Obtain appropriate inner packagings in accordance with the specification of 49 CFR.
2. Close the bottle using 18 inch-pounds of torque.
3. Remove the backing of the 1” X 12” secondary closure tape. Stick one end of the tape on the bottle cap so that it overlaps the cap and the bottle neck. Continue wrapping the tape around the bottle until all of the tape is adhered to the bottle. (Omit this step if secondary closure tape is not needed)
4. At the bottom of the box, fold the ID dimensions flap and the opposing flap so that the ends meet. Fold the remaining two flaps so that the ends meet. CAUTION: The manufacturer’s seal must appear on the outside of the box.
5. Tape the flaps closed by peeling the backing off one of the pieces of tape and place the adhesive side over the seam formed by the flaps being folded together.

## FOR CLOSURE

6. Place the bottom piece of the two piece foam insert in the bottom of the box.
7. If liner bag is required follow steps 8-9. If liner bag isn’t required it may be omitted.
8. Place the bottle in the liner bag.
9. Close the bag by tightly knotting it.
10. Place the bottle in the foam insert.
11. Place the top piece of foam insert over the bottle and bag.
12. Fold the “ASSEMBLY INSTRUCTION” and “FOR CLOSURE” flap toward each other.
13. Fold the “THIS SIDE UP” flaps together.
14. Tape the flaps closed by peeling the backing off one of the pieces of tape and place the adhesive side over the seam formed by the flaps being folded together.

## SHIPPERS RESPONSIBILITIES

This UN combination package is performance tested for use with 1 inner container that is a 4- liter pharmacy jug with Phenolic cap with Teflon liner. If using a smaller bottle, cushioning material must be added to fill void spaces. For AIR SHIPMENT, the inner container must pass a valid hydrostatic pressure test in accordance with 49 CFR 178.605, 173.27(c)(1) and (c)(2) and other applicable regulations. If the packaging is compatible with and authorized for your materials, then follow the instructions for proper closure. Consult 49 CFR 178.601(g)(1) for the rules on inner packaging and other applicable regulations.

**\*These components may be used with this packaging if additional means of containment and closure are needed, consult applicable regulations and packing instructions.**