

<b>Part#</b> w324NPS	<b>Title:</b> <b>Department:</b>	<b>Closure Instruction</b> <b>Product Management</b>
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**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.

**Product Components**

**INCLUDED WITH THE PACKAGING**

- 1 – Corrugated box (KB324NPSR1)
- 4 – Foam top pad (KF32NPSA)
- 4 – Foam middle insert (KF32NPSB)
- 4 – Foam bottom pad (KF32NPSC)
- 3 – Closure Tape (KTAP218S)
- \*4 – Secondary Closure Tape (KTAP112)
- \*1 – Liner Bag (K284674)
- \*1 – Nylon tie (K84103)

**MAY NOT BE INCLUDED WITH THE PACKAGING**

- 4 – Nalgene polyethylene cap and bottle
  - [KPN32WUNR – wide mouth (torque - 40 in/lbs)]
  - [KPN32NUNR – narrow mouth (torque - 27 in/lbs)]

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

*\*If secondary closure tape is needed, wrap the 1 X 12 in. red tape tightly around the cap of the bottle. The tape must make contact with the bottle cap and neck.*

**ASSEMBLY INSTRUCTIONS**

1. Fill and close the bottle(s) following manufacturer’s instructions.
2. Place the four foam plates (flat pieces) inside the box.
3. Place one of the columnar pieces of foam with the center cut out on top of the foam pieces inside the box.
4. Place the bottle(s) inside the foam pieces in an upright position.
5. Place the remaining foam blocks on top of the bottle(s).
6. \*If using the liner bag, place the four foam plates (flat pieces) in the bag first and follow the steps 3-5. Twist the bag and tightly close it using the nylon tie.
7. Fold the top flaps of the box toward each other to close the box.
8. Tape box closed along center seam. A minimum of 2” overlap is required on each side.

**SHIPPERS RESPONSIBILITIES**

This UN combination package is performance tested for use with up to 4 inner containers that are 32 oz. Nalgene HDPE packaging bottles with caps. If using a smaller bottle, cushioning material must be added to fill void spaces. For AIR SHIPMENT, the bottle 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.