

Part# W164NPS	Title: Department:	Closure Instruction Product Management
-------------------------	-------------------------------------	---

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 (KB164NPS)
- 4 – Foam top pad (16oz.= KF16NPSA; 8oz.= KF8NPSA; 4oz.= KF4NPSA)
- 4 – Foam middle insert (16oz. = KF16NPSB; 8oz. = KF8NPSB; 4oz. = KF4NPSB)
- 4 – Foam bottom pad (KF32NPSC)
- 2 – 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
 - Narrow Mouth (16oz. KPN16NUN; 8oz. KP8; 4oz. KP4-R)
 - Wide Mouth (16oz. KPN16WUNR; 8oz. KPN8WUN; 4oz. KPN4WUN)

Bottle Volume	Narrow Mouth Torque (in/lbs.)	Wide Mouth Torque (in/lbs.)
16oz.	16	33
8oz.	12	28
4oz.	12	20

**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. Close bottles using the appropriate closure torque as per manufacturer’s instructions.
2. Fold the bottom flaps to close the box. Be sure the Manufacturer’s certification is on the outside of the box.
3. Tape the box closed along the seam. A minimum of 2” overlap is required on each side.
4. *If using a liner bag, place and open the bag inside the box first and follow steps 5-8. Close the bag using the nylon tie.
5. Place the foam bottom pads (flat piece) in the bottom of the box.
6. Place the foam middle inserts (columnar piece with the center cut out) on top of the bottom pads in the box.
7. Place the bottles in the foam middle inserts in an upright position.
8. Place the remaining foam top pads (flat piece with cut out) on top of the bottles.
9. Fold the top flaps of the box toward each other to close the box.
10. 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 4 inner containers that are 16 oz. or less 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.