

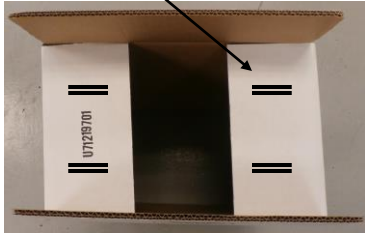


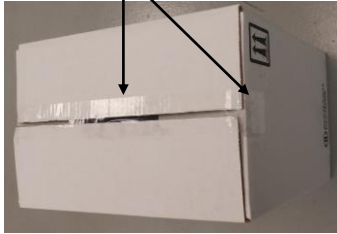


2.5 GALLON ASSEMBLY GLUED BOTTOM – TAPED TOP Assembly/Closing Instructions

<p>#1</p> <p>Phoenix Closures, Inc., Cap# 063S019312U Item: 632E70V</p>  <p>2.5 Gallon Bottle (2) Required</p> <p>APPLY CAP TO BOTTLE, TORQUE CAP TO 25 IN-LBS AND INDUCTION SEAL THE CAP ON THE BOTTLE</p>	<p>#2</p>  <p>CARTON: Longview Fiber Paper & Packaging, Inc.</p> <p>WITH THE “UN” NUMBER ON THE SIDE AND THE HANDLE INSERTS DOWN WITH ARROWS FACING DOWN FOLD THE INSIDE SHORT FLAPS IN.</p>	<p># 3</p> <p>ADHESIVE HOT MELT – TECHNO MELT 8990. MACHINE APPLIED THERMO-SET</p>  <p>WITH THE “UN” NUMBER ON THE SIDE AND THE HANDLE INSERTS DOWN WITH ARROWS FACING DOWN FOLD THE INSIDE SHORT FLAPS IN APPLY THE GLUE IN AN EIGHT- BEAD PATTERN (FOUR BEADS ON EACH SIDE OF THE SHORT FLAPS ON THE BOX</p>
<p># 4</p>  <p>INSERT TWO BOTTLES THAT HAVE BEEN PREPARED ACCORDING TO STEP 1</p>	<p># 5</p>  <p>WITH THE “UN” NUMBER FACING THE SIDES, FOLD THE INSIDE SHORT FLAPS IN.</p>	<p># 6</p> <p>2” - 3M 375 # Sealing Tape</p>  <p>FOLD THE REMAINING FLAPS OVER THE 2 INSIDE SHORT FLAPS. APPLY 2” – 3M 375# SEALING TAPE ACROSS EXTENDING THE TAPE APPROXIMATELY 2” – 2 ½”, APPROXIMATELY TO THE MIDDLE OF THE PERFORATED HANDLE ON EACH SIDE OF THE CARTON.</p>