



\*\* PAILS MUST BE INVERTED \*\* (U0590A12PM1)

## Ropak Packaging

A MEMBER OF THE LINPAC GROUP OF COMPANIES

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## UN Closing Instructions

Marketing  
Updated November 2009

### UN Open Head Packaging with U5 Cover

The following information is being provided to customers and distributors of the ROPAK Corporation to fulfill the notification requirements of 178.2(c) of the 49 CFR. These closing instructions are based upon the procedures used during assembly for testing and certifying this packaging to a UN standard. Alternative methods used for final assembly and closure may not effectively provide a certified UN standard packaging.

#### RECOMMENDED COVER INSTALLATION

Using a pneumatic press type closer with a 1" x 3" burper plug attached to the closing platen:

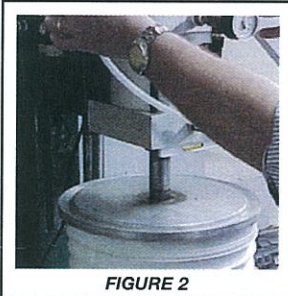


FIGURE 2

1. Begin by adjusting the downward stroke of the closing platen to 1/4" past the top of the pail (without cover).
2. Place the cover over the pail ensuring that any fitment closure is aligned properly between the handle bails. (fig. 1)
3. Center the pail and cover beneath the top platen of the pneumatic closer.
4. Activate the pneumatic closer so that it snaps the cover onto the pail leaving approximately 1/4" clearance between the lower edge of the cover and the top satellite ring on the pail body. (fig. 2)

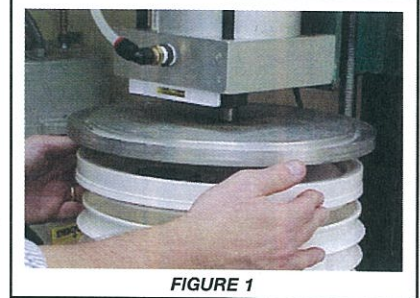


FIGURE 1

**Note:** The pneumatic press type closer should be equipped with at least a six-inch bore cylinder to effectively apply the cover utilizing a minimum of 80 psi from a regulated air supply. A roller compression closer may also be used provided it is equally as effective as the previously described closing method.

#### PROPER CRIMP-ON SPOUT INSTALLATION

1. Place the Rieke fitment on top of the opening on the U5G cover. (fig. 3)
2. Place a Rieke Model FS-600 crimping tool over the fitment and simultaneously depress both handles. (fig. 4 & 5)
3. Visibly inspect and manually check to ensure that crimping is straight and secure.

**Note:** A pneumatic Rieke, IA-FS-600, IA-FS-600-06, or ADP-7 with HFS-600 sealing tool may be used provided that the Rieke installation instructions are followed accordingly. For more information, please contact the Rieke Corporation directly at (219) 925-3700.

#### PROPER SCREW CAP INSTALLATION

1. Place the Rieke cap (70 mm series) on top of the threaded opening and manually thread onto the neck of the U5G cover. (fig.6)
2. Place a Rieke Model W-397 wrench tool over the cap and torque down to 10 foot pound pressure. (fig. 7 & 8)
3. Visibly inspect and manually check to ensure that the cap is straight and completely threaded onto the neck.

**Note:** A customized breakaway wrench may be used in replacement to the Rieke W-397 wrench. Set the torque level to 10 foot pounds and torque accordingly. For more information, please contact the Rieke Corporation directly at (219) 925-3700.



FIGURE 3

FIGURE 4



FIGURE 5



FIGURE 6

FIGURE 7



FIGURE 8

The ROPAK Corporation does not make recommendations in regards to the use of this packaging in transporting hazardous materials. It is the responsibility of the hazardous material shipper to ensure that the packaging's specifications meet the requirements of the hazardous material lading. Each user of this packaging should reference the respective certification test report to obtain the minimum performance standards in which this packaging was tested. In addition, it is the responsibility of the hazardous material shipper to ensure compatibility of the lading with the packaging material. For more information, please contact the ROPAK Corporation at (714) 845-2845.