

Dynalab Corp. Closing Instructions for MultiCan[®] EVOH Barrier Containers (3H1)

The United States Department of Transportation (DOT) regulations require that packaging manufacturers notify each person to whom the packaging is transferred of all requirements not met at the time of transfer.

The requirement is given in 49CFR Part 178 Specifications for Packaging. In addition, the closing information must be provided to any person who may need to reseal the package prior to reshipment. It is the shipper's responsibility to ensure that these closing instructions are implemented.

PURPOSE:

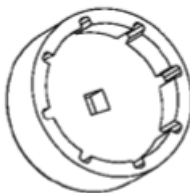
To ensure that the threaded screw cap is properly sealed when assembled onto Dynalab Corp. MultiCan[®] Containers. The DOT/UN Performance Certification only applies to a container that is closed per this procedure.

SIGNIFICANCE:

The sealing performance of the cap is compromised if the top surface of the neck is rough, has a burr, or is not clean; in addition, if the gasket in the cap is not properly seated in the O-Ring groove, twisted, or is not clean. The caps are only to be assembled on the MultiCan[®] after all sealing surfaces pass inspection.

APPARATUS:

- 60/61 Torque Head Fixtures
- Torque Wrench (Adjustable to accommodate 18 ft-lbs. or 220 in-lbs.)
- The use of calibrated automatic torque application machine permissible if it does not damage the threads or seating surface of the container.



REPRESENTATIVE TORQUE HEAD FIXTURE

BREAKAWAY-STYLE TORQUE WRENCH



BEAM-STYLE TORQUE WRENCH

PROCEDURE:

1. Inspect the top surface of the neck to ensure an acceptable sealing surface, clean and free of any debris.
2. Inspect the cap to ensure the gasket is properly assembled and is clean.
3. Start the cap on the neck by hand, rotating the cap in a clock-wise direct on. Take care not to cross thread the cap; this will result in damage to the cap or to the neck finish.
4. Using the 60/61mm torque head fixture mounted onto a torque wrench, tighten the cap per the below information.

5L, 10L and 20L MultiCan® Barrier Containers

Closure Type: HDPE Screw Cap with Tamper Evident Security Ring

Closure Size: DIN61 (45/65mm)

In-liner (Gasket): PE, flat, foamed

To apply proper torque, use the custom torque wrench socket which fits a 3/8" torque socket drive wrench –

Torque Setting: 220 IN-LBS (18 FT-LBS)



NOTE: The chemical filler and the shipper may rely upon the marking as certification that the package meets the applicable UN performance standards. The shipper is responsible for ensuring the product is authorized in the package and must consult General Shipper Requirements, including modal requirements. To meet UN standards, the package must be properly closed for shipment. Failure to follow the closure instructions or substitution of packaging components other than those identified in the closure instructions will render the UN certification invalid. Dynalab Corp., Inc. shall not be held liable for any special, consequential or incidental damages for breach of warranty or any other breach of proper use of MultiCan®. In no event shall Dynalab Corp., Inc. be held liable for the cost of procurement of substitute goods.