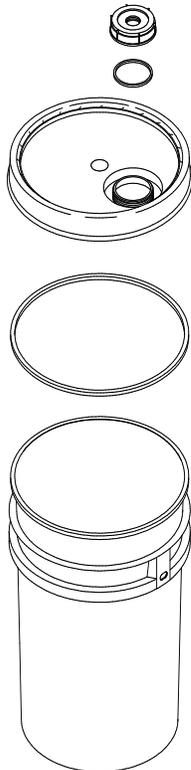


## UN 1H2 OPEN HEAD CLOSING INSTRUCTIONS



### PACKAGE:

1H2 Open-Head Package 3½ – 6 Gallon Liquid UN rated packages  
1H2 Open-Head Package 3½ – 7 Gallon Solids UN rated packages

### PURPOSE:

To insure that the 1H2 UN Cover is properly applied and sealed to the 1H2 Open-Head Pail

### INSTRUCTION:

Press the cover downward onto the top of the drum with sufficient force so that the hook of cover engages the curl of the drum fully to ensure there isn't any leakage of the contents from the assembled package

### PACKAGE ASSEMBLY:

- Ensure the gasket is in place in the cover and not twisted or deformed
- Loosely place the cover on top of the pail with any fittings 90° from the bail ears of the pail
- Apply the cover using an appropriate tool, making certain the cover is fully engaged

The BWAY Corporation has certified UN 1H2 packages using three methods:

- Vertical Press
- Roller Press
- Mallet

Methods are described below:



### VERTICAL CYLINDER PRESS:

- Air pressure required will vary depending on equipment used
- The platen of the press must be parallel to the surface plate
- Ensure the package is centered under press to allow uniform down-force during application
- Application pressure must be maintained for a minimum of one to two seconds
- The cylinder must be allowed to stroke a minimum of 1/4" below the top of covers
- A Burp Plug should not be used for this application

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### ROLLER PRESS:



- Design and operating rates for this type of press vary therefore the manufacturers operating instructions should be followed
- BWAY recommends as a starting point that the exit end of a roller cover press be set to the pail height (without cover) plus 0.200"
- Minor adjustments should be made as needed to ensure complete cover installation
- The rollers should exert even down-force through the length of the press such the package is completely sealed at the exit

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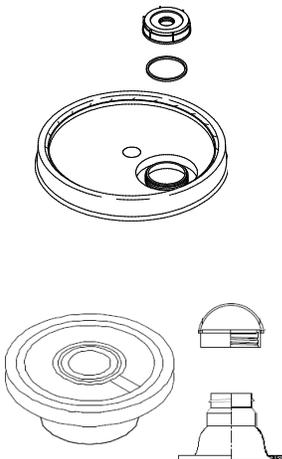
### MALLET:



- Only a rubber faced 3 lb Dead Blow Mallet should be used to close the BWAY 1H2 package
- Claw, ball peen or sledge hammers should not be used
- Strike the cover on the top-center of the outer ring until the hook of the cover snaps over the curl of the pail
- Continue to strike around the center of the outer ring in a clockwise or counter clockwise direction approximately every 2 inches until the cover is evenly seated

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### CLOSURE APPLICATION:



#### 70mm SCREW CAP:

- Inspect the surface of the neck and the cap to ensure a smooth land area and properly formed threads
- Ensure the gasket is firmly seated into the closure
- Place the closure loosely over the opening
- Use calibrated equipment to tighten the cap to the specified closure torque
- Closure Torque for 70mm screw caps: 120"lbs – 150"lbs

#### Crimp-on Pour Spout:

- Inspect the surface of the neck and ensure the top curl is smooth and free from damage
- Push the fitting snugly onto the neck finish
- Using the appropriate crimp tool for the respective cap
- Operate the manual crimp tool or automatic pneumatic tool to full stroke to ensure complete crimp