



UNi-Pak Cradle Closing Instructions

CSC Form QA-FM-L250

Rev. 5

Date 8/07/02

Page 1 of 2

1. Verify that the gasket is securely attached to the Cradle.
2. Position the cradle into the filled pail as shown.
3. Install the (1) gallon container horizontally into the Cradle.
4. Place the Hiperform Liner cover on top of the pail.
5. Position the closing tool on top of the Hiperform Liner cover. The jaws of the closing tool should be centered between the lugs. Apply downward pressure on the closing tool to ensure that the eye lugs are below the curl of the pail.

6. For Automated / In-line Closing Tool:

- a. Check that the tool is centered evenly on top of the cover.
- b. Once the crimping cycle is complete, verify that the lugs of the cover are completely tucked under the curl of the pail.

For Pneumatic Semi-Automatic Tool:

- a. Adjust the air pressure to the recommended 100psi. Connect the air line to the closing tool.
- b. Press and hold the actuator buttons until crimping operation is complete.
- c. Turn the closing tool 90° and repeat step b.
- d. Once the crimping cycle is complete, verify that the lugs of the cover are completely tucked under the curl of the pail.

Signature: _____

A handwritten signature in black ink, appearing to read "Michael J. De...".



UNi-Pak Cradle Closing Instructions

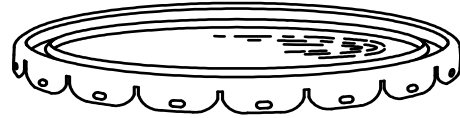
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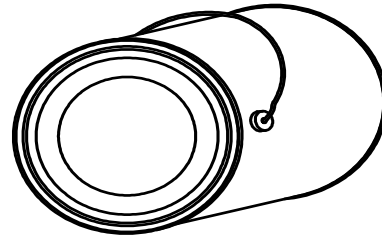
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Page 2 of 2

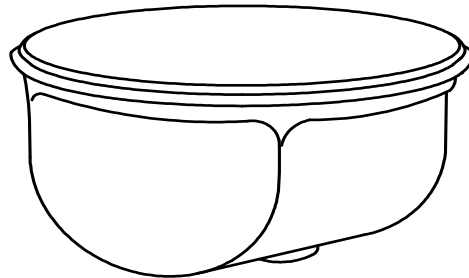
5. HYPERFORM LINER COVER →



4. (1) GALLON CONTAINER →



3. CRADLE →



2. GASKET →



1. STEEL PAIL →

