

CUBITAINER®

Combination Package

INFLATION & ASSEMBLY INSTRUCTIONS

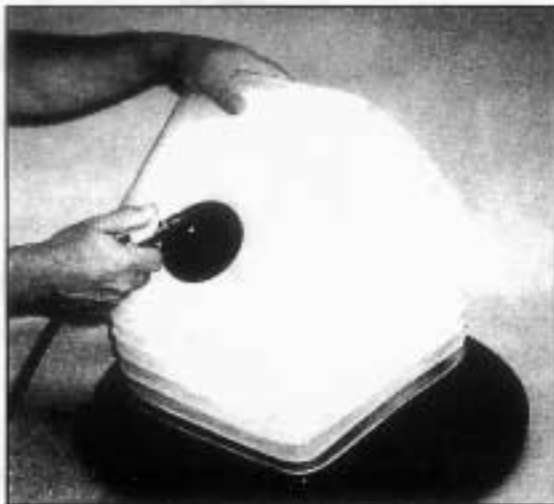


INFLATING CUBITAINER® CUBE® INSERTS

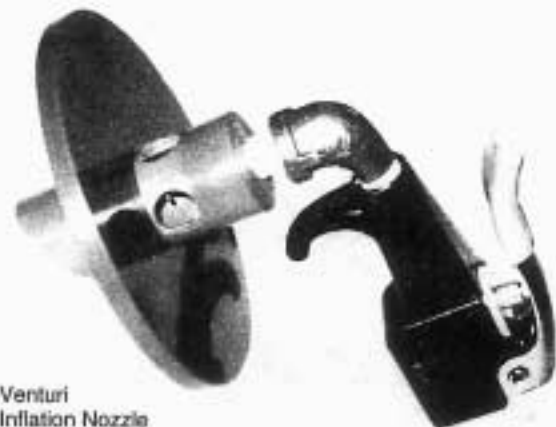
CUBITAINER® polyethylene Inserts shipped to the filling location collapsed and nested considerably reduces the shipping and storage space required for unfilled containers. Prior to filling, each insert must be inflated. The inflation "off-the-stack" technique is recommended for all sizes. Inflating without such a method of "unfolding" the deflated half of the Insert can cause severe localized stress areas ("craze" marks) and this can lead to small leaks in the insert wall.

A low pressure, high volume air source is required for fast, safe inflation without excessive stress on the side walls and creasing of the corners as the insert is expanded. **DO NOT USE** compressed "plant air" since the high pressure can damage the insert wall. What is needed is a high volume, low pressure air supply such as a centrifugal pump, the "output" of a vacuum cleaner or a commercial blower-compressor. Another satisfactory air source can be obtained by converting high pressure plant air with a Venturi device as shown below. This device is available from the Hedwin Corporation.

A turntable is available to support a stack of unnested units. The stack is positioned and supported at the base in a manner which protects the bottom insert from abrasion and damage, at the same time permitting it to be inflated without crease marks.



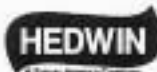
Special form underneath bottom CUBE
protects CUBE fold line from wood surface.



Venturi
Inflation Nozzle

50-100# PS1
"Plant-Air"
from compressor

INFLATION INSTRUCTIONS: A stack of nested CUBE® Inserts is placed on the turntable fixture and the air nozzle is placed into the closure opening. As the air enters the CUBE® Insert the operator's free hand should press firmly downward on the top of the Insert **until the unit is fully inflated**. Inserts should be inflated vertically from the top of the stack (not "rolled off"). The entire inflation process should take no more than 2 or 3 seconds. Care should be taken to insure that the air source is filtered to prevent foreign matter, such as moisture or oil vapor from plant air, from entering the Insert.



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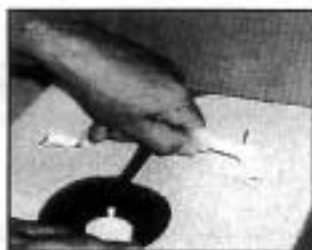
ASSEMBLY EQUIPMENT

Polyethylene inserts (flexible CUBE®) are shipped from Hedwin in bulk. If cartons are to be produced by the shipper and assembly is to be accomplished in his plant, consideration should be given to the type of assembly equipment to be required. Automatic equipment is available which can select, erect and glue the bottom flaps of CUBITAINER® cartons. Equipment is also available to close and glue (or tape) the top flaps. Equipment is not readily available to fold and insert the four panel vertical side and end liner. Hand operated equipment is preferable for low volume operations (less than 100-200 per hour) especially during the initial use of CUBITAINER®. Hedwin can provide information on appropriate automatic and hand operated carton assembly equipment.

HANDLE ASSEMBLY



Push "T" end of handle through the slot provided in the inner flap. Turn handle 90° to lock in place.



Twist handle and push other end through slot in opposite flap.



Apply glue to inside top flaps and close. Position handle as shown. Squeeze top flaps toward handle to crush carton around handle. (Note cuts in flaps to facilitate crushing.) Turn carton over to allow glue to set.



ACCESS TO THE CLOSURE

CARTON OPENINGS: The CUBITAINER® carton is designed with a die cut hole or perforated "tear-out" section in the top front flap. In the former concept, a molded plastic cap is snapped into the die cut hole to eliminate contamination (dust, dirt) from accumulating around the CUBE® Insert closure (photo 1). For shipment of product, especially regulated (hazardous) commodities, a special tape is needed to withstand drop test forces (photo 2). Both the taped die cut and perforated tear-out section (photo 3) cartons would be tamper-proof.



PHOTO #1



PHOTO #2



PHOTO #3

FILLING: The top flaps of the die cut carton are usually sealed before filling, with the plastic cap and tape being affixed afterwards. The perforated tear-out section on the other carton model remains unsealed until after the filling operation.

Hedwin Corporation strongly recommends that the neck of the CUBITAINER® package be supported during filling and especially during cap application and torquing to the recommended level of 25 in-lbs. Special rails which support the scalloped neck ring during filling and capping are available from Hedwin Engineering Group. Contact your Hedwin customer service representative for assistance with these support rails.

Information on filling equipment is also available from Hedwin Corporation.

**HEDWIN RECOMMENDED
RAIL DESIGN**



NOT RECOMMENDED



* Rail system supports and stabilizes CUBE® insert neck throughout the filling and capping operation.