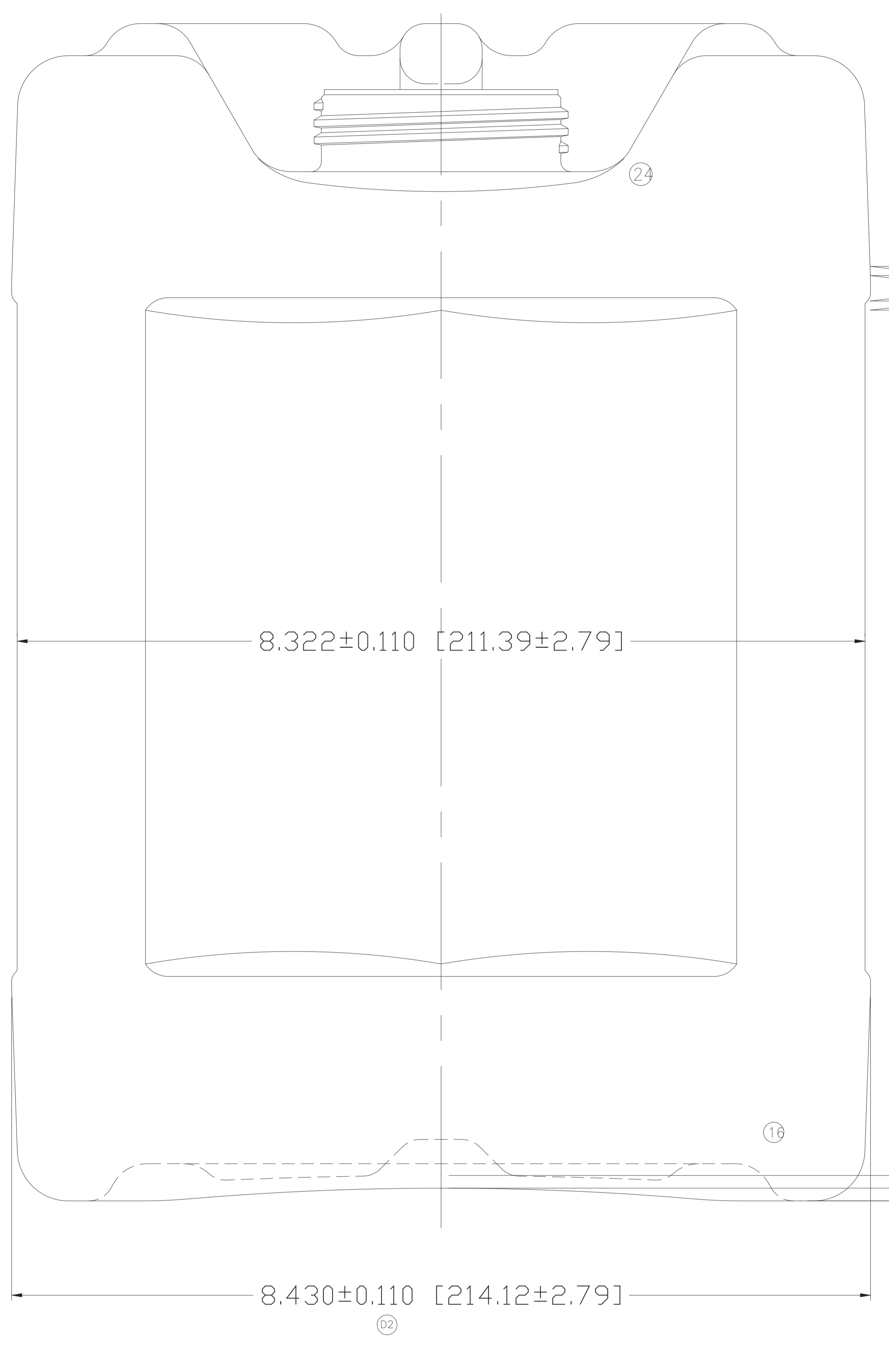
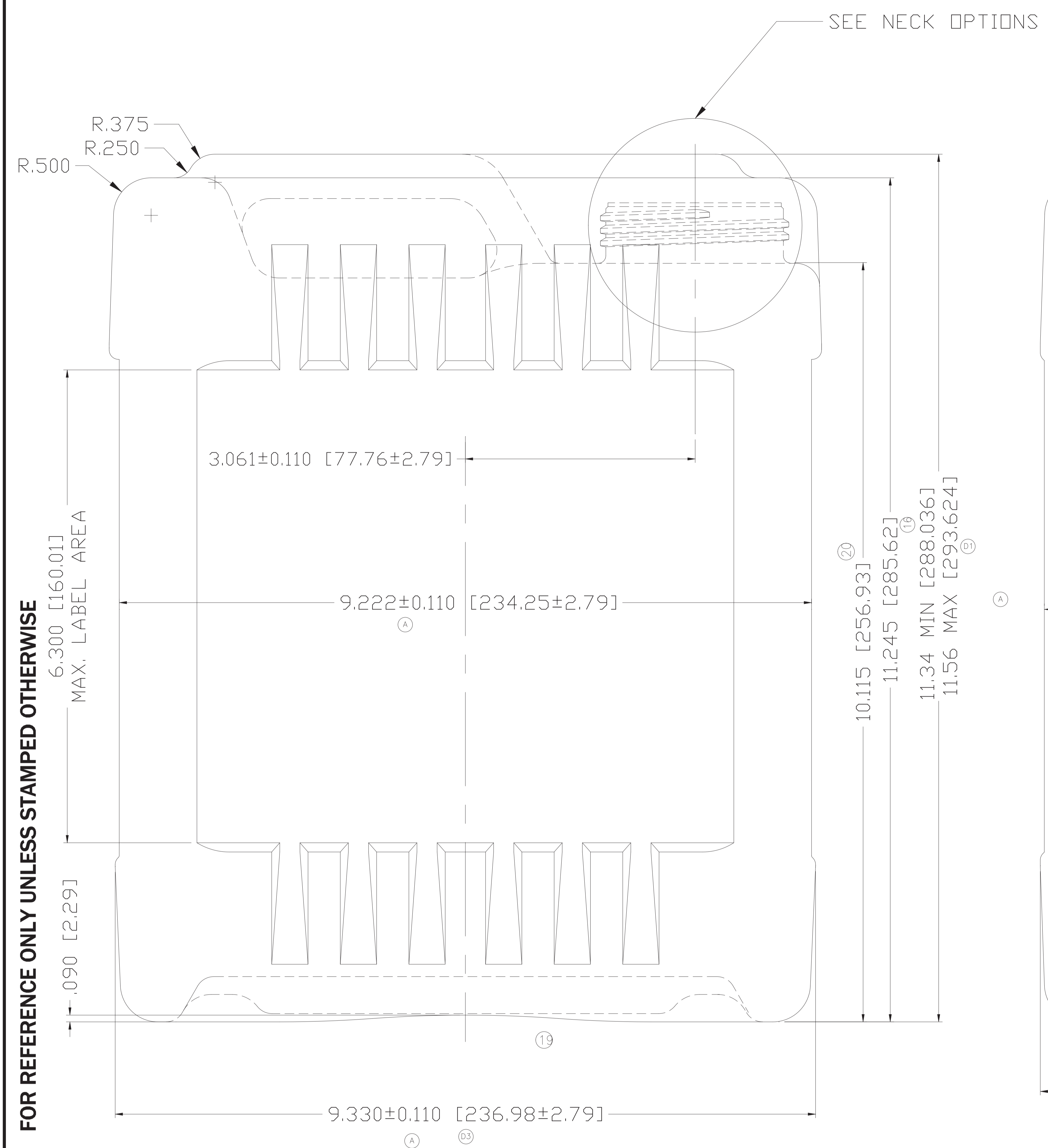
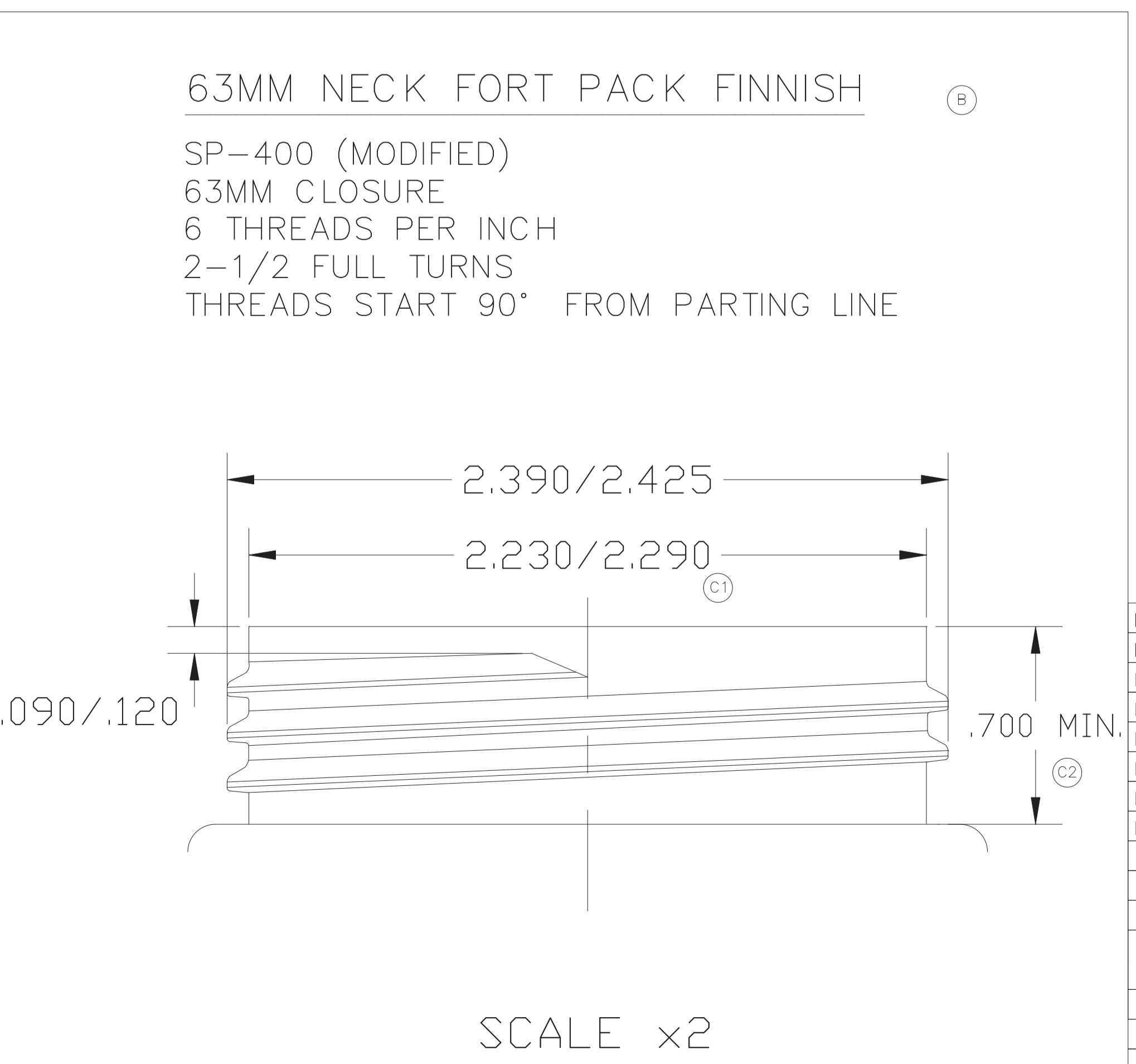
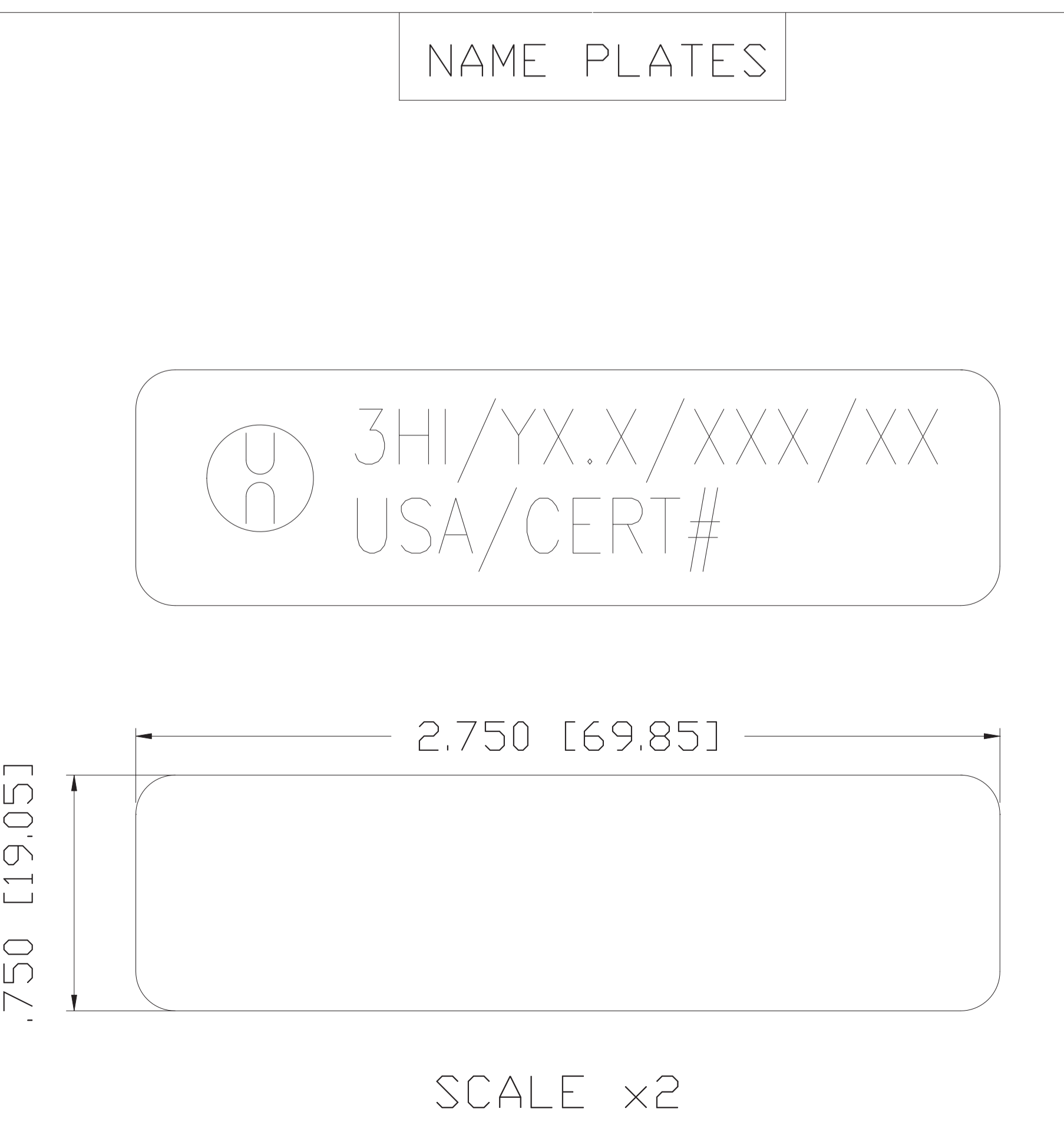
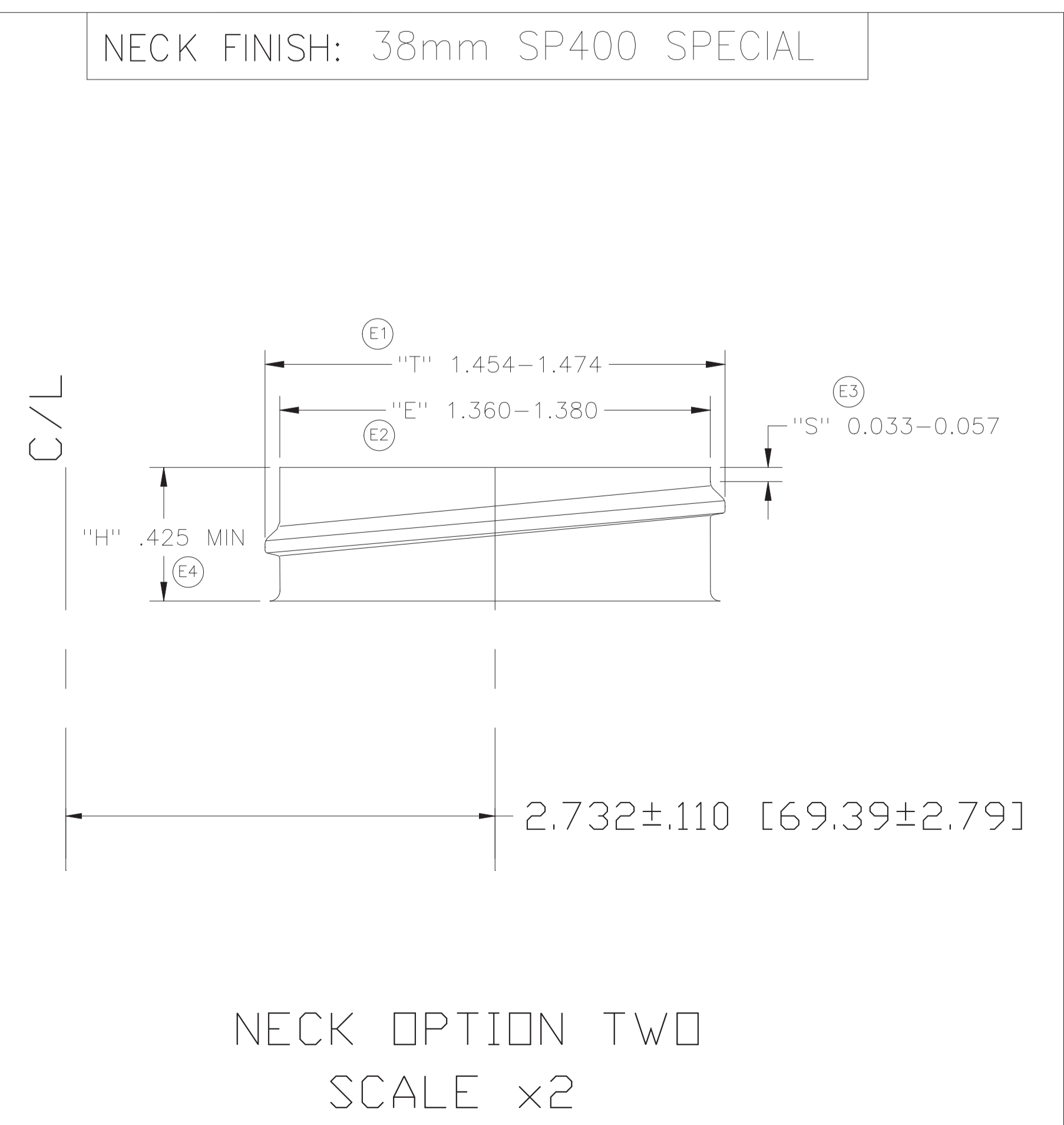
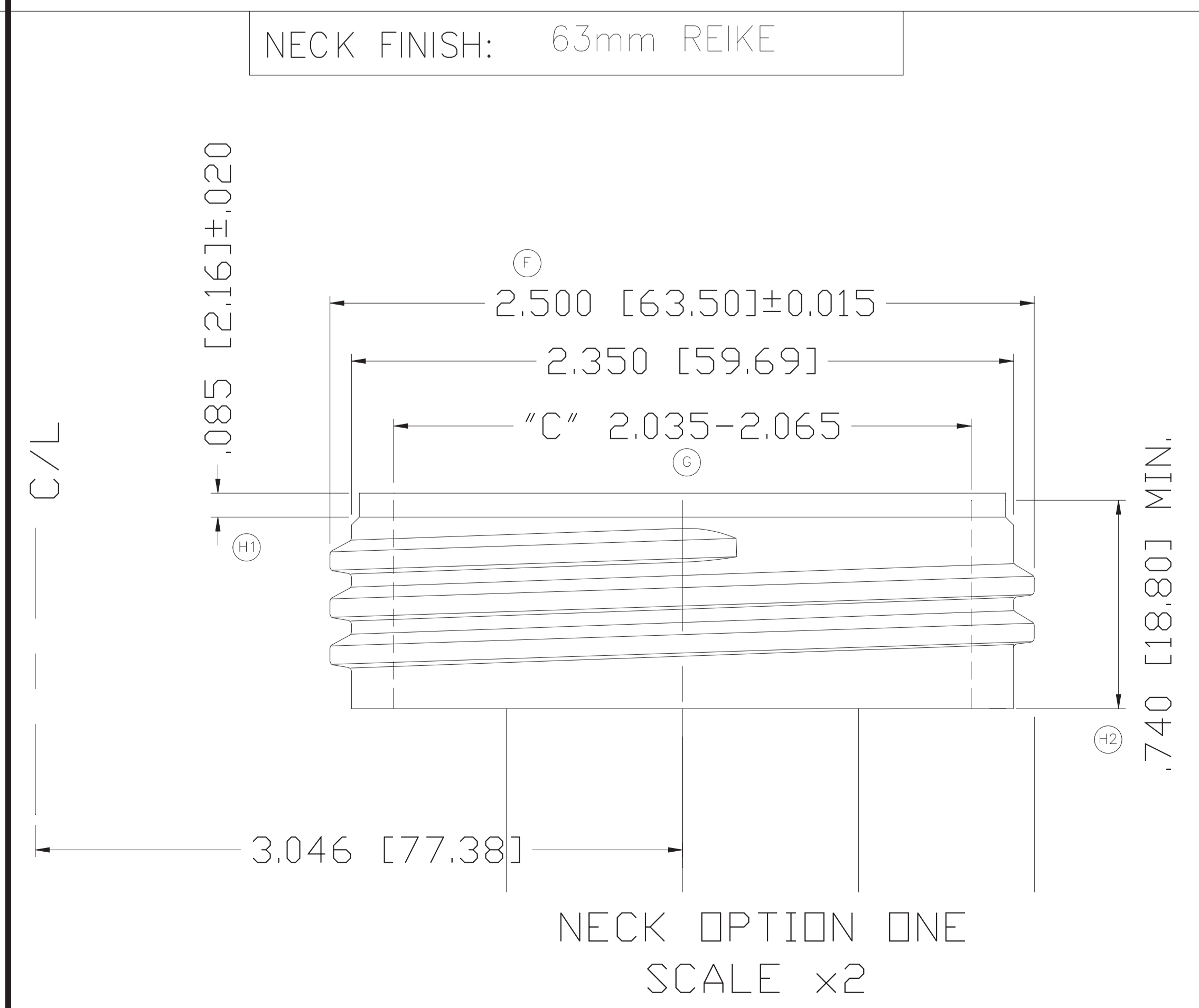
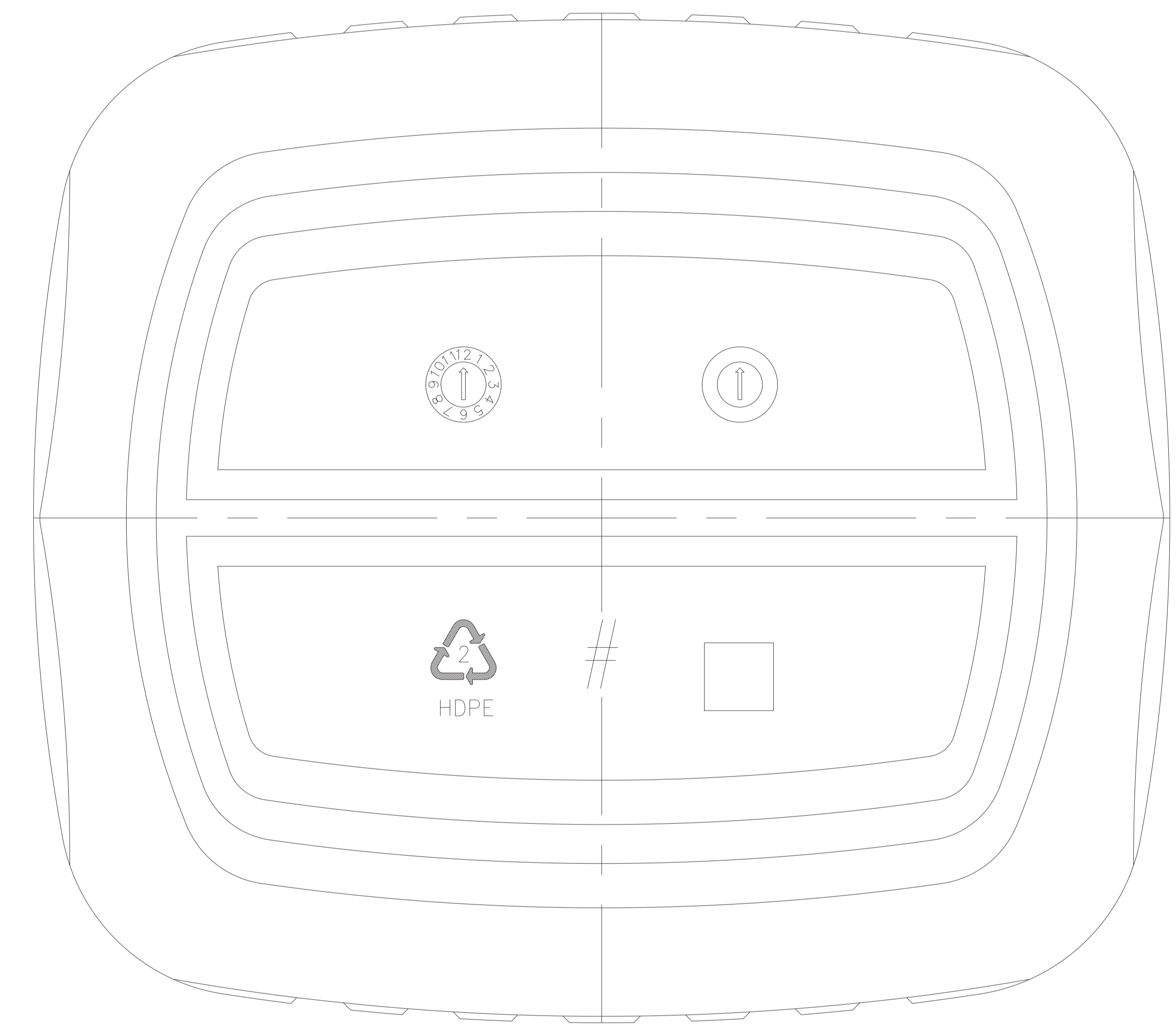
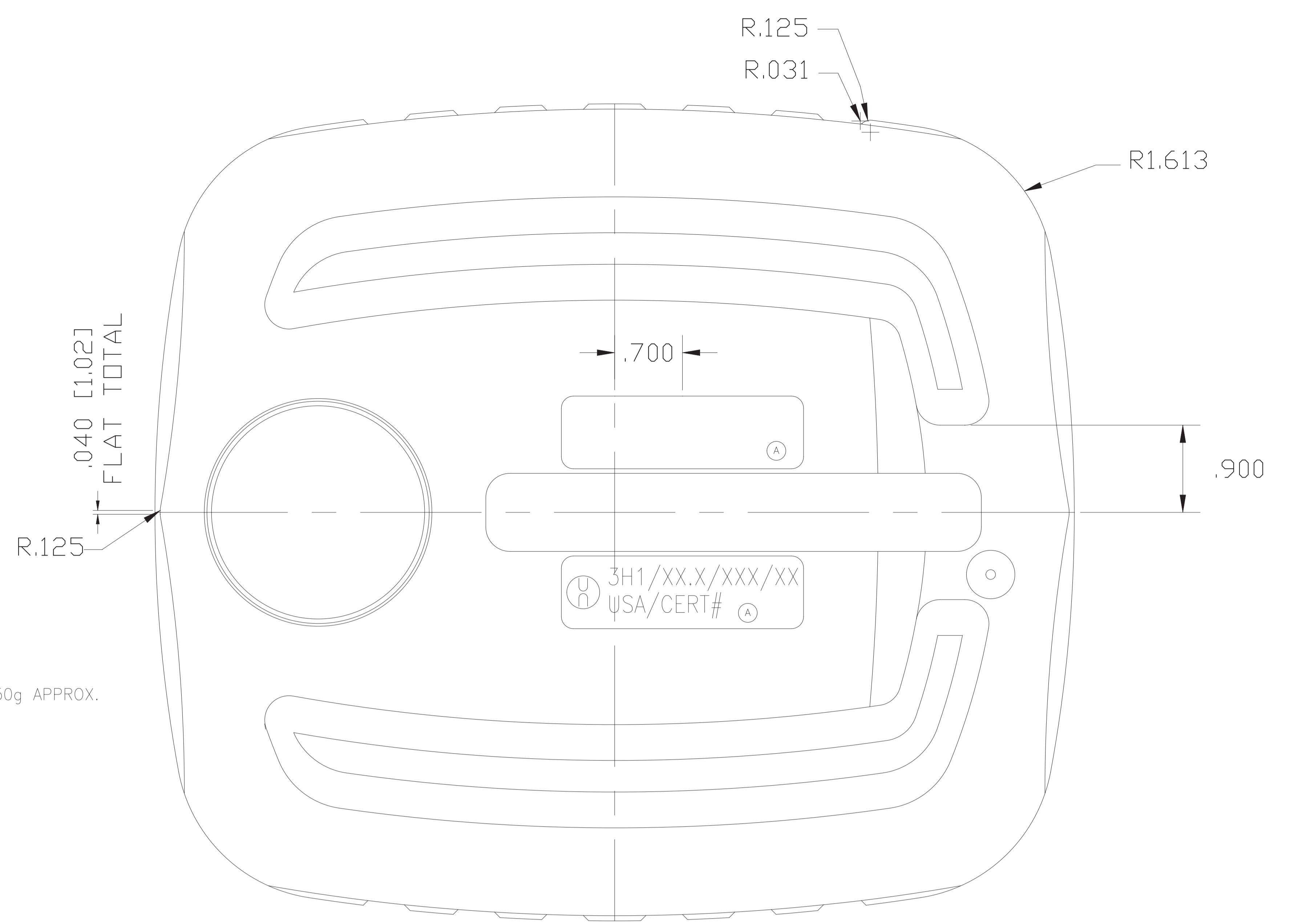


□ - LAYOUT NUMBER  
 ○ - CRITICAL CHARACTERISTIC  
 ⊙ - KEY CRITICAL CHARACTERISTIC

FOR REFERENCE ONLY UNLESS STAMPED OTHERWISE



MAX FILL 750g APPROX.  
 MEAN FILL REGION 750g - 450g APPROX.  
 MIN FILL 450g APPROX.



NOTES  
 1. "YX.X IS SPECIFIC GRAVITY/"XXX" IS KPA AND "XX" INDICATES YEAR OF MANUFACTURE / CERT# INDICATES CERTIFICATION NUMBER.

28	TJZ	38mm NECK ADDED PER CUST DWG#2056	10-Jun-02
27	TJZ	GENERAL REVISION AND UPDATE	10-Jun-02
26	TJZ	RAD. INCREASE VAR. FROM DECK TO ANGLE	29-May-02
25	TJZ	BOTTOM PINCH RED. .100" ANGLE NOW 45°	29-May-02
24	TJZ	CORNERS @ NECK SOFTENED TO R.500"	29-May-02
23	TJZ	.375" RADIUS WAS .250"	29-May-02
22	TJZ	DECK UNDER HANDLE/NECK RAISED .100"	29-May-02
21	TJZ	.090" ROCKER COMP. ADDED	29-May-02
20	TJZ	3.046 DIM WAS 3.461 ON 38mm NECK	MAY-02
19	GRD	.365 BOTTOM RIB HT. WAS .453	MAY-02
18	GRD	11.475 REF. HT. WAS 11.425	MAY-02
17	TJZ	SHEET 3 ADDED WITH 38mm SP 400 NECK	22-Apr-02
16	TJZ	LABEL AREA REDUCED TO 6.500" ACTUAL	22-Apr-02
15	TJZ	NECK OFFSET WAS 3.350"	22-Apr-02
14	TJZ	DISHED AREA ADDED AT REAR OF HANDLE	22-Apr-02
13	TJZ	NECK / HANDLE AREA REVISED	22-Apr-02
12	TJZ	63mm RIEKE NECK ADDED	22-Apr-02
11	TJZ	11.425" HEIGHT WAS 11.556"	22-Apr-02
10	TJZ	YEAR REMOVED FROM MONTH CLOCK	9-Apr-02
9	TJZ	NAME PLATE LOCATION + DETAIL ADDED	9-Apr-02
8	TJZ	HEIGHT OF BI INCREASED TO 0.250" @ INT.	9-Apr-02
7	TJZ	LABEL AREA INCREASED TO 6.500" MAX.	9-Apr-02
6	TJZ	RADIUS FROM BI TO BASE WAS R0.125	9-Apr-02
5	TJZ	BASE OF STACKING LUGS WAS R0.125	9-Apr-02
4	TJZ	NAIL VENT AREA ADDED	9-Apr-02
3	TJZ	HANDLE EXT. TOWARDS BACK OF CONTAINER	9-Apr-02
2	TJZ	DESCRIPTION	DATE
NO	REV.	BY	DATE
HEX: 6 T.P.A.: 6 [CUTT DIA.: 500 [12.70]			
CAPACITY TO FILL LEVEL BEFORE DECORATING			
CAPACITY TO FILL LEVEL AFTER DECORATING			
OVERFLOW CAPACITY BEFORE DECORATING 2.8 ± .1GAL			
OVERFLOW CAPACITY AFTER DECORATING			

ED8-004	8/08	H2	"H" WAS .800.	TV
ED8-004	8/08	H1	"S" WAS .090	TV
ED8-007	8/08	G	ADDED "C" DIM.	TV
E07-020	10/4/07	F	"T" WAS 2.495 ±0.015	KW
E07-017	9/07	E4	ADDED H DIM	KW
E07-017	9/07	E3	S WAS 0.046	KW
E07-017	9/07	E2	E WAS 1.356	KW
E07-017	9/07	E1	T WAS 1.454	KW
E06-04	9/06	D3	WAS 9.19/9.41	KW
E06-04	9/06	D2	WAS 8.22/8.44	KW
E06-04	9/06	D1	WAS 11.505/11.515	KW
04-033	12/04	C2	"H" .700 MIN WAS .650 MIN	ES
-	12/04	C1	"E" 2.330/2.290 WAS 2.244/2.279	ES
03-002	2/03	A	ADDED FORT PACK NECK FINNISH	ES
-	-	-	CHANGED DIMENSION/ADD NP	ES
ECN.	DATE	LET.	CHANGE	BY

COMPACT Mould Ltd.  
 WOODBRIDGE, ONTARIO TEL (905) 851-7724

DRAWN BY: TJ Zuber  
 SCALE FACTOR: 2.5 GALLON HANDLE

DATE: 3/27/02  
 SCALE FACTOR: 1:1.25

REVISIONS: 8/18/08

500 Industrial Park Road  
 PORTLAND, INDIANA 47371  
 860-726-7000

Priority Plastics

DRAWING DESCRIPTION:  
 947 CONT. - 2 1/2 GAL.

DRAWING NUMBER:  
 7947-000

# Closing Instructions

Corporate Office  
500 Industrial Park Dr.  
Portland IN 47371  
Tel 260.726.7000 Fax 260.726.8111

Date Created:  
Updated to New Format: 8.08.2019

## Closing Instructions for 2.5 Gallon Containers

Caps that this closing instruction includes are:

Priority Plastics 63mm cap manufactured by Miami Valley Plastics is 8728-204-060 (63mm Cap W/EPDM gasket.)



Step 1. Ensure the gasket is in the 63mm closure.



Step 2. Turn the 63mm cap to get started over the threads of the 63mm neck.



Step 3. Place an overcap fixture over the 63mm cap.



Step 4. Torque the cap to 150-160 in-lbs.

NOTE: Priority Plastics, Inc. certifies that these containers have been manufactured and certified in accordance with Performance Requirements of Part 178 Subpart M of title 49CFR. 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 and 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.

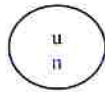
**DOT/UNITED NATIONS  
Performance Oriented Packaging Certification**



**3H1 PERIODIC RETEST**

**7947 2.5 Gallon Rectangle 63mm  
NoVent- Group II  
HDPE**

**Test Report #: 2020-12**



**3H1/Y1.6/150/\*\*  
USA /M5105**

**\*\*Insert year the packaging is manufactured**

**TESTING PERFORMED FOR:**

**PRIORITY PLASTICS, INC.**  
500 Industrial Park Rd.  
Portland, IN 47371

**TESTING PERFORMED BY:**

**Priority Plastics, Inc.**  
500 Industrial Park Rd.  
Portland, IN 47371  
**Phone:** (260) 726-7000  
**Fax:** (260) 726-8111

Certification Date: 03/24/2020  
Re-Certification Date: 03/24/2021



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**SECTION I: Certification**

Periodic Retest  
 2.5 Gallon Rectangle HDPE Packaging (HDPE Resin)

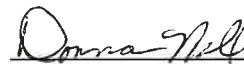
Priority Plastics, Inc. certifies that the packaging referenced above has passed the standards of the DEPARTMENT OF TRANSPORTATION'S TITLE 49 CFR; Performance Oriented Packaging Standards, Section 178. It is the responsibility of the end user to determine authorization for use under these regulations. The use of other packaging methods or components other than those documented in this report may render this certification invalid.

SUMMARY OF PERFORMANCE TESTS					
UN/DOT TEST	CFR REFERENCE	TEST LEVEL	TEST CONTENTS	TEST COMPLETED	TEST RESULTS
Drop	178.603	1.6 m	Windshield Fluid/Antifreeze Coolant 50/50 Diluted (WW?A)	March 24, 2020	PASS
Leakproofness	178.604	20 kPa – 5 Min. 3 PSI	Empty	March 23, 2020	PASS
Hydrostatic	178.605	150 kPa – 30 Min.	Water	March 23, 2020	PASS
Stacking/ Dynamic Compression	178.606	534.2 lbs	Water	March 23, 2020	PASS
Vibration	178.608	1.6mm – 1 Hr	Water	March 23, 2020	PASS
TEST REPORT NUMBERS: 2018-15, 2019-14, 2020-12					
UN MARKING: (CFR 49 – 178.503)				3H1/Y1.6/150/** USA /M5105	
PACKAGING IDENTIFICATION CODE:			3H1 (178.509)		
PERFORMANCE STANDARD:			Y (Packaging meets Packing Group II test)		
MAXIMUM PRODUCT SPECIFIC GRAVITY:			1.6		
INTERNAL TEST PRESSURE:			150 kPa		
YEAR OF MANUFACTURE:			**Insert year the packaging is manufactured		
STATE AUTHORIZING THE MARK:			USA		
PACKAGING CERTIFICATION AGENCY:			(M5105) Priority Plastics, Inc.		
PACKAGE IDENTIFICATION:			M5105		
PERIODIC RETEST DATE:			March 24, 2021		

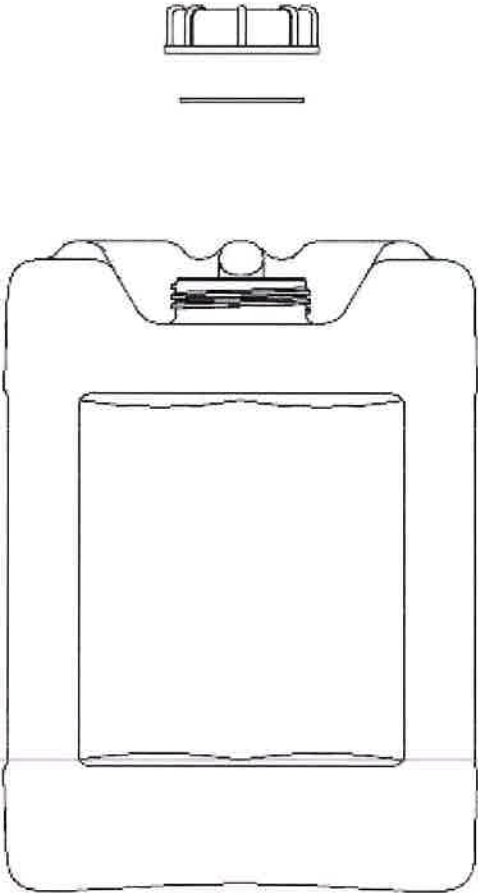
In the event of future changes to the above referenced test standard, it is the responsibility of Priority Plastics to determine whether additional testing or updating of past testing is necessary to verify that the packaging tested remains in compliance with those standards.

**MANUFACTURER:**

Priority Plastics, Inc.  
 500 Industrial Park Road  
 Portland, IN 47371



Donna Noll  
 Quality Manager  
 Priority Plastics, Inc.  
 500 Industrial Park Rd  
 Portland, IN 47371

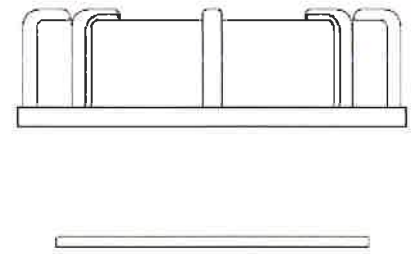
<b>SECTION II: PACKAGING DESCRIPTION / COMPONENTS</b>		
<b>2.5 Gallon Rectangle, No Vent, HDPE Packaging</b>		
	Certification Type: Periodic Retest	
	Packaging Code Designation: 3H1	
	Packing Group: II	
	Specific Gravity: 1.6	
	Hydrostatic Pressure: 150 kPa	
	<b>TEST SAMPLE PREPARATION</b> (Refer to Section IV)	
	Overall Package Tare Weight: 0.674 Kg	
	Fill Capacity (98% Overflow):	
	• WW/A 10.192 Kg	
	• Water 10.388 Kg	
	Package Test Weight:	
	• WW/A: 10.866 Kg	
	• Water 11.362 Kg	
	Calculated Package Gross Mass: 17.3 Kg (38.1 Lbs.)	
	<b>CLOSING METHODS</b>	
Application Torque for 63mm Cap: 150- 160 In-Lbs.		
Equipment for 63mm Cap: GP-045,GP-052 & V-GP-064-A		


**COMPONENT INFORMATION**

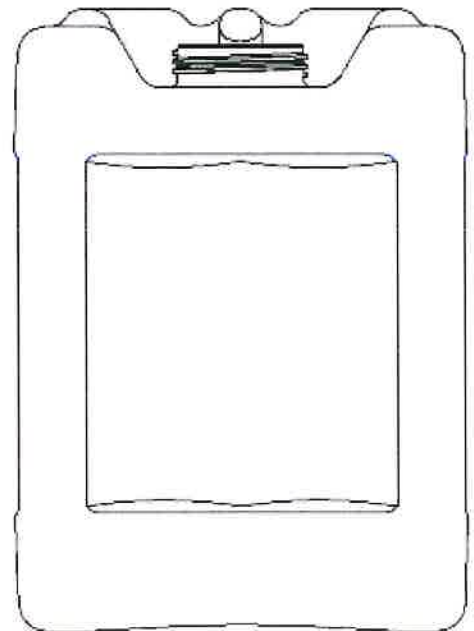
**CLOSURE (8728-204-060)**

**Manufacturer: Miami Valley Plastics, Eldorado, OH**

<b>Description:</b> 63MM Cap with 3/4" NPT and EPDM Gasket	
<b>Priority Item Number:</b>	8728-204-060
<b>Tare Weight:</b>	28.52 Grams
<b>Closure Overall Dimensions:</b>	
• <b>Height</b>	0.862"
• <b>Diameter</b>	2.895"
<b>Finish Dimensions:</b>	
• <b>T</b>	2.437"
• <b>E</b>	2.324"
<b>Markings ( QC Audit):</b>	2, 8 ribs around the outside
<b>Liner/Gasket</b>	55 Durometer White EPDM
<b>Identification:</b>	None
<b>Height Thickness:</b>	0.070"
<b>Diameter:</b>	2.300"



<b>TIGHT HEAD PLASTIC JERRICAN (7947)</b>			
<b>Manufacturer: Priority Plastics, Portland, IN</b>			
<b>Description: 2.5 Gallon Rectangle with Integrated Handle</b>			
<b>Material / Pigment: High Density Polyethylene / Natural</b>			
<b>Method of Manufacturer:</b>	Blow Molded		
<b>Tare Weight:</b>	0.645 Kg		
<b>Capacity:</b>			
• <b>Rated:</b>	2.5 Gallons		
• <b>Overflow:</b>	10.600 Kg (2.797 Gallons)		
<b>Overall Dimensions:</b>			
• <b>Height:</b>	11.530"		
• <b>Length:</b>	9.197"		
• <b>Width:</b>	8.368"		
<b>Finish Dimensions:</b>			
• <b>63mm T</b>	2.426"		
• <b>63mm E</b>	2.282		
• <b>63mm Neck Height</b>	0.851"		
<b>Wall Thickness:</b>	Body	Top Head	Btm Head
• <b>Minimum</b>	0.036	0.029"	0.040"
• <b>Minimum from Design Qualification 2018-15</b>	0.033"	0.026"	0.038"
• <b>Material:</b>	High Density Polyethylene		
<b>Markings (QC Audit)</b>	 3H1/Y1.6/150/20 USA/M5105 "2" HDPE Recycling Symbol, Month/ Year Clock, 3, WWW.PRIORITYPLASTICS.COM		






**SECTION III: TEST PROCEDURES AND RESULTS**


**DROP TESTS**

TEST INFORMATION	TEST CRITERIA
<p><b>TEST CONTENTS:</b> Windshield Washer/Antifreeze(0.984SG)</p> <p><b>SAMPLE PREPARATION:</b> REFER TO Section II</p> <p><b>CONDITIONING:</b> -18°C (0°F), Chamber #</p> <p><b>TEST CONTENTS TEMP.:</b> -18.35°C (-1.03°F)</p> <p><b>DROP HEIGHT:</b> 1.6 Meters (63") (Refer to Section IV)</p> <p><b>TEST EQUIPMENT:</b> L.A.B. Accu drop</p>	<ul style="list-style-type: none"> <li>For packaging containing liquid, each packaging does not leak when equilibrium has been reached between the internal and external pressures.</li> <li>Any discharge from a closure is slight and ceases immediately after impact with no further leakage. (§ 178.603)</li> </ul>

**DIAGONAL TOP CHIME DROP TEST SET-UP AND RESULTS**


	Sample #	Results	Comments / Observations
	1	PASS	No leakage or Breakage
	2	PASS	No leakage or Breakage
	3	PASS	No leakage or Breakage

**FLAT ON SIDE, NECK DOWN SIDE DROP TEST SET-UP AND RESULTS**

	Sample #	Results	Comments / Observations
	6	PASS	No leakage or Breakage
	7	PASS	No leakage or Breakage
	8	PASS	No leakage or Breakage

**LEAKPROOFNESS TESTS**


TEST INFORMATION		TEST CRITERIA
<b>TEST CONTENTS:</b>	Empty	<ul style="list-style-type: none"> <li>A packaging passes the test if there is no leakage of air from the packaging. (§ 178.604)</li> </ul>
<b>CLOSURE APPLICAAION:</b>	Refer to Section II	
<b>CONDITIONING:</b>	Ambient	
<b>TEST PRESSURE:</b>	20.7 kPa (3 PSI)	
<b>TEST DURATION:</b>	5 Minutes	
<b>AREA OF PRESSURIZATION:</b>	Through the Sidewall	
<b>TEST EQUIPMENT:</b>	Regulated Air Source Pressure Monitoring Gauge	

LEAKPROOFNESS TEST SET-UP & RESULTS			
	Sample #	Results	Comments / Observations
	9	PASS	All three samples maintained the 20.7 kPa test pressure for 5 minutes without leakage.
	10	PASS	
	11	PASS	

**HYDROSTATIC PRESSURE TEST**

TEST INFORMATION		TEST CRITERIA
<b>TEST CONTENTS:</b>	Water	<ul style="list-style-type: none"> <li>For each test sample, there is no leakage of liquid from the package. (§ 178.604)</li> </ul>
<b>FILL CAPACITY:</b>	Maximum Capacity	
<b>CLOSURE APPLICATION:</b>	Refer to Section II	
<b>CONDITIONING:</b>	Ambient	
<b>TEST PRESSURE:</b>	150 kPa (21.76 psi)	
<b>TEST DURATION:</b>	30 Minutes	
<b>AREA OF PRESSURATION:</b>	Through the Sidewall	
<b>TEST EQUIPMENT:</b>	Regulated Water Source Pressure Monitoring Gauge	

**HYDROSTATIC PRESSURE TEST SET-UP & RESULTS**

	Sample #	Results	Comments / Observations
	12	PASS	All three samples maintained the 150 kPa test pressure for 30 minutes without leakage.
	13	PASS	
	14	PASS	

**DYNAMIC COMPRESSION TEST RESULTS**

TEST INFORMATION		TEST CRITERIA
<b>TEST CONTENTS:</b>	Empty and Without Closure	<ul style="list-style-type: none"> <li>• After application of the required load, there can be no buckling of the sidewalls sufficient to cause damage to its expected contents.</li> <li>• In no case may the maximum deflection exceed one inch. (§ 178.606)</li> </ul>
<b>SAMPLE PREPARATION:</b>	Refer to Section II	
<b>CONDITIONING:</b>	Ambient	
<b>PRE-LOAD APPLIED:</b>	50 Lbs.	
<b>MINIMUM TEST LOAD REQUIRED:</b>	242.55 Kg (534.7 Lbs.) (Refer to Section IV.)	
<b>TEST EQUIPMENT:</b>	TLS(Tech Lab Systems)	

**DYNAMIC COMPRESSION TEST SET-UP & RESULTS**

	Sample #	Load	Deflection	Results
	21	534.7 Lbs.	0.992"	Passed
	22	534.7 Lbs.	0.937"	Passed
	23	534.7 Lbs.	0.891"	Passed


**NOTE:** After meeting the minimum to load requirement of 178.606 ©(2)(ii), each container was taken to failure. Refer to Section VI for the Load vs Deflection Graphs and the maximum compression strength of each test sample.



**REPETITIVE SHOCK VIBRATION TESTS**

TEST INFORMATION		TEST CRITERIA
<b>TEST CONTENTS:</b>	Water	Immediately following the period of vibration, each package must be removed from the platform, turned on its side, and observed for any evidence of leakage. <ul style="list-style-type: none"> <li>• A package passes the vibration test if there is no rupture or leakage from any of the packages.</li> <li>• No test sample should show any deterioration which could adversely affect transportation safety or any distortion liable to reduce packaging strength. (§ 178.608)</li> </ul>
<b>SAMPLE PREPARATION:</b>	Refer to Section II	
<b>CONDITIONING:</b>	Ambient	
<b>TABLE DISPLACEMENT:</b>	1"	
<b>TEST FREQUENCY:</b>	4.0 Hz	
<b>TEST DURATION:</b>	1 Hour	
<b>TEST EQUIPMENT:</b>	Vertical motion using Vibration Tester	

**VIBRATION TEST SET-UP & RESULTS**

	Sample #	Results	Comments / Observations
	24	PASS	No leakage or damage.
	25	PASS	
	26	PASS	

**REGULATORY AND INDUSTRY STANDARD REFERENCES**

<b>REGULATORY REFERENCES</b>	
<b>TEST</b>	<b>49 CFR 2019 EDITION</b>
<b>Drop:</b>	178.603
<b>Leakproofness:</b>	178.604
<b>Hydrostatic Pressure:</b>	178.605
<b>Stack:</b>	178.606
<b>Vibration:</b>	178.608

1. United States Department of Transportation Code of Federal Regulations (CFR) Title 49, Transportation, Parts 100-185

**SECTION IV: MATHEMATICAL CALCULATIONS**

**INFORMATION USED FOR CALCULATIONS**

Overall Packaged Tare Weight (PTW):	.674 Kg (1.5 Lbs.)	<u>WW/A SG</u>
Overflow Capacity (OFC) :		SG: 0.984
Windshield Washer/Antifreeze	10.400 Kg	
Water	10.600Kg	2.8 Gallons (GAL)
Packing Group:	II	
Product Specific Gravity (PSG):	1.6	
Packing Group Multiplication Factor (MF):	1.00	
Nesting Height of one Package (NH):	11.530 Inches	
Stack Test # of Samples Tested Simultaneously:	0	

**98% OF OVERFLOW**

Overflow Capacity (OFC) x 98%

<u>OFC</u> x <u>98%</u>		
10.400 x 98% =	10.192 Kg	WW/A
10.600 x 98% =	10.388 Kg	Water

**PACKAGED TEST WEIGHT**

Overall Pkg Tare Weight (PTW) + 98% Overflow Capacity (OFC)

<u>PTW</u> + <u>98% OFC =</u>		
.674 + 10.192	10.866 Kg	23.955 Lbs. WW/A
.674 + 10.388	11.062 Kg	24.387 Lbs. Water

**CALCULATED PACKAGE GROSS MASS (CPGM)**

Overall Pkg Tare Weight (PTW) + (Product SG(PSG) x 98%Overflow (OFC)

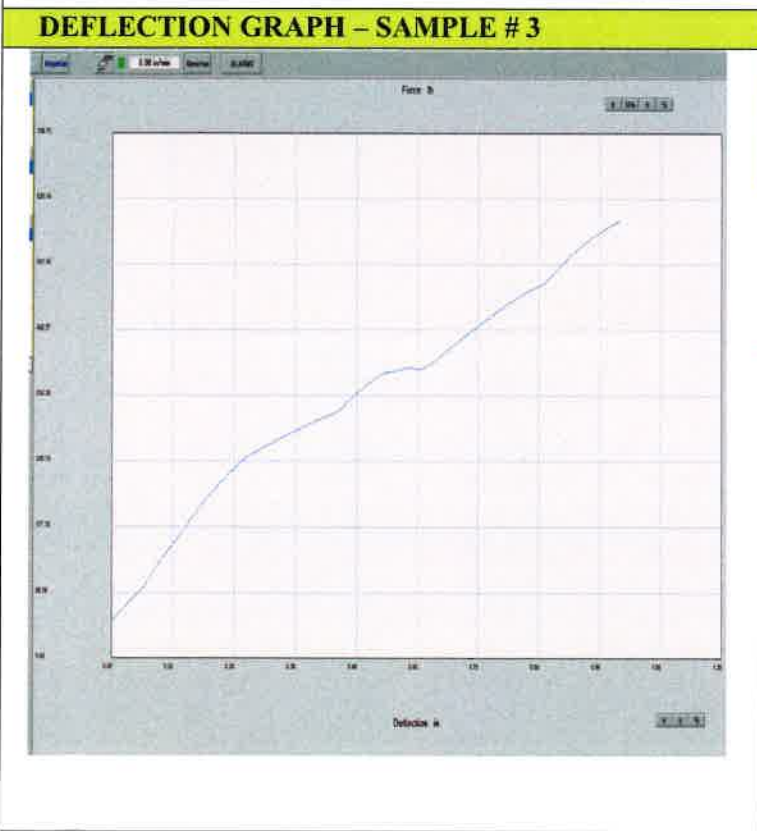
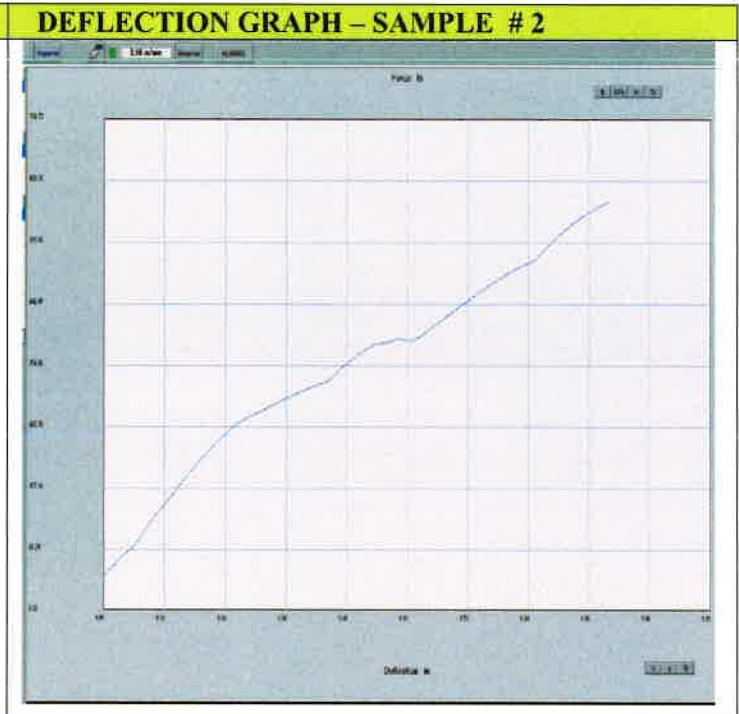
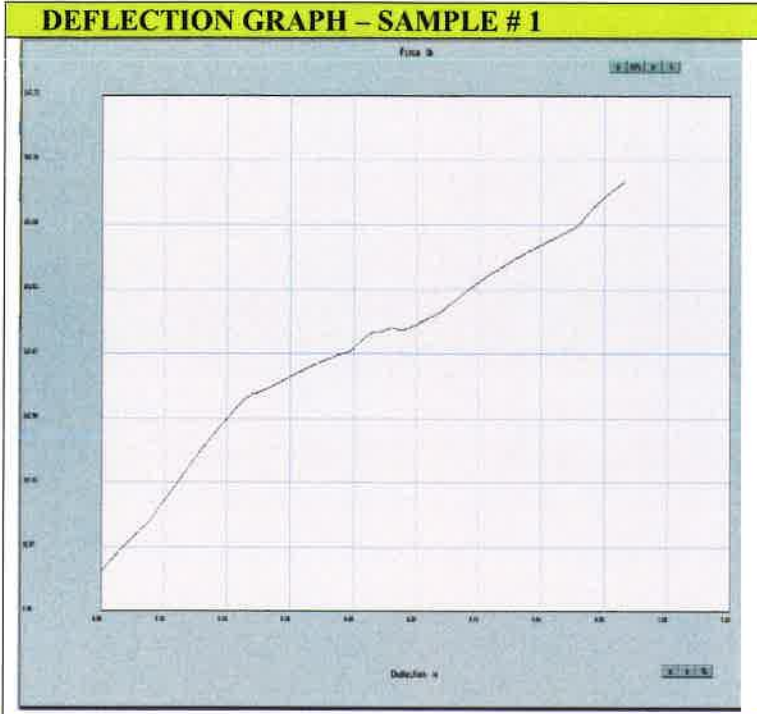
<u>PTW</u> + <u>(PSG</u> x <u>98% OFC)</u>		
.674 + 1.6 x 10.388		
	17.3 Kg	38.1 Lbs.

DROP HEIGHT CALCULATION (FOR SPECIFIC GRAVITIES EXCEEDING 1.2)				
Product Specific Gravity (PSG) x Packing Group Multiplication Factor (MF)				
PSG	x	MF	<b>Packing Group: II</b>	
1.6	x	1.00	<u>Required Drop Height</u>	<u>Actual Drop Height</u>
		1.60	Meter	62.99 Inches
				63.0 Inches

DYNAMIC COMPRESSION TEST LOAD CALCULATIONS				
Dynamic Compression Test Load Calculation				
<b>Where</b>				
A = Applied Load in Lbs.				
n = Minimum number of containers that, when stacked reach a height of 3m(118 inches) (See Calculation below)				
s = Product Specific Gravity—(PSG)				
w = Overall package tare weight (Lbs.)				
v = Maximum Container Capacity (Gal.)				
8.3 = Weight in pounds of 1 gallon of water				
1.5 = Compensation factor that converts the static load of the stacking test into a load Suitable for Dynamic Compression Testing				
<u>A</u>	=	<u>n x (w + (s x v x 8.3 x 0.98)) x 1.5</u>		
525.852 Lbs.		9.24	1.5	1.6 2.8 8.3 0.98 1.5
		238.522 Kg		525.852 Lbs.
<b>Minimum Required Top Load Used in Design Qualification Testing x 1.5 Compensation Factor*</b>				
Top Load used in Design Qualification Testing: 161.5 Kg x 1.5 = 242.3Kg 534.2 Lbs.				
Minimum Required Top Load				
<b>n = Number of Packages in a 3m high Stack (118/Nesting Height (NH) – 1)</b>				
118.11/Nesting Height of one Pkg (NH) – 1				
<u>(118.11</u>	/	<u>NH</u>	-	<u>1</u>
118.11	/	11.53	-	1
			=	<u>n</u>
			=	9.24



**SECTION V: INDIVIDUAL LOAD VS. DEFLECTION GRAPHS AND DATA**



**MAXIMUM LOAD VS. DEFLECTION**

Sample #	Maximum Load – Lbs.	Deflection – Inch
21	539.77 Lbs.	1.0”
22	566.77 Lbs.	1.0”
23	590.638 Lbs.	1.0”



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## Closing Instructions for 2.5 Gallon Containers

Caps that this closing instruction includes are:

Priority Plastics 63mm cap manufactured by Miami Valley Plastics is 8728-204-060 (63mm Cap W/EPDM gasket.)



Step 1. Ensure the gasket is in the 63mm closure.

Step 2. Turn the 63mm cap to get started over the threads of the 63mm neck.

Step 3. Place an overcap fixture over the 63mm cap.

Step 4. Torque the cap to 150-160 in-lbs.

NOTE: Priority Plastics, Inc. certifies that these containers have been manufactured and certified in accordance with Performance Requirements of Part 178 Subpart M of title 49CFR. 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 and 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.