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Product Specification Sheet

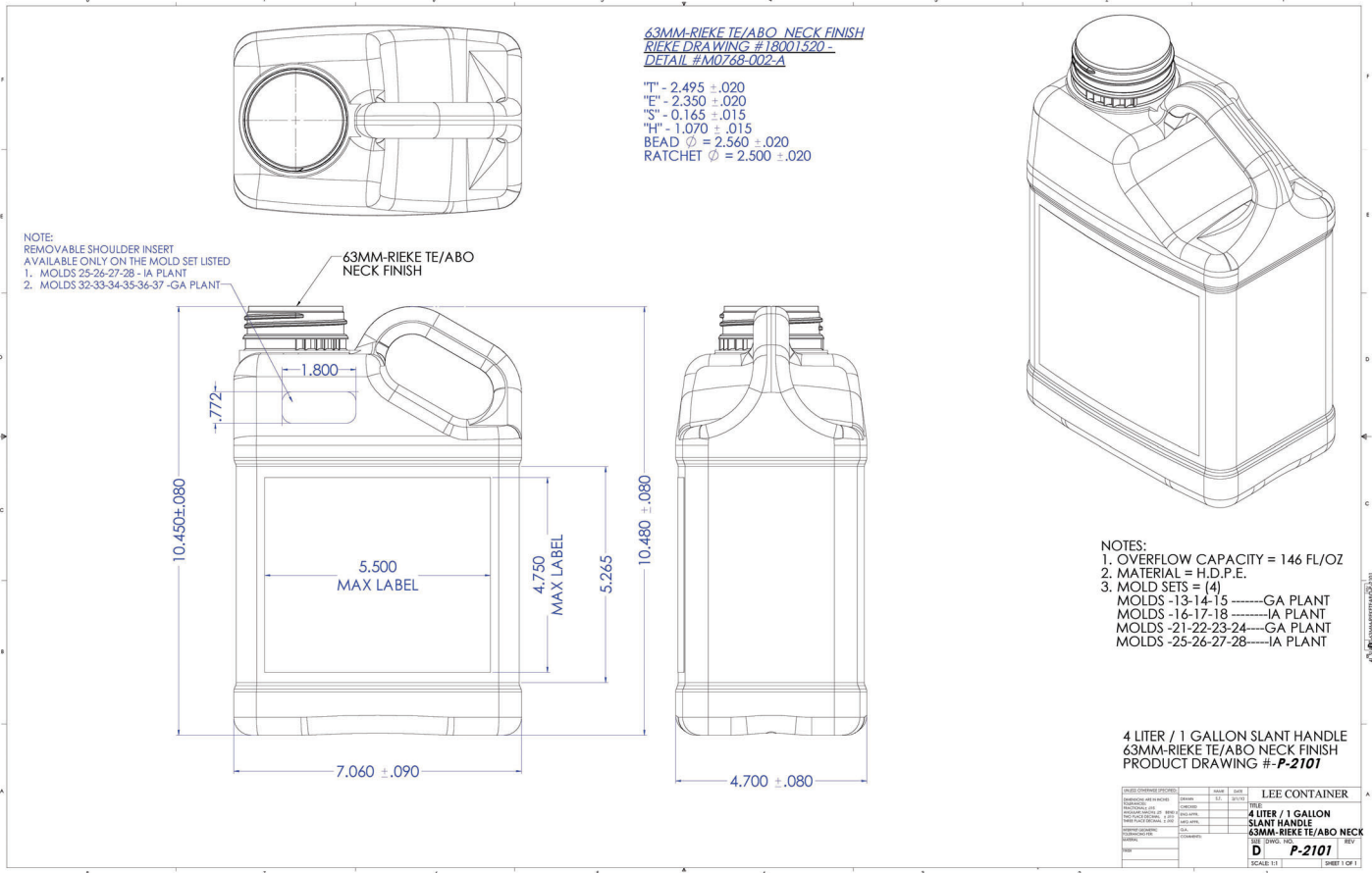
Illing Part#

3460NSH

1 GALLON NATURAL HDPE SLANT HANDLEWARE 63MM TE-ABO 180G

Part #: 3460NSH

Size:	1 Gallon
Color:	Natural
Material:	HDPE
Style:	Slant Handle
Additional Info:	63MM TE-ABO
Case Pack:	264/300 each
Pallet Pack:	594 each





Lee Container Production Specification

Bottle Description			
Item Code:	04SH0-215	Weight:	180 +/-5
Product Drawing:	P-2101	Resin(s):	EXXON AA45-004 or equivalent
Bottle Type:	4 LTR/1GAL SH, 264/330	Fluorination Level:	UNFLUORINATED
Color Pigment(s):	N/A	Label(s):	
Customer:	STOCK	Flame Treatment:	N/A

Bottle Attributes			
Height (Over Handle):	10.480 +/-0.080	Neck Finish:	63MM-RIEKE TE-ABO
Height (Over Neck):	10.450 +/-0.080	Neck ID:	N/A
Width:	7.060 +/-0.090	Viewstripe Location:	N/A
Depth:	4.700 +/-0.080	E Dimension:	2.350 +/-0.020
Wall Thickness:	0.015	T Dimension:	2.495 +/-0.020
Base and Shoulder Inserts:		S Dimension:	0.165 +/-0.015
		H Dimension:	1.070 +/-0.015
		Bead Diameter:	2.560 +/-0.020
Blow Pin OD:	N/A	Ratchet Dimension:	2.500 +/-0.020

Packaging Requirements			
Tray:	SLANT HANDLE TRAY 51 15/16 X 42 5/8	Divider:	N/A
Bottles per Unit:	264/330 (4/5 High)	Bottles per Tray:	66
Bottle Direction in Carton:	All necks turned in the same direction	Carton Sealed	N/A
Cartons / Layer:	N/A	Pack Layout	04SH264-330
Stretchwrap:	WHOLE UNIT	Straps / Unit:	N/A

1. Cap bottom layer of trays.

Drop Test Procedure	
Procedure 1	Drop test should be performed two times per 8 hour shift. Drop one bottle from each mold from 4 feet high in 4 orientations. If a bottle fails, perform a re-drop of the same mold number at 4 feet starting with the failed orientation and continue with the remaining drop test orientations. If a bottle fails a re-drop, notify the shift supervisor immediately and place bottles back to the previous test on hold.

Lee Container Procedure Manual	Issue # 1	Date 12-28-2016
Department of Quality Assurance	Authorized by: Johnathan Shiflet	Created by: Johnathan Shiflet
Procedure: Master Specification (07.1.3.G)		Edited by: Johnathan Shiflet