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ILLINGTM
P A C K A G I N G

Product Specification Sheet

Illing Part#

3485WWP

64 OZ WHITE HDPE ROUND BOTTLE 38-400 NECK

Part #: 3485WWP

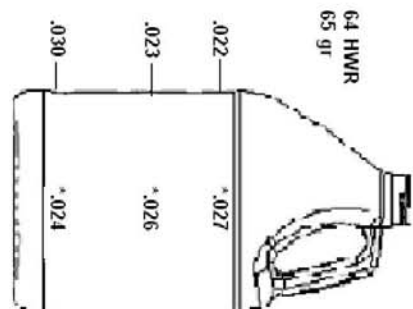
Size:	64 oz
Color:	White
Material:	HDPE
Style:	Plastic Round Bottle
Additional Info:	38-400 Neck
Case Pack:	84 each
Pallet Pack:	840 each



PRODUCT SPECIFICATION SHEET

FORM #QAS-SPE Revised By: Veronica Belms Approved By: DeWayne Utrup
JO #

SIDEWALL THICKNESS MINIMUM GUIDELINES



Allowable sidewall variance
.005 F28 .010 S2S

Creation Date:	64H06	Mold Part #	64HWR-38SPHu-04R-065
Ppl Part #		Cavity #s	1-4
Customer		# of Molds	4
Customer Part #		Neck Finish	38-SPH
Bottle Descr	64 HRD	T Dim	1.452-1.476
Color - W/W	CCWW#67	E Dim	1.358-1.382
Color LDR %	2.0%	I Dim	1.240-1.265
Resin	LT523501 or Equivalent	H Dim	.390-.420
Special	0	L Dim	0
Weight/Grams	+/- 3	S-1 Dim	.125-.155
Flame Treat	YES	Ratchet	0
Label	SILKSCREEN	Barrel	0
Name		Inside I	0
Label Number		Dam Ring	0
H2O spots	No water spots allowable in label area. 10% other areas.	Upper Ratchet	0
Box/Bag	B-27	Lower Ratchet	0
Bag liner	3 in tape single strand top and bottom	L-1 H-dim	0
Box Sealant	NONE	L-2 H-dim	0
Divider/pad		Shear Ring	1.4
Pack	84	Overall Height	9.67 +/- .06
CS/Layer	2	Over flow Capacity	2007 ml +/-24 or 67.9 oz
CS/Stack	4 THEN 6 10/STACK	DWN Pressure	26 lbs min.
Stack instructions	MAKE BUNDLE OF 4 CASES AND HAND STRETCH WRAP AROUND THE MIDDLE OF THE TOP ROW OF 4. MAKE BUNDLE OF 6 CASES AND HAND STRETCH WRAP AROUND THE MIDDLE OF THE TOP ROW. STACK TO MAKE STACK OF 10	Recipe #	64HWR-38SPHu-04RD-065
		Leak Detector	LAND SEAL
		Size/probe	
		Best Cycle	
		Grams Color Per / 3 Min	
		#s / 8 hrs. @ 90%	
		Die	
Cap Used		Mandrel	
		Striker	
		Blow Nose	
		Other	

Memo:

NEED TO USE LIGHT TO CHECK FOR BUSTERS
IN HANDLE AREA. CUT ALL CAVITIES APART
EVERY HOUR. FLAME TREAT CHECKED EVERY
15 MIN.

Label memo

Tooling Memo

QC Issues

blisters in handle area, bad lands (ugly roll in flow lines on
to lands), sunken seams