Pails Manual

UN SOLID SECURE RANGE

ROPAC® - Premium Packaging Protection

JANUARY 2019

Schoeller Allibert

www.ropac-packaging.com
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Closing

For clients with high volumes and large throughput we can recommend suppliers of automatic lidding presses which can be integrated into the clients filling line. Alternatively, for more modest requirements, we suggest a semi-automatic lidding press which is very easy to use.

For smaller production series you can close the containers manually.

Manual Closing

- With a nylon or rubber hammer hit the lid evenly and flatly in 4 positions on the lid to close the container fully and evenly
- Inspect where the lid and pail meet to ensure that the closure gap is consistent and even.

Semi-Automatic Closing

- Place the container under the Lid Press and ensure an even pressure of circa 6 bar
- The container is now closed.
Opening - Whole Container

Remove tear-off band

1. Placing the container on a flat and even surface to avoid any spillage of the content.

2. Take the finger hole on the right hand side of the lid and evenly and consistently pull away from the pail at 90 degrees, rotating the pail as necessary. (Ensure the tear-off band remains HORIZONTAL to avoid being broken off).

Lift up plastic lid

3. With one hand, push firmly on the middle of the lid; with the other hand, take the remaining opening loop and pull it upwards to release the lid partly from the pail. Now the lid can be easily opened with one hand.

The packaging will be no longer UN certified.
Opening - Containers with Flex-Spout

1. Placing the container on a flat and even surface to avoid any spillage of the content.

2. Ease up the Finger-Pull element of the Flex-Spout by pulling firmly upwards.

3. Once the Flex-Spout is completely upright and extended you can then open the Closure to give access to the contents.

4. This closure is re-sealable numerous times for part usage within your organisation.

(Flex-spout available on 5, 6, 15 & 20 litres UN solid)

The packaging will be no longer UN certified.
Opening device

1. Place the two hooks of the metallic bar into the opening eyelets.

2. Lift the bar towards you, the lever mechanism will allow the lid to open easily.

This opening device can be used with all of our product ranges that are fitted with eyelets.
Use

1. Filling Temperature
   The maximum filling temperature of the contents is 80°C (175°F). We recommend to cool down the content to 30°C (85°F) before the Pail can be closed and stacked. This prevents a vacuum forming inside the container and a deformation of the pail after filling instead of at lidding.

2. Filling Level
   The UN Solid pails have to be filled at least 95% of the maximum volume under lid (and not weight).

3. Emptying
   Open the container following the instructions under Opening. Holding the handle with one hand, place your other hand in the recess in the base of the container to tip the container and pour out the contents as required.

4. Lifting
   The pail can be easily lifted and moved, both mechanically and manually. On the smaller sizes, use the carry handles to move each pail easily, on the larger sizes be aware of the pack weight and carry singularly with both hands if necessary.

   NOTE! Please be aware of any local and/or corporate Health and Safety restrictions when handling or lifting the containers.

5. Freezing
   The range of ROPAC® pails are manufactured from high performance HDPE and are resistant to temperatures down to -18°C. At temperatures below -5°C it is important to protect the Pail from shock loads.

6. Air Transport
   Schoeller Allibert Swiss recommends shipment in pressurized cargo holds for air transport of packaging. We cannot guarantee optimal or correct performance if packaging is shipped in cargo holds without pressure regulation. Due to differences in air pressure a container can begin to deform.

   The duration of transport, filling level, type of contents and the way of packing and palletising can all have different effects on the packaging and contents.

   We strongly advise clients to test each packaging and shipping mode prior to dispatching.

   For food or pharma applications, the pails should be washed before use.
Static Load

When stacking the ROPAC® SECURE range of products for storage in e.g. a warehouse or cold store it is important to know what the maximum stacking load can be on the bottom container. The stacking load depends enormously on: the container weight, the number of containers to be stacked, the weight of interlayers and pallets, surrounding temperature, the duration of the load and the surface beneath the bottom containers.

The table shows for each ROPAC® SECURE products the maximum stacking load (in kg) at a given surrounding temperature during 24 hours placed on a flat and closed surface or pallet.

**Attention! The above mentioned figures are indicative. Schoeller Allibert Swiss recommends to perform additional testing.**

When stacking the pails, the temperature of the content has to be equal or lower than the ambient temperature.

<table>
<thead>
<tr>
<th>Set</th>
<th>Load (Kg)</th>
<th>Temperature (ºC)</th>
<th>Time (hours)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Ropac® MP 3 LH</td>
<td>80</td>
<td>23</td>
<td>24</td>
</tr>
<tr>
<td>Ropac® MP 5 LH</td>
<td>78</td>
<td>23</td>
<td>24</td>
</tr>
<tr>
<td>Ropac® MP 6 LH</td>
<td>66</td>
<td>23</td>
<td>24</td>
</tr>
<tr>
<td>Ropac® MP 10 LH</td>
<td>140</td>
<td>23</td>
<td>24</td>
</tr>
<tr>
<td>Ropac® MP 15 LH</td>
<td>230</td>
<td>23</td>
<td>24</td>
</tr>
<tr>
<td>Ropac® MP 20 LH</td>
<td>216</td>
<td>23</td>
<td>24</td>
</tr>
<tr>
<td>Ropac® MP 31 LH</td>
<td>280</td>
<td>23</td>
<td>24</td>
</tr>
<tr>
<td>Ropac® MP 32 LH</td>
<td>252</td>
<td>23</td>
<td>24</td>
</tr>
</tbody>
</table>
Palletisation - Filled pails

1. Pallet
The pallet has to present an almost plain surface fitted with planks which intermediate gaps shall not exceed 5 cm. In case a pallet is placed on top of another pallet, the surface between both pallets needs to be flat and rigid to avoid pressure points on the top layer.

2. Recommendations
Schoeller Allibert recommends to place the filled containers on a pallet as shown on pages 10 - 17.

3. Stacking
Filled containers are placed on a flat surface and stacked by placing the base of the container on the counter shape of the lid.

In case a pallet is placed on top of another pallet, the surface between both pallets needs to be flat and rigid to avoid pressure points on the top layer.

Attention! The total static load on the bottom container of a stack shall never exceed the maximum load indicated on page 08.

When positioning the ROPAC® Pails on a pallet it is important to turn the handgrips away from the pallet corners to avoid damaging the shrink-wrap or the stretch foil.

4. Packing
We recommend the use of a pallet shrink covers which needs to be shrunken around the pallet as well. Additionally, the bottom of the pallet needs to be stretched with Pallet-wrap as well.

The containers at the base of a stack will carry most of the load and to avoid a collapse they cannot be deformed by overstretching the foil or over-heating the wrap.

5. Pallet handling
From a safety point of view Schoeller Allibert recommends the transport of one pallet at a time. In order not to disturb the stack the fork of the lift truck needs to be kept almost horizontal.

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<table>
<thead>
<tr>
<th>Palette 80cm x 120cm</th>
<th>3 Litre Pail</th>
<th>16 pieces per layer</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>5 and 6 Litre Pails</td>
<td>18 pieces per layer</td>
</tr>
<tr>
<td></td>
<td>10 Litre Pail</td>
<td>12 pieces per layer</td>
</tr>
<tr>
<td></td>
<td>15 and 20 Litre Pails</td>
<td>8 pieces per layer</td>
</tr>
<tr>
<td></td>
<td>31 Litre Pail</td>
<td>6 pieces per layer</td>
</tr>
<tr>
<td></td>
<td>32 Litre Pail</td>
<td>6 pieces per layer</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Pallet 114cm x 114cm (45&quot; x 45&quot;)</th>
<th>3, 5 and 6 Litre Pails</th>
<th>27 pieces per layer</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>10 Litre Pail</td>
<td>16 pieces per layer</td>
</tr>
<tr>
<td></td>
<td>15 and 20 Litre Pails</td>
<td>12 pieces per layer</td>
</tr>
<tr>
<td></td>
<td>31 Litre Pail</td>
<td>9 pieces per layer</td>
</tr>
<tr>
<td></td>
<td>32 Litre Pail</td>
<td>9 pieces per layer</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Pallet 100cm x 120cm (40&quot; x 48&quot;)</th>
<th>3, 5 and 6 Litre Pails</th>
<th>18 pieces per layer</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>10 Litre Pail</td>
<td>15 pieces per layer</td>
</tr>
<tr>
<td></td>
<td>15 and 20 Litre Pails</td>
<td>10 pieces per layer</td>
</tr>
<tr>
<td></td>
<td>31 Litre Pail</td>
<td>6 pieces per layer</td>
</tr>
<tr>
<td></td>
<td>32 Litre Pail</td>
<td>7 pieces per layer</td>
</tr>
</tbody>
</table>

Refer to technical data sheets regarding stacking heights.

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Schoeller Allibert
ROPAC® PACKAGING PROTECTOR

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ROPAC® PACKAGING PROTECTOR

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Ropac® MP 3 LH SECURE

STANDARD PALLETISATION

PLAN ELEVATION

SIDE ELEVATION

PALLETISATION FOR SEA CONTAINER

PLAN ELEVATION

SIDE ELEVATION

SPECIAL PALLETISATION ON REQUEST

PLAN ELEVATION

SIDE ELEVATION
Ropac® MP 5 LH SECURE

**STANDARD PALLETISATION**

Europallet: 80cm x 120cm

**PALLETTISATION FOR SEA CONTAINER**

Pallet: 114cm x 114cm

**SPECIAL PALLETISATION ON REQUEST**

Pallet: 100cm x 120cm

Plan Elevation

Side Elevation
Ropac® MP 6 LH SECURE

**Plan Elevation**

- **Plan Elevation**
- **Plan Elevation**
- **Plan Elevation**

**Side Elevation**

- **Side Elevation**
- **Side Elevation**
- **Side Elevation**

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**Standard Palletisation**

- **Standard Palletisation**
- **Standard Palletisation**
- **Standard Palletisation**

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**Palletisation for Sea Container**

- **Palletisation for Sea Container**
- **Palletisation for Sea Container**
- **Palletisation for Sea Container**

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**Special Palletisation On Request**

- **Special Palletisation On Request**
- **Special Palletisation On Request**
- **Special Palletisation On Request**
Ropac® MP 10 LH SECURE

**STANDARD PALLETISATION**

- Plan Elevation: 1200mm
- Side Elevation: 1200mm

**PALLETSATION FOR SEA CONTAINER**

- Plan Elevation: 1140mm
- Side Elevation: 1140mm

**SPECIAL PALLETISATION ON REQUEST**

- Plan Elevation: 1200mm
- Side Elevation: 1200mm

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Europallet: 80cm x 120cm

Pallet: 114cm x 114cm

Pallet: 100cm x 120 cm
Ropac® MP 15 LH SECURE

**STANDARD PALLETISATION**

**PALLETSATION FOR SEA CONTAINER**

**SPECIAL PALLETISATION ON REQUEST**

Europallet: 80cm x 120cm

Pallet: 114cm x 114cm

Pallet: 100cm x 120cm
Ropac® MP 20 LH SECURE

**STANDARD PALLETTISATION**

Plan Elevation:
- 1200mm x 355mm x 701mm

Side Elevation:
- 1200mm x 355mm x 701mm

**PALLETTISATION FOR SEA CONTAINER**

Plan Elevation:
- 1140mm x 1140mm x 800mm

Side Elevation:
- 1140mm x 1140mm x 800mm

**SPECIAL PALLETTISATION ON REQUEST**

Plan Elevation:
- 1200mm x 1200mm x 355mm

Side Elevation:
- 1200mm x 1200mm x 355mm

Pallet:
- 114cm x 114cm

Europallet:
- 80cm x 120cm

Pallet:
- 100cm x 120cm

Standard Palletisation

Special Palletisation on request
Ropac® MP 31 LH SECURE

StANDARD PALLETTISATION

Europallet: 80cm x 120cm

Pallet: 114cm x 114cm

Pallet: 100cm x 120cm

Palletisation for Sea Container

Special Palletisation on Request
Ropac® MP 32 LH SECURE

STANDARD PALLETTISATION

PLAN ELEVATION

SIDE ELEVATION

Europallet: 80cm x 120cm

PLAN ELEVATION

SIDE ELEVATION

Pallet: 114cm x 114cm

PLAN ELEVATION

SIDE ELEVATION

PALLETTISATION FOR SEA CONTAINER

SPECIAL PALLETTISATION ON REQUEST

PLAN ELEVATION

SIDE ELEVATION

Pallet: 100cm x 120cm
Contact ROPAC®
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