



## Closure Instructions 5 Wall Heavyweight IBC

1. Square up Box.
2. Nail bottom flap A into top deck boards with 6 nails as shown in diagram 1 on box.
3. Fold in bottom flap B.
4. Fold in flaps C & D and position box in upright position.
5. Insert Poly Liner.
6. When full, gather liner and twist.
7. Secure with (1) 12" strip (min) of 3M #375 (48MM) Clear plastic tape or HyStik #970 (3") clear filament tape.
8. One (1) strip of 3M #375 (48MM) clear plastic tape or HyStik #970 (3") clear filament tape along center seam and two (2) strips offset by ½" with 4" minimum overhang.
9. Secure the IBC to the pallet using (4) ¾" Steel straps positioning 2 parallel to the pallet entry and 2 perpendicular.