

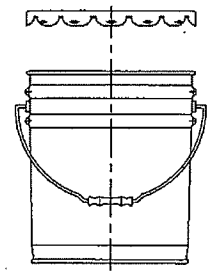
GRUPO ZAPATA

TECHNICAL DIRECTION

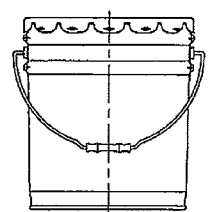
CORPORATIVE STANDARS

5 GLS OPEN HEAD PAIL OPEN HEAD PAILS CLOUSURE PROCEDURE

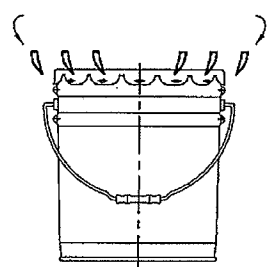
Reviso : Ing. Primitivo Martínez Carmona | Aprobó : Ing. Roberto Ugalde Zavala
 Dibujo : Jorge Herrera Garduño | Fecha : 30/Mayo/05 | No- 5 31 00 1-5



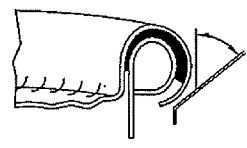
MAKE A VISUAL INSPECTION OF THE PAIL AND THE LID (NO DEFORMATION ARE ACCEPTED)



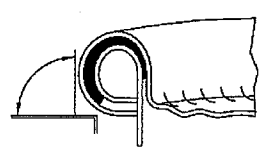
PLACE THE METAL LID IN THE CORRECT POSITION THE LID SHOULD FIT CORRECTLY IN THE BODY PAIL CURL.



CRIMP THE METAL LID USING THE CLOSER MACHINE ACCORDING TO THE USER'S HANDBOOK, MAKE SURE THAT THE CLOSING TOOL IS BEING USED PROPERLY. IF IS NECESSARY, ADJUST THE CLOSING TOOLS TO PROVIDE PROPER CRIMPING. USE THE FOLLOWING DRAWINGS AS YOUR GUIDE



THE WRONG WAY
LESS THAN 90°



THE RIGHT WAY
90° OR MORE

GRUPO ZAPATA

TECHNICAL DIRECTION

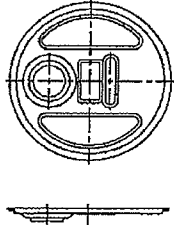
CORPORATIVE STANDARS

5 GLS TIGHT HEAD PAIL

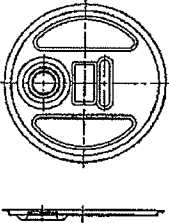
SCREW CAP WITH SPILLWAY PLACEMENT PROCEDURE

Reviso : Ing. Prímula Martínez Carmona | Aprobó : Ing. Pabla Rodríguez Zavala

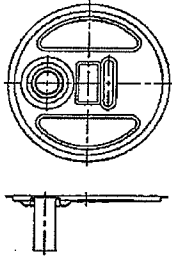
Dibujo : Jorge Herrera Garduño | Fecha : 30/Mayo/05 | No- 5 81 00 1-2



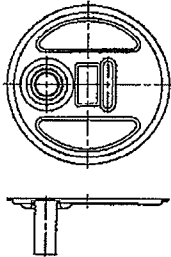
LID PERFORATION



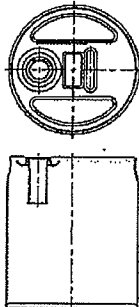
SCREW NECKED PLACEMENT
BY CLINCHING



SPILLWAY PLACEMENT



55 mm SCREW CAP PLACEMENT



PAIL SEAMING

GRUPO ZAPATA

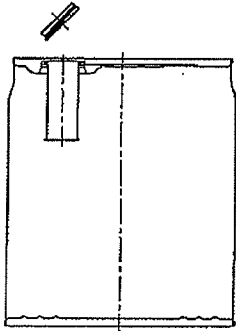
TECHNICAL DIRECTION

CORPORATIVE STANDARS

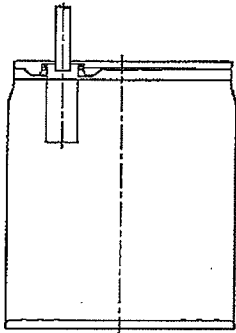
5 GLS TIGHT HEAD PAIL

FILLING PROCEDURE

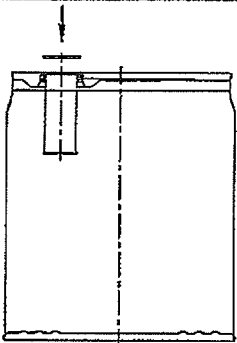
Reviso : Ing. Primitivo *[Signature]* Carmona | Aprobado : Ing. Roberto *[Signature]* Zúñiga
Dibujó : Jorge Herrera Garduño | Fecha : 30/Mayo/05 | No- 5 31 00 1-2



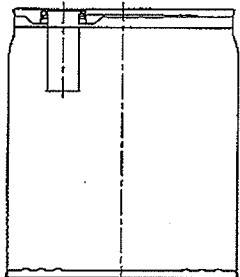
REMOVE THE SCREW CAP



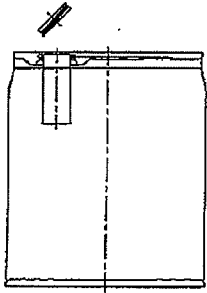
FILL THE PAIL BY ORIFICE



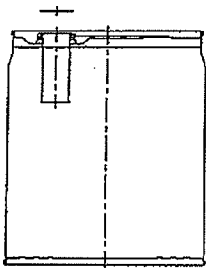
PUT THE PROTECTION COVER



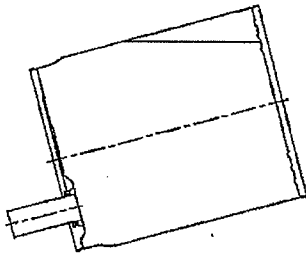
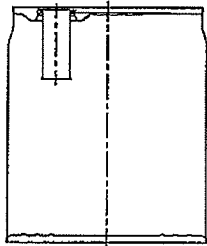
PUT THE SCREW CAP CLOCK WISE
TIGHTENED TO 60 In-lbs

GRUPO ZAPATA**TECHNICAL DIRECTION****CORPORATIVE STANDARS****5 GLS TIGHT HEAD PAIL****DRAINED PROCEDURE**Reviso : Ing. Primitivo Martínez Carmona | Aprobó : Ing. Roberto Cevallos Zavala
Dibujo : Jorge Herrera Garduño | Fecha : 30/Mayo/05 | No- 5 31 00 1-2

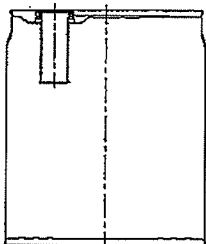
REMOVE THE SCREW CAP



REMOVE THE PROTECTION COVER

INCLINE THE PAIL TO SERVE THE
CONTENT. THE SPILL WAY WILL
GO OUT TO EASE THE OPERATION

PUT THE PROTECTION COVER

PUT THE SCREW CAP
TIGHTENED TO 60 In-lbs

GRUPO ZAPATA

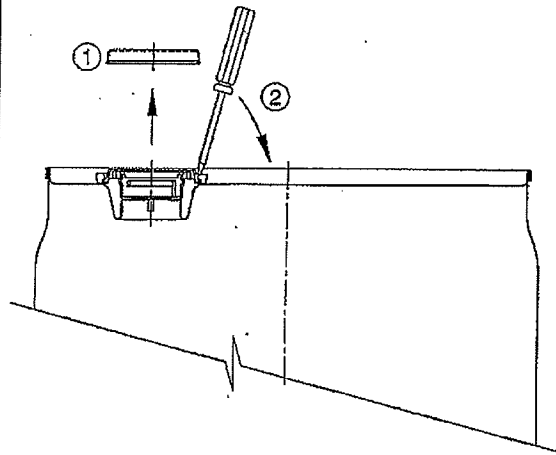
TECHNICAL DIRECTION

CORPORATIVE STANDARS

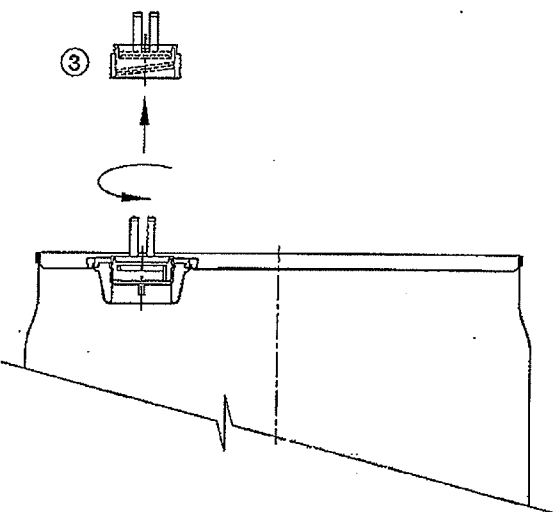
5 GLS TIGHT HEAD PAIL

FLEX SPOUT CAP OPENING PROCEDURE

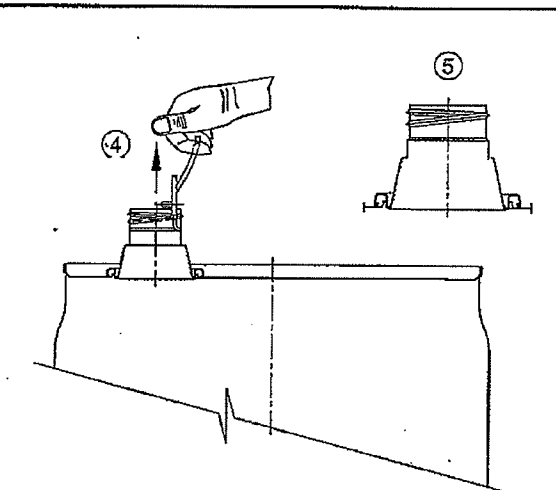
Reviso : Ing. Prudencio Martínez Carmona | Aprobado : Ing. Roberto Gómez Zapata
Dibujo : Jorge Herrera Garduño | Fecha : 30/Mayo/05 | No- 5 31 00 1-4



TO OPEN PRY OUT THE PLASTIC CAP ①
WITH A HAND PROPERLY TOOL ②



BY HAND LIFT LUGS UP AND ③
TWIST COUNTER CLOCK WISE THE PLASTIC SPOUT



FOR DRAINING THE CONTENT, PULL UP THE
INTERNAL FLEX HANDLE UNTILL BE BROKEN ④
AND THE PLASTIC SPILL WAY GO OUT ⑤

GRUPO ZAPATA

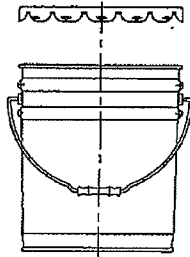
TECHNICAL DIRECTION

CORPORATIVE STANDARS

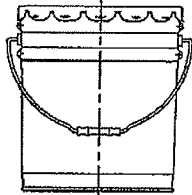
5 GLS OPEN HEAD PAIL

OPEN HEAD PAIL S-CLOSURE PROCEDURE

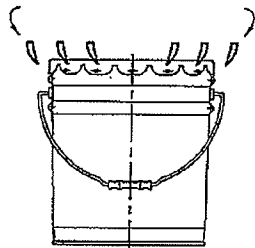
Reviso : Ing. Primitivo Martínez Carmona | Aprobó : Ing. Roberto Agalde Zavala
 Dibujo : Jorge Herrera Garduño | Fecha : 30/Mayo/05 | No. 5 31 00 1-5



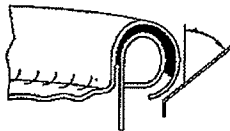
MAKE A VISUAL INSPECTION OF THE PAIL AND THE LID (NO DEFORMATION ARE ACCEPTED)



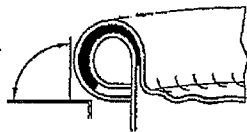
PLACE THE METAL LID IN THE CORRECT POSITION THE LID SHOULD FIT CORRECTLY IN THE BODY PAIL CURL.



CRIMP THE METAL LID USING THE CLOSER MACHINE ACCORDING TO THE USER'S HANDBOOK, MAKE SURE THAT THE CLOSING TOOL IS BEING USED PROPERLY. IF IS NECESSARY, ADJUST THE CLOSING TOOLS TO PROVIDE PROPER CRIMPING. USE THE FOLLOWING DRAWINGS AS YOUR GUIDE



THE WRONG WAY
LESS THAN 90°



THE RIGHT WAY
90° OR MORE

GRUPO ZAPATA

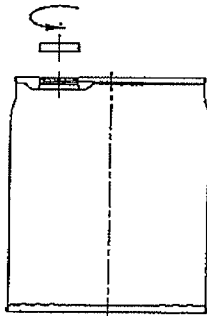
TECHNICAL DIRECTION

CORPORATIVE STANDARS

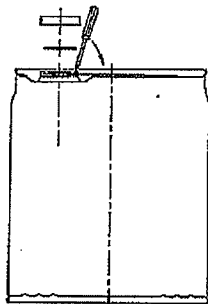
5 GLS TIGHT HEAD PAIL

55 mm SCREW CAP OPENING PROCEDURE

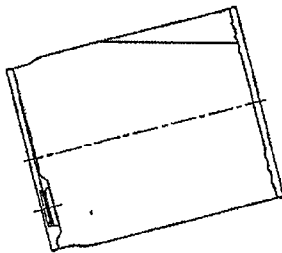
Reviso : Ing. *Edmundo Martínez Carmona* | Aprobó : Ing. *Roberto S. S. S. S.*
 Dibujo : Jorge Herrera Garduño | Fecha : 30/Mayo/05 | No- 531 00 1-8



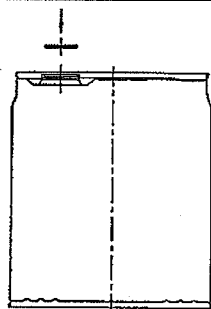
FOR OPENING, BY HAND TWIST
 COUNTER CLOCK WISE THE SCREW CAP
 UNTIL IT BE FREE



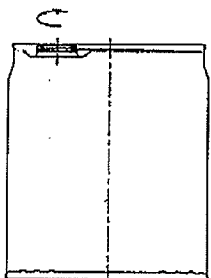
REMOVE THE METAL PROTECTION COVER
 WITH A HAND PROPERLY TOOL



INCLINE THE PAIL TO SERVE THE CONTENENT



FOR CLOSING,
 PUT BY HAND THE PROTECTION METAL COVER



PUT THE SCREW CAP TWISTING
 CLOCK WISE UNTIL BE TIGHTENED ENOUGH