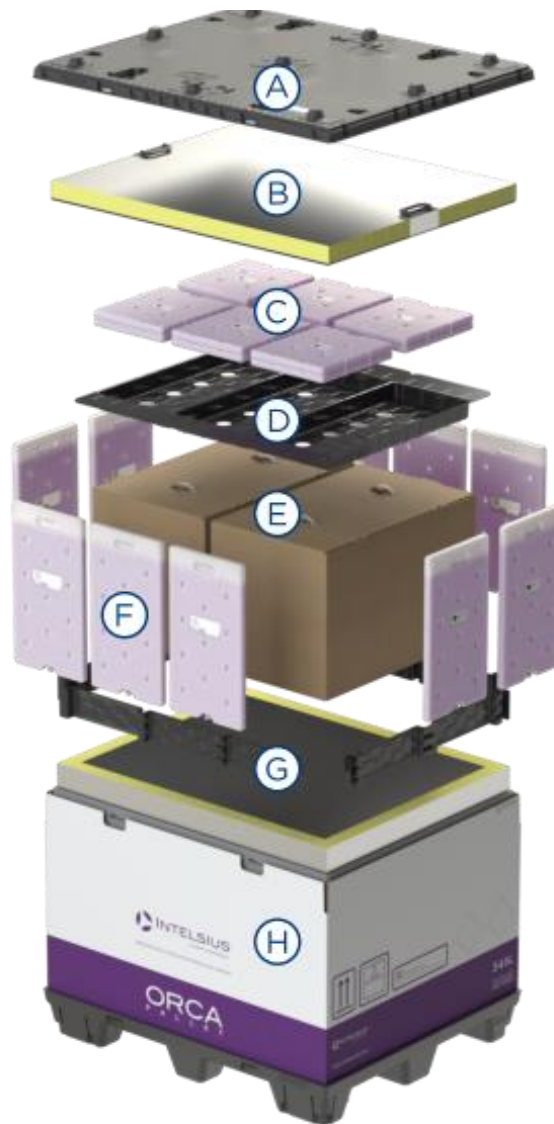


## 2. Assembly

OPAL331 - ORCA Pallet 345L 2°C to 8°C



Component		Quantity
A	ORCA Pallet 345L Outer Lid	1
B	Lid VIP Panel	1
C	ORCA Multi-Use 23L PCM Bottle (Top)	12
D	ORCA Pallet Bottle Tray	3
E	ORCA Pallet Payload Carton	2
F	ORCA Pallet PCM Bottle (Sides)	10
G	ORCA Pallet Brackets	4
H	ORCA Pallet 345L System	1

## 2.1 Conditioning

- 2.1.1 Place the ORCA Pallet and ORCA Multi-Use 23L bottles PCM bottles in a freezer with a minimum temperature of  $-30^{\circ}\text{C}$  for a minimum time of 48 hours.
- 2.1.2 Spread the bottles across a shelf with plenty of airflow to provide uniform, quick freezing of the PCM. Stacking the bottles may result in inadequate freezing of the PCM and will take longer to become fully solid.
- 2.1.3 Before using, ensure that the PCM bottles are solid throughout by examining the bottles. If not solid, then continue to freeze until the PCM is fully frozen. Once suitably frozen, the PCM bottles can be stored in the freezer until needed.
- 2.1.4 The PCM bottles can be directly stored in a refrigerator with the payload and ready for use after 24 hours.
- 2.1.5 Alternatively, after removing the bottles from the freezer, the PCM bottles can be placed on a countertop or workbench for 40 minutes at an ambient temperature of  $20^{\circ}\text{C}$  before preparing and packing in the ORCA system.

## 2.2 Packing Instructions

- 2.2.1 The ORCA Pallet 345L System (H) is assembled by locking the return collar and outer sleeve into the plastic pallet base, ensuring that the base locking tabs engage with the cut outs in the walls of both parts.
- 2.2.2 Place the layer pad onto the pallet base and put the bottom VIP panel directly onto the layer pad with the foam gasket facing upwards. The side VIP panels can then be slotted together inside the pallet sleeve.
- 2.2.3 Assemble the ORCA Pallet bottle brackets (G) inside the system (H).
- 2.2.4 Place the ORCA Pallet PCM bottles (F) vertically into the bracket slots as shown in the assembly diagram (section 2). The brackets will hold the bottles in the correct vertical position.
- 2.2.5 Pack your payload into the payload carton (E) and place into the space created by the PCM bottles within the pallet.
- 2.2.6 Place three ORCA Pallet bottle trays (D) over the payload with the handles resting on the top of the VIP assembly.
- 2.2.7 Place the remaining 12 ORCA Multi-Use 23L PCM top bottles (C) in the three trays, four per tray.
- 2.2.8 Place the lid VIP (B) on the VIP assembly, covering the bottle tray handles.
- 2.2.9 Place the ORCA Pallet lid (A) on top of the ORCA Pallet 345L System (G), ensuring that the locking tabs engage with the cut outs in the wall of the outer sleeve.