



Exemplary drawing of a OnePak 43.

LOADING ONEBLOKS AND PROOFBLOKS INTO ONEPAK 4-74

Engineered for endurance and efficiency, OnePak is qualified according to ISTA 7D, maintaining temperatures from -70°C to +20°C for over 96 hours, even in extreme weather conditions. This ensures the safe arrival of pharmaceuticals regardless of the destination. Advanced vacuum insulation panels (VIPs) deliver enhanced thermal efficiency in a remarkably thin profile making it ideal for space-constrained environments, and the unique combination of low box tare weight and high thermal performance leads to streamlined and cost-saving logistics. This instruction document describes each step of the loading process for OnePak 4-74 with the corresponding OneBlocs respectively ProofBlocs. The following loading instruction is only valid for: **OnePak 4-74**.

Note:

This SOP is valid for **OnePak 4, 8, 23, 43 and 74**. The OnePak 23 is shown in the pictures as an example.

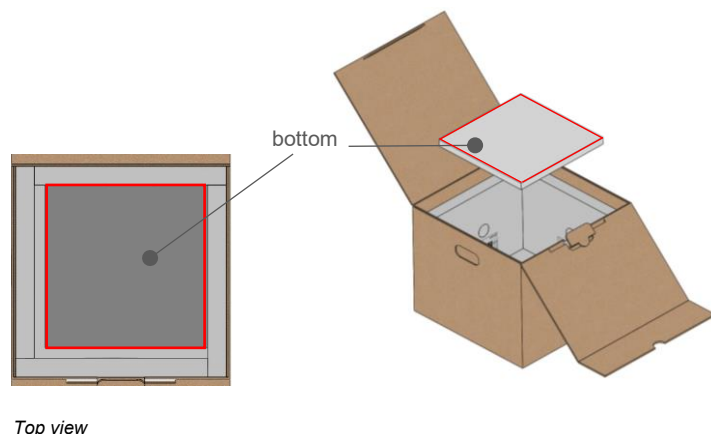
Prior to loading, the OneBloks (OnePak 4, 8, 23 and 43) or ProofBloks (OnePak 74) must be preconditioned as per the respective SOP instructions for the desired temperature range. The desired temperature range depends on the PCM (phase change material) utilized and is indicated by the color code of the OneBlok or ProofBlok. Tab. 1 summarizes the different PCMs of the OneBloks and ProofBloks, their corresponding color codes and application temperatures. For reasons of simplification, only OneBloks are referred to in the following, the procedure with ProofBloks for the OnePak 74 is identical.

A OnePak box uses a total of six OneBloks. The size of the OneBloks used depends on the OnePak size. Tab. 2 at the end of the document provides the relevant OneBlok sizes for each OnePak size.

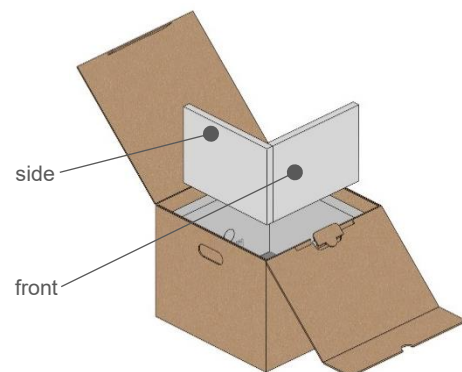
Throughout this SOP, the OneBloks required for each loading step will be referred to as OneBlok A (Bottom and Top position), OneBlok B (Back and Front position), and OneBlok C (Left and Right position). Please use the OneBlok A, OneBlok B, and OneBlok C specified in Table 2 for the corresponding OnePak size and configuration when following the loading SOP.

Step 1

- Open the lid of the OnePak and place top panel aside
- Place 1 piece of **OneBlok A** at the bottom corner of the OnePak.

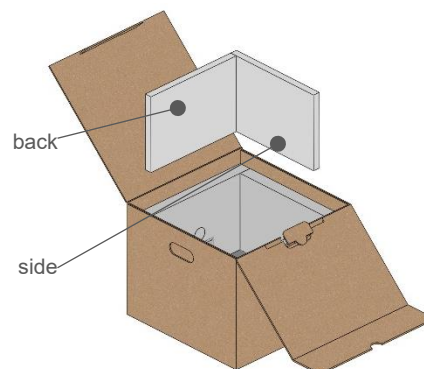
**Step 2**

- Load 1 piece of **OneBlok B** and 1 piece of **OneBlok C** in the corner besides OneBlok A from Step 1.



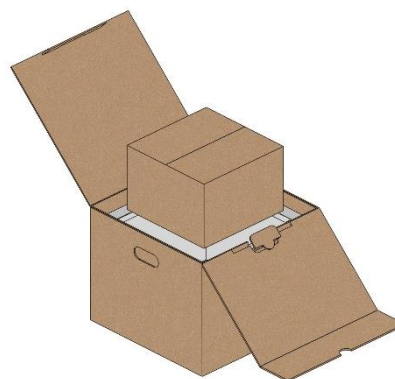
Step 3

- Load 1 piece of **OneBlok B** and 1 piece of **OneBlok C** in the corner on top of OneBlok A from Step 1.



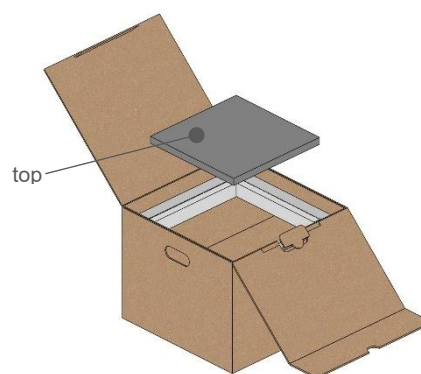
Step 4

- Load the product into the OnePak.



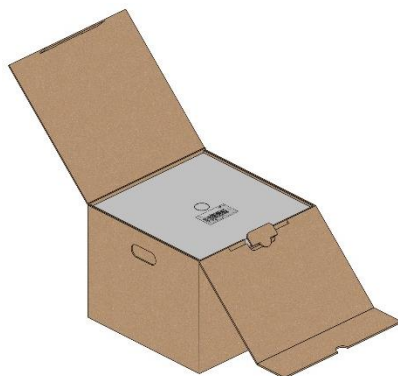
Step 5

- Place 1 piece of **OneBlok A** on top of the product.



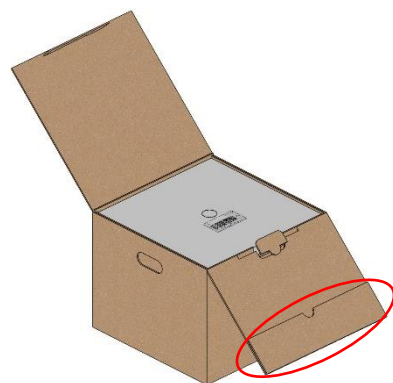
Step 6

- Place top panel on top. Ensure a proper fit.



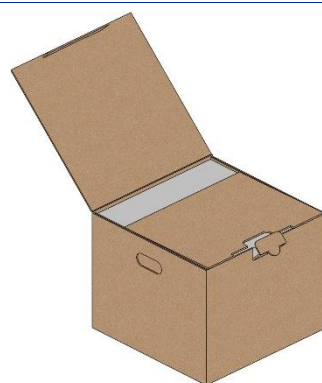
Step 7

- Fold over marked part of the front flap.



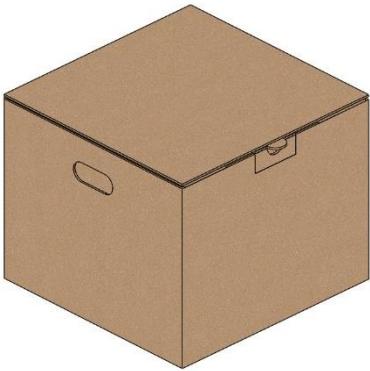
Step 8

- Fold over front flap.



Step 9

- Close lid, insert tuck in flap at front side and seal OnePak with tape.



TAB. 1: ONEBLOKS - COLOR CODE FOR DIFFERENT PCM CONFIGURATIONS

PCM	Application	Label Color Code
+22G	For +20°C shipments	
+05G EL	For +5°C shipments	
-21G	For -20°C shipments	

PROOFBLOKS - COLOR CODE FOR DIFFERENT PCM CONFIGURATIONS

PCM	Application	Color Code	
		PCM	Cap
+22G	For +20 °C shipments		
+05G	For +5 °C shipments		
-21G	For -20 °C shipments		

TAB. 2: CORRESPONDING ONEBLOK AND PROOFBLOK SIZES FOR ONEPAK SIZE

OnePak size	OneBlok A Top/Bottom	OneBlok B Back/Front	OneBlok C Left/Right
4	20204	20204	20204
8	23233	23233	23233
23	34342	34242	34242
43	44342	44342	34342
	ProofBlok A Top/Bottom	ProofBlok B Back/Front	ProofBlok C Left/Right
74	46462	46462	46462

For more information please contact support@envirotainer.com