

**STANDARD OPERATING PROCEDURE – Assembly of Three-Gallon Frozen Dessert Containers**

**INTRODUCTION**

Frozen desserts are packaged in three-gallon containers which are assembled prior to use and stored in a sanitary condition until needed.

**MATERIALS**

1. Supplies
  - a. Automatic Bulkan Assembler
  - b. Compressed air
  - c. Container sidewalls, rings and bottoms
  - d. Utility cart
  - e. Plastic
2. Hazards
  - a. Be careful of moving parts on the container assembly machine.
  - b. Be careful of sharp edges on the metal rings.

**PROCEDURE**

1. Turn the power on
2. Turn the air on
3. Place a sidewall over the mandrel
4. Place a ring on the top of the sidewall
5. Switch the lever over. This secures the ring to the top of the sidewall
6. Put another sidewall on the opposite side with a ring for the top. Switch the lever back over and then alternate the process of ring and bottom on the sidewalls.
7. Take off the sidewall with the ring and turn the container over. Place a bottom on the bottom end of the sidewall.
8. Switch the lever over to secure the bottom.
9. Cover a utility cart with clean plastic. Stack all finished containers upside down on the cart.
10. Lids for the three-gallon are purchased pre-assembled and are stored in closed boxes until needed.

**REFERENCES**

Automatic Bulkan Assembler is manufactured by Sealright Engineering Services  
7805 NW 97<sup>th</sup> Terrace  
Kansas City, Missouri 64153  
Phone: 816-891-8899

The following individual is responsible for implementation of this SOP and has the overall authority on-site:

Name: \_\_\_\_\_ Title: \_\_\_\_\_ Date: \_\_\_\_\_