



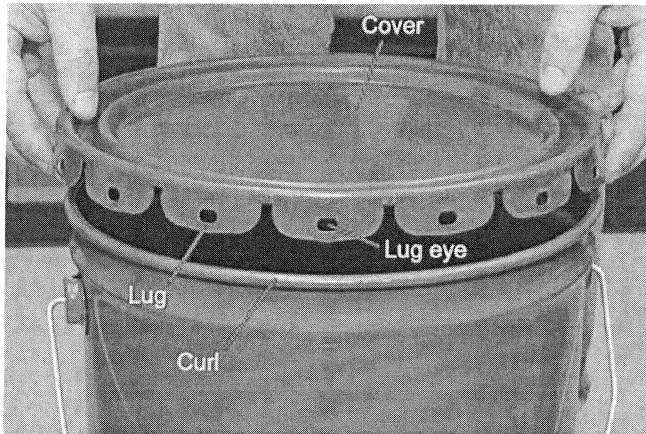
Open Head Closing Instructions

Document: QA-FM-L251 Date: 8/23/12 Rev: 6 Page: 1 of 3

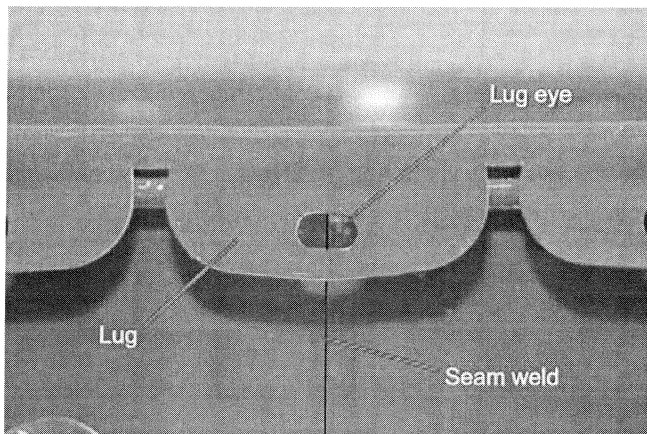
Open Head Pail Closing Instructions

Step 1--Determine that the pail/cover combination is the correct specification for the material being filled.

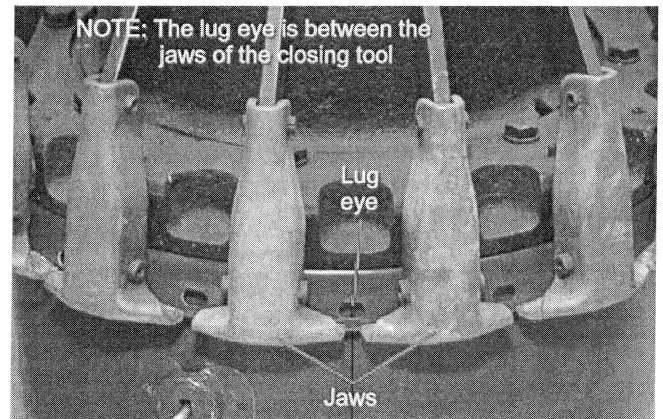
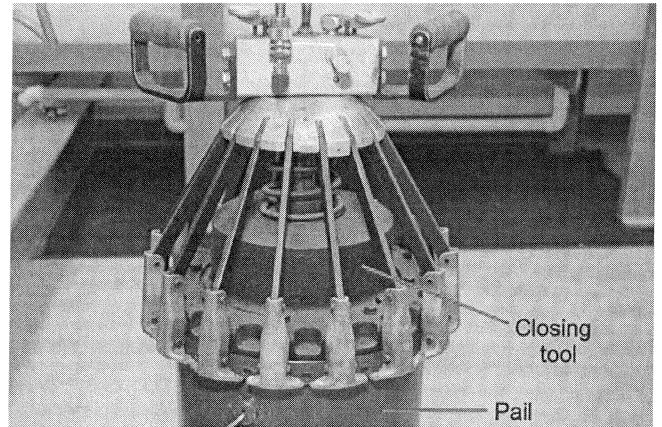
Step 2--Place the cover on pail. Ensure that it is evenly seated around the curl of the pail.



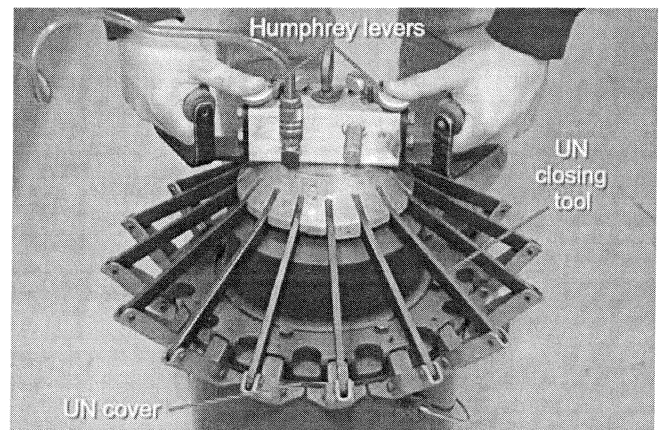
The eye of one of the lugs should be centered directly over the seam weld of the pail.



Step 3--Lower the closing tool onto the cover. Rotate the tool in order to position the lug eyes between the jaws of the closing tool.



Step 4a--To close the pail with the *pneumatic closing tool*, push the Humphrey levers on the top of the closing tool



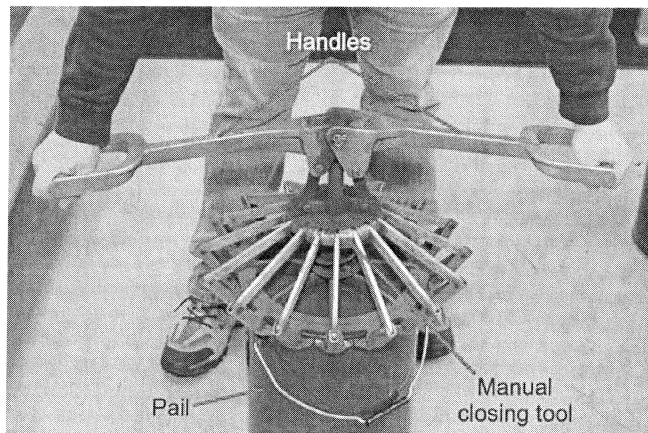
When the downward motion of the tool stops, release the levers.



Open Head Closing Instructions

Document: QA-FM-L251 Date: 8/23/12 Rev: 6 Page: 2 of 3

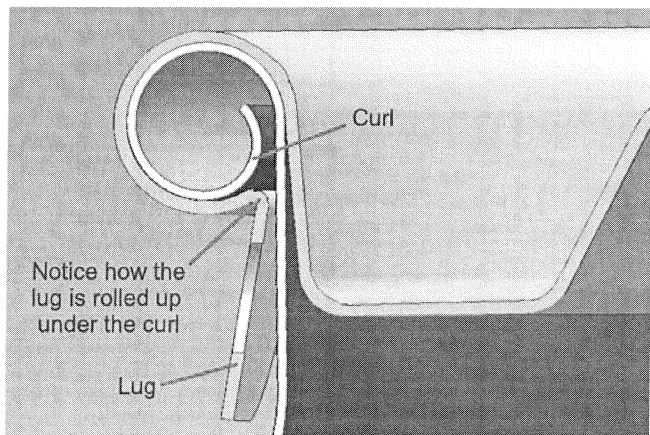
Step 4b--To close the pail with the *manual closing tool*, push the handles down and out until the downward motion stops



When the downward motion of the tool stops, release the handles.

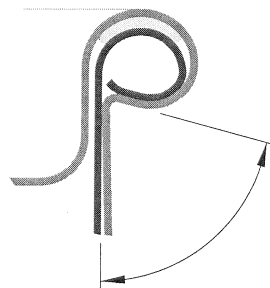
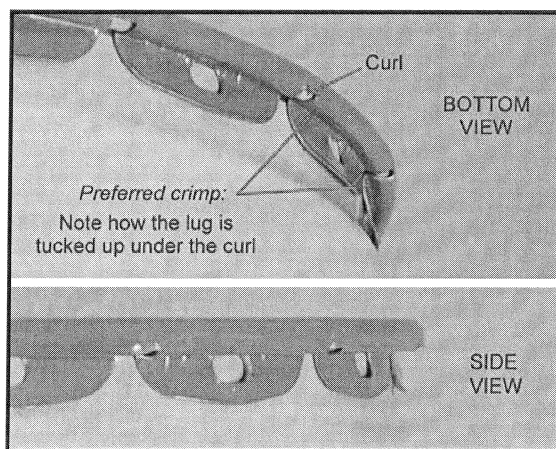
Note: The use of pneumatic and manual closing tools is detailed in this closing instruction; however, many packaging facilities use automated closing tools; regardless of the closing tool used, the quality of the closure is critical

Step 5--Check the integrity of the close to be sure that the cover is properly crimped. Ideally, the cover lugs should be rolled up under the curl as shown in the drawing below.



Step 6--Remove the closing tool. The lugs should be crimped under the curl of the pail at least 90° from the starting position

Review the following photographs and drawings that illustrate the *preferred* crimp, the *acceptable* crimp and the *unacceptable* crimp.



Preferred Crimp



Open Head Closing Instructions

Document: QA-FM-L251 Date: 8/23/12 Rev: 6 Page: 3 of 3

