



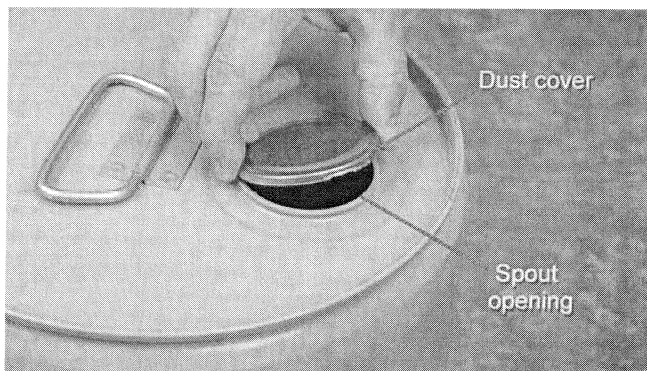
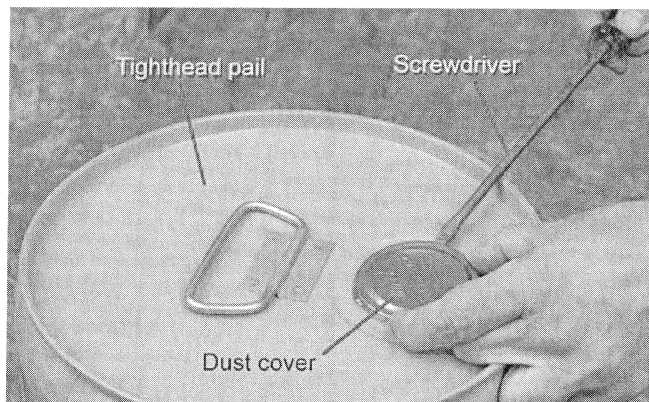
Rieke® FlexSpout Closing Instructions

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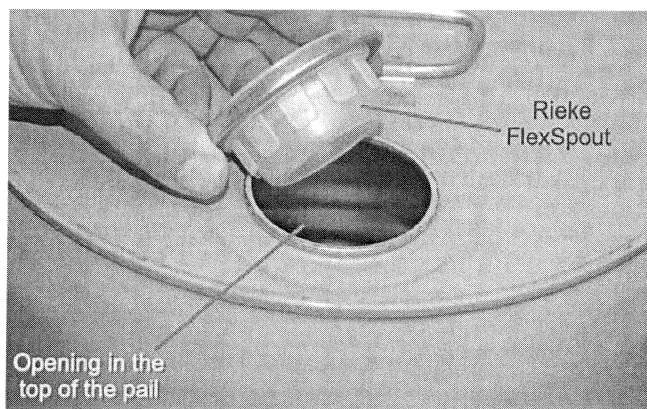
Rieke® FlexSpout Closing Instructions

Manual, Hand-Operated Crimping Tool

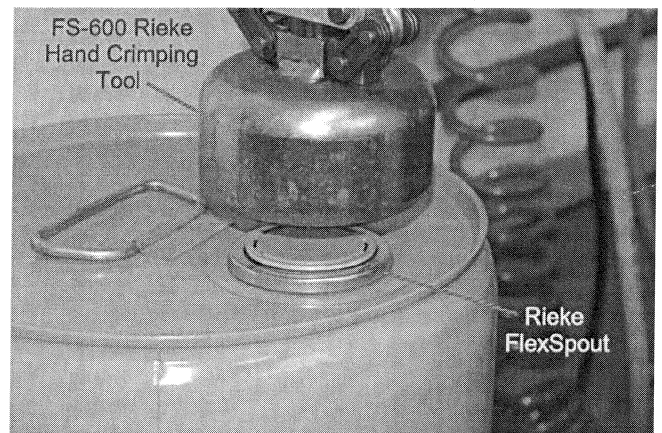
Step 1--Place the pail on a flat surface. Using a screwdriver, pry off the dust cover.



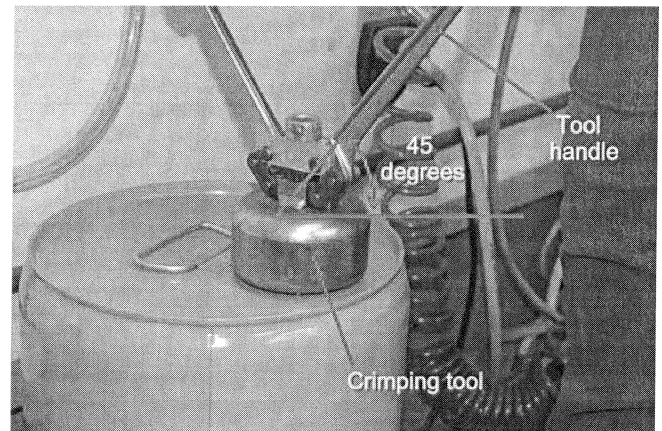
Step 2-- Place the Rieke® FlexSpout in the opening on the top of the pail.



Step 3--The FS-600 Rieke® Hand Crimping Tool is used to crimp the FlexSpout to the opening. Place the crimping tool evenly over the fitting on the pail.



Step 4--In the resting position, the handles of the crimping tool should be approximately 45° to the top of the pail.

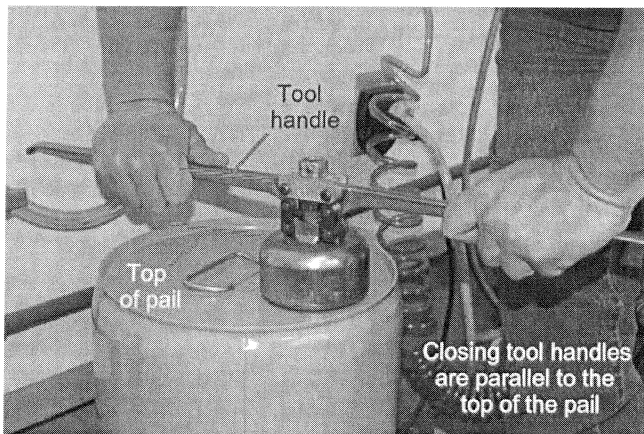
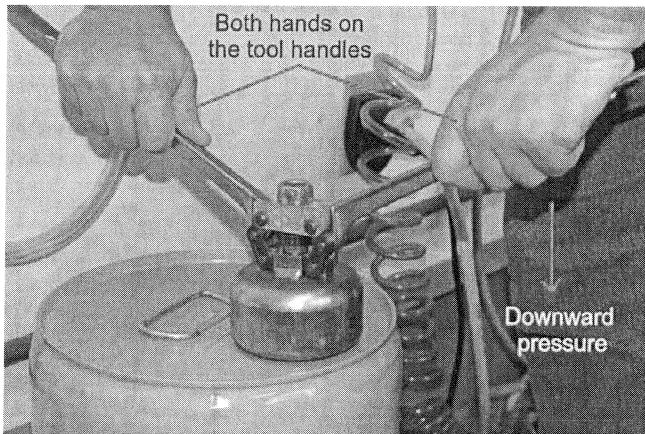


Step 5--Grip the handles of the crimping tool with your hands. Apply *even* downward pressure until the handles are parallel to the top of the pail in order to properly crimp the fitting.



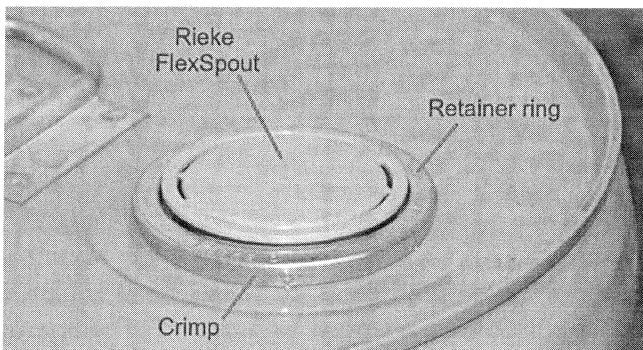
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Note: The use of the hand crimping tool is detailed in this closing instruction; however, many packaging facilities use automated crimping tools; regardless of the crimping tool used, the quality of the crimp is critical

Step 6--Visually inspect the crimped FlexSpout. The crimp should be uniform and consistent around the entire circumference of the retainer ring of the fitting.



Note: It is important that the closing tool is resting *evenly* on the FlexSpout when applying the downward pressure; if the tool is *cocked* or *tilted* when crimping the fitting, an improper seal can result which might cause leakage of the contents of the pail

Step 7--Check the crimp of the Rieke® FlexSpout fitting using the **G-101 go / no go gauge**. As the gauge is moved over the fitting, the edge must be able to pass by the side of crimp.

Note: Contact Rieke® Corporation, or your Cleveland Steel Container Regional Sales Manager, to obtain this gauge

