



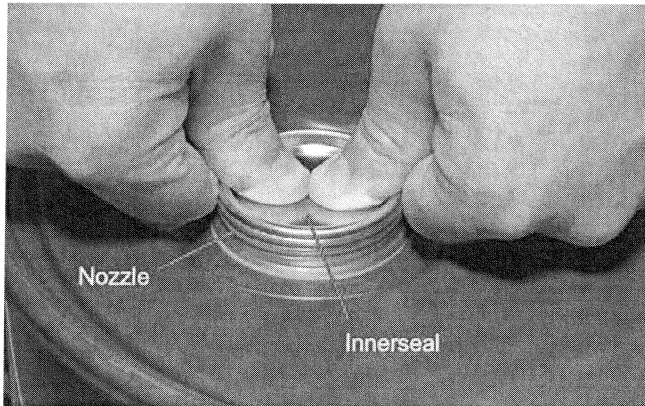
Metal Screw Cap Closing Instructions

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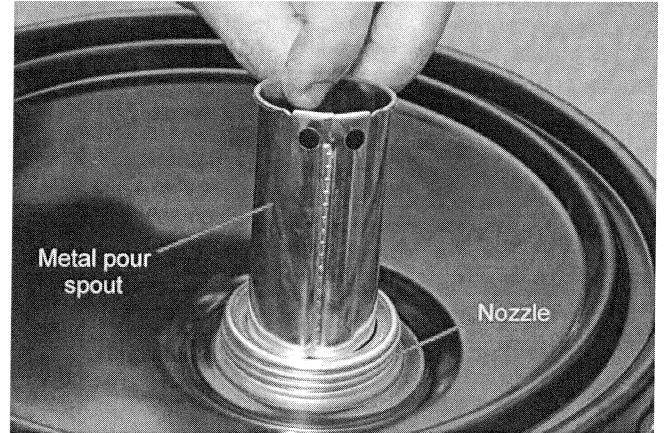
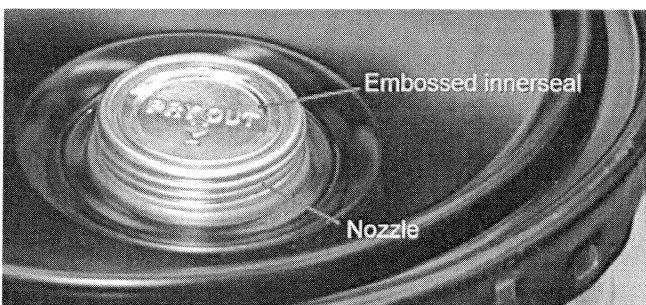
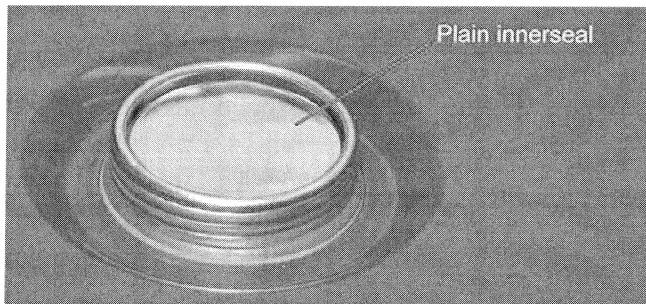
Step 1--Hold the pail securely on a flat surface.

Step 2-- Place the innerseal over the opening in the nozzle. Apply pressure to the innerseal to ensure that it locks completely into the nozzle opening.



Note: Use caution in order to prevent distortion to the innerseal while applying pressure

Note: There are 2 styles of innerseals, *plain* and *embossed*; both are installed in the same manner; the embossed style is designed to accommodate a metal pour spout and must be used with the nozzle



Step 3--Place the screw cap over the opening in the nozzle. Gently rotate the screw cap clockwise until the threads of the cap smoothly engage the threads in the nozzle.



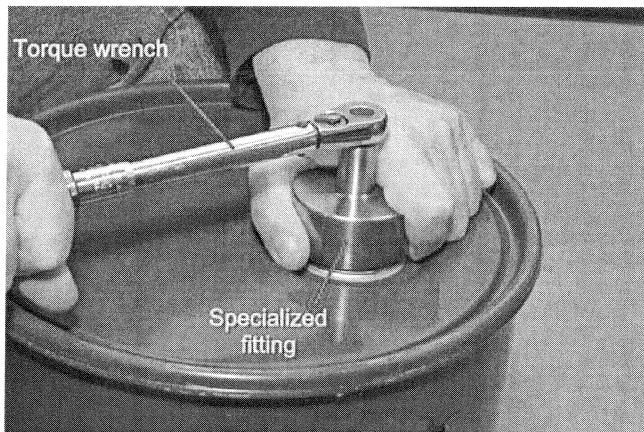
Step 4--Continue to rotate the screw cap clockwise until it cannot be tightened any further by hand. Using a torque wrench and specialized fitting for the particular cap screw being installed, tighten it to at least 80 inch-pounds.

Refer to the **Recommended Torque Specifications** chart for the torque specification required for the hydrostatic pressure rating marked on the pail.



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Automatic Application

Step 1--Set the capping machine torque adjustment to the required specification for the product being packaged in the pail. As a guide, tighten the cap screw to at least 80 inch-pounds.

Refer to the ***Recommended Torque Specifications*** chart for the torque specification required for the hydrostatic pressure rating marked on the pail.

Step 2--Be sure that the screw cap is not misaligned or mis-threaded. If it is, adjust the alignment of the screw cap and nozzle.

Recommended Torque Specifications for Screw Cap Fittings

Hydrostatic Pressure Rating	Torque
< 80 kPa	80 in-lbs
80 - 100 kPa	100 in-lbs