



Screw Cap Closing Instructions

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Manual Application:

- 1) Hold the container securely on a flat surface.
- 2) Place Innerseal over opening in nozzle. Apply pressure to Innerseal to ensure that it locks completely into the nozzle opening. ***Use caution to not distort innerseal while applying pressure.**
- 3) Place the Screw Cap over the opening in the nozzle. Gently turn the Screw Cap clockwise until the threads of the cap smoothly engage the threads of the nozzle.
- 4) Continue to turn the Screw Cap clockwise until the cap can no longer be torqued any tighter by hand. Using a torque wrench and specialized fitting for the size of the Screw Cap being applied, tighten the Screw Cap to no less than 80 inch-pounds. See table below for recommended torque specification in relation to Hydrostatic pressure rating marked on the container.

Automatic Application:

- 1) Set capping machine torque adjustment to varying specifications depending on product packaged. As a guide, the torque should be no less than 80 inch-pounds. See table below for recommended torque specification in relation to Hydrostatic pressure rating marked on the container.
- 2) Be alert for excessive misaligned or misthreaded caps, adjust alignment of cap and nozzle if necessary.

Recommended Torque Specifications for Screw Cap Fittings

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

Signature: _____