

51, 61, 63 and 70mm Screw Cap Closure Instructions

PURPOSE:

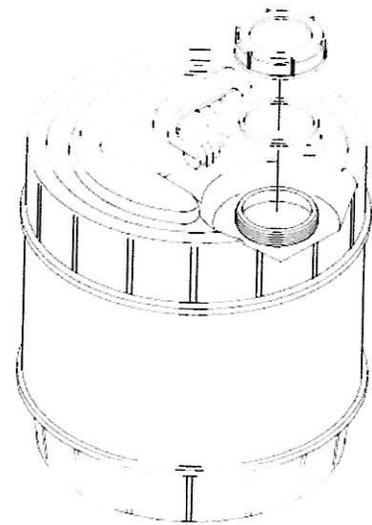
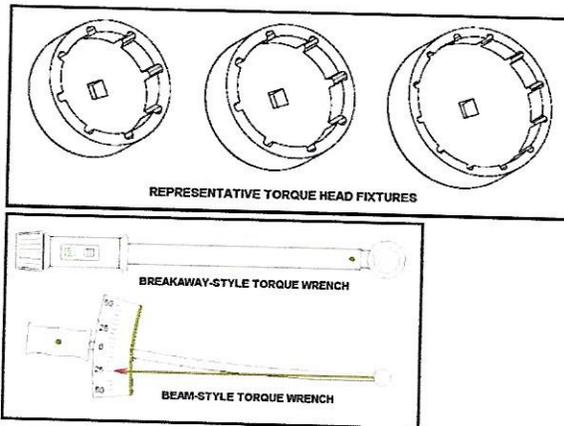
To ensure that the threaded screw cap is properly sealed when assembled onto BWAY's jerricans and tighthead drums. The DOT/UN Performance Certification only applies to a Tight Head Container that is closed per this procedure.

SIGNIFIGANCE:

The sealing performance of the Cap is compromised if the top surface of the neck is rough, has a burr, or is not clean; in addition, if the gasket in the cap is not properly seated in the O-Ring groove, twisted, or is not clean. The Caps are only to be assembled on the jerrican after all sealing surfaces pass inspection.

APPARATUS:

- 51, 61, 63 or 70mm Torque Head Fixture
- Torque Wrench (Adjustable from 10 - 15 ft-lbs or 120 - 180 in-lbs)
- The use of a calibrated automatic torque application machine is permissible if it does not damage the threads or seating surface of the container.



70 mm Tamper Evident Screw Cap
Recommend: 12 ft. lb.

PROCEDURE:

1. Inspect the top surface of the neck to ensure an acceptable sealing surface, clean and free of any debris.
2. Inspect the cap to ensure the gasket is properly assembled and is clean.
3. Start the cap on the neck by hand, rotating the cap in a clock-wise direction. Take care not to cross thread the cap; this will result in damage to the cap or to the neck finish.
4. Using the 51, 61, or 70mm torque head fixture mounted onto a torque wrench, tighten the cap per the table below.

| CAP SIZE (DIA) | Thread Pitch | INSTALLATION TORQUE |
|----------------|--------------|---------------------------------------|
| 51mm | 6mm (4TPI) | 180 IN-LBS (15 FT-LBS) |
| 61mm | 6mm (4TPI) | 180 IN-LBS (15 FT-LBS) |
| 63mm | 8TPI (3mm) | 120 IN-LBS (10 FT-LBS) |
| 70mm | 8TPI (3mm) | 120 IN-LBS (10 FT-LBS) |
| 70mm | 6TPI (4mm) | 120 to 150 IN-LBS (10 to 12.5 FT-LBS) |