



**Ropak Packaging**

A MEMBER OF THE LINPAC GROUP OF COMPANIES

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 **Closing Instructions**

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## UN Closed Head Packaging



FIGURE 1



FIGURE 2



FIGURE 3



FIGURE 4



The following information is being provided to customers and distributors of the ROPAK Corporation to fulfill the notification requirements of 178.2(c) of the 49 CFR. These closing instructions are based upon the procedures used during assembly for testing and certifying this packaging to a UN standard. These instructions apply to all sizes of Ropak's round straight bottom, tapered bottom and jerricans. Alternative methods used for final assembly and closure may not effectively provide a certified UN standard packaging.

### PROPER SCREW CAP INSTALLATION

1. Place the Rieke cap ( FS-70, FS-80, FS-80-T series 70 mm screw caps) on top of the threaded opening and manually thread onto the neck of the container. (fig. 1)
2. Place a Rieke Model W0399PT01 wrench over the cap and tighten down to 10 foot pounds of force. (fig. 2) Recommended torque for tightening small screw cap over 18mm vent is 15 in/lbs.
3. Visibly inspect and manually check to ensure that the cap is straight and completely threaded onto the neck.

**Note:** A customized breakaway wrench may be used in replacement to the Rieke W0399PT01 wrench. Set the torque level to 10 foot pounds and tighten accordingly.

### PROPER CRIMP-ON SPOUT INSTALLATION

1. Place the Rieke fitment on top of the opening of the container neck and snap into place. (fig. 3)
2. Place a Rieke Model FS-600 crimping tool over the fitment and simultaneously depress both handles. (fig. 4)
3. Visibly inspect and manually check to ensure that crimping is straight and secure.

**Note:** A pneumatic Rieke, IA-FS-600, IA-FS-600-06, or ADP-7 with HFS-600 sealing tool may be used provided that the Rieke installation instructions are followed accordingly. For more information, please contact the Rieke Corporation directly at (219) 925-3700.



FIGURE 1



FIGURE 2



FIGURE 3



FIGURE 4

