

PDC0005SC00019 - 5 GAL NATURAL HDPE RECTANGULAR T/H W/ SWING HANDLE 70MM 6TPI T/E OPENING W/ DUST CAP W/ 28MM VENT UN EMBOSSED 7705127

## 50/51, 60/61, 63 and 70mm Screw Cap Closure Instructions

**PURPOSE:**

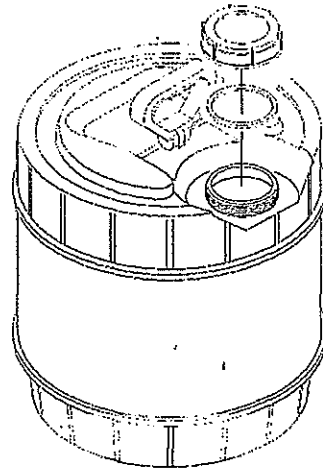
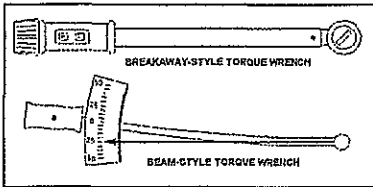
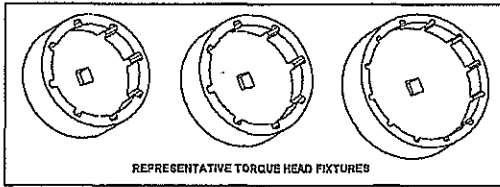
To ensure that the threaded screw cap is properly sealed when assembled onto BWAY's jerricans and tighthead drums. The DOT/UN Performance Certification only applies to a Tight Head Container that is closed per this procedure.

**SIGNIFICANCE:**

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:**

- 50/51, 60/61, 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.



**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 50/51, 60/61, or 70mm torque head fixture mounted onto a torque wrench, tighten the cap per the table below.

CAP SIZE (DIA)	Thread Pitch	INSTALLATION TORQUE
50/51mm	6mm (4TPI)	180 IN-LBS (15 FT-LBS)
60/61mm	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)

# 18, 22, 24 and 28mm Screw Cap Vent Closure Instructions

## PURPOSE:

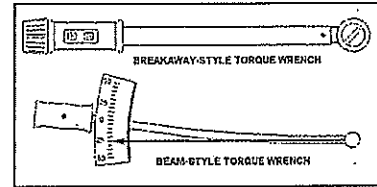
These instructions are designed to ensure the proper installation of 18, 22, 24, and 28mm screw caps onto their respective threaded vent openings on BWAY jerricans and tighthead drums. The UN Regulated Container Certification applies to marked UN 1H1 and 3H1 Tight Head packages that are closed per this procedure.

## SIGNIFICANCE:

The sealing performance of the UN components can be compromised if the components have been damaged in shipment or handling and all components should be inspected prior to cover application.

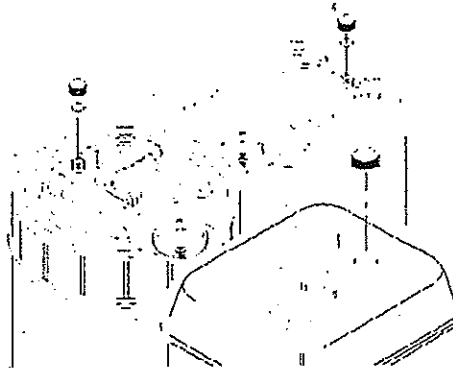
## APPARATUS:

- o Torque wrench of suitable measuring capacity (25 ft-lbs minimum), digital breakaway style or T-Handle preferred.
- o Torque Wrench Head Fixture specific to the screw cap being installed. Wrench Head should be shape matched and fitted securely to the outer diameter of the screw cap and mount directly to the torque wrench shaft. Contact the specific screw cap manufacturer for additional Wrench Head Fixture information.



## ASSEMBLY INSTRUCTIONS:

1. Verify that the top sealing surface of the container vent is clean and free of defects or debris. Clean as needed.
2. Verify that the gasket is properly placed inside the closure and fully seated against the closure's top inner surface. Install or adjust the gasket if required and ensure that the gasket surfaces are free of defects or debris.
3. Start the screw cap onto the container neck by hand, turning clockwise until the threads have engaged.
4. Use the manual or mechanical Torque Wrench and Torque Wrench Fitting as described above to finish seating the closure to the recommended torque (see Closure Application Torque table below).



Screw Cap Size	Application Torque
18mm SP400	15 in-lbs (1.3 ft-lbs)
22mm SP400	20 in-lbs (1.6 ft-lbs)
24mm SP400	23 in-lbs (1.9 ft-lbs)
28mm SP400	25 in-lbs (2.0 ft-lbs)

**CLOSURE TOOL REFERENCE TABLE**

Closure Mfg'r	Closure Types	Closure Size (mm)	Closure Tool Model	Closure Tool Description
Various	Vent Caps	18,22,28		T-Handle Torque wrench
American Flange	Tri-Sure Tab Seal		UG	Manual Crimping Tool
	Tri-Sure Uni-Grip		UAG	Pneumatic Crimping Tool
Norpak / Norton	Norcap	70		Seekonk Torque Wrench (Gauge) or Equivalent with Rieke Cap Wrench Adapter, W394; or contact your Norpak/Norton representative for equivalent adapter
	Norcap Vented			
Republic	Comack	70		Seekonk Torque Wrench (Gauge) or Equivalent with Rieke Cap Wrench Adapter, W394; or contact your Republic representative for equivalent adapter
	Comack TEXT			
	SC63R Vented			
Brandt (BWAY)	Brandt 70mm Brandt 70 Vented Brandt 70mm TE	70		Seekonk Torque Wrench (Gauge) or Equivalent with Rieke Cap Wrench Adapter, W394; or contact your BWAY representative for equivalent adapter
Brandt (BWAY)	Brandt 61mm Brandt 61 Vented Brandt 61mm TE	61		Seekonk Torque Wrench (Gauge) or Equivalent with Rieke Cap Wrench Adapter, W394; or contact your BWAY representative for equivalent adapter
BeriCap	60/61mm DIN	60/61		Seekonk Torque Wrench (Gauge) or Equivalent with Rieke Cap Wrench Adapter, W394; or contact your BWAY representative for equivalent adapter
Westphal Lange	Westphal Lange 61mm TE	61		Seekonk Torque Wrench (Gauge) or Equivalent with Rieke Cap Wrench Adapter, W394; or contact your BWAY representative for equivalent adapter
Brandt (BWAY)	Brandt 51mm Vented	51		Seekonk Torque Wrench (Gauge) or Equivalent with Rieke Cap Wrench Adapter, W394; or contact your BWAY representative for equivalent adapter
Rieke	FS-60	70		Seekonk Torque Wrench (Gauge) or Equivalent with Rieke Cap Wrench Adapter, W394
	FS-70			
	FS-70 TE			
	FS-70 Vented			
	SC-76			
	SC-76 TE			
	FS-80			
FS-80 TE				
FS-80 Vented				
SC-86				
SC-86 TE				
Rieke/Bomag/Technocraft Pour Spouts	FS-10-6-300		FS-600 IA-FS-600 HFS-600	Manual Flexspout Crimping Tool Airmatic Flexspout Crimping Tool Airdraulic Flexspout Crimping Head and Hose
	FS-10-6-624			
	FS-10-8V-300			
	FS-300		FS-600 IA-FS-600 HFS-600	Manual Flexspout Crimping Tool Airmatic Flexspout Crimping Tool Airdraulic Flexspout Crimping Head and Hose
	FS-II			
	Bomag Crimp-on			
Technocraft Crimp-on	FS-600 IA-FS-600 HFS-600	Manual Flexspout Crimping Tool Airmatic Flexspout Crimping Tool Airdraulic Flexspout Crimping Head and Hose		

Many Torque Wrench Heads are custom made to suit a particular brand of closure. If you do not see yours listed on the chart above, please contact your BWAY sales representative who can help you source one for your particular application.