B-WAY Corporation

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CLOSING INSTRUCTIONS FOR PAILS

MANUAL CRIMPING TOOLS

Tool: Rieke FS-600 FLEXSPOUT Crimping Tool

1. Products
    a) FS-10-6 FLEXSPOUT
    b) FS-10-7 FLEXSPOUT
    c) FS-10-8V FLEXSPOUT
    d) FS-10-10 FLEXSPOUT
    e) FS-40 Poly-Flexcap
    f) FS-41 Poly-Flexcap – Retainer and diaphragm only
    g) PFA-22 3/4" Flange and plug assembly
    h) PFA-32 3/4" Flange and crimping ring only
2. Operation
    a) The closure is to be fully seated on the container opening.
    b) Place the FS-600 crimping tool over the closure, tool should rest on the container.
    c) Grasp the handles (one in each hand). Fully depress the handles applying even pressure on each handle to affect a full crimp.
3. Gauging
    a) Use the G-101-1 gauge to check the crimp. The gauge must pass freely over the crimped closure.

57 mm REL PLASTIC CLOSURE INSERTION

After the container is filled, place the closure in the opening and center it as closely as possible. Apply downward force until the closure is fully seated. The closure will normally snap in with a distinct sound. Do not continue to apply force after the insertion is complete because this could result in damage to the opening.

After the closure has been inserted into the opening, there may be a need to remove the diaphragm and apply the screw cap. The application torque for the screw cap should be 20-25 inch pounds.

DRUM FITTING APPLICATION TORQUE VALUES

Steel Plug with Visecar (Buna N)
- 2" 30 Foot Lbs.
- 1-½" 30 Foot Lbs.
- ¾" 15 Foot Lbs.

Steel Plug with Polyseal or Iradiated Polyseal
- 2" 40 Foot Lbs.
- ¾" 20 Foot Lbs.

Nylon or Plastic plug with White EPT or White Visecar
- 2" 30 Foot Lbs.
- ¾" 15 Foot Lbs.

Tri-Sure or Rieke Steel plug with Black Buna or EPDM gaskets
- 2" 30 Foot Lbs.
- ¾" 15 Foot Lbs.

SCREW NOZZLE AND ASSEMBLIES

Install inner seal if applicable by pressing firmly into the crevice of the nozzle.

The recommended application torque for 2-⅛" and 2-¼" inch screw nozzles is 80-100 inch pounds. Thread-stripping can occur if the screw cap is over torqued.