



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: _____

