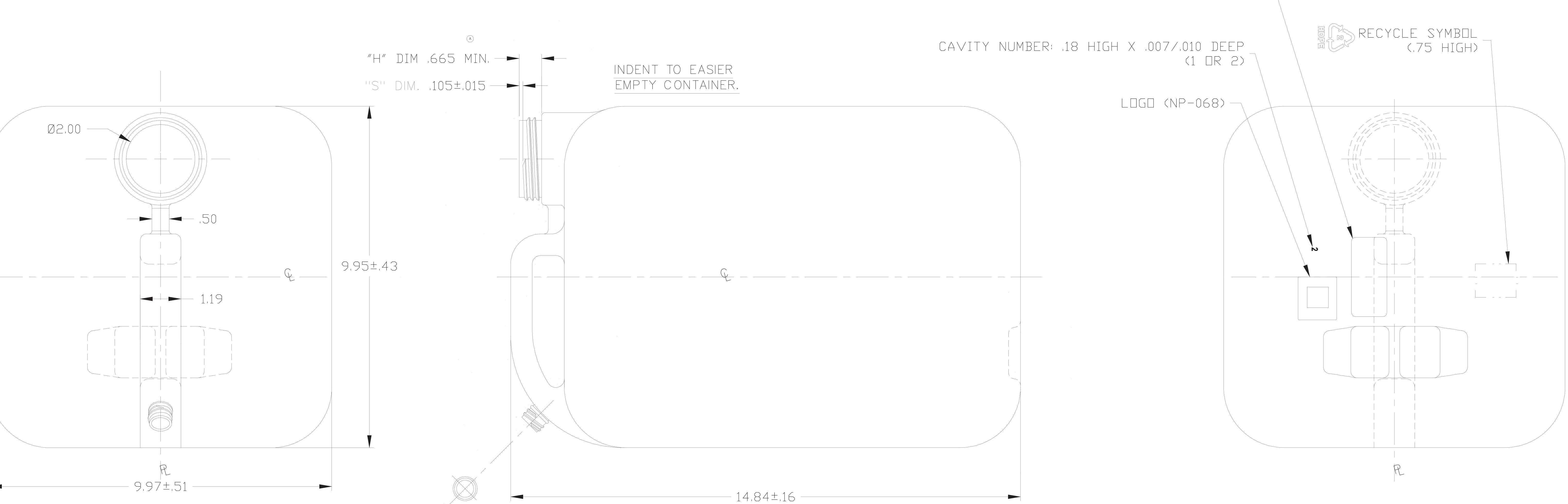


63MM NECK SPECIFIC ATIONS

SP-400 (MODIFIED)
63MM CLOSURE

"E" 2.223/2.258 ©©

"T": 2.390/2.425
6 THREADS PER INCH
2-1/2 FULL TURNS
THREADS START 90° FROM PARTING LINE



BOTTOM VIEW

18MM NECK SPECIFIC ATIONS:

SP-415 (MODIFIED)

18MM CLOSURE

MINOR DIA: .600/.620

MAJOR DIA: .688/.704

"S" DIM: .022/.052

8 THREADS PER INCH

2 FULL TURNS

THREAD STARTS 90° FROM PARTING LINE

NOTES:

1. 14.84 HIGH X 9.95 X 9.97 B
2. RATED CAPACITY: 5 GALLONS
3. WEIGHT: 905 GRAMS

DATE TAG (NP-003) -



Closing Instructions

Date Created: 1.29.2018 Updated: 11.09.2020

Corporate Office 500 Industrial Park Dr. Portland IN 47371 Tel 260.726.7000 Fax 260.726.8111





Figure 1



Figure 2



Figure 3



Figure 4

For Non-UN 2.5 & 5 Gallon Ft. Pack Containers

PROPER SCREW CAP INSTATLATION

Caps that this closing instruction includes are: Priority Plastics Cap 8728-201-060-63MM Natural Screw on Cap with a Sure Seal 222 gasket. Priority Plastics Cap 8728-211-060-63MM Natural Screw on Cap with a Sure Seal 222 gasket Sure Seal 222 gasket.

18mm Cap: Amcor Rigid Plastics USA, Inc: Priority item # 6010-000-070 with F-217 Liner.

- 1. Place the correct 63mm cap as listed above on the container ensuring the gasket is in the cap (Fig.1)
- 2. Manually screw the cap on the container (Fig. 2)
- 3. Place an overcap fixture over the 63mm cap (Fig 3)
- 4. Use a Snap on Tool Hand Torque-O-Meter Torque Wrench 0-300 in-lb and torque the 63mm cap to 25 43 in-lbs. (Fig 4).
- 5. Ensure the F-217 liner is in the 18mm cap (Fig. 5)
- 6. Manually screw the 18mm cap on the 18mm vent opening (Fig 6)
- 7. Place an overcap fixture over the 18mm cap (Fig. 7)
- 8. Use a Snap on Tool Hand Torque-O-Meter torque Wrench. 0 -125 in-lb or 0-300 in-lb and torque the 18mm cap to 12 25 in-lb.



Figure 5



Figure 6



Figure 7



Figure 8