

_	12/07	J	"E" WAS 2.244/2.279
E05-019	9/05		OVERFLOW CAPACITY CHA
E05-013	6/05	G	"E" Ø2.244/2.279 WAS Ø2.223/2.25
E04-020	6/04	F	UPDATED PRINT PER ECN#
E03-010	6/03	E	"H" DIM .650 MIN WAS .665
_	5/03	D	"H" DIM .665 MIN WAS .65
_	2/03	С	ADD +015 TOLERANC
	10/98	В	ADDED RIB & BOTTOM VI
96-019	6/96	A2	MAJ. DIA. WAS 2.380/2.41
		A1	"S" DIM. WAS .031/.056
ECN.	DATE	LET.	CHANGE

SHEET <u>1</u> OF <u>1</u> 8818-000

8818-000

BY DO NOT SCALE PRINT



Closing Instructions

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

Date Created: 1.29.2018 Updated: 11.09.2020



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 Wrench0- 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 7



Figure 8