**Metal Screw Cap Closing Instructions**

*Step 1*—Hold the pail securely on a flat surface.

*Step 2*—Place the innerseal over the opening in the nozzle. Apply pressure to the innerseal to ensure that it locks completely into the nozzle opening.

*Note:* Use caution in order to prevent distortion to the innerseal while applying pressure.

*Note:* There are 2 styles of innerseals, *plain* and *embossed*; both are installed in the same manner; the embossed style is designed to accommodate a metal pour spout and must be used with the nozzle.

*Step 3*—Place the screw cap over the opening in the nozzle. Gently rotate the screw cap clockwise until the threads of the cap smoothly engage the threads in the nozzle.

*Step 4*—Continue to rotate the screw cap clockwise until it cannot be tightened any further by hand. Using a torque wrench and specialized fitting for the particular cap screw being installed, tighten it to at least 80 inch-pounds.

Refer to the *Recommended Torque Specifications* chart for the torque specification required for the hydrostatic pressure rating marked on the pail.
Metal Screw Cap Closing Instructions

Refer to the *Recommended Torque Specifications* chart for the torque specification required for the hydrostatic pressure rating marked on the pail.

*Step 2*—Be sure that the screw cap is not misaligned or mis-threaded. If it is, adjust the alignment of the screw cap and nozzle.

**Recommended Torque Specifications for Screw Cap Fittings**

<table>
<thead>
<tr>
<th>Hydrostatic Pressure Rating</th>
<th>Torque</th>
</tr>
</thead>
<tbody>
<tr>
<td>&lt; 80 kPa</td>
<td>80 in-lbs</td>
</tr>
<tr>
<td>80 - 100 kPa</td>
<td>100 in-lbs</td>
</tr>
</tbody>
</table>

**Automatic Application**

*Step 1*—Set the capping machine torque adjustment to the required specification for the product being packaged in the pail. As a guide, tighten the cap screw to at least 80 inch-pounds.