



Closing Instructions for Steel Containers

Tin Coated Steel Screw Caps

Closing instructions apply to a container with or without the use of a tamper evident seal.

Nozzle sizes – 1 inch, 1 1/8 inch, 1 1/4 inch, 1 3/4 inch and 2-1/8 inch

After cans are filled, if the tamper evident seal is required, place tamper evident seal on top of nozzle. Apply pressure using seal insertion tool (sized for seal size) until the seal is below the nozzle surface.

Apply screw cap and torque to the torque specified by the manufacturer.

REIKE CUSTOMER SERVICE REPORT

Subject: Crimping Tools

I. MANUAL CRIMPING TOOLS

A. Tool: FS-600 FLEXSPOUT Crimping Tool

1. Products

- a) FS-10-6 FLEXSPOUT
- b) FS-10-7 FLEXSPOUT
- c) FS-10-8V FLEXSPOUT
- d) FS-40 Poly-Flexcap
- e) FS-41 Poly-Flexcap – Retainer and diaphragm only
- f) PFA-22 3/4" Flange and plug assembly
- g) 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.