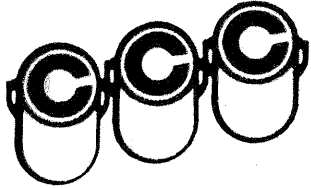


# CENTRAL CAN COMPANY

3200 S. KILBOURN AVE., CHICAGO, IL 60623-4829 • 773-254-8700

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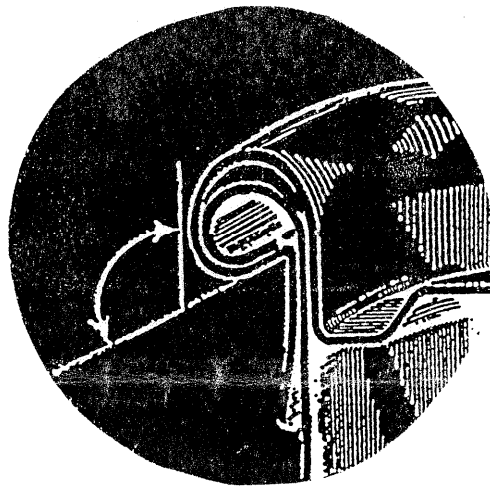
## CLOSURE INSTRUCTIONS

Listed below are detailed closure instructions for the closure supplied by Central Can to shippers so that shippers may close the package in the same manner as it was closed for UN testing.

A lug cover is considered a closure. Therefore, closure instructions will include both open head and closed top pails.

### 6-1/2", 8-1/2" and 11-1/4" LUG COVERS

Lug covers should be crimped so that the gasket is fully compressed and the crimp angle (see drawing) is 90° or more. All the lugs on the cover should meet the crimp angle requirement.



### BOLT RINGS REQUIRED

If the approved UN performance test calls for a bolt ring applied over a crimped lug cover on the pail, the nut on the bolt ring should be tightened to a minimum of 35 inch-pounds.

Over . . . .

**RIEKE CLOSURES**

Rieke flexspouts should be closed using Rieke manual or pneumatic crimping tools. The crimp can be checked with a Rieke go/no go gauge #6101-1 available from Rieke Corp.

Rieke Poly Reseal closure must be seated having full contact between upper closure lip and steel around the circumference of the opening.

Rieke Flexspout III closure must be seated having full contact between upper closure lip and steel around the circumference of the opening.

**AMERICAN FLANGE 63MM UNIGRIP**

American Flange 63mm unigrips should be closed using American Flange manual or pneumatic crimping tools. The crimp can be checked with a "Unigrip Crimp On Go Gauge" available from American Flange.

**SCREW NOZZLE ASSEMBLIES - 2-1/8", 2-1/4"**

The recommended final torque tightening for 2-1/8" or 2-1/4" screw nozzle is 40 to 60 inch pounds. Final screw nozzle torque tension must occur during final closure operation for U.N. performance. (Fittings are manufactured and pre-torqued to 30 inch pounds and may loosen during clinching process into pail parts.)

Please note that torque is in inch pounds. Shippers should be aware that over-torquing screw caps can cause spinning of the fitting and leakage.

**DRUM FITTINGS - 2", 1-1/2" AND 3/4"**

**Rieke Visegrip, Poly Visegrip and Tri-Sure Plug Information**  
**Application Torque and Type of Gasket for Steel Containers**

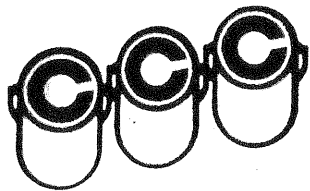
Steel Plug with Visecar (Buna N) EPT or Dapon	2"	30 ft. lbs.
	1-1/2"	30 ft. lbs.
	3/4"	15 ft. lbs.
Steel Plug with Polyseal or Irradiated Polyseal	2"	40 ft. lbs.
	3/4"	20 ft. lbs.
Nylon or Plastic Plug with White EPT or White Visecar	2"	20 ft. lbs.
	3/4"	9 ft. lbs.
Tri-Sure Steel Plug with Black Buna or EPDM Gaskets	2"	20 ft. lbs.
	3/4"	12 ft. lbs.

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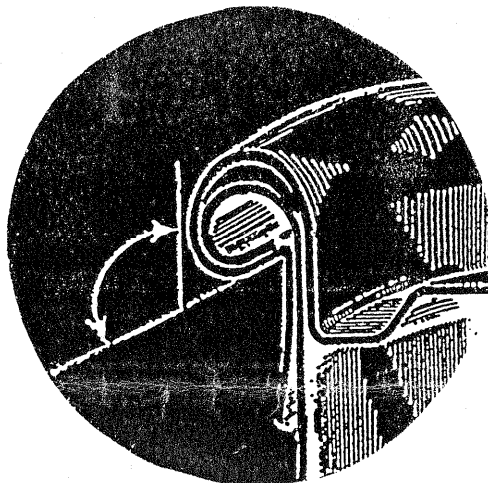
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**DRUM FITTINGS - 2", 1-1/2" AND 3/4"**

**Rieke Visegrip, Poly Visegrip and Tri-Sure Plug Information**  
**Application Torque and Type of Gasket for Steel Containers**

Steel Plug with Visecar (Buna N) EPT or Dapon	2"	30 ft. lbs.
	1-1/2"	30 ft. lbs.
	3/4"	15 ft. lbs.
Steel Plug with Polyseal or Irradiated Polyseal	2"	40 ft. lbs.
	3/4"	20 ft. lbs.
Nylon or Plastic Plug with White EPT or White Visecar	2"	20 ft. lbs.
	3/4"	9 ft. lbs.
Tri-Sure Steel Plug with Black Buna or EPDM Gaskets	2"	20 ft. lbs.
	3/4"	12 ft. lbs.