MANUAL CRIMPING TOOLS

Tool: Rieke FS-600 FLEXSPOUT Crimping Tool

(Rieke automatic crimp heads are approved, but their operation is not described herein)

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

57 mm REL PLASTIC CLOSURE INSERTION

After the container is filled, place the closure in the opening and center it as closely as possible. Apply downward force until the closure is fully seated. The closure will normally snap in with a distinct sound. Do not continue to apply force after the insertion is complete because this could result in damage to the opening.

After the closure has been inserted into the opening, there may be a need to remove the diaphragm and apply the screw cap. The application torque for the screw cap should be 20-25-inch pounds.

DRUM FITTING APPLICATION TORQUE VALUES

Steel Plug with Visecar (Buna N)

2"	30 Foot Lbs.
1-½"	30 Foot Lbs.
¾"	15 Foot Lbs.

Steel Plug with Polyseal or Iradiated Polyseal

2"	40 Foot Lbs.
¾"	20 Foot Lbs.

Nylon or Plastic plug with White EPT or White Visecar

2"	30 Foot Lbs.
¾"	15 Foot Lbs.

Tri-Sure or Rieke Steel plug with Black Buna or EPDM gaskets

2"	30 Foot Lbs.
¾"	15 Foot Lbs.

SCREW NOZZLE AND ASSEMBLIES

Install inner seal if applicable by pressing firmly into the crevice of the nozzle.
The recommended application torque for 2-⅛" and 2-¼" inch screw nozzles is 100-inch pounds. Thread-stripping can occur if the screw cap is over torqued.

OPEN HEAD PAILS WITH LUG COVER

1. Fill the container to the desired level. Do not exceed maximum gross mass or the rated fill volume.
2. Place the UN lug cover on top of the pail curl.
3. Align the eye of one lug over the welded side seam.
4. Lower the closer onto the cover such that the closer jaws are placed over the lugs covering the eyes on the lugs
5. Actuate the closer by pressing the pneumatic levers (pneumatic closer) or pushing the handles down until they stop (manual closer).
6. Remove the closer and ensure that the lugs are crimped under the curl of the pail at least 90° from the starting position.

Lug covers are available in 6½", 8½", and 11¼" diameters.

