

3/4” NPS Bung Plug Closure Instructions

PURPOSE:

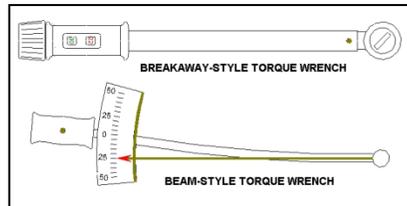
These instructions are designed to ensure the proper installation of any one of several vented and non-vented 3/4” NPS threaded bung plugs into the vent orifice on jerricans and tighthead drums produced by BPI.

SIGNIFICANCE:

The UN Regulated Container Certification applies to marked UN 1H1 and 3H1 Tight Head packages that are closed properly, as per this procedure. Failure to follow this procedure may render the UN certification null. The sealing performance of the UN components can be compromised if the components have been damaged in shipment or handling and all components should be inspected prior to cover application.

APPARATUS:

- Torque wrench of suitable measuring capacity (25 ft-lbs minimum), breakaway style preferred
- Torque Wrench Fitting specific to the bung plug being installed. shape matched to and fit securely inside the center impression in and mount directly to the torque wrench shaft. Contact the specific manufacturer for additional Torque Wrench Fitting information.
- The use of a calibrated automatic torque application machine is permissible if it does not damage the threads or seating surface of the container.



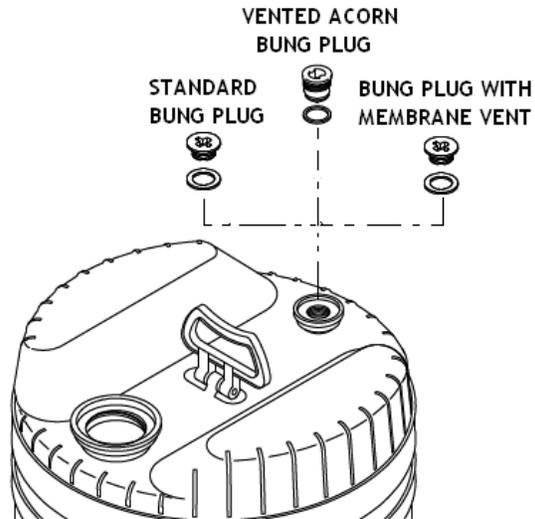
digital
Fitting should be the bung plug bung plug

ASSEMBLY INSTRUCTIONS:

1. Verify that the top sealing surface of the container vent is clean and free of defects or debris. Clean as needed.
2. Verify that the gasket is properly placed onto the closure and fully seated against the closure flange. Install or adjust the gasket if required and ensure that the gasket surfaces are free of defects or debris.
3. Start the vent plug into the container neck by hand, turning clockwise until the threads have engaged.
4. Use the manual or mechanical Torque Wrench and Torque Fitting as described above to finish seating the closure to the recommended torque (see **Plug Installation Torque** table

Wrench below).

Vent Plug Type	Installation Torque
3/4” Standard Bung Plug	85 in-lbs (7 ft-lbs)
3/4” Bung Plug with Membrane	85 in-lbs (7 ft-lbs)
3/4” Vented ACORN Bung Plug	85 in-lbs (7 ft-lbs)



18, 22, 24 and 28mm Screw Cap Vent Closure Instructions

PURPOSE:

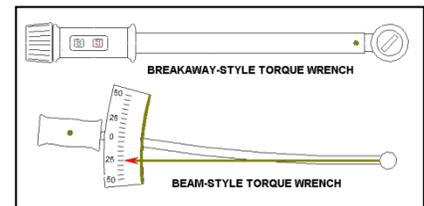
These instructions are designed to ensure the proper installation of 18, 22, 24, and 28mm screw caps onto their respective threaded vent openings on jerricans and tighthead drums produced by BPI. The UN Regulated Container Certification applies to marked UN 1H1 and 3H1 Tight Head packages that are closed per this procedure.

SIGNIFICANCE:

The sealing performance of the UN components can be compromised if the components have been damaged in shipment or handling and all components should be inspected prior to cover application.

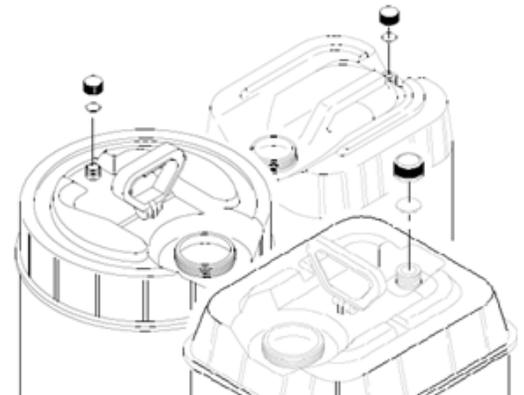
APPARATUS:

- Torque wrench of suitable measuring capacity (25 ft-lbs minimum), digital breakaway style or T-Handle preferred.
- Torque Wrench Head Fixture specific to the screw cap being installed. Wrench Head should be shape matched and fitted securely to the outer diameter of the screw cap and mount directly to the torque wrench shaft. Contact the specific screw cap manufacturer for additional Wrench Head Fixture information.



ASSEMBLY INSTRUCTIONS:

1. Verify that the top sealing surface of the container vent is clean and free of defects or debris. Clean as needed.
2. Verify that the gasket is properly placed inside the closure and fully seated against the closure's top inner surface. Install or adjust the gasket if required and ensure that the gasket surfaces are free of defects or debris.
3. Start the screw cap onto the container neck by hand, turning clockwise until the threads have engaged.
4. Use the manual or mechanical Torque Wrench and Torque Wrench Fitting as described above to finish seating the closure to the recommended torque (see **Closure Application Torque** table below).



Screw Cap Size	Application Torque
18mm SP400	15 in-lbs (1.3 ft-lbs)
22mm SP400	20 in-lbs (1.6 ft-lbs)
24mm SP400	23 in-lbs (1.9 ft-lbs)
28mm SP400	25 in-lbs (2.0 ft-lbs)

21/24mm Captive Screw Cap Vent Closure Instructions

PURPOSE:

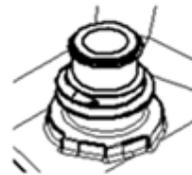
These instructions are designed to ensure the proper installation of 21/24mm captive screw caps onto the mating threaded vent nipple on jerricans and tighthead drums produced by BPI. The UN Regulated Container Certification applies only to marked UN 1H1 and 3H1 Tight Head packages that are closed per this procedure.

SIGNIFICANCE:

The sealing performance of the UN components can be compromised if the components have been damaged in shipment or handling and all components should be inspected prior to cover application.



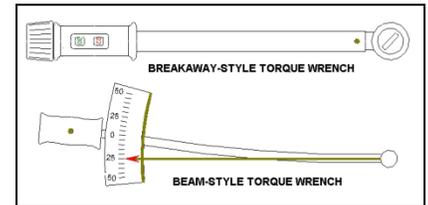
21/24mm Captive Closure



21/24mm Vent Nipple

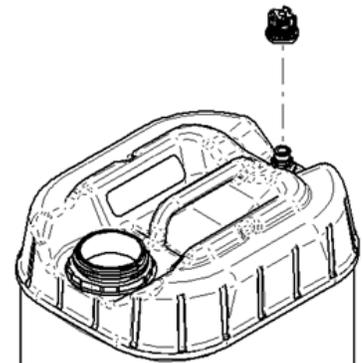
APPARATUS:

- Torque wrench of suitable measuring capacity (20 in-lbs minimum), digital breakaway style or T-Handle preferred.
- Torque Wrench Head Fixture specific to the screw cap being installed. Wrench Head should be shape matched and fitted securely to the outer diameter of the screw cap and mount directly to the torque wrench shaft. Contact the specific screw cap manufacturer for additional Wrench Head Fixture information.



ASSEMBLY INSTRUCTIONS:

1. Verify that the top sealing surface of the container vent is clean and free of defects or debris. Clean as needed.
2. Verify that the gasket is properly placed inside the closure and fully seated against the closure's top inner surface. Install or adjust the gasket if required and ensure that the gasket surfaces are free of defects or debris.
3. Press the closure downward to snap it onto the vent nipple, then turn the closure clockwise until the threads have engaged.
4. Use the manual or mechanical Torque Wrench and Torque Wrench Head Fixture as described above to finish seating the closure to the recommended torque.
5. Application torque for this closure is **20 in-lbs (1.6 ft-lbs)**.



CLOSURE TOOL REFERENCE TABLE

Closure Mfg'r	Closure Types	Closure Size (mm)	Closure Tool Model	Closure Tool Description
Various	Vent Caps	18,22,28		T-Handle Torque wrench
American Flange	Tri-Sure Tab Seal		UG	Manual Crimping Tool
	Tri-Sure Uni-Grip		UAG	Pneumatic Crimping Tool
Norpak / Norton	Norcap	70		Seekonk Torque Wrench (Gauge) or Equivalent with Rieke Cap Wrench Adapter, W394; or contact your Norpak/Norton representative for equivalent adapter
	Norcap Vented			
Republic	Comack	70		Seekonk Torque Wrench (Gauge) or Equivalent with Rieke Cap Wrench Adapter, W394; or contact your Republic representative for equivalent adapter
	Comack TEXT			
	SC63R Vented			
Brandt (MAUSER)	Brandt 70mm Brandt 70 Vented Brandt 70mm TE	70		Seekonk Torque Wrench (Gauge) or Equivalent with Rieke Cap Wrench Adapter, W394; or contact your BWAY representative for equivalent adapter
Brandt (MAUSER)	Brandt 61mm Brandt 61 Vented Brandt 61mm TE	61		Seekonk Torque Wrench (Gauge) or Equivalent with Rieke Cap Wrench Adapter, W394; or contact your BWAY representative for equivalent adapter
BeriCap	60/61mm DIN	60/61		Seekonk Torque Wrench (Gauge) or Equivalent with Rieke Cap Wrench Adapter, W394; or contact your BWAY representative for equivalent adapter
Westphal Lange	Westphal Lange 61mm TE	61		Seekonk Torque Wrench (Gauge) or Equivalent with Rieke Cap Wrench Adapter, W394; or contact your BWAY representative for equivalent adapter
Brandt (MAUSER)	Brandt 51mm Vented	51		Seekonk Torque Wrench (Gauge) or Equivalent with Rieke Cap Wrench Adapter, W394; or contact your BWAY representative for equivalent adapter
Rieke	FS-60	70		Seekonk Torque Wrench (Gauge) or Equivalent with Rieke Cap Wrench Adapter, W394
	FS-70 FS-70 TE FS-70 Vented			
	SC-76 SC-76 TE			
	FS-80 FS-80 TE FS-80 Vented			
	SC-86 SC-86 TE			
Rieke/Bomag/Technocraft Pour Spouts	FS-10-6-300 FS-10-6-624 FS-10-8V-300 FS-300 FS-II		FS-600 IA-FS-600 HFS-600	Manual Flexspout Crimping Tool Airmatic Flexspout Crimping Tool Airdraulic Flexspout Crimping Head and Hose
	Bomag Crimp-on		FS-600 IA-FS-600 HFS-600	Manual Flexspout Crimping Tool Airmatic Flexspout Crimping Tool Airdraulic Flexspout Crimping Head and Hose
	Technocraft Crimp-on		FS-600 IA-FS-600 HFS-600	Manual Flexspout Crimping Tool Airmatic Flexspout Crimping Tool Airdraulic Flexspout Crimping Head and Hose

