

APPLICATION AND REMOVAL OF THREADED CLOSURES USING PUREPAK CAP TORQUE SOCKETS

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Purpose: To detail the procedure for using a PurePak Cap Torque Socket and Torque Wrench to properly apply threaded closures to PurePak Bottles at the correct application torque or for measurement of subsequent closure removal torque.

Tools: PurePak Cap Torque Socket (specific to the particular cap being applied)
Hand Torque Wrench
3/8 inch to 1/4 inch Drive Reducer (if needed)

Procedure:

1. Insert Hand Torque Wrench drive post into the 3/8 inch square hole in top of Cap Torque Socket. If the Cap Torque Wrench drive post is 1/4 inch, insert a 3/8 inch to 1/4 inch Drive Reducer into the Cap Torque Socket then onto the Hand Torque Wrench.
2. Turn the Torque Wrench trailing indicator to "0" and overlay the Cap Torque Socket cup side onto the subject threaded closure which was previously applied to a bottle.
3. While firmly holding the capped bottle firmly at the shoulder, grasp the Torque Wrench handle end and smoothly turn it clockwise (as viewed from the top) until the trailing indicator reaches the intended application torque. Read and record the resulting position of the trailing indicator.
4. Remove Cap Torque Socket assembly from the threaded closure and repeat the process for subsequent bottles.
5. For measurement of removal torque from an already torque applied threaded closure, follow above Steps 1,2 and 3 with the trailing indicator zeroed by moving it clockwise to zero and turning the Torque Wrench handle in the counterclockwise direction while firmly grasping the capped bottle at the shoulder. Read and record the resulting position of the trailing indicator.

Notes: The Application Torque Specifications for PurePak combination packagings are listed below and contained in Packaging Instructions online at www.purepaktechnology.com.

Hoffer 38 mm T/E Drop Lok Closure: 20 to 25 inch-pounds (2.26 to 2.82 n-m)
Berry Plastics (Rexam) 38-439A Acid Cap: 35 to 50 inch-pounds (3.95 to 5.65 n-m)
Menshen I Tamper Evident 45mm Closure: 23 to 28 inch-pounds (2.60 to 3.16 n-m)
Menshen II Tamper Evident 45mm Closure: 35 inch pounds (3.95 n-m)