

Closing Instructions For U.N. Certified Packaging

Phoenix Container, Inc. offers the following instructions regarding the closing and final assembly of our U. N. Marked metal pails.

Tight - Head Pails - These packages are supplied in two levels of certification having different thickness of metal. The tops are equipped to accept either a Rieke Flex Spout or 2 1/8 metal screw cap.

Proper assembly of the Rieke Flex Spout is covered in the attached instructions written by the manufacturer.

Proper assembly of the screw cap is as follows.

Insure that the proper cap is being applied.

Apply the cap manually or mechanically, without distortion to either the cap or threaded fitment.

Cap should be tightened to a minimum of 40 in.-lbs. Torque as recommended by the supplier.

Open - Head Pails - Assembly of the open-head pails includes applying the top lug-cover to the pail. The tool used for assembling the cover to the pail for certification testing is manufactured by Atlanta-Grotnes. A reprint of their instructions is attached. In addition to applying the cover properly, it is incumbent to the filler to insure that the proper gauge cover is used for the U.N. Marking printed on the bottom side of the pail.

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Cover Closing Instruction

Closing Open Head Metal Pails with Covers -

Determine the gauge of the containers to be closed. Gauges on Phoenix Container, Inc., metal pails range from 24 gauge to 29 gauge. Make sure that you are using the proper UN certified cover to complete the package.

To Operate the Manual Tool -

Place the cover on the pail, then set the tool on top of the cover (lining the tab lugs on the cover up with the jaws on the tool), and then press the handles down. Repeat process in between lugs. Make sure all the lugs are secured properly.

To Operate the Semi-Automatic Tool -

Connect the tool to your airline, then set the tool on the pail and press the actuator buttons. The head will actuate down and close the cover onto the pail. Repeat process in between lugs. Make sure all the lugs are secured properly.