



Open Head Closing Instructions

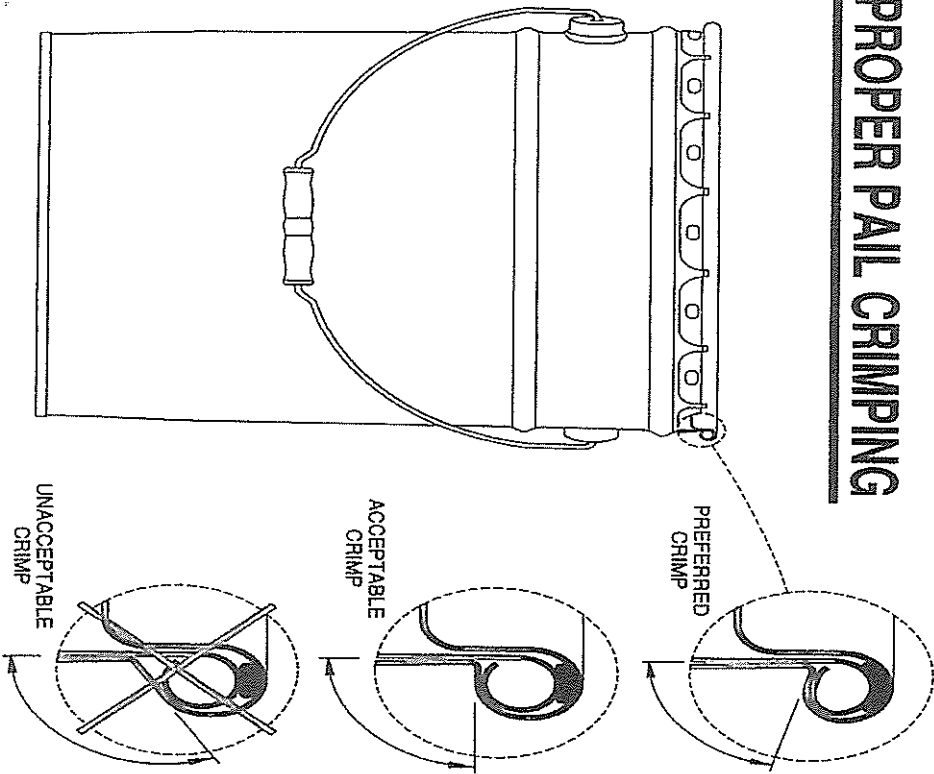
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PROPER PAIL CRIMPING



Open Head Closing Instructions

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- 1) Determine that the pallet/lever combination is the correct product code for the material being filled.
- 2) Place cover on pail with the eye of one of the lugs centered directly over the sideseam of the pail.
*Ensure that it is evenly seated around the curl of the pail.
- 3) Lower the closing tool onto the cover as shown in figure A.
- 4) Rotate the tool such that the eye of the lugs are positioned between the jaws of the closing tool as shown in Figure B.
- 5) A) For pneumatic closing tool: Depress both Humpfrey Levers on top of Manifold and hold down. When tool completes downward motion, release levers.
B) For manual closing tool: Push out and down on handles until both handles come to stop. Refer to figure C and page 2 (Proper Pail Crimping) of this document to ensure integrity of the close. If necessary, a second crimping operation should be done by positioning the tool onto the pail such that the jaws of the tool are centered directly over the closed lug and repeating step 5.
- 6) Remove the closing tool. Lugs should be crimped under the curl of the pail at least 90° from their starting position. See Figure C or acceptable crimp on page 2 (Proper Pail Crimping).
- 7)

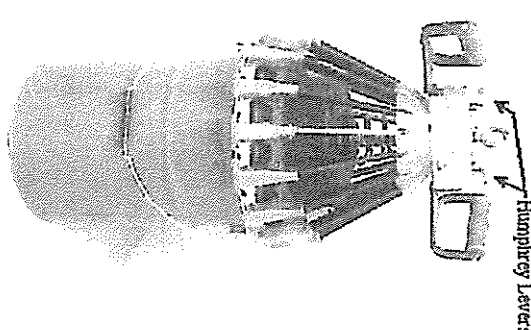


Figure A

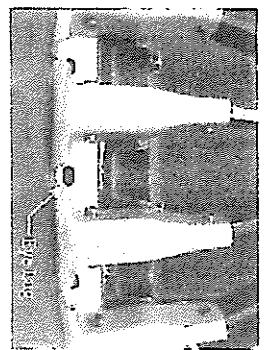


Figure B

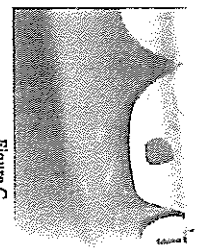


Figure C

Signature: