

SN-ENG-KIP-EN “Closure Torques”

Release Date	Functional Owner / Champion	Approved by (Process Owner):
18.01.2021	Tim Rippinger (Project Engineer & QMS IP)	Tim Rippinger (Project Engineer & QMS IP)

The following table contains the closure torques of „Industrial Association plastic packaging Germany” (IK), manufacturer recommendations and internal Kautex standards.

	Closure torque recommendation for bottles
Closure	IK recommendation (ADR)
32 mm	5-7 Nm
45 mm	6-9 Nm
45E mm	7-10 Nm
50 mm	7-10 Nm
54 mm	7-10 Nm
80 mm	10 Nm

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Closure torque recommendation for series 401 (LDPE)			
Diameter	Closure torque [Nm]		
	Bottles raw material		
	LDPE	HDPE	PP
14	1,0	-	-
18	1,0	1,0	-
25	2,5	2,5	2,5
28	2,5	-	-
32	4,0	-	3,0-3,5
40	4,5	4,0	4,5
50	5,0	5,0	5,0
65	10,0	-	10,0

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Closure torque recommendation for series 401 (PP)			
Diameter	Closure torque [Nm]		
	Bottles raw material		
	LDPE	HDPE	PP
14	1,0	-	-
18	1,0	1,0	-
25	3,0	3,0	-
28	3,5 - 4,0	3,5 - 4,0	-
32	4,0 - 4,5	-	4,0
40	4,5	4,5 - 5,0	4,5 - 5,0
50	7,0	7,0	7,0
65	10,0 - 12,0	-	10,0 - 12,0

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Closure torque recommendation for series 805 (PP)			
Diameter	Closure torque [Nm]		
	Bottles raw material		
	HDPE	PVC	PETG
32	-	1,6	1,5
40	4,0	3,5	3,5
50	4,0	4,5	4,5
65	5,5	5,5	5,0

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Closure torque recommendation for series 801 (PP)			
Diameter	Closure torque [Nm]		
	Bottles raw material		
	LDPE	HDPE	PP
14	1,0	-	-
18	1,0	1,0	-
25	3,0	3,0	-
28	3,5 - 4,0	3,5 - 4,0	-
32	4,0 - 4,5	-	4,0
40	4,5	4,5 - 5,0	4,5 - 5,0
50	7,0	7,0	7,0
65	10,0 - 12,0	-	10,0 - 12,0

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Closure torque recommendation for series 801 (LDPE)			
Diameter	Closure torque [Nm]		
	Bottles raw material		
	LDPE	HDPE	PP
14	1,0	-	-
18	1,0	1,0	-
25	2,5	2,5	2,5
28	2,5	-	-
32	4,0	-	3,0-3,5
40	4,5	4,0	4,5
50	5,0	5,0	5,0
65	10,0	-	10,0

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	Closure torque recommendation for jerry cans
Closure	IK recommendation (ADR)
45 mm	7-12 Nm
45 CR mm	3-5 Nm
50 mm	7-15 Nm
55 mm	8-15 m
60 mm	13-20 Nm
63 mm	13-20 Nm

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Revisionshistorie:

Rev.Nr.	Date	Changes	Chapter
0	15.05.2017	Creation	all
1	24.05.2017	Adaption of torques and Layout	all
2	20.09.2017	Adaption of lists	All
3	29.05.2018	Adding of list for series 401 and 805	All
4	22.07.2019	Adding of 14mm and 18mm for series 401,801 and 805	All
5	20.01.2020	Adding of Series 801	All
6	21.04.2020	Adaption of raw material (PP → LDPE)	All
7	18.01.2021	Adaption of values	all