

SN-ENG-KIP-EN-Rev.2- “Closure Torques”

Release Date	Functional Owner / Champion	Approved by (Process Owner):	Signature (Process Owner)
21.09.16	Tim Rippinger (VPE)	Tim Rippinger (VPE)	

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

	Closure torque recommendation for bottles			
Closure	IK recommendation (ADR)	Kautex recommendation (ADR)	Kautex recommendation (ISO 14401)	Manufacturer recommendations
32 mm	5 Nm	5-7 Nm	5-7 Nm	5 Nm
45 mm	5 Nm	10 Nm	4-5.5 Nm	6-9 Nm
45E mm	7 Nm	10 Nm	7-10 Nm	-
50 mm	7 Nm	10 Nm	7 Nm	7-9 Nm
54 mm	7 Nm	10 Nm	n.a.	n.a.
80 mm	10 Nm	10 Nm	n.a.	n.a.

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Closure torque recommendation for jerry cans				
Closure	IK recommendation (ADR)	Kautex recommendation (ADR)	Kautex recommendation (ISO 14401)	Manufacturer recommendations
45 mm	15 Nm	15 Nm	7 Nm	6-9 Nm
45 CR mm	k.A.	3-5 Nm	k.A.	3-5 Nm
50 mm	17 Nm	17 Nm	11 Nm	7-9 Nm
55 mm	k.A.	20 Nm	11 Nm	8-12 Nm
60 mm	25 Nm	25 Nm	12 Nm	13-17 Nm
63 mm	15 Nm	15 Nm	6-6.5 Nm	k.A.

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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