

Table II

Range of Application Torque Values Recommended by Various Industry Sources for Screw-Type Containers

Closure Size (mm)	Application Torque*	
	Inch – Pounds	Newton – Meters
8	5	0.56
10	6	0.68
13	8	0.90
15	5 – 9	0.56 – 1.02
18	7 – 10	0.79 – 1.13
20	8 – 12	0.90 – 1.36
22	9 – 14	1.02 – 1.58
24	10 – 18	1.13 – 2.03
28	12 – 21	1.36 – 2.37
30	13 – 23	1.47 – 2.60
33	15 – 25	1.69 – 2.82
38	17 – 26	1.92 – 2.94
43	17 – 27	1.92 – 3.05
48	19 – 30	2.15 – 3.39
53	21 – 36	2.37 – 4.07
58	23 – 40	2.60 – 4.52
63	25 – 43	2.82 – 4.86
66	26 – 45	2.94 – 5.08
70	28 – 50	3.16 – 5.65
83	32 – 65	3.62 – 7.35
86	40 – 65	4.52 – 7.35
89	40 – 70	4.52 – 7.91
100	45 – 70	5.09 – 7.91
110	45 – 70	5.09 – 7.91
120	55 – 95	6.22 – 10.74
132	60 – 95	6.78 – 10.74

***Note:** Immediate removal torque values are approximately 40-60% of the application torque values. Production capping equipment should be adjusted to provide similar immediate removal torque values.

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