

SEALING PROBLEMS

A) No Seal or Weak Seal

1. Output setting too low
 2. Conveyor line speed set too fast
 3. Container/sealing head adjustment
 - a. coupling distance extreme
 - b. off center
 - c. head not parallel
 4. Insufficient cap torque
 5. Product contamination
 6. Marginal quality container finish
 - a. insufficient land area
 - b. mold marks, flashing, or parting line
 - c. saddle or taper
 7. Bottle treatments and pigments
 8. Incompatible liner material
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B) High Removal Torque

1. Insufficient wax absorption due to lack of power or excessive conveyor line speed
 2. Bonded backing sticking to closure (single element)
 3. Liner quenched by product splashing
 4. Excessive application torque
 5. Undersized liner disk and plastic from the container finish invading the pulp
 6. Excess amount of bonding wax or wrong temp wax
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C) Scorching

1. Excessive output power setting
 2. Closure sealing head alignment
 - a. not centered
 - b. not parallel
 3. Low application torque
 4. Improper liner material
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D) Low Removal Torque

1. Excessive power melting down container finish
 2. Insufficient application torque
 3. Excess application torque
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E) Pulp Shears Out of Closure

1. Insufficient wax absorption [see "B"]
 2. Improper gluing
 3. Friction fit liner is undersized
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Other Factors to be considered;

1. The proper sealing head for the closure
2. Variations in container height
3. Dimensional conflicts between closure and container
4. Storage considerations of the liner material or container
5. Porosity of the pulp
6. Liner insertion into the closure
7. Package, material, or equipment changes

Note: **Application Torque**, to calculate application torque the standard "rule of thumb" is to take the closure diameter in mm, divide by 2, the result equals the application torque in inch pounds.*



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