



PRODUCT SPECIFICATION

Closure Range - Application Torque Guide

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DOCUMENT NO.

WP01CSTDASS03

SUBJECT

Customer Specification

VERSION

1

DOCUMENT DATE

26/08/2026

PRODUCT OVERVIEW

MATERIAL

High Density Polyethylene (HDPE)

MATERIAL GRADE

Virgin

COLOUR

As required / subject to type availability

7

CLOSURE TYPES

Customer product range

CLOSURE SPECIFICATIONS & RECOMMENDED TORQUE

Closure description	Mass (g)	Closure type	Thread / neck finish	Application torque (Nm)	Removal torque (Nm)
5 litre closure	5.3	Standard	Waverley 5 L container finish	2.6 - 3.0	1.3 - 1.8
20/25 litre closure	23.5	Standard	61 mm container neck finish	5 - 10	3 - 8
28 mm flip-top	4.4	Flip-top	28 mm PCO 1881 short-neck	1.5	1.2 - 1.6
28 mm closure (not for carbonated)	2.8	Standard	28 mm PCO 1881 short-neck	1.5	1.2 - 1.6
38 mm closure	3.6	Standard	38 mm threaded neck finish	1.2 - 1.5	0.5 - 0.7
28 mm pull-top	6.0	Pull-top	28 mm PCO 1881 short-neck	1.5	1.2 - 1.6

APPLICATION TORQUE GUIDANCE

SETTING

Use application torque as the initial capper setting.

VERIFY

Confirm removal torque after capping and conditioning.

28 mm PCO

Use tighter control for carbonated applications.

QUALITY / VALIDATION

INSPECTION

Visual and dimensional checks

FIT TESTING

Confirm on actual bottle / container finish

END CAP

Torque not applicable - validate insertion and retention

IMPORTANT NOTE

Torque values are recommended starting settings matched to the closest equivalent closures in the African Closures Application Guide 2.2025. Actual optimum torque can vary with neck finish, liner/seal design, filling temperature, capper condition and storage. Validate on the actual Waverley closure and customer container before production use.