

Torque Tables for Screw Caps

There are many slight variations of vial thread although they are all commonly referred to as a 'finish' or GPI (Glass Packaging Institute) internal manufacturing standard. These are commonly described as 8-425, 13-425 or 24-400. It is critical to marry correctly the container 'finish' to the correct cap size.

Closures are designated by their inside diameter in millimeters followed by a CMA (Closures Manufacturers Association) designation number. For example 8-425 closure identifies the cap as having an 8mm inside diameter and will fit a 425 finish container.

The 9mm 'short thread' cap does not have a standardized description and needs careful marrying to specific vials.

As a basic guide application torque in inch-pounds should be about half the closures diameter in millimeters

Application Torque

Cap Size (mm)	Inch-Pounds
8	04-06
9	04-07
10	05-08
13	06-09
15	07-10
20	08-12
24	12-18
28	14-21
33	16-25