

The petainerKeg™ USD format can be filled on many suitably modified steel Keg-Fillers. Suitable fillers must have the inert gas (i.e. CO<sub>2</sub>) flush and beer fill process on a single filling head. Please contact the filling machine supplier for advice, format parts and program modifications. When using the petainerKeg™ USD format, please note the following:

## General

Modify the machine program in accordance with the instructions below:

1. All steel Keg washing and sterilising functions need to be inhibited.
2. Keg must be filled volumetrically to the required capacity to provide head space.
3. For accurate fill level control, Inductive flow Metering (IFM) should be used.

## Racker Conversion

1. Check that the filling head spear adaptor (piston top) dimensions comply with the Petainer closure drawing. Failure to do so may damage the closure and prevent its proper operation!
2. Mount a plate/disc below the Keg clamp to apply pressure evenly across the USD packaging.
3. Maximum allowed top load is:
  - a. 30 l USD: 1600 N (360 lbf)
  - b. 20 l USD: 1300 N (292 lbf)

## Filling

1. Check that the stroke of the filling head piston comply with the Petainer closure drawing.
  - a. Too short stroke: The automatic pressure relief function in the fitting doesn't get activated.
  - b. Too long stroke: The mechanism inside the fitting is destroyed.
2. Allow only one stroke during the filling process, otherwise the fitting will remain open after filling.
3. Purge/rinse the Keg with CO<sub>2</sub> (or other appropriate inert gas) to remove air from the Keg prior to filling.
4. Keg counter-pressure and filling (maximum pressure 3 bar / 43.5 psig) can then proceed as normal.

## Intermediate head rinsing

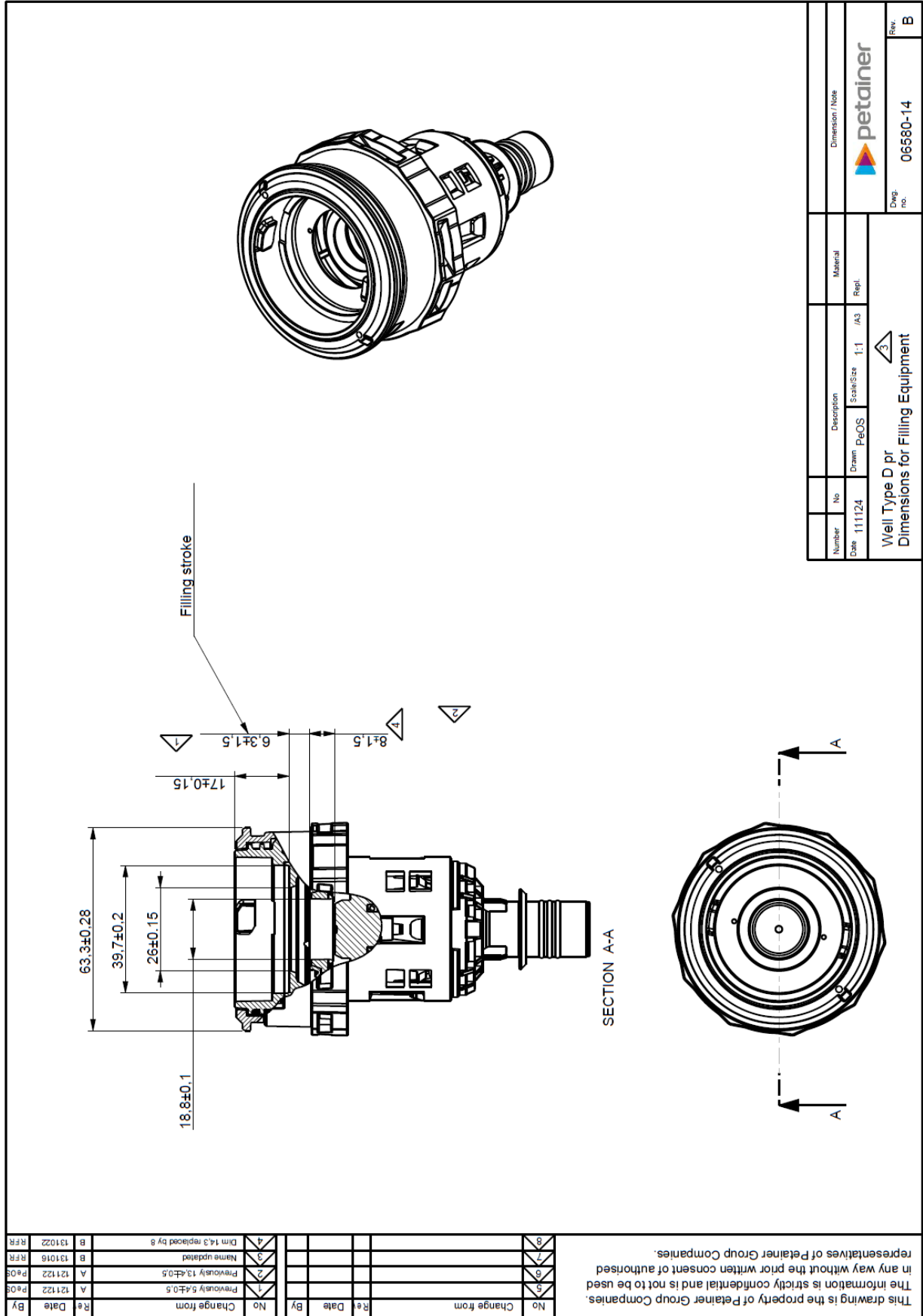
If the racker design allows, it is desirable to flush/disinfect the filling head and each keg valve from outside before and after filling.

1. e.g. with hot water (1 second with 85°C / 185 F).
2. Water pressure before filling maximum 1,0 bar / 14 psig
3. Water pressure after filling should not exceed the pressure in the Keg.

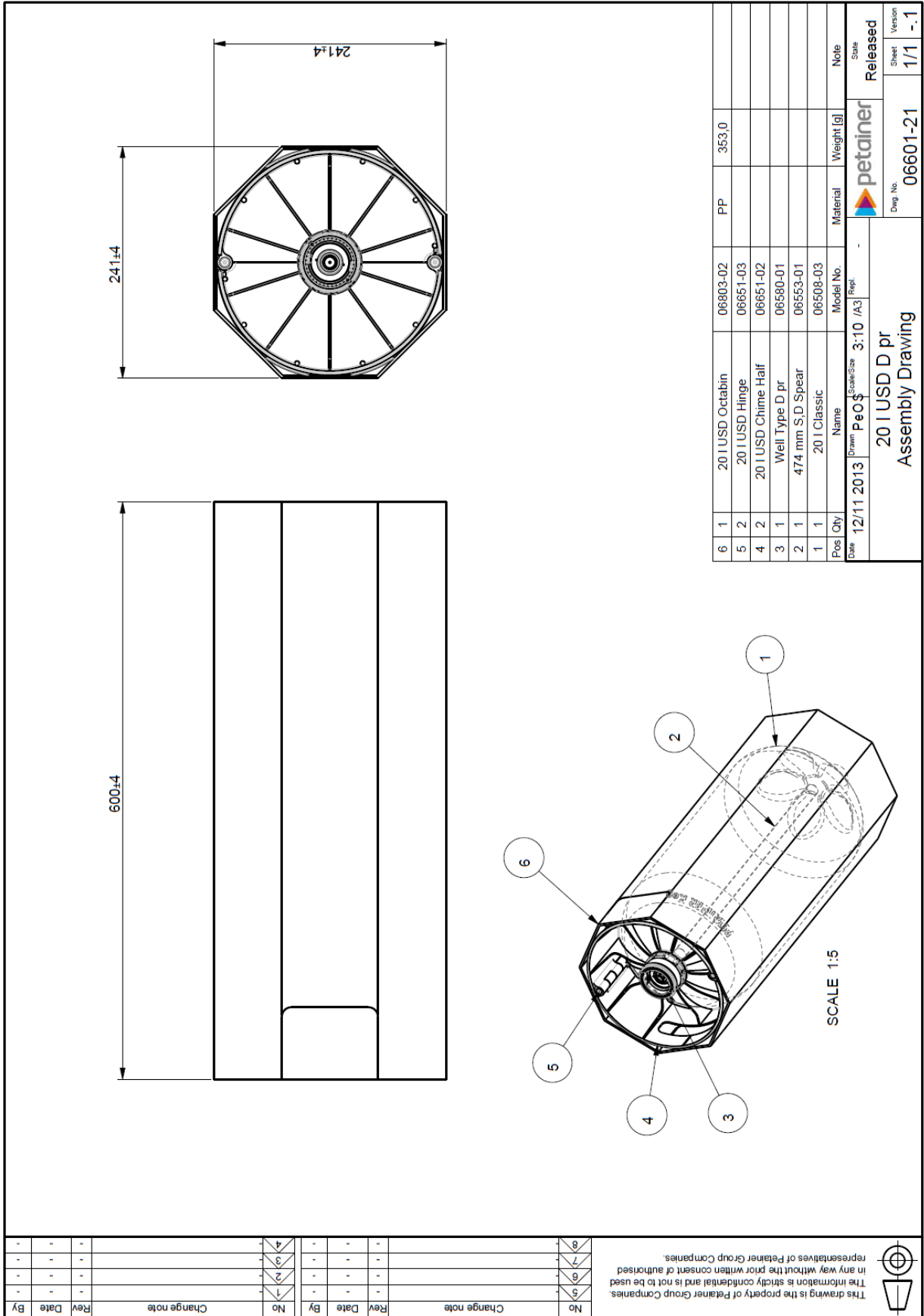
## Safety

1. All machinery must be guarded in accordance with local regulations.
2. Eye and ear protection, together with work-wear should be used.
3. PET Kegs can burst when damaged by sharp objects
4. Under filled Kegs or other rejects should be de-pressurised prior to disposal.





This drawing is the property of Petainer Group Companies. The information is strictly confidential and is not to be used in any way without the prior written consent of authorised representatives of Petainer Group Companies.



No	Change note	Rev	Date	By
1				
2				
3				
4				

Rev	Date	By
1		
2		
3		
4		

Rev	Date	By
-	-	-
-	-	-
-	-	-
-	-	-

This drawing is the property of Petainer Group Companies. In any way without the prior written consent of authorised representatives of Petainer Group Companies.

