

The petainerKeg USD format can be filled on many suitably modified steel Keg-Fillers.  
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, including the “head seal check” and the spear adapter moving, except on the filling head.
2. Keg must be filled volumetrically to the required capacity to provide head space.

## 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 clamp pressure is:
  - a. 30 l USD: 1600 N (360 lbf)
  - b. 20 l USD: 1300 N (292 lbf)

## Filling

1. We recommend disinfecting the fitting surface before filling (e.g. with 70% alcohol).
2. Purge/rinse the Keg with CO<sub>2</sub> (or other appropriate inert gas) to remove air from the Keg prior to filling.
3. **By request** we deliver the USD with >99% N<sub>2</sub> inside.
4. Keg counter-pressure and filling (maximum pressure 3 bar / 43.5 psi) can then proceed as normal.

## Intermediate head rinsing

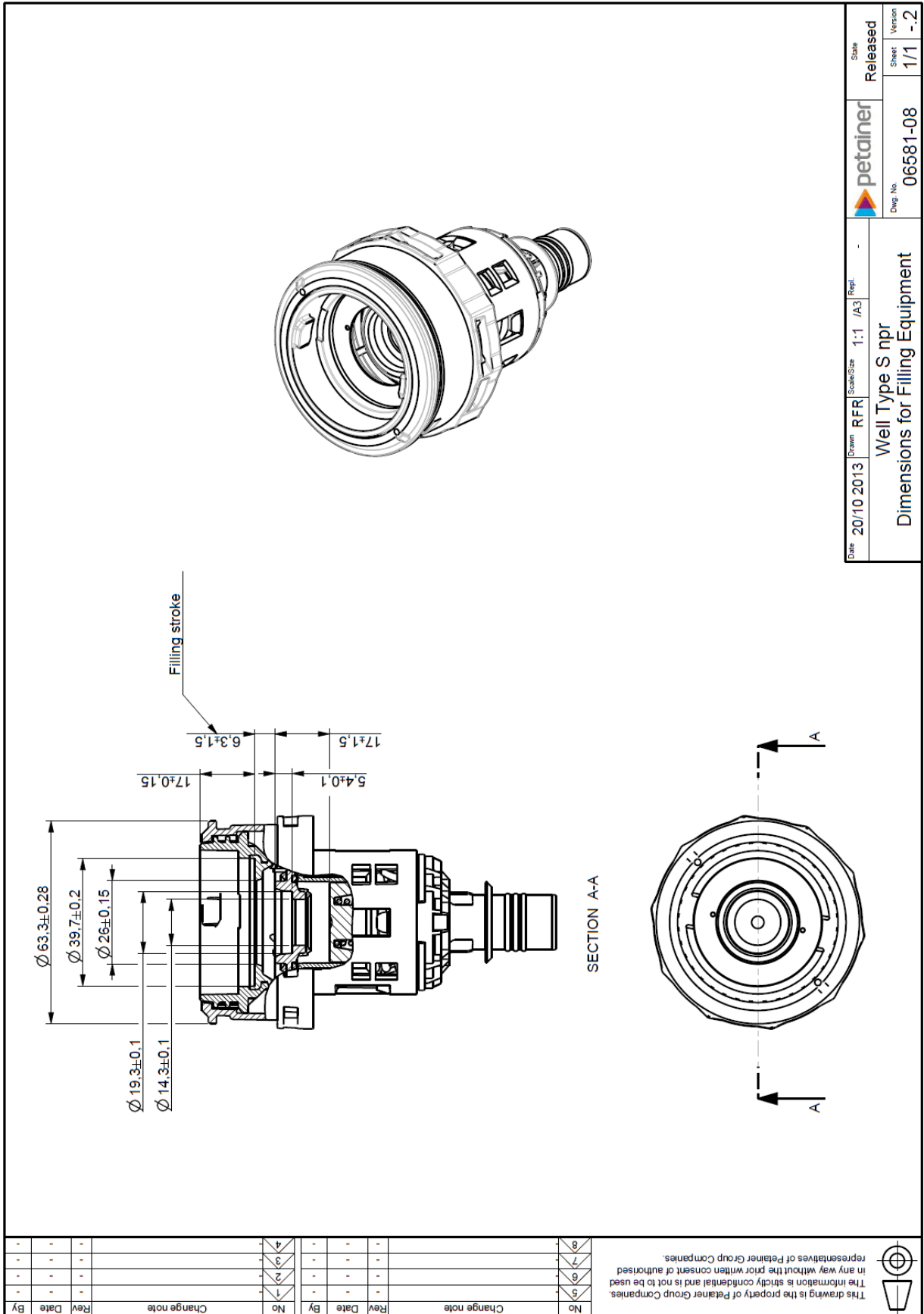
If the racker design allows, it is desirable to flush/disinfect the filling head and each keg valve from outside before and after filling.

1. e.g. with hot water (1 second with 85°C / 185 F).
2. Water pressure before filling maximum 1.0 bar / 14 psi.
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, using the Pressure Release Tool (PRT) supplied.

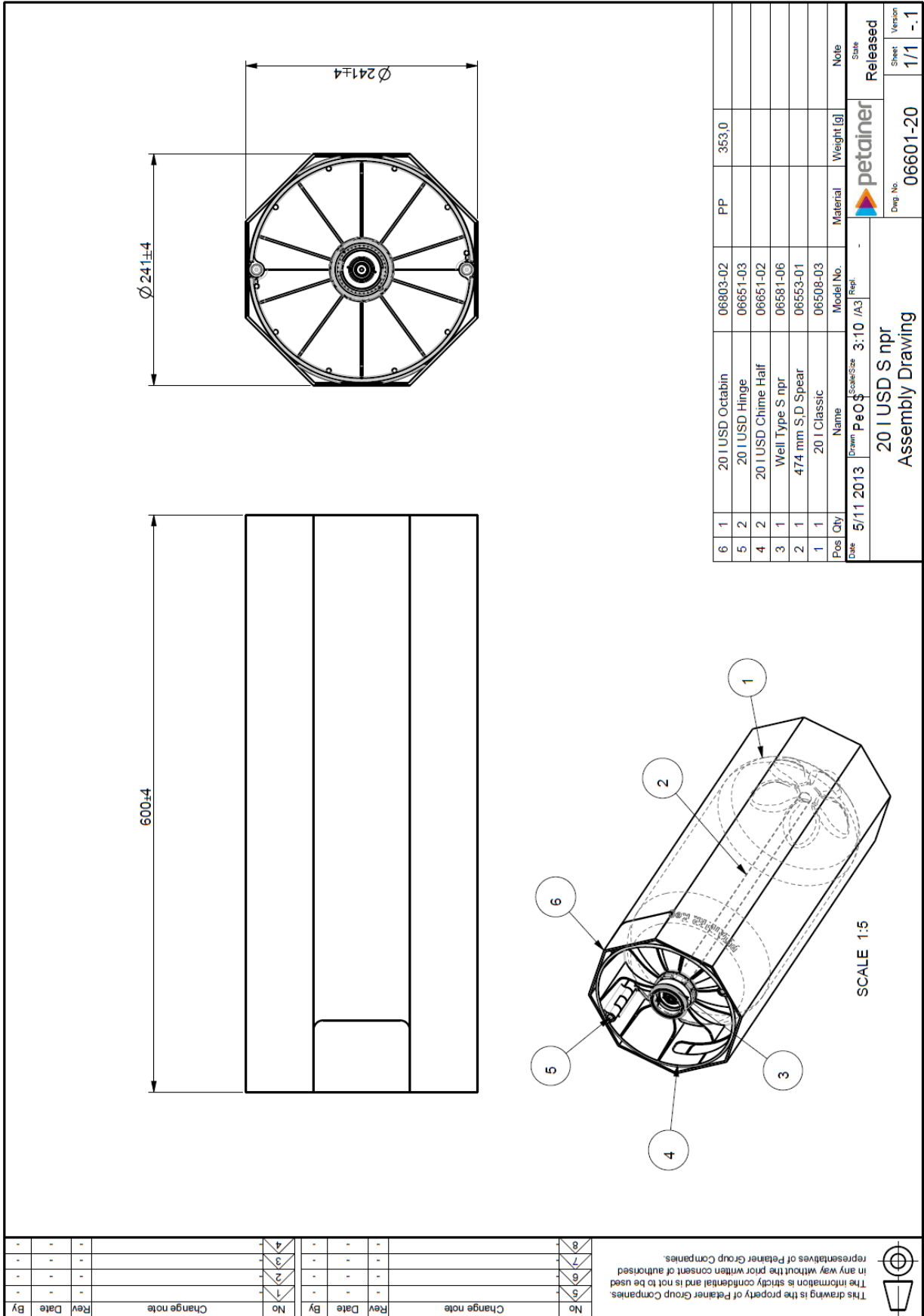




Date	20/10 2013	Drawn	RFR	Scale/Size	1:1 /A3	Repl.	-	State	Released
Dwg. No.	06581-08	Sheet	1/1	Version	-2				
Well Type S npr Dimensions for Filling Equipment									

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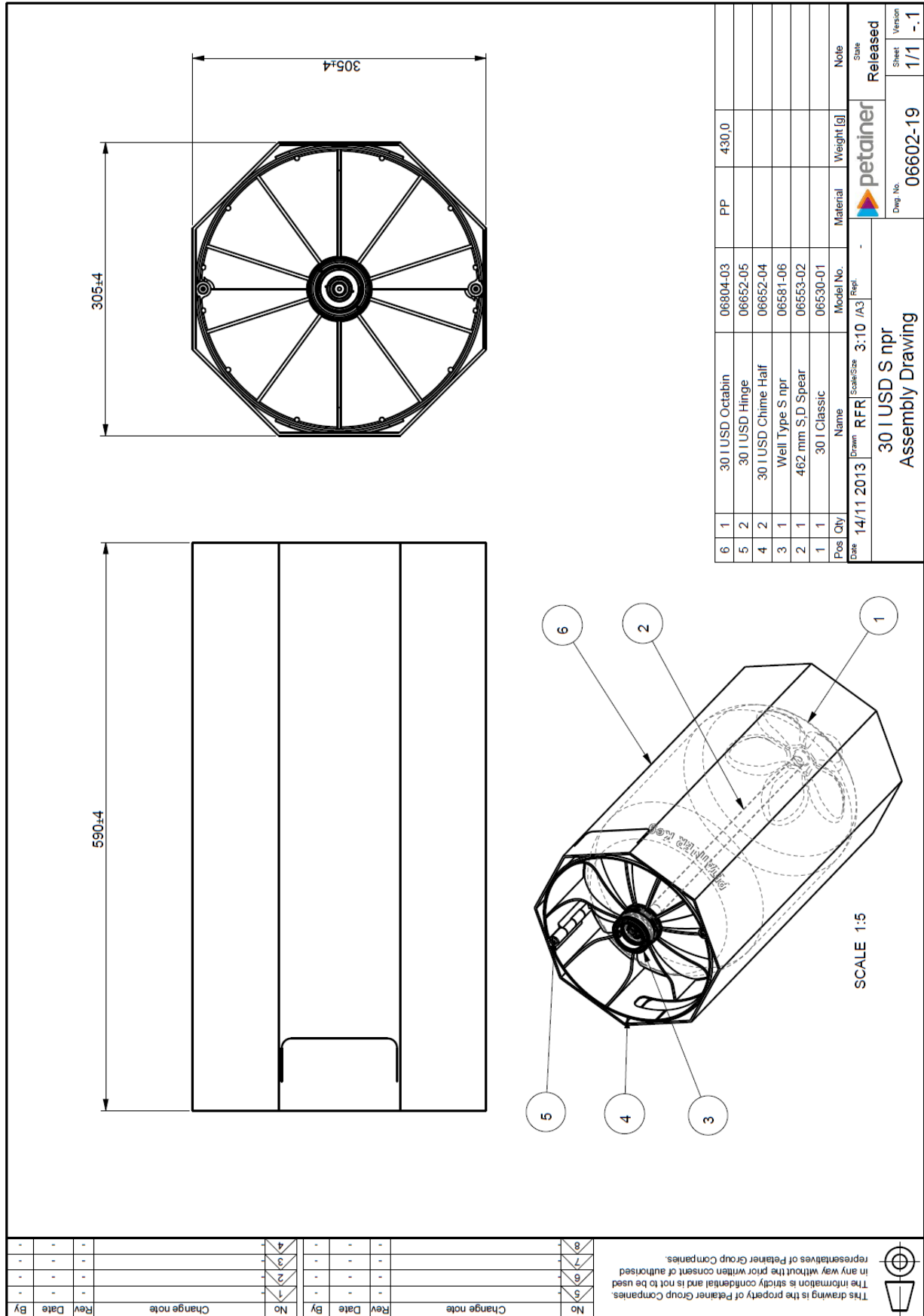


6	1	20 I USD Octabin	06803-02	PP	353,0	
5	2	20 I USD Hinge	06651-03			
4	2	20 I USD Chime Half	06651-02			
3	1	Well Type S npr	06581-06			
2	1	474 mm S,D Spear	06553-01			
1	1	20 I Classic	06508-03			
Pos/Qty		Name	Model No.	Material	Weight [g]	Note
Date	5/11 2013	Drawn	Scale/Size	Repl.		
		Peo3	3:10 /A3			
20 I USD S npr Assembly Drawing						petainer Dwg. No. 06601-20
						Released Sheet Version 1/1 -1

No	Change note	Rev	Date	By
1		-	-	-
2		-	-	-
3		-	-	-
4		-	-	-

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S npr = S-type without automatic pressure relief function



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SCALE 1:5