

## **CLOSURE NOTIFICATION ADVICE** **STEEL DRUMS**

Pursuant to the requirements of the U.S. Department of Transportation at 49 CFR 178.2(c)(1), we hereby provide this *Notification* of the closing method to be used for the containers sold to you under our *Quotation*. This method of closure will ensure that your containers will be closed in the same manner as when they were initially tested. Under the applicable DOT regulations, any changes made to (a) the type, materials or dimensions of closures or (b) the method of closure **may constitute a change to the design type of these containers, voiding the UN certification we have marked on them.** If there are any questions regarding proper closing methods, please contact your Account Manager or Customer Service representative. **Industrial Container Services highly recommends a copy of this *Notification* be kept on file and posted in a conspicuous location at your facility.**

### **TO PROPERLY CLOSE ALL PLUGS IN THE DRUM:**

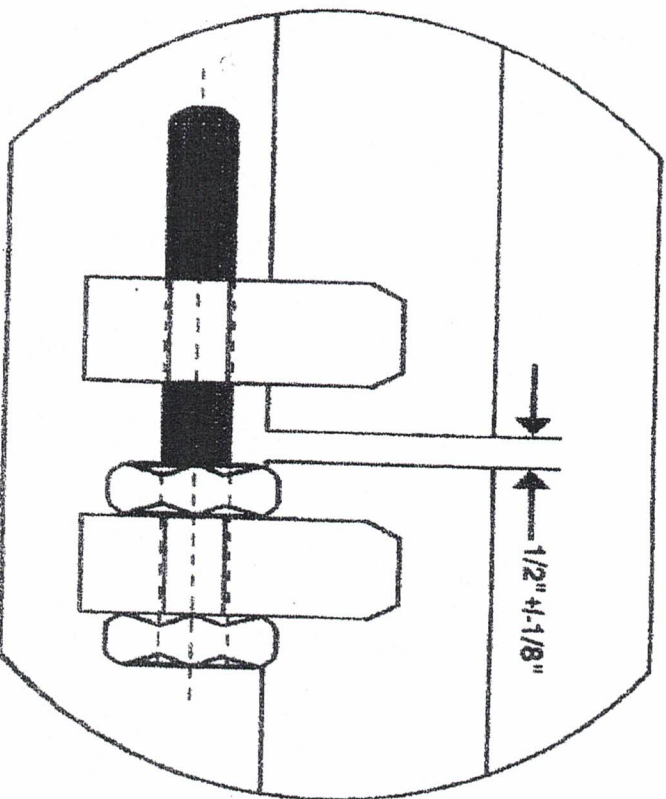
1. Use only the plugs and gaskets we have supplied with the drums.
2. Tighten **all** plugs into their appropriate threaded flanges until snug.
3. Using a torque wrench, tighten each fitting to the correct torque. See below for correct torques.  
Torques are based on the closure manufacturers' recommendations.

SIZE & FITTING STYLE	REQUIRED TORQUE				
	STEEL PLUGS			NYLON OR POLY PLUGS	
	Buna Rubber Gasket	Poly Gasket	EPT Gasket	Buna Rubber Gasket	Poly Gasket
2" Rieke Type	30 ft. lbs.	40 ft. lbs.	30 ft. lbs.	20 ft. lbs.	20 ft. lbs.
1 ½" Rieke Type	30 ft. lbs.	40 ft. lbs.	30 ft. lbs.	30 ft. lbs.	40 ft. lbs.
¾" Rieke Type	15 ft. lbs.	20 ft. lbs.	15 ft. lbs.	9 ft. lbs.	9 ft. lbs.
2" Trisure Type	20 ft. lbs.	30 ft. lbs.	20 ft. lbs.	20 ft. lbs.	30 ft. lbs.
¾" Trisure Type	12 ft. lbs.	20 ft. lbs.	12 ft. lbs.	8 ft. lbs.	8 ft. lbs.
REQUIRED TORQUE					
2" Leak Lock	25 ft.-lbs.				
¾" Leak Lock	20 ft.-lbs.				

# 1A2 Container Closure Assembly Instructions

## 1A2 CONTAINERS

- 1A2 CLOSURE SYSTEM COMPONENTS**
- 12 Gauge Forged Lug Locking Ring**  
 **$\frac{5}{8}$ " Standard Drum Bolt**  
 **$\frac{5}{8}$ " Standard Jam Nut (Optional)**



1. Inspect cover gasket to ensure it is fully retained in cover curl.
2. Place cover on container false wire (OH curl).
3. Install 12 ga. locking ring over cover curl and false wire.
4. Insert  $\frac{5}{8}$ " bolt and locking jam nut, if applicable.
5. Tighten  $\frac{5}{8}$ " bolt completely (ring ends should be within  $\frac{1}{2}$ "  $\pm$   $\frac{1}{8}$ " each end for optimum seal).
6. Tighten jam nut against locking ring bolt lug.

**Note:** If drum is filled through bungs, follow procedure for 1A1 containers.

## 1A1 CONTAINERS

1. Inspect all bungs which have been removed to ensure gaskets are in place
2. Insert all bungs and hand thread in clockwise direction until bungs are hand tight.
3. With a calibrated torque wrench, torque tighten all applicable bungs (Ref. Chart 1).
4. Wipe clean any spillage or debris.
5. Apply applicable cap seals.

**CHART 1**  
**Recommended Plug (Bung) Torque in FT/LBS**

Tensile Strength (Pounds) Torque in FT/LBS									
Size/Type	Tri-Sure Steel		Tri-Sure Poly		Flake Steel		Flake Poly		Nylon
2"	20	30	12	12	30	40	20	20	40
1 1/2"	N/A	N/A	N/A	N/A	25	30	N/A	N/A	N/A
3/4"	12	20	5	15	15	20	9	9	20
Gasket Type	Rubber	Poly	Rubber	Poly	Rubber	Poly	Rubber	Poly	Poly

**UN certified container closures must be installed and secured in accordance with the above procedure and specifications.**

**Note:** To ensure compliance to the UN marking, filler should inspect and re-tighten all applicable closures prior to shipment.

Customer

Name

Date