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Guideline for Tightening of Closures

Based on the guidelines provided by the United States Department of Transportation regulations, the packaging manufacturer is required to provide the operating instructions to the user of the packaging product. Packaging products need to meet and qualify for the requirement laid down in Title 49, Code of Federal Regulations (49 CFR), Part 178 Specifications for Packaging. In addition to the above, the packaging manufacturer needs to provide the closure tightening process and procedure to the users of packaging prior to shipment.

It is solely the shipper's responsibility to ensure adherence of the instructions provided by the packaging manufacturer. Core Plastech International INC is committed to providing all the necessary Standard Operating Procedure (SOP) which needs to be followed while handling and usage of packaging products.

Core Plastech further would like to provide adequate training to the users of packaging products for their safe handling and usage. As a continual improvement process, the Core team are dedicated to providing the best of support and guidelines to the users for following the standard practices as the manufacturer has got the packing tested and approved for the UN rating performances.

Core Plastech recommends the standard torque required for the closures of the PE drums and Intermediate Bulk Containers (IBCs). It is the shipper's responsibility as set forth in §173.22(a) (4) to ensure that these closing instructions are carried out as described. The process of sending the closing instructions is followed by Core Plastech along with the shipping documents with each shipment of drums and IBCs.

Note –

Before applying the designated torque on the closures, it is a must to ensure the closure has the desired gasket in place along with the condition of the closures and the gasket. The drums and the IBC sealing surface need to be inspected for no visual defect or damage to the sealing surface.

TIGHT HEAD & OPEN HEAD PE DRUMS

TIGHT-HEAD 55 PE DRUMS:

For tightening the plugs, a suitable adaptor needs to be used matching the slot provided on the top of the plug. A torque wrench is recommended use for tightening the plug.

Sr. No.	Description	Torque (ft-lbs)
1	2" NPS AND 2" BUTTRESS @ 150 kPa	30
2	2" NPS AND 2" BUTTRESS @ 100 kPa	20
3	3/4" NPS @ 150 kPa	9
4	3/4" NPS @ 100 kPa	9

OPEN HEAD PE DRUMS:

Snap fit lid having gasket secured by metal clamping ring with locking clip.

Sr. No.	Description	Torque (ft-lbs)
1	2" NPS AND 2" BUTTRESS	20
2	3/4" NPS	9

INTERMEDIATE BULK CONTAINER (IBC) : 135 G /275 G /330 G

The top lid needs to match with the threading of filling opening prior to applying the torque with the help of torque wrench.

Sr. No.	Description	Torque (ft-lbs)
1	6" Top Filling Cap	80 - 90
2	G2 Plug	15 -18
3	Discharge Valve	70 -75

Note:

The above recommended torques is only applicable for Core Plastech International Inc. packaging material. Core Plastech is not liable for any consequential or third party liability. The user has to ascertain and undertake all liability in respect to application, processing or use of aforementioned information.

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