

CLOSURE INSTRUCTIONS

IMPORTANT NOTICE: Please give to person responsible for closing these containers for shipment pursuant to Title 49 Code of Federal Regulations, part 178(c)(a)(ii), you are notified in writing of the type and dimension of closures, including gaskets, needed to satisfy performance test requirements. This includes tightening instructions for closures. You are required to provide closing information to any person to whom this package is transferred who may need to close the package prior to reshipment.

ALL UN 1H1 PACKAGES (Plastic 55 Gallon Closed Head Drums)

- 1) Check plugs making certain gasket is properly seated
- 2) Carefully screw in plug to insure no cross threading
- 3) Using a properly calibrated torque wrench, tighten both NPS-fine and/or course-buttruss thread plugs to 20 ft/lbs.*

ALL UN 1A1 PACKAGES (Steel 55 gallon Closed Head Drums)

- 1) Check plugs making certain gasket is properly seated
- 2) Carefully screw in plug to insure no cross threading
- 3) Using a properly calibrated torque wrench, tighten "Tri-Sure™ style" 2" plugs with rubber gaskets to 20 ft/lbs, 30 ft/lbs. with polyethylene gaskets; tighten "Rieke™ style" 2" plugs with rubber gaskets to 30 ft/lbs., 40 ft/lbs. with polyethylene gaskets*
- 4) Using a properly calibrated torque wrench, tighten "Tri-sure™ style" ¾" plugs with rubber gaskets to 12 ft/lbs. 20 ft/lbs. with polyethylene gaskets; tighten "Rieke™ style" ¾" plugs with rubber gaskets 15 ft/lbs., 20 ft/lbs. with polyethylene gaskets*

*Torque may change in transit due to weather, filling conditions, temperature and consistency of product filled in packaging. Fillers and shippers of packaging are responsible for closing packagings to the above specification. Container Distributors, Inc. can not be held responsible for closures that do not meet the torque values specified.

CLOSURE REQUIREMENTS: 1A1/1A2 BUNG CLOSURE

-----DOT PART 178 NOTICE-----

For UN/DOT marked specification containers, the DOT regulations in 49 CFR 178.2 (c) require the packing manufacturer to provide a written notification to customers covering any additional requirements after transfer of the packaging necessary to comply with the performance test requirements indicated by the UN marking on the drum.

Notice: Drums must be closed for shipment by tightening the plugs to the recommended closure torque.

Recommended T-Type Closure Torques, ft.-lbs., for Steel Drums

T-Type Steel Plug	<u>¾"</u>	<u>2"</u>
With Rubber Gasket	12	20
Polyethylene or Teflon Gaskets	20	30
T-Type Polypropylene & Nylon Plugs		
With Rubber Gasket	12	20
Polyethylene or Teflon Gasket	12	30
T-Type Polyethylene Plug-High Density		
With Rubber Gasket	8	15
Polyethylene or Teflon Gasket	8	15
T-Type Self-Gasketing Polyethylene Plug	5	12

Note: Materials classified as "poisonous by inhalation" must be sealed with Tri-Sure® Steel Side Gaskets tab seal caps.

Recommended R-Type Closure Torques, ft.-lbs., for Steel Drums

R-Type Steel Plug	<u>¾"</u>	<u>1 ½"</u>	<u>2"</u>
With Rubber Gasket	15	30	30
Polyethylene Gasket	20		40
R-Type Plastic Plug			
With Rubber Gasket	9		20
R-Type Self-Gasketing Plug	9		20

Drums bear a DOT/UN specification mark solely on the basis of the use with components specified in design qualification tests. Drums were tested with water and according to specific gravity or marked on the drums and closed according to closure manufacturer's recommendations. Use of these drums and any components supplied in the respect to relevant compatibility is the responsibility of the user.

RINGS FOR 55 AND 30 GALLON DRUMS

A 12-guage ring will require a torque of 60 ft/lbs. to properly close and seal. Do not apply more than the recommended torque, this could cause the bolt threads to strip making it difficult or impossible to remove.

A 16-guage ring will require a torque between 8 and 15 ft. / lbs.