

**Drum Closure Statement per 49 CFR 178.2 ( c ) ( 1 )**

<b>Closing Torques for Plug/Gasket Combinations</b>			
<b>Plug Type</b>	<b>Gaskets</b>	<b>Tightening Torque</b>	
		<b>3/4" Dia Plugs</b>	<b>2" Dia Plugs</b>
Tri-Sure Steel	Rubber - Black Buna, White Buna; Butyl; White Neoprene; Viton; Silicone & EPDM	12 ft. lbs.	20 ft. lbs.
	Polyethylene; Irradiated Polyethylene; Teflon	20 ft. lbs.	30 ft. lbs.
Tri-Sure Polyethylene, Polypropylene, Nylon	Rubber - Black Buna, White Buna; Butyl; White Neoprene; Viton; Silicone & EPDM	8 ft. lbs.	20 ft. lbs.
	Polyethylene; Irradiated Polyethylene; Teflon	8 ft. lbs.	30 ft. lbs.
Tri-Sure Polyethylene	None (Self Gasketing)	5 ft. lbs.	12 ft. lbs.
Tri-Sure Polypropylene (Poly Clad)	None (Self Gasketing)	1/2" Plug	2 1/2" Plug
		5 ft. lbs.	12 ft. lbs.
Rieke Steel (For 1 1/2" use 2" torques)	Rubber - Quartermaster Hycar, White Buna; White Asbestos; White Dapon; EPT White & Black	15 ft. lbs.	30 ft. lbs.
	Poly Seal (Plastic) Irradiated & Non-Irradiated	20 ft. lbs.	40 ft. lbs.
Rieke Polyethylene, Polypropylene, Nylon	Rubber - White Buna; EPT Black & White; Dapon - Irradiated & Non-Irradiated	9 ft. lbs.	20 ft. lbs.
Rieke Polyethylene, Polypropylene, Nylon	None (Self Gasketing)	9 ft. lbs.	20 ft. lbs.

**Open Head Containers**

All Open Head containers should have the locking ring Bolt torques checked after filling and before transportation in accordance with the procedures below. To tighten, follow the following procedures:

1. Release the Jam Nut
2. Tighten the Locking Ring Bolt to the torque stated below. While torquing, bump the ring with a mallet directly opposite the lugs, and on both sides. Note: Bump the ring at a 30 degree downward angle.
3. Retighten the Jam Nut to 25-30 ft. lbs. torque, against the unthreaded lug

<b>55 Gallon Ring</b>	<b>Gasket Types</b>	<b>Bolt Tightening Torque</b>
12 Gauge Forged Lug "C" Section - All Types	All Gaskets Except G557	60 ft. lbs <b>minimum</b> - Ring Gap of <b>1/8" - 5/8"</b>

<b>30 Gallon Ring</b>	<b>Gasket Types</b>	<b>Bolt Tightening Torque</b>
12 Gauge Forged Lug "C" Section - All Types	All Gaskets Except G557	60 ft. lbs <b>minimum</b> - Ring Gap of <b>1/8" - 5/8"</b>

**Note:** For leverlock rings - the Rings should be closed securely and latched