

Drum Closure Notification Form

Pursuant to the requirements of the Department of Transportation in CFR 49 Part 178.2 (c)(1), this is your notification of the closing method used for the containers sold to you on the attached delivery ticket or bill of lading. This method of closure should be used to ensure that you containers have been closed in the same manner as when they were initially tested.

**TIGHT HEAD STEEL DRUMS
OPEN HEAD STEEL DRUMS WITH FITTINGS**

To close fittings, Tighten with a torque wrench to the following manufacturer's recommended torques:

PLUG TORQUE IN FOOT-POUNDS

PLUG SIZE	TRISURE				RIEKE			
	STEEL PLUGS		POLY PLUGS		STEEL PLUGS		POLY PLUGS	
	POLY GASKET	OTHER GASKET						
¾"	20	12	8	20	20	15	9	15
2"	30	20	30	30	40	30	20	30

FULL OPEN TOP STEEL DRUM WITH BOLTED RING CLOSURE

1. Place cover on drums.
2. Snap the closing ring over the cover and top lip of the drum. Make sure the ring's lugs point down below the ring. Also make sure that the bottom edge of the closing ring engages under the top lip of the drum.
3. Insert the bolt through the lug without threads. Next, screw on the locking nut. Finally, screw the bolt onto the threaded lug.
4. While tightening the bolt, tap the entire perimeter of the ring with a mallet, starting directly across from the bolt.
5. Tighten the bolt until 50 foot pounds of pressure is reached. The cover and ring should not spin, but the free ends of the rim should have a ¼" space maximum.
6. Drums closed in this manner have met the UN performance test requirements as specified in the container markings.

DISCLAIMERS

Tests were conducted using water for liquid containers, sand and saw dust for solid containers, or water and anti-freeze mixture for plastic drums used to contain liquids. Your product may adversely affect container materials, bung threads, or closing devices. Product compatibility with the container is a shipper's responsibility.

These instructions for container closure are based upon the closure methods used to enable these containers to pass the United Nations test requirements as outlined by the UN marking on the package.

These closure recommendations do not take into account any hazards present in your facility, or the handling, filling or shipping of your product. The use of sparkless tools and proper equipment is recommended. Consult your supervisor for your special safety precautions.

Any containers used for packing of hazardous materials should be inspected prior to filling and shipment. Containers with obvious damage or deterioration should not be filled or shipped.

Open-Head Steel Drum (1A2)

Bolt-Ring Closure

1. Check the gasket to ensure it is properly fitted into the bottom groove of the drum cover (Figure 1 and 2).
2. Place the cover on the drum, being careful to seat the gasket onto the entire lip (curl) of the drum sidewall (Figure 3).
3. Position the closure ring, with lugs downward, so that it engages the entire circumference of the drum cover and sidewall. Apply pressure on the ring and cover, and tap the circumference of the ring with a non-sparking mallet to further seat the cover and sidewall into the inner channel of the ring (Figure 4).
4. Insert the bolt into the unthreaded lug of the ring. (If the ring is equipped with a locking hex nut, affix the nut onto the bolt.) Direct the end of the bolt into the threaded lug of the ring (Figure 5). Close the ring to an initial gap between the lugs of approximately $\frac{1}{2}$ inch.
5. Tighten the bolt while further tapping the edges of the ring with the mallet.
6. When fully assembled, the gap between the free ends of the ring should not exceed $\frac{1}{4}$ inch, nor should the ends of the ring touch (Figure 6).

