



Drum Closure Instructions

In order that the reconditioned drum supplied to you performs to the UN designation specified and your contents are packaged in a safe and responsible manner, the following closure instructions need to be specifically followed. The substitution and use of any other drum components (rings, gaskets or fittings) not supplied with this product, or the use of any other method of assembly or closure is not recommended since it may negatively affect the performance of your drum.

Open Top Drums with Bolted Ring Closure

1. Place cover on drum.
2. Place the bolt ring over the cover and top lip (the curl) of the drum with the lugs pointed downward. Make sure the bottom edge of the ring engages the drum curl.
3. Insert the bolt through the unthreaded lug then through nut which must be between the lugs. Next, thread the bolt through the threaded lug.
4. Insure the ring is seated properly around the lid and the curl. Using a torque wrench, tighten the bolt to 75 foot pounds of torque. You may need to tap on the ring with a soft mallet while tightening to assist in seating the ring.
5. Tighten the nut against the unthreaded lug to prevent the bolt from backing out.

Closed Top Drums and Open Top Drums with Fittings

1. Insure gaskets are flat and properly seated against base of fitting. This will assist in maintaining gasket integrity.
2. Gently screw in the plug (to avoid cross threading) until the plug is snug.
3. Using a torque wrench, tighten each fitting to the torque shown below

PLUG TYPE	PLUG GASKETS	CORRECT TORQUE	
		3/4" plugs	2" plugs
Round Head – Steel	Rubber-Black Buna, White Buna, EPDM, Butyl, White Neoprene Viton, and Silicone	12	20
	Polyethylene, Irradiated Polyethylene, and Teflon	20	30
Round Head – Polyethylene	Rubber-Black Buna, White Buna, EPDM, Butyl, White Neoprene Viton, and Silicone	12	20
	Polyethylene, Irradiated Polyethylene, and Teflon	8	30
Round Head – Polyethylene (Self Gasketing)	None Needed	5	12
Round Head – Polypropylene (Self Gasketing) (Poly Clad)	None Needed	5	12
Hex Head - Steel	Rubber-Black Buna, White Buna, EPDM, Butyl, Black Visecar, White Visecar, White Dapon, White EPT, Black EPT	15	30
	Poly Seal (plastic) – Irradiated and Non-Irradiated	20	40
Hex Head – Polyethylene Polypropylene, Nylon	Rubber-White Buna, Black EPDM, White Epdm, Dapon Irradiated and Non-Irradiated	9	20
Hex Head – Polyethylene Polypropylene, Nylon (Self Gasketing)	None Needed	9	20
Poly Standard Threaded Plug (NPT) Poly Buttress Threaded Plug (coarse)	All	-	20
ACT I or ACT II Poly Plugs	All		30-35
Rieke Round Poly Plug	All	9	-

All measurements are in foot-pounds.

Note: Gasket compression occurs with the passing of time. Therefore, retightening closures immediately prior to shipment is recommended.