

**Subject: 49 CFR 178.2c- Notification**

In accordance with the Department of Transportation Title 49, Code of Federal Regulations (49 CFR), container manufacturers are required to notify each person to whom the container is transferred of all requirements not met at the time of transfer and of all the necessary materials and procedures to prepare the containers that when closed for shipment are capable of meeting the performance standards indicated by the UN marking on the side of the container.

The following instructions and guidelines are given to purchasers of containers made or re-manufactured by our company in accordance with the requirements of 49 CFR 178.2c and 178.601b.

**IBC Closing Statement**

All IBC's should be closed after filling and before transportation in accordance with the recommended plug cap torque as stated below.

**Correct Closing Torque For 6" and 9" Caps**

<u>Cap Type</u>	<u>Gasket</u>	<u>Tightening Torque</u>
6" Polyethylene	EPDM	54 FT. LB
6" Polyethylene	VITON	58 FT. LB
9" Polyethylene	EPDM	60 FT. LB.
<b><u>Cap/2" Plugs</u></b>	<b><u>Gasket</u></b>	<b><u>Tightening Torque</u></b>
2" Polyethylene	EPDM	20 FT. LB.
	Santoprene Rubber	20 FT. LB.
	Polyethylene	20 FT. LB.

**Unit of Measurement**

FT. LB. = Foot Pound Torque  
 1 FT. LB. = .7736 Joule/M (Newtons)

*update 8/22/11*

**Drum Closing 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 opposite the seam. Make sure the bottom edge of the ring engages the drum curl.
3. Insert the bolt through the unthreaded lug, then through the nut which must be between the lugs. Next, thread the bolt through the threaded lug.
4. Tighten the bolt to 75 foot pound of torque while reducing the gap between the ends of the rings to between 1/8 and 3/8 inch. You may need to tap on the ring while tightening with a soft mallet to attain the correct ring gap.
5. Tighten the nut against the unthreaded lug to prevent the bolt from backing out.

**Closed Top Drums and Open Top Drums with Fitting**

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

Fitting type	Tinsure®		Rietke®	
	Steel	Poly	Steel	Poly
Fitting Material	Steel	Poly	Steel	Poly
Gasket Material	Rubber	Poly	Rubber	Poly
Size of fitting				
2"	20	22	30	40
3/4"	12	18	8	15
				20
				9

All measurements are in foot-pounds