



CLOSING INSTRUCTIONS – PLASTIC DRUMS, Plain Cover

1. All removable head, UN1H2, Plastic drums of nominal capacity 15 to 60 U.S. gallons supplied with plastic lids, gaskets and associated closing rings and or bands must be closed for shipment using only the components supplied and specified in the design and qualification tests according to the following installation instructions:
 - a. Inspect drum & drum lid for any cracks in the lid or gasket separation.
 - b. Open side lever lock ring so as the secure locking mechanism is on top of the ring. Open the ring and place it over the drum opening.
 - c. Place drum lid onto drum opening. Apply downward pressure to seat the gasket in the lid to the drum opening.
 - d. Pull up the locking ring to secure the ring completely around the lid & opening of the drum. Close side lever locking mechanism and secure the latch by inserting locking tab into slots in the lever lock handle.
 - e. Bolt locking ring: the channel shaped Bolt Ring locking band is placed around the drum with the lugs facing downward. Insert bolt into the non-threaded lug, the locking nut is then threaded onto the bolt. Inset bolt & locking nut into the threaded side lug, the locking nut will be between the lugs. Tighten bolt until the gaps between the locking-band ends are no more than 1/4". Tighten locking nut against non-threaded lug, the ends of the bolt ring should not touch. Verify that the lid and ring do not spin.

CLOSING INSTRUCTIONS – PLASTIC DRUMS, Covers with Fittings

1. Inspect each closure to insure the closure has the proper gasket & both closure and gasket are in good condition. Inspect the sealing surface for damage, the threads for damage or cross threading. The sealing surface is to be clean and dry.
 - a. The plugs are to be hand tighten insuring no cross threading of the plug nor flange.
 - b. Plugs are to be torqued per plug manufactures recommendations listed below.

Plug Torque Requirements

3/4" Plug Torque @ 4 ft.-lbs.

2" Plug torque @ 10 ft.-lbs.

Drums closed in the manner described above have met the UN Performance test requirements as specified in the container's markings.