

DOCUMENT NO: QWI-00352	PROCESS: 17 - Production	PAGE 1 of 3
QWI_00352_UN_Container_Closing_Instructions (3)	VERSION: 2.0	MODIFIED: 01/21/19
Uncontrolled copy; see footer for location of controlled document		

1.0 Purpose:

In compliance with 49 CFR §178.2(c), persons shipping Letica Corporation containers must comply with the following closure instructions.

2.0 Application Methods:

Letica Product	Recommended Mechanism	Material Type Packaged
5UND Container / 5LUND Lid	Pneumatic Press	Liquid Hazardous Materials Group II & III
5DMU Container / 5LUND Lid	Pneumatic Press	Liquid Hazardous Materials Group II & III
20NSU Container / 5LUND Lid	Pneumatic Press	Liquid Hazardous Materials Group II & III
20NEU Container / 5LUND Lid	Pneumatic Press	Liquid Hazardous Materials Group II & III
5100U Container / 5LUND Lid	Pneumatic Press	Liquid Hazardous Materials Group II & III
3590U Container / 5LTBU Lid	Pneumatic Press	Solid Hazardous Materials Group II & III
5DMU Container / 5LTBU Lid	Pneumatic Press	Solid Hazardous Materials Group II & III
20NSU Container / 5LTBU Lid	Pneumatic Press	Solid Hazardous Materials Group II & III
6RU Container / 5LTBU Lid	Pneumatic Press	Solid Hazardous Materials Group II & III
65RU Container / 5LTBU Lid	Pneumatic Press	Solid Hazardous Materials Group II & III
7RUN Container / 5LUND Lid	Pneumatic Press	Solid Hazardous Materials Group II & III

The Letica Corporation does not recommend the use of a mallet or roller closure for lid application. A pneumatic press is the recommended equipment for applying lids to Letica Corporation UN designated containers.

3.0 Pneumatic Press:

3.1 Design Criteria:

- 3.1.1 The frame of the pneumatic press and the surface Where the container stands must be of significant strength to resist deflection during the application of a lid.
- 3.1.2 The closing plate has to be parallel to the base, within 1/32" (.79 mm), and be of sufficient strength to withstand deflection during the application of a lid (the plate should be made of steel, have a minimum thickness of 1/4", and have a minimum diameter of 13").
- 3.1.3 A burp plug must be installed in the center of the closing plate. Dimensions for the burp plug are 2 3/4" in diameter and 3/4" in depth.



DOCUMENT NO:
QWI-00352

PROCESS:
17 - Production

PAGE 2 of 3

QWI_00352_UN_Container_Closing_Instructions (3)

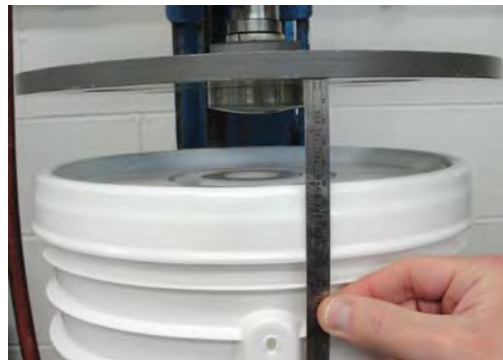
VERSION:
2.0

MODIFIED:
01/21/19

Uncontrolled copy; see footer for location of controlled document

3.2 Press Setup:

3.2.1 The size and pressure of the pneumatic cylinder is dependent on the type of lid and pail. Packages meeting the requirements for UN liquid or solid hazardous materials are to utilize a cylinder with a 6" minimum diameter. The air pressure supplied to this cylinder is to be a minimum of 90 psi of uninterrupted air (load = 2545# min) and is not to exceed 110 psi (load = 3110# max).



3.2.2 The height of the plate should be set to between 1.5" and 2.5" above the package with the lid positioned for closure.

3.3 Lid Application:

Note: The fill level of the product in the container is not to interfere with the lid when closing.

3.3.1 Visually verify the container is undamaged including dents, nicks, scratches, etc.

3.3.2 Visually verify that the lid is undamaged, that any fittings are properly installed, and that there is a gasket fully installed in the lid.

3.3.3 Position the lid on the container with the fitting located between the handle attachment points. Be sure the lid is centered on the container.

3.3.4 Center the container / lid under the plate.

3.3.5 Confirm that the area is clear of anything that may potentially interfere with the plate travel and engage the closer. *The lid should lock with minimal hesitation (< 2 seconds) and produce an audible "snap".

3.3.6 Verify that the lid is fully locked and that the perimeter of the lid skirt is free from bulging or flaring. If the lid skirt is bulged or appears uneven it may indicate that the lid is not fully locked.

Caution: *Insufficient momentum of plate travel may result in incomplete closure.

***If difficulties are encountered in the closing process place any affected containers in quarantine and contact The Letica Corporation for further instructions.**

DOCUMENT NO: QWI-00352	PROCESS: 17 - Production	PAGE 3 of 3
QWI_00352_UN_Container_Closing_Instructions (3)	VERSION: 2.0	MODIFIED: 01/21/19
Uncontrolled copy; see footer for location of controlled document		

4.0 Applicable Lid Attachments - No substitutes to the below identified attachments may be made.

Lids	Attachments
5LUND	Plain Lid APC 25 Pour Spout APC 25 Pour Spout - Vented Tri-Sure 70mm Screw Cap Tri-Sure 70mm Screw Cap - Vented Uni-Grip Flexspout Notes: The “APC25 Pour Spout” is the only option available for the 7RUN. The “APC25 Pour Spout” and the “APC25 Pour Spout – Vented” are the only options available for the 5100U.
5LTBU	Plain Lid

Application of the lid attachments is as follows:

- 4.1 The APC closures require the use of an APC Installation Press with the following specifications: pneumatic cylinder – air pressure 100 psi, 5 inch stroke, 4 inch diameter bore, floating piston – minimum air pressure of 25 psi.
- 4.2 A recommended torque of 9 +6 / -2 ft-lbs is to be applied on the Tri-Sure 70mm PLASTICAP™ (Screw Cap) with EPDM rubber gasket. (Nominal 9 ft-lbs, range 7 – 15 ft-lbs / 108 in-lbs, range 84 – 180 in-lbs).
- 4.3 A Tri-Sure “Uni-Grip Hold Down Unit” is the recommended method for the application of the Uni-Grip spouts. Verification of the crimp must be performed using a Uni-Grip Crimp On “Go” Gage.

Caution: Improper installation of an attachment may result in leakage.