



Closing Instructions Remanufactured 1A2 Open Top Drum

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 for the use of Hazardous Materials.

These instructions for 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. This method of closure should be used to ensure that your containers have been closed in the same manner as when they were initially tested. To be UN certified, this drum must be closed with the same cover, closing ring, gasket, and plugs (if applicable) that is provided at the time of purchase.

Your product may adversely affect container and its components. Product compatibility with the container is the shipper's responsibility. The closure recommendations do not take into account any hazards present at your facility, or the handling, filling or shipping of your product.

Any container used for packaging hazardous material should be inspected before filling and shipment. Containers with obvious damage or deterioration should not be filled or shipped.

Ring Closing Instructions:

1. Place cover on the drum, making sure that the gasket is in place. If the lid has bungs they should be at 45 degrees from the welded seam on the drum.
2. Snap the closing ring over the cover and top lip of the drum. Make sure that the ring's lugs are pointing down below the ring. Lugs should be at 45 degrees from bung and 180 degrees from the welded seam.
3. Insert the bolt completely through the lug without threads. Next, screw on the jam nut, if included. Finally, screw the bolt into the threaded lug.
4. While tightening the bolt, tap along the entire perimeter of the ring with a mallet, starting directly across from the bolt.
5. Tighten the bolt according to the manufacturer's recommended torque and gap listed below. The cover and ring should not spin, and the free ends of the ring should not touch.
6. If used, tighten the jam nut or locking nut against the lug without threads. This prevents the bolt from backing out of the closing ring.

Plug Closing Instructions:

1. Place plugs into the appropriate bung.
2. Turn the plug gently clockwise, making sure that the plug is entering the bung properly
3. Using a torque wrench, tighten the plug according to the manufacturer's recommended settings below.

Drums with rings and plugs closed in this manner have met the UN performance requirement as specified in the container markings.

Closing Ring	Torque	Gap
12 Gauge Bolt Ring with EPDM Gasket	60 Ft-Lbs	1/8" to 5/8"

Closing Plug	Torque
American Flange style 2" Steel with Buna Gasket	15-22 Ft-Lbs
American Flange style 3/4" Steel with Buna Gasket	8-15 Ft-Lbs