



## DRUM and IBC CLOSING INSTRUCTIONS

### **IMPORTANT NOTICE:**

Please give this document to the person responsible for closing these containers for shipment. Pursuant to Title 49 Code of Federal Regulations, part 178.2(c)(1)(ii), you are notified in writing of the type and dimension of closures, including gaskets, needed to satisfy performance test requirements, which includes tightening instructions for closures. You are required to provide closing information to any person to whom this package is transferred who may need to close the package prior to reshipment.

### **Closing Instructions:**

Intermediate Bulk Containers (IBC) of type 31HA1, plastic tight head drums of type 1H1, and plastic open head drums of type 1H2, are to be prepared for shipment using only the closures supplied by Encore Container or closures tested and approved by Encore for use in the packaging supplied. Successful preparation for shipment must also include proper installation of the closure into the corresponding opening and the use of a calibrated torque wrench, when required, as follows:

#### **IBC Caps (6" and 9") and Drum Plugs (2" and ¾")**

1. Check to ensure that there is an undamaged gasket and that threads are dry.
2. Spin on the cap or plug by hand to make sure the threads are not cross threaded.
3. Adjust the calibrated torque wrench to the required setting.
4. Tighten the cap or plug, using the torque wrench and applicable fitting, until the wrench releases or "clicks".
5. Do not tighten caps or plugs beyond the required torque setting as the closure might be damaged.

#### **Plastic Open Head Drum Lids**

1. Check to ensure that the lid gasket is undamaged and in good condition.
2. Place lids onto the drum opening evenly and firmly and ensure that the gasket is resting on the drum chime.
3. Place lever lock ring around the lid and drum chime with the lever lock mechanism rotating down.
4. Close the lever lock ring by pushing the lock ring handle toward the drum until it locks in place.
5. Engage the lever lock mechanism by rotating down through the receiving opening until it locks in place.

### **Required Torque Settings:**

for IBC Caps (6" or 9"), torque setting is dependent upon the manufacturer, as identified on the bottle:

Encore: 50 ft-lbs	Mauser: 70 ft-lbs	Schutz: 75 ft-lbs	Greif: 45 ft-lbs
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for 2" and ¾" plugs, torque setting dependent upon size and type of plug and type of packaging:

IBC Caps	2" plug with gasket	20 ft-lbs
	¾" plug with gasket	9 ft-lbs
Plastic Tight Head Drums (1H1)	2" plug with gasket (Buttress and NPT)	25 ft-lbs
Plastic Open Head Drums (1H2)	2" plug without gasket	18-20 ft-lbs
	¾" plug with gasket	7-9 ft-lbs

### **Torque Wrench and Closure Fittings**

Adjustable torque wrenches and closure fittings (for caps and/or plugs) may be purchased from auto parts stores, hardware or home improvement stores, industrial supply companies, and many other sources. It is important that torque wrenches used for closure of packaging be properly calibrated for accuracy and repeatability.

Effective Date: 10.14.2021

Supercedes: 05.06.2019

Approved By: C. Key, Chief Compliance Officer, Encore Container