

Pursuant to the requirements of the U.S. Department of Transportation at 49 CFR 178.2(c)(1), we hereby provide this *Notification* of the closing method used for the containers sold to you under our *Quotation*. 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. Under the applicable DOT regulations, any changes made to (a) the type, materials or dimensions of closures or (b) the method of closure **may constitute a change to the design type of these containers, voiding the UN certification we have marked on them.** If there are any questions regarding proper closing methods, please contact your Account Manager or Customer Service representative. **Chemtron Corporation highly recommends a copy of this Notification be kept on file and posted in a conspicuous location at your facility.**

TO CLOSE FITTINGS IN HEADS OR COVERS:

1. Use only the plugs and gaskets we have supplied with the drums.
2. Insert and tighten all plugs into their appropriate threaded flanges until snug.
3. Using a torque wrench, tighten each fitting to the correct torque. See below for correct torques. Torques are based on the closure manufacturers' recommendations.

REQUIRED TORQUE

SIZE & FITTING STYLE	STEEL PLUGS			NYLON OR POLY PLUGS	
	Buna Rubber Gasket	Poly Gasket	EPT Gasket	Buna Rubber Gasket	Poly Gasket
2" Rieke Type	30 ft. lbs.	40 ft. lbs.	N/A	20 ft. lbs.	20 ft. lbs.
1 ½" Rieke Type	30 ft. lbs.	40 ft. lbs.	30 ft. lbs.	N/A	N/A
¾" Rieke Type	15 ft. lbs.	20 ft. lbs.	N/A	9 ft. lbs.	9 ft. lbs.
2" Trisure Type	20 ft. lbs.	30 ft. lbs.	N/A	20 ft. lbs.	30 ft. lbs.
¾" Trisure Type	12 ft. lbs.	20 ft. lbs.	N/A	8 ft. lbs.	8 ft. lbs.

Drums closed in this manner meet the UN performance oriented packaging standards test requirements for the container markings shown on our *Quotation*.

TO CLOSE OPEN HEAD DRUMS:

A. FOR CUSTOMERS WHO ASSEMBLE THE COVER AND RING AFTER FILLING:

1. Place cover on drum, using only the cover gasket we have supplied and which is described in our *Quotation*.
2. Snap the closing ring over the cover and the bead of the drum. Make sure the ring's lugs point down, toward the floor. Also make sure that sufficient downward pressure is applied to the cover so that the bottom edge of the closing ring is fully engaged under the bottom edge of the drum bead.
3. If there are fittings in the cover, the ¾" bung should be oriented above the ring lug. If no ¾" bung, orient the 2" bung 180 degrees from the ring lug.
4. Insert the bolt through the lug without threads. Then screw lock nut on bolt (if provided see section 6). Finally, screw the bolt into the threaded lug.
5. Tighten the bolt in the locking ring lugs, to 60 ft. lbs. of torque. **While tightening the bolt, tap the entire perimeter of the locking ring with a mallet until there is no further loosening. Begin each tapping cycle 180° across the drum head from the locking ring lugs; repeat several times.** Check to ensure that the ring is seated tightly against the bottom edge of the drum bead and cover.
6. If jam nuts are provided, finger tighten jam nut against threaded lug of ring (metal to metal); then wrench tighten the jam nut an additional 14 to 28 degrees. **Note:** If Fas lok bolts or shoulder bolts are provided (which manufacturers are using at an increased rate), they do not require a jam nut for proper closure.

B. FOR CUSTOMERS WHO PURCHASE DRUMS ASSEMBLED TIGHT:

1. Ensure that the locking ring, bolt and nut have not been disturbed from the time of our delivery.
2. After filling, close the fitting in the cover used for filling, as described on the reverse.
3. Check the tightness of the bolt and nut, per A.5 & 6, above. (Some loosening of the ring is inevitable, over time, because of gasket compression.) Ensure that torque levels meet those shown above.

Drums closed in the above manner meet the UN performance-oriented packaging standards test requirements for the container markings shown on the *Quotation*.

Note: Consideration should be given to the possible effects heating and cooling may have on containers resulting in the need to tighten the closure(s). Drum gaskets will compress and lose their memory over time affecting their ability to seal. It is recommended that you limit to a minimum the time assembled gaskets are kept under full compression.

Under DOT regulations, any changes made to the type and dimensions of closures or the method of closure may constitute a change in design type of this packaging, voiding the certification we have marked on it and requiring retesting and recertification.