



*Integrity. Quality. Service.*

## **Closing Instructions**

### **Intermediate Bulk Containers**

All reconditioned Intermediate Bulk Containers marked UN31HA1, of capacity 275 – 330 gallons US, and supplied with plastic caps must be closed for shipment using the closures and gaskets supplied by the manufacturer and according to the following instructions:

1. Place 6" cap, with rubber gasket installed, on opening of IBC bottle.
2. Turn the cap clockwise to engage the threads.
3. Depending upon the manufacturer, as identified on the bottle, tighten caps to:
  - a) Schutz- 75 ft-lbs
  - b) Greif- 45 ft-lbs
  - c) Mauser- 70 ft-lbs
  - d) Varicon- 50 ft-lbs
4. If present, 2" plugs (with gasket) should be tightened to 20 ft-lbs.
5. If present, ¾" plugs (with gasket) should be tightened to 9 ft-lbs.

### **Plastic Open-Head Drums**

All open head plastic drums marked UN1H2, of capacity 20 – 59 gallons US, and supplied with plastic lids and locking rings must be closed for shipment using the closures and gaskets supplied and according to the following instructions:

1. Place drum lid on top opening and ensure that drum chime is under gasket area.
2. Place locking ring over cover and secure lid.
3. If present, 2" plugs (self sealing) should be hand tightened plus an additional quarter turn.
4. If present, ¾" plugs (self sealing) should be hand tightened plus an additional quarter turn.

### **Plastic Tight-Head Drums**

All tight head plastic drums marked UN1H1, of capacity 20 – 59 gallons US, and supplied with plugs and gaskets must be closed for shipment using the closures and gaskets supplied and according to the following instructions:

1. Install 2" buttress and/or 2" NPT plugs (with gasket) in the corresponding drum opening and tighten to 25 ft-lbs.

Effective Date: 5/1/12 Approved by: C. Key

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