



S-10758, S-16913, S-14364  
S-19414, S-19411

## OPEN TOP STEEL DRUMS

1-800-295-5510

uline.com

### CLOSURE INSTRUCTIONS

Pursuant to the requirements of the Department of Transportation in CFR 49 Part 178.2(c)(1), 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.

#### RING CLOSURE INSTRUCTIONS

1. Place cover on the drum, making sure that the gasket is in place.
2. Snap the closing ring over the cover and top lip of the drum. Make sure that the ring's lugs point down below the ring. Also, make sure the bottom edge of the closing ring engages under the lip of the drum.
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 locknut against the lug without threads. This prevents the bolt from backing out of the closing ring.

#### PLUG CLOSURE INSTRUCTIONS

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

#### TORQUE SPECIFICATIONS



**NOTE:** Uline does not ship containers to customers with closures secured to compliance specifications. It is the responsibility of the individual who fills the container to ensure the container is in UN compliance before shipping. Contact Uline with questions regarding proper closing methods.



**CAUTION!** Use only the plugs and gaskets supplied with the drums. Insert and tighten all plugs into their appropriate threaded flanges until snug. Using a torque wrench, tighten each fitting to the correct torque. Torque is based on the manufacturer's closure recommendations. Drums closed in this manner meet the UN performance-oriented packaging standards test requirements for the container markings shipped.



**CAUTION!** After filling and prior to transport, the shipper should check the closures to determine if closures need to be tightened due to heating, cooling or gasket relaxation.

| SIZE AND FITTING STYLE                     | TORQUE          | GAP          |
|--|-----------------|--------------|
| AMERICAN FLANGE - 2" STEEL - EPDM GASKET   | 15-22 FT. LBS   | -----        |
| AMERICAN FLANGE - 3/4" STEEL - EPDM GASKET | 8 - 15 FT. LBS. | -----        |
| 12GA STEEL BOLT RING - EPDM GASKET         | 60 FT. LBS.     | 1/8" to 5/8" |

