

## 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.

### TO CLOSE

1. Insert and tighten all fittings into their appropriate threaded flanges until snug.
2. Using a torque wrench, tighten each fitting to the correct torque. See the list below for correct torques.
3. If this is an open head drum, follow the additional closing instructions for top head. Torques are based on closure manufacturer's recommendations.
4. Drums closed in this manner have met the UN performance test requirements as specified in the container markings.

### FITTINGS/ORIGINAL DESIGN TYPE

| BRAND   | SIZE     | FLANGE | PLUG  | GASKET | POSITION         | TORQUE FOOT LBS |
|---------|----------|--------|-------|--------|------------------|-----------------|
| Rieke   | 2" NPT   | Steel  | Nylon | EPDM   | Cover Center     | 40              |
| Trisure | 2" NPT   | Nylon  | Nylon | EPDM   | Cover - Standard | 15-22           |
| Trisure | 3/4" NPT | Nylon  | Nylon | EPDM   | Cover - Standard | 8-11            |
| Trisure | 2" NPT   | Steel  | Steel | EPDM   | Cover - Standard | 15-22           |
| Trisure | 2" NPT   | Steel  | Steel | Buna   | Cover - Standard | 15-22           |
| Trisure | 2" NPT   | Steel  | Steel | Buna   | Cover Center     | 15-22           |

REV-KF-05/03/07

Drum Code: SU550C31292\*\*\*\*\*4LSXXX1.8/300

Report#: S-1307

Technician: HS (Sample drums were closed exactly as described above.)

This UN test certification report form is a sample of the closure notification form. The data on this form reflects the components of the tested sample drums; it details the closing methods followed at the lab for the fittings supplied.

The closure notification form should be completed using information from the actual customer specification, referencing fitting type, manufacturer and gasket, along with the associated torque values for the closures supplied. These values may differ from the sample closing instructions supplied with the UN test certification report.