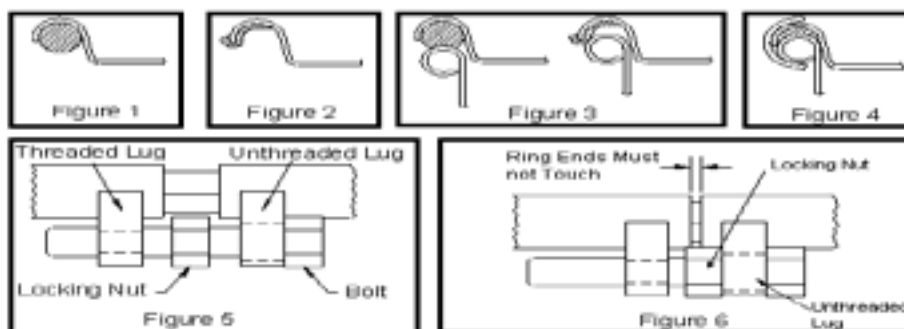


CLOSURE INSTRUCTIONS

BOLT RING CLOSURE FOR OPEN HEAD DRUMS

1. **CHECK GASKET** – to ensure cover gasket is properly fitted into cover groove (See Figure 1 or 2).
2. **PLACE COVER ON DRUM** – being careful to properly seat gasket all around curl (See Figure 3).
3. **POSITION & SEAT RING** – with lugs downward. Ensure the inner channel of the closure ring engages entire drum curl and cover (See Figure 4). Apply downward pressure on cover. Use a non-sparking dead-blow mallet to further seat cover and drum curl into the inner channel of the ring.
4. **INSERT BOLT** – through the unthreaded lug of the ring. Assemble the locking hex nut onto the threaded end of the bolt and tighten into the threaded lug (See Figure 5). Close the ring to an initial gap of about 1/2".
5. **TIGHTEN THE BOLT** – with a calibrated torque wrench while using downward pressure on the cover and hammering the outside of the ring with a non-sparking dead-blow mallet to further seat the ring. Continue tightening and hammering the ring until the torque stabilizes at 55 - 60 ft-lbs and does not decrease when further hammering on the ring circumference is performed. Ring ends must not touch. (Effective 25 September, 2006 and in accordance with CFR 178.2(c), we have revised this procedure to use torque as the most effective closure requirement.)
6. **LOCK RING** – by tightening the nut against the unthreaded lug (See Figure 6).



DRUMS WITH FITTINGS

1. **CHECK GASKETS** – and ensure gasket is properly seated on plug.
2. **TIGHTEN** – to specifications listed in the table, and do not cross thread.

PLUG TYPE	Tri-Sure style			Rieke style (Plastic)	Rieke style (Steel)	
GASKET TYPES	Buna	Poly or Teflon	PE / PP (Composite Drums)	—	Poly	All Others
3/4" PLUG	12 ft-lbs	20 ft-lbs	—	9 ft-lbs	20 ft-lbs	15 ft-lbs
2" PLUG	20 ft-lbs	30 ft-lbs	10 ft-lbs	20 ft-lbs	40 ft-lbs	30 ft-lbs

IMPORTANT

DRUMS WITH FITTINGS

1. Closure Instructions Rev. D are valid to close all product tested with and / or manufactured under Closure Instructions Rev. C. & Rev. B. Revisions are clerical and do not effect the actual closing of product.
2. A drum is properly closed only when all steps are completed in the matter and sequence indicated. If difficulties are encountered, do not ship the drum call Skolnik for further instruction.
3. Under the applicable DOT regulations, any changes made to the method of closure or closure components constitute a change in the design type of this packaging, and invalidates the certification.
4. After filling and prior to transport, the shipper should verify the torque of all closures to determine if the effects of heating and cooling or gasket relaxation have resulted in the need to re-tighten the closure.
5. Drums (other than the composites) are tested at room temperature.