

**STEEL DRUM CLOSING STATEMENT
CFR 49 PART 178-178.2 (c) (1) NOTIFICATION**

All steel containers should be closed after filling and before transportation in accordance with the tightening torque's in Appendix 1.

Containers fitted with crimped overseals over the closures will be fully torqued at the plant of manufacture.

APPENDIX 1

Closing Torques for Plug / Gasket Combinations

PLUG TYPE	GASKETS	TIGHTENING TORQUE	
		3/4" Dia Plugs	2" Dia Plugs
Tri-Sure Steel	Rubber - Black Buna. White Buna. Butyl, White Neoprene, Viton, Silicone & EPDM	12 Ft. lbs	20 Ft. lbs
	Polyethylene, Irradiated Polyethylene & Teflon	20 Ft. lbs	30 Ft. lbs
Tri-Sure Polyethylene Polypropylene/Nylon	Rubber - Black Buna. White Buna. Butyl, White Neoprene, Viton, Silicone & EPDM	8 Ft. lbs	20 Ft. lbs
	Polyethylene, Irradiated Polyethylene & Teflon	8 Ft. lbs	30 Ft. lbs
Tri-Sure Polyethylene	None (Self Gasketing)	5 Ft. lbs	12 Ft. lbs
Tri-Sure Polypropylene (Poly Clad)	None (Self Gasketing)	1/2" Plug	2 1/2" Plug
	None (Self Gasketing)	5 Ft. lbs	12 Ft. lbs
Rieke Steel For 1 1/2" steel plugs use 2" plug torques	Rubber - Quartermaster Hycar, White Buna, White Asbestos, White Dapon, EPT Wht&Black	15 Ft. lbs	30 Ft. lbs
	Poly Seal (Plastic) Irradiated & Non-Irradiated	20 Ft. lbs	40 Ft. lbs
Rieke Polyethylene Polypropylene/Nylon	Rubber - White Buna, EPT Black & White Dapon, Irradiated & Non-Irradiated	9 Ft. lbs	20 Ft. lbs
Rieke Polyethylene Polypropylene/Nylon	None - (Self Sealing)	9 Ft. lbs	20 Ft. lbs

Open Head Containers

18 3/8" Diameter and 22 1/2" Diameter

All Open Head containers should have the Locking Ring Bolt torque's checked after filling & before transportation in accordance with Appendix Procedure for Checking Bolt Tightening Torque's:

- 1) Release the Jam Nut.
- 2) Tighten the Locking Ring Bolt to torque's stated in Appendix 2.
While torquing, bump the ring with a mallet directly opposite the lugs, and on both sides.
Note: Bump the ring at a 30 degree downward angle.
- 3) Retighten the Jam Nut to 25-30 Ft. lbs. torque, against the Unthreaded Lug.

APPENDIX 2

Closing Torques for Locking Rings for 30 & 55 AG Drums

55 GAL RING	GASKET TYPES	BOLT TIGHTENING TORQUE
12 GA Forged Lug - X391	G557	45 Ft. lbs. - Ring Gap 1/16" to 3/8"
12 GA Forged Lug "C" Section All Types	ALL GASKETS Except G557	60 Ft. lbs. MIN Ring Gap Min 1/8" to Max 5/8"
16 GA Bolt Ring All Types	ALL GASKETS	Torque - 8 to 15 Ft. lbs. Ring Gap Min 1/8" to Max 5/8"
30 GAL RING	GASKET TYPES	BOLT TIGHTENING TORQUE
12 GA Forged Lug All Types	ALL GASKETS	60 Ft. lbs. MIN Ring Gap Min 1/8" to Max 5/8"
16 GA Bolt Ring All Types	ALL GASKETS	Torque - 8 to 15 Ft. lbs. Ring Gap Min 1/8" to Max 5/8"

Note: For Lever Locking Rings: Rings should be closed securely & Latched

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