



QUALITY PRODUCTS
FOR INDUSTRY

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CLOSING INSTRUCTIONS

*These closing instructions must be given to the individual(s) responsible for closing the drums prior to shipment. **UPDATED: March 15, 2022. Supersedes all prior Closing Instructions.***

PLASTIC OPEN HEAD DRUMS, Plain Cover

1. All removable head, UN1H2, Plastic drums of nominal capacity 15 to 60 U.S. gallons supplied with plastic lids, gaskets and associated closing rings and/or bands must be closed for shipment using only the components supplied and specified in the design and qualification tests according to the following installation instructions:
 - a. Inspect drum & drum lid for any cracks in the lid or gasket separation.
 - b. Open side lever lock ring so as the secure locking mechanism is on top of the ring. Open the ring and place it over the drum opening.
 - c. Place drum lid onto drum opening. Apply downward pressure to seat the gasket in the lid to the drum opening.
 - d. Pull up the locking ring to secure the ring completely around the lid & opening of the drum. Close side lever locking mechanism and secure the latch by inserting locking tab into slots in the lever lock handle.
 - e. Bolt locking ring: The channel shaped Bolt Ring locking band is placed around the drum with the lugs facing downward. Insert bolt into the non-threaded lug, the locking nut is then threaded onto the bolt. Inset bolt & locking nut into the threaded side lug, the locking nut will be between the lugs. Before tightening, orient ring and cover to desired position (e.g. ring gap 90° from 2" bung). With rubber mallet, make two to three mild horizontal impacts on the back of the ring profile on the opposite side of the drum from the ring gap, this will bring most of the initial slack towards the ring gap. Tighten the bolt until moderate resistance is met. Make mild, horizontal impacts again, starting opposite the ring gap and moving radially around each side towards the ring gap. Tighten the bolt simultaneously, if possible. If not, alternate between mallet blows and bolt tightening until moderate resistance is met. Tighten bolt until the gaps between the locking-band ends are no more than 1/4". Tighten locking nut against non-threaded lug, the ends of the bolt ring should not touch. Verify that the lid and ring do not spin.

PLASTIC OPEN HEAD DRUMS, Cover with Fittings

1. Inspect each closure to insure the closure has the proper gasket & both closure and gasket are in good condition. Inspect the sealing surface for damage, the threads for damage or cross threading. The sealing surface is to be clean and dry.
 - a. The plugs are to be hand tighten insuring no cross threading of the plug or flange.
 - b. Plugs are to be torqued per plug manufacturer's recommendations listed below:

Plug Torque Requirements

- ¾” Plug Torque @ 4 ft.-lbs.
- 2” Plug torque @ 10 ft.-lbs.

Drums closed in the manner described above have met the UN Performance test requirements as specified in the container’s markings.

PLASTIC NON-REMOVABLE HEAD DRUMS

All non-removable head, UN1H1, plastic drums supplied with plugs must be closed for shipment using only the closures and gaskets supplied and specified in the design qualification test.

PRIOR TO CLOSING:

Inspect each closure to ensure that the closure has the proper gasket and that both closure and gasket are in good condition. Inspect the sealing surface for damage and make sure the threads and sealing surface are dry. Replace any defective gaskets, plugs or lids with new, defect free closures identical to those in the design qualification.

CLOSING PROCEDURES FOR PLUGS:

1. The plug is inserted into the appropriate opening and screwed down “hand tight” until the gasket is in contact with the sealing surface.
2. A torque wrench capable of applying the proper torque to the fitting as specified below is used to tighten the plug until the preset torque as indicated by a release or click.

PLUG TORQUE SETTINGS:

- 2-inch NPS Thread plug torque at 45 foot lbs.
- 2-inch buttress plug torque at 45 foot lbs.
- ¾-inch plug with microporous vent at 9 foot lbs.

UN CERTIFICATION DOES NOT PERMIT SWAPPING COMPONENTS

When purchasing a UN certified drum, the entire design of the drum and all its’ components (bolt, nut, ring, lid, head, cover, gaskets, plugs, gauge, minimum mil thickness, etc.) are defined in the certification testing. All of these elements are incorporated into a drum type that must meet a test standard. Users, therefore, cannot alter or exchange any of these components as it might impact the ability of the drum to perform as certified.

If a filler were to change any of the components, even a plug gasket, this would void the UN certification for the container.

If replacement parts are needed, fillers must make sure they contact the manufacturer of the drum and get original parts that meet the test criteria of that specific drum. Once the drum is filled, compliance with UN certification is the responsibility of the shipper.

Please reference 49CFR173.22 for additional information regarding Shipper’s Responsibility.