



Extending the Lifecycle of Industrial Packaging

CLOSURE NOTIFICATION IBCs/PLASTIC DRUMS

rev 08/2015

This notification is provided as required in 49 CFR 178.2(c). Instructions below describe procedures for closing packaging prior to shipment. All packaging supplied with lids, gaskets, clamp bands, locking rings, bolt rings, bungs, plugs, caps or other fittings must be closed for shipment using only the components supplied.

Prior to closing:

1. Inspect each closure to ensure: a) proper gasket is in place; b) threads and sealing surfaces are dry; c) both closure and gasket are in good condition.
2. Replace any defective gaskets, plugs or lids with new, defect free parts identical to the original packaging design.

Closing plug and cap fittings:

1. Insert the plug or cap into the appropriate opening and screw down "hand tight" until the gasket is in contact with the sealing surface.
2. Using a torque wrench capable of applying the proper torque as specified below, tighten the plug or cap until it reaches the pre-set torque as indicated by a release or click. Torque wrenches should be calibrated at least annually.

Closing removable head drums:

1. Place drum lid with gasket and selected clamp band as supplied on the top opening of the drum body.
2. Firmly place lid onto top opening by applying downward pressure to lid above drum sidewall.
3. While pressing down on lid, engage locking mechanism of clamp band to secure the lid in place. Make sure the locking mechanism is completely latched. Insert locking tab into slots in level lock handle.

| INTERMEDIATE BULK CONTAINERS (IBCs) | | | | |
|-------------------------------------|---|--|--|--------|
| ID | Manufacturer/Container Type | Gasket Type | Closing Torque (ft-lbs) | |
| A | MAUSER SM series 275/330 w/6" or 9" lid | any | 70 (6" fill cap) | |
| B | MAUSER 2" plug in 6" or 9" lid | EPDM/FKM | 20-25(fill cap) | |
| C | MAUSER 56mm plug in 6" or 9" lid, vented and solid | EPDM/FKM | 20-25 (fill cap) | |
| D | MAUSER 2" buttress plug in top of IBC | EPDM/FKM | 20 (fill cap) | |
| E | IBCNA | | 40 (6" fill cap; 75 (9" fill cap) 30 (2" opening) 45 (Bottom discharge valve – NPT or camlock end) | |
| F | Greif: Tighten 6" cover ½ turn after gasket contact with the top of the bottle | Not specified | 45: (6" fill cap) 20 (2" NPT fitting); 9(3/4 fitting) | |
| G | SCHUETZ: note – for new style valves – 2 turns and line up the hole in the valve body and the hole in the bottle insert and insert clip | Not specified | 75 (6" and 9" fill cap) 20 (2" fitting); 55 (valve nut) | |
| PLASTIC DRUMS | | | | |
| ID | Manufacturer/Container Type | Closing Torque (ft-lbs) by fitting type/size | | |
| | | 2" NPT | 2" Buttress | ¾" NPT |
| A | MAUSER nonremovable head - L10-xx with L11-xx | | 20 | |
| B | MAUSER nonremovable head - L16-xx with L12-xx | 20 | | |
| C | MAUSER nonremovable head - C34 with C31 | | | 6 |
| D | MAUSER open head - Vanguard Lid | 9 | | 5 |
| E | MAUSER open head – Standard Lid | 15 - 20 | | 9 |
| F | GREIF | 20 | 20 | 9 |
| G | SCHUETZ 250 and 150 kPa tight (closed) head | 30 | 30 | 9 |
| H | SCHUETZ open head drum | 20 | 20 | 9 |