

## RIPA Model Packaging Closure Notification

Pursuant to the requirements of the U.S. Department of Transportation at 49 CFR 178.2 (c) (1), we hereby provide this notification of the closing method used for the containers procured from \_\_\_\_\_(our company)\_\_\_\_\_. 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 and qualified for hazardous materials (*aka* UN dangerous goods). Under the applicable U.S. DOT regulations, any changes made to (a) the type, materials or dimensions of closures, or (b) the method of closure **may constitute a change to the design type of these containers, voiding the UN certification and performance levels we have marked on them.** If there are any questions regarding proper closing methods, please contact our Customer Service Department.

Closures must be tightened to assure that the container does not leak under conditions of normal transportation. If a filled container is left in storage without being shipped for more than 24 hours, closures should be checked again for tightness. If a filled container is not shipped for more than 30 days, gaskets should be replaced and closures tightened according to these instructions.

The torque values presented here are recommended torques; they are levels at which closure manufacturers have tested and certified the closure/gasket/drum combination as capable of passing U.S. and UN packaging standards, and performing to the levels marked on the drum. Fillers are advised to have readily available at filling operations a torque wrench with which to measure applied torque. U.S DOT has indicated that it will enforce all provisions appearing in a Closure Notification. Not having a torque wrench available when torque levels are specified has been, in some cases, cited as a violation.

Procedures in addition to simply tightening closures must be followed carefully, as they are a required part of the closure process.

### Closed-Head Steel Drum (1A1)

1. Check gaskets and ensure that they are properly seated on the plugs.
2. Tighten plugs using a torque wrench to the torque specifications presented here.
3. Take care not to cross threads.

Size & Fitting Style	REQUIRED TORQUE			
	STEEL PLUGS		NYLON OR POLY PLUGS	
	Buna Rubber Gasket	Poly Gasket	Buna Rubber Gasket	Poly Gasket
2" Rieke Type	30 ft. lbs.	40 ft. lbs.	20 ft. lbs.	20 ft. lbs.
3/4" Rieke Type	15 ft. lbs.	20 ft. lbs.	9 ft. lbs.	9 ft. lbs.
2" Tri-Sure Type	18 - 22 ft. lbs.	18 -22 ft. lbs.	18 -22 ft. lbs.	10 -20 ft. lbs.
3/4 Tri-Sure Type	11 -15 ft. lbs.	14 -18 ft lbs.	7 -11 ft. lbs.	8 - 12 ft. lbs.

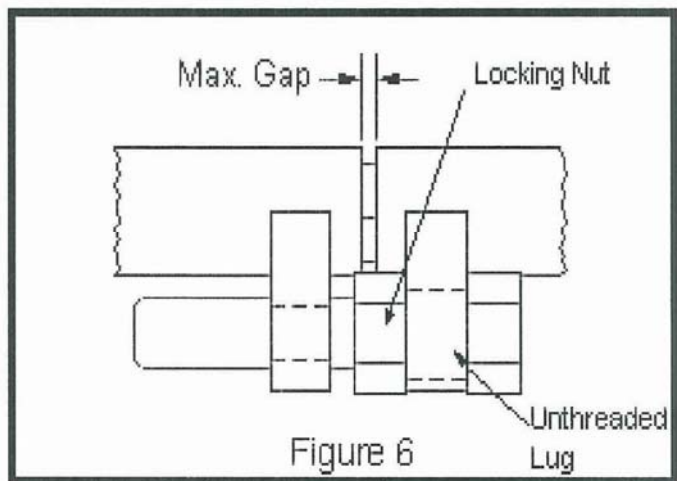
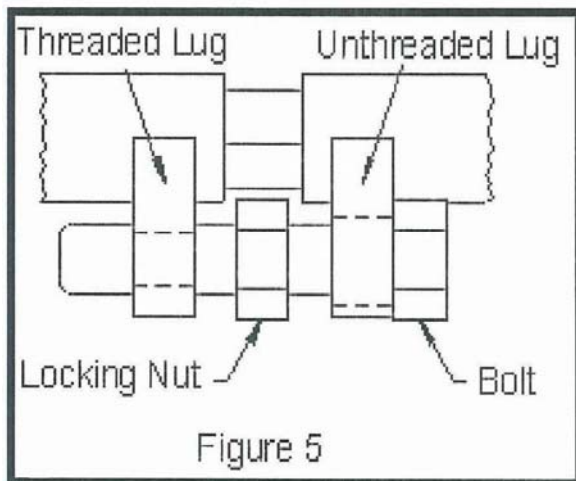
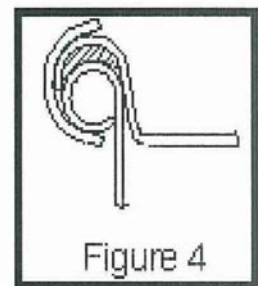
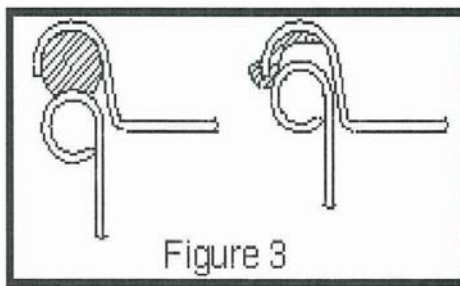
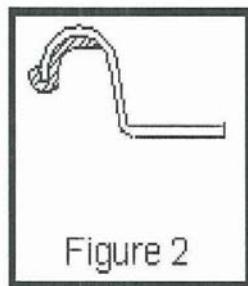
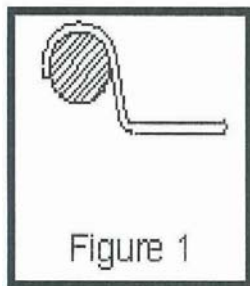
### Open-Head Steel Drum (1A2)

#### Bolt-Ring Closure

1. Check the gasket to ensure it is properly fitted into the bottom groove of the drum cover (Figure 1 and 2).
2. Place the cover on the drum, being careful to seat the gasket onto the entire lip (curl) of the drum sidewall (Figure 3).
3. Position the closure ring, with lugs downward, so that it engages the entire circumference of the drum cover and sidewall. Apply pressure on the ring and cover, and tap the circumference of the ring with a non-

sparking mallet to further seat the cover and sidewall into the inner channel of the ring (Figure 4).

4. Insert the bolt into the unthreaded lug of the ring. (If the ring is equipped with a locking hex nut, affix the nut onto the bolt.) Direct the end of the bolt into the threaded lug of the ring (Figure 5). Close the ring to an initial gap between the lugs of approximately  $\frac{1}{2}$  inch.
5. Tighten the bolt while further tapping the edges of the ring with the mallet.
6. When fully assembled, the gap between the free ends of the ring should not exceed  $\frac{1}{4}$  inch, nor should the ends of the ring touch (Figure 6).



## CLOSED HEAD PLASTIC DRUMS (1H1)

1. Place plugs (with gasket) into the corresponding drum opening of corresponding size and thread pattern.
2. Tighten to torque values as follows:

Size & Fitting Style	REQUIRED TORQUE		
	NYLON & POLYPROPYLENE		POLYETHYLENE
	Buna Rubber Gasket	Poly Gasket	Self-Gasketing
2" Rieke Type	20 ft. lbs.	20 ft. lbs.	20 ft. lbs.
3/4" Rieke Type	9 ft. lbs.	9 ft. lbs.	9 ft. lbs.
2" Tri-Sure Type	20 ft. lbs.	30 ft. lbs.	12 ft. lbs.
3/4" Tri-Sure Type	8 ft. lbs	8 ft. lbs	5 ft. lbs.

## OPEN HEAD PLASTIC DRUMS (1H2)

1. Covers supplied with the drums must be attached to the drums with lever action or bolt ring locking bands.
2. Bolt rings are tightened down until  $\frac{1}{4}$ " –  $\frac{1}{2}$ " of space separates each end of the ring.
3. Bung openings in open top drum lids must be fitted with the proper 2" or  $\frac{3}{4}$ " bung.      Torque      2" 20 FT LBS       $\frac{3}{4}$ " 9FT LBS
4. Gaskets are not required for packaging dry products.

<b>Composite Intermediate Bulk Containers (31HA1)</b>
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1. 6" top cover should be torqued to 45 FT LBS
2. 6" lids containing smaller openings should have the smaller closures torqued as follows:  
    2" Plugs: 30 FT LBS      ¾" Plugs: 9 FT LBS

**I acknowledge receipt of drum closure instructions (Notification) from  
    (company)    .**

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Name

Date

Company

Date Notification Issued: \_\_\_\_\_

A copy of the Notification for each packaging design-type is to be maintained on file for at least one year by the packaging manufacturer and each subsequent distributor.