



# Drum Service of Richmond, Inc.

Responsible Container Management

## INTERMEDIATE BULK CONTAINER CLOSING INSTRUCTIONS

### IBC Lid Torque Requirements

- \* 275 and 330 gallon 6" and 9" IBC Lids at 75 ft.- lbs.
- \* 2" plug in Standard lid, vented at 30 ft.- lbs.

1. All UN 31HA1 and 31 HG1 Composite IBC's 49CFR § 178.707 (a) (5) that are supplied with lids, cages, pallets and service equipment must be closed for shipment using only the components supplied and specified in the design qualification tests for that IBC.
  - a) Place the lid with gasket in place on the top opening of the IBC.
  - b) Screw the lid by hand until the gasket is in contact with the sealing surface.
  - c) Using the lid adaptor and torque wrench tighten the lid to the recommended torque.
  - d) Present torque wrenches or adjustable torque wrenches are suitable for this procedure.

### Closing Procedures for plugs and caps:

The plug or cap is inserted into the appropriate opening and screwed down hand tight until the gasket is in contact with the sealing surface. A torque wrench capable of applying the proper torque to the fitting as specified by the closing instructions is then used to tighten the plug or cap until it reached the pre-set torque.

**ALL VALVES MUST HAVE A CAP INSTALLED ON OUTLET.**

### IBC Valve Removal Instructions:

Using the valve tool and torque wrench or breaker bar loosen the valve counterclockwise. Remove the remainder of valve from the IBC by hand.

### IBC Valve and Valve Cap Torque Requirements:

- a) **Metal Collar IBC Valves:** 275 and 330 gallon 2" IBC Valves Torque to 55-60 ft.-lbs.
  - b) **Poly Collar IBC Valves:** 275 and 330 gallon 2" IBC Valves Torque to 35-40 ft.-lbs.
1. All UN 31HA1 and 31 HG1 Composite IBC's 49CFR § 178.707 (a) (5) that are supplied with lids, cages, pallets and service equipment must be closed for shipment using only the components supplied and specified in the design qualification tests for that IBC.
    - a) Place the valve with gasket in place on the bottom opening of the IBC.
    - b) Screw the valve by hand until the gasket is in contact with the sealing surface.
    - c) Using the valve tool and torque wrench tighten the valve to the recommended torque.

IBC supplied is: (check one) Date \_\_\_\_\_

- NEW  
 REBOTTLED-REPAIRED  
 REBOTTLED- REMANUFACTURED



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