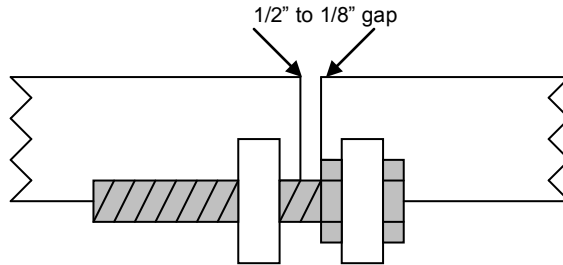


Reconditioned Steel Drum Closure & Assembly Instructions

1A2 Containers (Open-Head with lid and 5/8" bolt ring)

- 1) Inspect cover (lid) gasket to ensure it is fully retained in cover curl.
- 2) Place cover on container false wire (OH curl on top of drum).
- 3) Install 12 gauge locking ring over cover curl and false wire.
- 4) Insert 5/8" bolt (and locking jam nut if applicable).
- 5) Tighten the bolt and occasionally tap around the entire perimeter of the ring with a rubber mallet. Tighten to assure that the gasket is compressed and that the package will not leak under conditions normally incident to transportation. When fully assembled, the free ends of the ring should not touch but the gap should not be wide as to compromise the effectiveness of the drum. Min. torque: 50 ft/lbs.
- 6) If a locking nut is used, it should be tightened against the unthreaded lug to prevent the bolt from backing out of the closing ring.



1A1 Containers (Closed-head with bungs)

- 1) Inspect all bungs which have been removed to ensure gaskets are in place.
- 2) Insert all bungs and hand thread in clockwise direction until bungs are hand tight.
- 3) With a calibrated torque wrench, torque tighten all applicable bungs (see Chart below).
- 4) Wipe clean any spillage or debris.
- 5) Apply applicable cap seals.

Chart of Recommended Plug (Bung) Torque in FT/LBS

Bung Type	Tri-Sure Steel		Tri-Sure Poly		Rieke Steel		Rieke Poly		Nylon
Gasket Type	Rubber	Poly	Rubber	Poly	Rubber	Poly	Rubber	Poly	Poly
2"	20	30	12	12	30	40	20	20	40
1 1/2"	n/a	n/a	n/a	n/a	25	30	n/a	n/a	n/a
3/4"	12	20	5	15	15	20	9	9	20

UN certified container closures must be installed and secured in accordance with the above procedures and specifications. To ensure compliance to the UN markings, we recommend that the filler inspect and re-tighten all applicable closures prior to shipment.