

# Abbey Drum Company

## 49 CFR 178.2C

### Closure Instructions

Per 49 CFR 178.2C, the Department of Transportation requires container manufacturers and reconditioners to inform customers of how to properly close containers in order to assure UN marking performance.

in Ft.Lbs unless otherwise noted

Plug Type	Gaskets	3/4" Plug	2" Plug
Tri-Sure Steel	Rubber-Black Buna, White Buna, Butyl, White Neoprene, Viton, Silicone & EPDM	12	20
	Polyethylene, Irradiated Polyethylene & Teflon	20	30
Tri-Sure Polyethylene Polypropylene Nylon	Rubber-Black Buna, White Buna, Butyl, White Neoprene, Viton, Silicone & EPDM	12	20
	Polyethylene, Irradiated Polyethylene & Teflon	8	30
Tri-Sure Polyethylene	None (Self Gasketing)	5	12
Tri-Sure Polypropylene (PolyClad)	None (Self Gasketing)	5	12
Rieke Steel <small>Note: for 1 1/2" steel plugs use 2" plug torques</small>	Rubber-Quartermaster Hycar, White Buna, White Asbestos, White Dapon, EPT Black, EPT White	15	30
	Poly Seal (Plastic), Irradiated & Non-Irradiated	20	40
Rieke Polyethylene Polypropylene Nylon	Rubber White Buna, EPT Black, EPT White, Dapon	9	30
Rieke Polyethylene Polypropylene Nylon	None (Self Gasketing)	9	20
Rieke Flexspout FS-10-6	Crimp with Rieke Crimp Tool FS600 #1034 & check with Rieke Gauge G101-1	---	---
Screwcaps 70mm & 65 mm	Use Inner Seal Supplied with Screw Cap	---	120 In. Lbs
IBC 6" & 9" Fill Port Cap	Must use supplied Gasket	75	
IBC 6" & 9" Fill Port Cap 2" Plug	Must use supplied Gasket	---	15
IBC Valve Nut	Must use supplied Gasket	55	

#### Notes:

- 1.> Any changes made to the type and/or dimensions of closures or method of closure may void the certification that is marked on it and require re-testing and recertification
- 2.> After filling and prior to shipment, the shipper should check the tightness of closures to determine if the effects of heating, cooling or gasket relaxation have resulted in the need to tighten the closure.

# Abbey Drum Company

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## CFR 49. Part 178.2 (c)(1) Notification DRUM CLOSURES

### CLOSING INSTRUCTIONS FOR UN 1A2, REMOVABLE HEAD STEEL DRUMS

(DOT 17H, DOT 17C and Stainless Steel Open Heads)

Place drum head with gasket in place as supplied on the curl at the top of the drum body. (see figure 1)

Place bolt ring around drum head and curl.

Using head compressor apply force to top of drum head assembly to compress head gasket.

Drive bolt into lug until the ends of the bolt ring are as follows: (see figure 2)

a) for steel drum thickness marked on bottom of drum; 1.3/1.1/1.1 : 1/2 inch or less

b) for steel drum thickness marked on bottom of drum; 1.1/0.8/1.1 : 3/8 inch or less

If a head compressor is not available, start bolt into lug, alternate tapping of ring with a mallet and driving bolt with wrench, until bolt ring ends are within the dimensions above.

When righ has been tightened as described the jam nut must be tightened against the left lug.

FIGURE #1

Open Head Ring & Bolt

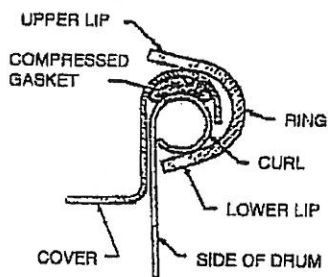
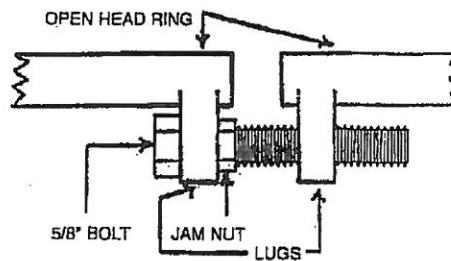


FIGURE #2



Gauge cover with EPDM gasket

Gauge bolt locking ring with 5/8" bolt and 5/8" locknut. Torque to 35 ft.lbs