GRAY CONTAINER LLC

Dealer of All Types of Containers

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CLOSURE NOTIFICATION ADVICE
STEEL DRUMS

Pursuant to the requirements of the U.S. Department of Transporation 49 CRF 178.2(c)(1),we hereby provide this notification of the closing method used for containers sold to you. This method of closure should be used to ensure that your containers have been closed in the same manner as they were initially tested. If there are any questions regarding proper closing methods, please contact our Customer Service Department at (216) 721-9900.

TO CLOSE FITTINGS IN HEADS OR COVERS

1. Insert and tighten all plugs into their appropriate threaded flanges until snug.
2. Using a torque wrench, tighten each fitting to the correct torque. See following table for correct torques. Torques are based on the closure manufacturers recommendations.

PLUG MAKE AND COMPOSITION GASKET TYPE	TORQUE SPECIFICATION 2"	3/4"
RIEKE STEEL BUNA GASKET	30 LB	15 LB
TRI-SURE STEEL BUNA GASKET	20 LB	12 LB
RIEKE STEEL POLYETHYLENE GASKETS	30 LB	15 LB
TRI-SURE STEEL POLYETHYLENE GASKETS	30 LB	20 LB
REIKE NYLON POLYETHYLENE GASKET	20 LB	9 LB
TRI-SURE NYLON POLYETHYLENE GASKET	30 LB	8 LB

To include Questar Part #'s as follows:

EDD317F, EDD317FE, EDD317FE-LG, EDD317FE-REP

RIEKE POLYETHYLENE BUNA GASKET	20 LB	9 LB
TRI-SURE POLYPROPYLENE BUNA GASKET	20 LB	9 LB

TO CLOSE OPEN HEAD DRUMS:

1. Place cover on drum, using only the cover gasket we have supplied.
2. Snap the closing ring over the cover and the bead of the drum. Make sure the ring's lugs point down toward the floor. Also make sure that sufficient downward pressure is applied to the cover so that the bottom edge of the closing ring is fully engaged under the bottom edge of the drum's bead.
3. Insert the bolt through the lug without thread and screw into the threaded lug. If your specifications include lock nuts, screw the lock nut on the threaded bolt on the outside of the lug
4. Tighten the bolt in the locking ring lugs, to 55# lbs of torque. While tightening the bolt, pound the entire perimeter of the locking ring with a non-sparking mallet until there is no further ring movement. Do not rely on wrench tightening to bring closure without pounding only as stripping of nut and/or lug will occur. Begin each pounding cycle 180 degrees across the drum head from the locking ring lugs. Check to ensure that the ring is seated tightly against the bottom edge of the drum bead and cover. Note: for UN drums which do not utilize a 12 gauge ring tighten 1/8 - 1/4" gap
pounding ring frequently to prevent lug deformation.
5. If your specifications included lock nuts, the lock nut must be tightened against the threaded lug of the bolt ring. Tighten lock nut to 25-30# lbs of torque. We advise all customers to recheck the torque on all fittings and bolts before your full container of product leaves your facility. Drums closed in the above manner meet the UN performance oriented packaging standards test requirements for the container markings shown on the drum.