



**STEEL DRUM CLOSING STATEMENT  
CFR 49 PART 178 –178.2 © (1) NOTIFICATION**

All Steel container should be closed after filling and before transportation in accordance with the tightening torques in Appendix 1.

**APPENDIX 1**

Closing Torques for Plug/Gasket Combinations

PLUG TYPE	GASKETS	TIGHTENING TORQUE	
		¾" Dia Plugs Ft lbs.	2" Dia Plugs Ft lbs.
Tri-Sure Steel	Elastomer	8 - 15	15-22
	Thermoplastic	11-18	15-22
Tri-Sure Plastic	All	8 - 11	15-22
Rieke Steel	Elastomer	15	30
For 1-1/12" Use 2" Torques	Thermoplastic	20	40
Rieke Plastic	All	9	20

Elastomer Gaskets include Nitrile (Buna), EPDM, VITON and Butyl.  
Thermoplastic Gaskets include Polyethylene

**OPEN HEAD CONTAINERS**

All Open Head containers should have the Locking Ring Bolt torque's checked after filling & before transportation in accordance with Appendix 2.

**APPENDIX 2**

Closing Torques for Locking Rings for 30 & 55 AG Drums

BOLT-RING CLOSURE	GASKET TYPES	For the <b>Bolt-Ring</b> locking band, snap the closing ring over the cover and top lip of the drum. Insert the bolt, through the lug without threads. Next, (if applicable) screw on the locking nut. Finally, screw the bolt into the threaded lug. While tightening the bolt, tap the entire perimeter of the ring with a mallet, starting directly across from the bolt. When required, tighten the locking nut 20-25 Ft. Lbs against the unthreaded lug.
12 GA Forged Lug – X391 55 Gallon Only	½" Diameter	45 Ft lbs. - Ring Gap 1/16" to 3/8"
12 GA Forged Lug "C" Section All Types (55 & 30 Gallon)	All Gaskets Except ½" Diameter	60 Ft lbs. - Ring Gap 1/8" to 5/8"
16 GA Bolt Ring (55 & 30 Gallon)	All Gaskets	8 to 15 Ft lbs. – Ring Gap 1/8" to 5/8"

For the **Lever-Action** locking band, snap the closing ring over the cover and top lip of the drum. Pull the locking lever closed, and at the same time, tap the edge of the closing ring, beginning directly opposite the closing lever, with a mallet until the lever is fully closed against the edge of the ring. Snap the latch into the lever until it locks, then apply a seal wire or other sealing device through the hole in the latch lever.