

Pursuant to 49 CFR §178.2 (c), Maxi Container, Inc., as a subsequent distributor of the packaging referenced on the front of this work order, states that, if a UN Number appears on the front of this work order, the packaging complies with the requirements of **Part 178 - Specifications for Packagings of 49 CFR**, except as delivered, the closures are not tightened for shipment.

This certification is applicable to the first use of the container(s) only. Any reuse of the container(s) is subject to the reuse and reconditioning regulations of 49 CFR.

This notification applies to the drum listed on the front the work order, provided that a UN number appears thereon, and that no other closure notification is attached hereto.

## HOW TO CLOSE A STEEL DRUM

### HOW TO CLOSE AN OPEN HEAD STEEL DRUM

Check Cover, Gasket should be secured in the Cover Groove.  
Place Cover with Gasket onto Drum Curl.  
Install the Drum Ring by Engaging the Cover and Drum Curl in Ring Channel all around top.  
Screw in Bolt with Nut through Ring's Lugs.  
Tap Ring to assist closing process.  
Torque up Bolt to 45 - 55 Ft./Lb.  
Use Ring Gap as a Guide (1/4" - 3/8")

ROUND HEAD PLUGS		3/4"	2"
Tri-Sure™ Steel Plugs	Rubber Gaskets	12	20
	Polyethylene, Teflon Gaskets	20	30
Tri-Sure™ Zinc Die Cast Plug	Rubber Gaskets	12	20
	Polyethylene, Teflon Gaskets	20	30
Tri-Sure™ Polypropylene & Nylon Plugs	Rubber Gaskets	12	20
	Polyethylene, Teflon Gaskets	20	30
Tri-Sure™ Polyethylene Plug, High Density	Rubber Gaskets	8	15
	Polyethylene, Teflon Gaskets	8	15
Tri-Sure™ Self Gasketing Polyethylene Plug		5	12

### HOW TO CLOSE A TIGHT HEAD STEEL DRUM

Check Plugs for proper Gasket Seat.  
Gently Screw in Plug to insure no Cross Threading  
Tighten to Prescribed Torque (as specified on chart) with Proper Wrench.  
Apply cap seals, if required.

HEX HEAD PLUGS	STEEL		PLASTIC	
	3/4"	2"	3/4"	2"
Rieke® Steel Plug	Rubber Gaskets	15	30	—
	Polyethylene Gaskets	20	40	—
Rieke® Plastic Poly-Visegrip Plug	Rubber Gaskets	9	20	9
Rieke® Plastic Tamper-Loc® Plug	Rubber Gaskets	—	—	25
Rieke® Poly-Visegrip	Plug with Built-In Gasket	9	20	9

## HOW TO CLOSE A PLASTIC DRUM

### HOW TO CLOSE AN OPEN HEAD PLASTIC DRUM

Covers Supplied with the drums must be attached to the drums with lever or bolt ring locking bands, as supplied with the drums.  
Openings in the drum covers must be fitted with bungs bearing NPS threads (2" NPS) or American Buttress threads (BTR 2") as appropriate, and must be tightened to a torque level of 15 foot pounds.

### HOW TO CLOSE A TIGHT HEAD PLASTIC DRUM

Openings in tight head plastic drums must be fitted with bungs bearing National Pipe Thread (NPS) and/or American Buttress (BTR) threads (2" NPS or 2" BTR) or equivalent.  
Bungs must be fitted with gaskets appropriate to the bung size and design.  
Bungs must be places into the appropriate openings and tightened to a torque level of 25 ft. pounds for 2" tamperproof bungs, 20 foot pounds for other 2" bungs and 9 foot pounds for all 3/4" bungs.