

Steel Drum Regulated and Non Regulated Container Closure & Assembly Instructions

UN certified container closures must be installed and secured in accordance with the following procedure and specifications.

1A2 CLOSURE SYSTEM COMPONENTS

To ensure compliance to UN markings, the filler/shipper must inspect and confirm all closures are properly installed prior to shipping.

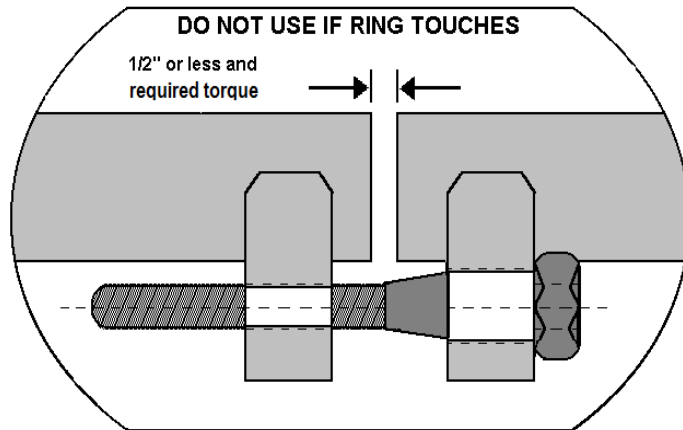
This Procedure is for new steel drums manufactured by GENERAL STEEL DRUM only!

DO NOT MIX DIFFERENT DRUM MANUFACTURERS' COMPONENTS!

For drums manufactured / re-manufactured by others suppliers, consult your specific supplier for torque and closing requirements.

16 Gauge Ring: *Torque: 15 to 20 ft-lbs*

12 Gauge Forged Lug Ring: *Torque: 60 to 70 ft-lbs*
 5/8" Standard Drum Bolt...**Jam Nut Required**
 5/8" Shoulder Bolt...**No Nut Required**



Lever Lock Rings

1. Position lid/ring on false wire (top lip/curl of drum).
2. Assure proper lid/ring placement on false wire.
3. Close handle on ring.
4. Tap around ring with non-sparking mallet as needed.
5. Secure handle on ring.

OPENHEAD DRUM CLOSURE PROCEDURE

1. Check Cover Gasket and False Wire to verify not damaged. Check Cover Gasket is properly seated in cover and both the gasket and false wire are clean. If product is present, Wipe Clean.

****If Damaged, Replace or Do Not Use!****

Position Lid and Ring onto Drum False Wire (top lip or curl of drum).

Assure proper Lid/Ring placement onto False Wire.

Start Bolt and tighten ring.

Tap around circumference of Ring with non-sparking mallet and continue to tighten ring.

Tighten ring until tapping with non-sparking mallet no longer loosens ring and ring gap is less than 1/2" but not touching and required torque is reached.

2. If jam nut is used, tighten jam nut against the unthreaded portion of the forged lugs.
3. Check all bungs for proper torque.
4. Prepare drum for shipping according to Internal Procedures and applicable DOT Requirements.

BUNG CLOSING PROCEDURES

1. Inspect all bungs to ensure gaskets are in place.
2. Insert all bungs and hand thread in a clockwise direction until hand tight.
3. Utilizing a CALIBRATED TORQUE WRENCH, confirm and/or torque tighten all bungs to required specification.
4. Wipe clean any spillage or debris.
5. If required, apply applicable cap seals.

MANUFACTURER'S RECOMMENDED TORQUE (ft-lbs) tolerance: ±10%

BUNG TYPE MATERIAL	ROUND Steel		ROUND Poly / Nylon		HEXAGONAL Steel		HEXAGONAL Poly / Nylon	
	Rubber	Poly	Rubber	Poly	Rubber	Poly	Rubber	Poly
2"	20	30	20	20	30	40	20	20
1 1/2"	N/A	N/A	N/A	N/A	30	40	N/A	N/A
3/4"	9	15	9	9	15	20	9	9

For more information, call (800) 796-4226

www.generalsteeldrum.com