

1A2 Container Closure Assembly Instructions

1A2 CONTAINERS

1. Inspect cover gasket to ensure it is fully retained in cover curl.
2. Place cover on container false wire (OH curl).
3. Install 12 ga. locking ring over cover curl and false wire.
4. Insert 5/8" bolt and locking jam nut, if applicable.
5. Tighten 5/8" bolt completely (ring ends should be within 1/2" ± 1/8" each end for optimum seal).
6. Tighten jam nut against locking ring bolt lug.

Note: If drum is filled through bungs, follow procedure for 1A1 containers.

1A1 CONTAINERS

1. Inspect all bungs which have been removed to ensure gaskets are in place.
2. Insert all bungs and hand thread in clockwise direction until bungs are hand tight.
3. With a calibrated torque wrench, torque tighten all applicable bungs (Ref. Chart 1).
4. Wipe clean any spillage or debris.
5. Apply applicable cap seals.

CHART 1

Recommended Plug (Bung) Torque in FT/LBS											
Size/Type	Tri-Sure Steel		Tri-Sure Poly		Rieke Steel		Rieke Poly		Rubber Poly		Nylon
2"	20	30	12	12	30	40	20	20			40
1 1/2"	N/A	N/A	N/A	N/A	25	30	N/A	N/A			N/A
3/4"	12	20	5	15	15	20	9	9			20
Gasket Type	Rubber	Poly	Rubber	Poly	Rubber	Poly	Rubber	Poly	Rubber	Poly	Poly

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

Note: To ensure compliance to the UN marking, filler should inspect and re-tighten all applicable closures prior to shipment.

Customer _____ Name _____ Date _____

1A2 CLOSURE SYSTEM COMPONENTS

12 Gauge Forged Lug Locking Ring
5/8" Standard Drum Bolt
5/8" Standard Jam Nut (Optional)

