

Berenfield Containers

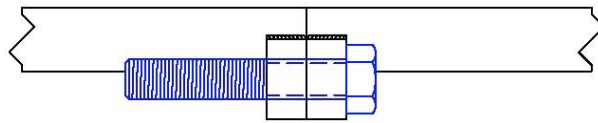
DOT 178 Notice

Closure Requirements for Steel Drums

In Regulation 49 CFR 178.2(c), the Department of Transportation (DOT) requires drum manufacturers to inform their customers of how to close drum fittings and closure rings in order to ensure the drum will perform to the marking level indicated thereon. Please see that this information is available to those responsible for closing the drums after filling. The use of non-sparking tools is recommended to close drums containing hazardous materials.

CLOSING INSTRUCTIONS FOR 1A2 FULL OPEN HEAD DRUMS WITH SOLID SEAL™ BOLT RING CLOSURE – TYPE II

**(TYPE II HAS A 5/8" BOLT WITH A NYLON LOCKING PATCH
WHICH ELIMINATES THE NEED FOR A RETAINING NUT OR
JAM NUT)**



- 1.) Covers must be firmly seated on the top of the drum with the gasket in place. Care must be taken to ensure that the gasket has not become dislodged, looped, or twisted during either removal or placement of the cover.
- 2.) Snap the closing ring over the cover and curl area of the drum, making sure that it is seated over the entire perimeter. Check to see that the cover and drum curl are fully contained and centered within the recess of the ring.
- 3.) The bolts for this application have a nylon locking patch on the threads. Insert the 5/8" diameter nylon patched bolt through the unthreaded ring lug and tighten the bolt while either compressing the gasket with a mechanical head compressing device, or, if a head compressor is unavailable, simultaneously tapping the outside of the closing ring around the entire perimeter with a non-sparking mallet.
 - a.) The bolt should be tightened until the two lugs meet and touch each other with no gap. A torque of at least 30 ft-lb should be applied. If a mechanical head compressor is not used, the torque required to bring the lugs together with no gap may be higher.
 - b.) When the ring and bolt are assembled and tightened correctly the two lugs should meet and touch each other with no gap, regardless of the torque required. If the lugs do not meet, repeat steps 1 through 3.
 - c.) For drums with poly liner bags, the gap should be 3/8" or less while ensuring that the liner is seated uniformly over the curl of the drum and protruding out from under the cover.

NOTE: Per IFI STD 124, a nylon patch bolt may be reused (re-torqued) a maximum of five (5) times, after which it should be replaced.