

# CLOSURE INSTRUCTIONS

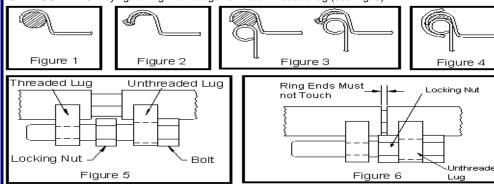
PQ 080 – Closure Instructions Revision: D

Revision Date: 1 January 2011 (See Important Note 1)

In compliance with DOT 49 CFR §178.2 (c), persons shipping Skolnik drums must comply with the following closure instructions.

### BOLT RING CLOSURE FOR OPEN HEAD DRUMS

- 1. CHECK GASKET to ensure cover gasket is properly fitted into cover groove (see Fig. 1 or 2).
- 2. PLACE COVER ON DRUM being careful to properly seat gasket all around curl (see Fig. 3).
- POSITION & SEAT RING with lugs downward. Ensure the inner channel of the closure ring
  engages entire drum curl and cover (see Fig. 4). Apply downward pressure on cover. Use a nonsparking dead-blow mallet to further seat cover and drum curl into the inner channel of the ring.
- 4. INSERT BOLT through the unthreaded lug of the ring. Assemble the locking hex nut onto the threaded end of the bolt and tighten into the threaded lug (see Fig. 5). Close the ring to an initial gap of about 1/2".
- 5. TIGHTEN THE BOLT with a calibrated torque wrench while using downward pressure on the cover and hammering the outside of the ring with a non-sparking dead-blow mallet to further seat the ring. Continue tightening and hammering the ring until the torque stabilizes at 55 60 ft-lbs and does not decrease when further hammering on the ring circumference is performed. Ring ends must not touch. (Effective 25 September, 2006 and in accordance with CFR 178.2(c), we have revised this procedure to use torque as the most effective closure requirement.)
- 6. LOCK RING by tightening the nut against the unthreaded lug (see Fig. 6).



### OPEN HEAD DRUM - LEVERLOCK CLOSURE

- 1. CHECK GASKET to ensure cover gasket is properly fitted into cover groove (see Fig. 1 or 2).
- 2. PLACE COVER ON DRUM being careful to properly seat gasket around curl (see Fig 3).
- OPEN LEVERLOCK and place expanded ring on to the drum cover with the vertical-skirt hugging the drum body (see Fig. 7).
- 4. CLOSE LEVERLOCK by slowly and <u>cautiously</u> pulling the LEVERLOCK so that the outer ring engages the cover / body juncture. Downward pressure along with tapping the outside of the ring may assist in an even closure (see Fig. 8).
- **5. ENGAGE LOCK** to complete closure.





Figure 7 – Expanded ring being placed on drum

Figure 8 - Lever being closed slowly

## DRUMS WITH FITTINGS

- CHECK GASKETS and ensure gasket is properly seated on plug.
- 2. TIGHTEN to specifications listed in the table, and do not cross thread.

| PLUG TYPE    | Tri-Sure style |                |                                 | Rieke style<br>(Plastic) | Rieke style<br>(Steel) |            |
|--------------|----------------|----------------|---------------------------------|--------------------------|------------------------|------------|
| GASKET TYPES | Buna           | Poly or Teflon | PE / PP<br>(Composite<br>Drums) | _                        | Poly                   | All Others |
| ¾" PLUG      | 12 ft-lbs      | 20 ft-lbs      |                                 | 9 ft-lbs                 | 20 ft-lbs              | 15 ft-lbs  |
| 2" PLUG      | 20 ft-lbs      | 30 ft-lbs      | 10 ft-lbs                       | 20 ft-lbs                | 40 ft-lbs              | 30 ft-lbs  |

### **IMPORTANT NOTES:**

- 1. Closure Instructions Rev. D are valid to close all product tested with and / or manufactured under Closure Instructions Rev C. & Rev. B. Revisions are clerical and do not effect the actual closing of product.
- 2. A drum is properly closed only when all steps are completed in the matter and sequence indicated. If difficulties are encountered, do not ship the drum call Skolnik for further instruction.
- 3. Under the applicable DOT regulations, any changes made to the method of closure or closure components constitute a change in the design type of this packaging, and invalidates the certification.
- 4. After filling and prior to transport, the shipper should verify the torque of all closures to determine if the effects of heating and cooling or gasket relaxation have resulted in the need to re-tighten the closure.
- **5.** Drums (other than the composites) are tested at room temperature.