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ASSEMBLY INSTRUCTIONS
FOR CLOSURES
OF
STEEL, PLASTIC, FIBER DRUMS
AND
X RATED CUBIC YARD BOXES

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PACKAGING NOTIFICATION

PACKAGING MANUFACTURES ARE REQUIRED BY CODE OF FEDERAL REGULATIONS (CFR), TITLE 49 TRANSPORTATION, PARTS 100 TO 177 AND 178 TO 199, TO NOTIFY THEIR CUSTOMERS OR DISTRIBUTORS IN WRITING OF ANY REQUIREMENT NOT MET AT THE TIME OF TRANSFER, OR STEPS THAT THE USER MUST TAKE (SUCH AS THE PROCEDURE FOR CLOSING A PACKAGING AFTER FILLING) AND THE TYPE AND DIMENSIONS OF ANY CLOSURE, INCLUDING GASKETS, NEEDED TO SATISFY PERFORMANCE TEST REQUIREMENTS.

178.2 (C) NOTIFICATIONS ①

...THE MANUFACTURER OR OTHER PERSON CERTIFYING COMPLIANCE WITH THE REQUIREMENTS OF THIS PART, **AND EACH SUBSEQUENT DISTRIBUTOR OF THAT PACKAGING SHALL—**

- (1) NOTIFY IN WRITING EACH PERSON TO WHOM THAT PACKAGING IS TRANSFERRED—
 - (i) OF ALL REQUIREMENTS IN THIS PART NOT MET AT THE TIME OF TRANSFER, AND
 - (ii) OF THE TYPE AND DIMENSIONS OF ANY CLOSURE, INCLUDING GASKETS, NEEDED TO SATISFY PERFORMANCE TEST REQUIREMENTS.
- (2) RETAIN COPIES OF EACH WRITTEN NOTIFICATION FOR AT LEAST ONE YEAR FROM DATE OF ISSUANCE; AND
- (3) MAKE COPIES OF ALL WRITTEN NOTIFICATION AVAILABLE FOR INSPECTION BY A REPRESENTATIVE OF THE DEPARTMENT.

OVERVIEW OF THE HAZARDOUS MATERIALS REGULATIONS

THE CODE OF FEDERAL REGULATIONS (CFR) IS A CODIFICATION OF THE GENERAL AND PERMANENT RULES OF THE FEDERAL GOVERNMENT, WHICH IS PUBLISHED IN THE FEDERAL REGISTER. THE CODE IS DIVIDED INTO 50 TITLES THAT REPRESENT BROAD AREAS SUBJECTED TO FEDERAL REGULATIONS. EACH TITLE IS DIVIDED INTO CHAPTERS THAT USUALLY BEAR THE NAME OF THE ISSUING AGENCY. EACH CHAPTER IS FURTHER SUBDIVIDED INTO PARTS COVERING SPECIFIC REGULATORY AREAS.

HAZARDOUS MATERIALS REGULATIONS (HMR) GOVERN THE SAFETY ASPECTS OF TRANSPORTATION OF HAZARDOUS MATERIALS IN COMMERCE. THE HAZARDOUS MATERIALS REGULATIONS ARE ADMINSTRATED BY THE DEPARTMENT OF TRANSPORTATION (DOT), AND ARE FOUND IN THE CODE OF FEDERAL REGULATIONS (CFR), TITLE 49 - TRANSPORTATION, PARTS 100 TO 177 AND 178 TO 199. THESE REGULATIONS CONTAIN DETAILED INSTRUCTIONS ON HOW HAZARDOUS MATERIALS HAVE TO BE IDENTIFIED, PACKAGED, MARKED, LABELED, DOCUMENTED, AND PLACARD. SHIPMENTS NOT IN COMPLIANCE WITH THE APPLICABLE REGULATIONS MAY NOT BE OFFERED OR ACCEPTED FOR TRANSPORTATION.

WITHIN THE REGULATORY PROCESS, THE CFR IS USED TO DETERMINE PACKAGING THAT CAN BE USED FOR SHIPPING REGULATED PRODUCTS, SUCH AS FLAMMABLE, TOXIC, AND CORROSIVE PRODUCTS.

THE GENERAL REQUIREMENTS IN TITLE 49 CFR 173.24 AND THE TEST REQUIREMENTS OUTLINED IN TILE 49 CFR 178.601 ARE INTENDED TO ENSURE THAT PACKAGING CONTAINING HAZARDOUS MATERIALS CAN WITHSTAND THE NORMAL RIGOROUS CONDITIONS OF TRANSPORTATION.

THE TEST REQUIREMENTS IN TITLE 49 CFR 178.601 ARE MINIMUM REQUIREMENTS. EACH PACKAGING MUST BE MANUFACTURED AND ASSEMBLED TO SUCCESSFULLY PASS THE PRESCRIBED TEST AND CONFORM TO THE GENERAL REQUIREMENTS OF TITLE 49.

IT IS RESPONSIBILITY OF THE PERSON OFFERING A HAZARDOUS MATERIAL FOR TRANSPORTATION TO ENSURE THAT SUCH PACKAGING ARE COMPATIBLE WITH THEIR LADING AND COMPLY WITH THE STANDARDS AND TEST REQUIREMENTS IN CFR.

THE D.O.T. MONITORS ALL CONTAINER MANUFACTURES AND SHIPPERS OF HAZARDOUS MATERIALS. MANUFACTURES AND SHIPPERS ARE ROUTINELY INSPECTED FOR COMPLIANCE IN SUCH AREAS AS RECORD KEEPING AND CONTAINER PERFORMANCE.

IF A SHIPMENT IS FOUND WITHIN THE TRANSPORTATION SYSTEM NOT TO BE IN COMPLIANCE WITH THE APPLICABLE REGULATIONS, IT WILL BE DELAYED. **IN ADDITION, NON-COMPLIANCE WITH THE APPLICABLE REGULATIONS CAN SUBJECT THE SHIPPER, FORWARDER, AND CARRIER, AS APPROPRIATE, TO *CIVIL PENALTIES* - FINES UP TO \$25,000 PER VIOLATION^② OR *CRIMINAL PENALTIES* - FINES, IMPRISONMENT UP TO FIVE (5) YEARS, OR BOTH.**

A **CIVIL PENALTY** IS GENERALLY IMPOSED WHEN HAZARDOUS MATERIALS REGULATIONS ARE NOT FOLLOWED. THIS CAN RESULT WHEN SOMETHING IS NOT DONE THAT THE REGULATIONS REQUIRE TO BE DONE, SUCH AS MARKING THE PROPER SHIPPING NAME ON A PACKAGING, OR WHEN SOMETHING IS DONE THAT THE REGULATIONS PROHIBIT, SUCH AS PUTTING A PLACARD ON A VEHICLE THAT DOES NOT CONTAIN HAZARDOUS MATERIALS.

A **CRIMINAL PENALTY** IS IMPOSED WHEN THE HAZARDOUS MATERIALS REGULATIONS ARE VIOLATED INTENTIONALLY. A TYPICAL VIOLATION WOULD BE OFFERING A HAZARDOUS MATERIAL PACKAGING REQUIRING A POISON LABEL FOR SHIPMENT WITHOUT THE LABEL BECAUSE THE CARRIER WILL NOT ACCEPT POISON LABELED PACKAGES.

② 107. 329 (a), CODE OF FEDERAL REGULATIONS (CFR), TITLE 49 - TRANSPORTATION, PARTS 100 TO 177

③ 107.333 CODE OF FEDERAL REGULATIONS (CFR), TITLE 49 - TRANSPORTATION, PARTS 100 TO 177

PERFORMANCE ORIENTED PACKAGING SELECTIONS

PERFORMANCE ORIENTED PACKAGING DESCRIBES MINIMUM PERFORMANCE LEVELS A PACKAGING MUST ACHIEVE. THE PERFORMANCE LEVEL REQUIRED IS BASED ON THE HAZARDOUS MATERIAL TO BE PACKAGED. THE SELECTION OF A PACKAGING MUST ALSO BE BASED ON CHEMICAL COMPATIBILITY.

THEREFORE, THE PACKAGING REQUIREMENTS FOR A HAZARDOUS MATERIAL ARE BASED ON THE FOLLOWING:

- THE CLASSIFICATIONS OF A PRODUCT INTO ONE OF THREE (3) DEGREES OF HAZARD.

PACKAGING GROUP I	STANDARD "X"	GREATER DANGER
PACKAGING GROUP II	STANDARD "Y"	MODERATE DANGER
PACKAGING GROUP III	STANDARD "Z"	LEAST DANGER

- THE SPECIFIC GRAVITY OF A PRODUCT.
- THE VAPOR PRESSURE OF A PRODUCT.
- AND THE CHEMICAL COMPATIBILITY OF A PRODUCT WITH ITS LADING.

SHIPPERS AND MANUFACTURES ARE JOINTLY RESPONSIBLE FOR PACKAGING DESIGNED CONSTRUCTION TO THE EXTENT THAT PACKAGING IS DETERMINED TO BE SUITABLE FOR ITS LADING AND THAT IT COMPLIES WITH THE STANDARD AND TEST REQUIREMENTS IN THE CFR.

5 GALLON

1A2/Y37/S

STEEL DRUMS OPEN HEAD

1. PLACE DRUM LID WITH GASKET AND SELECTED CLAMP BAND AS SUPPLIED ON THE TOP OPENING OF THE DRUM BODY.
2. FIRMLY PRESS LID ONTO TOP OPENING BY APPLYING DOWNWARD PRESSURE TO LID ABOVE DRUM SIDEWALL.
3. WHILE PRESSING DOWN ON LID ENGAGE LOCKING MECHANISM OF CLAMP BAND TO SECURE LID IN PLACE. MAKE SURE LOCKING MECHANISM IS COMPLETELY LATCHED.
4. VISUALLY INSPECT TO ASSURE THERE WAS NO MOVEMENT OF THE GASKET THAT WOULD PRODUCE A POOR SEAL.

5 GALLON

1A2/X36/S With Lug & Locking Ring Covers

1. LUG COVERS SHOULD BE CRIMPED SO THAT THE GASKET IS FULLY COMPRESSED AND THE CRIMP ANGLE IS 90° OR MORE. ALL THE LUGS ON THE COVER SHOULD MEET THE CRIMP ANGLE REQUIREMENT.

BOLT RINGS REQUIRED

IF THE APPROVED U.N. PERFORMANCE TEST CALLS FOR A BOLT RING APPLIED OVER A CRIMPED LUG COVER ON THE PAIL, THE NUT ON THE BOLT RING SHOULD BE TIGHTENED TO A MINIMUM OF 35 INCH/POUNDS.

STEEL DRUMS OPEN HEAD

9 GALLON	1A2/Y60/S			
10 GALLON	1A2/X70/S	1A2/Y1.2/100		
15 GALLON	1A2/X115/S			
20 GALLON	1A2/Y150/S			
30 GALLON	1A2/X205/S	1A2/X400/S		
55 GALLON	1A2/Y300/S	1A2/Y400/S	1A2/X400/S	1A2/Y1.2/100/S
83 GALLON	1A2/X435/S			
85 GALLON	1A2/X435/S			
110 GALLON	1A2/X435/S			

THE FOLLOWING PROCEDURE MUST BE FOLLOWED FOR A U.N. 1A2 DRUM WITH A HEAVY BOLT LOCKING RING AND COVER:

1. THE COVER IS PLACED UPON THE DRUM AND THE GASKET SHOULD SIT ON THE BEAD.
2. IF THE DRUM HAS A SIDE BUNG THIS SHOULD BE LINED UP WITH THE 3/4" BUNG LOCATED ON THE COVER.

GO TO NEXT PAGE FOR CORRECT CLOSURE TORQUES FOR PLUG/GASKET COMBINATIONS

3. THE HEAVY BOLT LOCKING RING IS THEN PLACED AROUND THE COVER SITTING SNUGLY OVER THE LID AND UNDER THE BEAD WITH THE LOCK POSITIONED UNDER ONE OF THE BUNGS IF SPECIFIED. PUT 5/8 X 4" BOLT THROUGH UNTHREADED LUG WITH JAM NUT THREADED ON BOLT BETWEEN LUGS OF THE CLOSING RING.
4. PRESSURE IS THEN APPLIED TO THE COVER (IF AVAILABLE A HEAD COMPRESSOR CAN BE USED) ON THE DRUM THROUGH A CYLINDER OF 4 INCHES UNDER 90 PSI OF PRESSURE. THIS ALLOWS THE HEAVY BOLT LOCK TO BE TIGHTENED. THE BOLT LOCK SHOULD BE PUT TOGETHER. TORQUE UP BOLT TO 45-55 FT./LB. USE RING GAP AS GUIDE. (1/4" TO 3/8") TAP RING TO ASSIST CLOSING PROCESS.
5. TIGHTEN BOLT UNTIL SPACE BETWEEN BOTH ENDS OF RING -
 - FOR STEEL DRUM THICKNESS MARKED ON BOTTOM OF DRUM:
1.3 OR 1.4 / 1.1 / 1.1 - 1/2 INCH OR LESS
 - FOR STEEL DRUM THICKNESS MARKED ON BOTTOM OF DRUM:
1.1/0.8/1/1 - 3/8 INCH OR LESS
6. LOCK 5/8" JAM NUT AGAINST UNTHREADED LUG OF CLOSING RING.
7. VISUALLY INSPECT TO ASSURE THERE WAS NO MOVEMENT OF THE GASKET THAT WOULD PRODUCE A POOR SEAL.

NOTE: IF A HEAD COMPRESSOR IS NOT AVAILABLE, START BOLT INTO LUG, ALTERNATE TAPPING OF RING WITH A Mallet AND DRIVING BOLT WITH WRENCH, UNTIL BOLT RING ENDS ARE WITHIN THE INDICATED DIMENSIONS

CORRECT CLOSURE TORQUES FOR PLUG/GASKET COMBINATIONS

TRI-SURE STEEL PLUG

GASKETS MADE OF RUBBER - BLACK BUNA, WHITE BUNA, BUTYL, WHITE NEOPRENE, VITRON, SILICONE & EPDM

3/4" 12 FOOT/POUNDS 2" 20 FOOT/POUNDS

GASKETS MADE OF POLYETHYLENE, IRRADIATED POLYETHYLENE & TEFLON

3/4" 20 FOOT/POUNDS 2" 30 FOOT/POUNDS

TRI-SURE ZINC CAST PLUG

GASKETS MADE OF RUBBER - BLACK BUNA, WHITE BUNA, BUTYL, WHITE NEOPRENE, VITRON, SILICONE & EPDM

3/4" 12 FOOT/POUNDS 2" 20 FOOT/POUNDS

GASKETS MADE OF POLYETHYLENE, IRRADIATED POLYETHYLENE & TEFLON

3/4" 20 FOOT/POUNDS 2" 30 FOOT/POUNDS

RIEKE STEEL PLUGS

GASKETS MADE OF RUBBER QUARTERMASTER HYCAR, WHITE BUNA, WHITE ASBESTOS, WHITE DAPON, EPT BLACK, EPT WHITE

3/4" 15 FOOT/POUNDS 2" 30 FOOT/POUNDS

GASKET MADE OF POLY SEAL (PLASTIC) IRRADIATED AND NON-IRRADIATED

3/4" 20 FOOT/POUNDS 2" 40 FOOT/POUNDS

STEEL DRUMS CLOSED HEAD

5 GALLON	1A1/Y1.2/100
15 GALLON	1A1/Y1.6/200
30 GALLON	1A1/Y1.6/200
55 GALLON	1A1/X1.2/300

TO CLOSE FITTING

1. INSERT AND TIGHTEN ALL FITTINGS INTO THEIR APPROPRIATE THREADED FLANGES UNTIL SNUG.
2. USING A TORQUE WRENCH, TIGHTEN EACH FITTING TO THE CORRECT TORQUE. SEE PRIOR PAGE FOR CORRECT CLOSURE TORQUES FOR PLUG/GASKET COMBINATIONS FOR TRI-SURE AND RIEKE. TORQUE'S ARE BASED ON CLOSURE MANUFACTURERS RECOMMENDATIONS.

**55 GAL STEEL CLOSED HEAD 6HA1/Y1.8/100
2" & 3/4" EMABOND FITTINGS, 3 WEEP HOLES**

TO CLOSE FITTING

1. INSERT AND TIGHTEN ALL FITTINGS INTO THEIR APPROPRIATE THREADED FLANGES UNTIL SNUG.
2. USING A TORQUE WRENCH, TIGHTEN EACH FITTING TO THE CORRECT TORQUE. SEE THE LIST BELOW FOR CORRECT TORQUES. TORQUE'S ARE BASED ON CLOSURE MANUFACTURERS RECOMMENDATIONS.
3. IF THIS IS AN OPEN HEAD DRUM, FOLLOW THE ADDITIONAL CLOSING INSTRUCTIONS FOR THE TOP HEAD.
4. DRUMS CLOSED IN THIS MANNER HAVE MET THE UN PERFORMANCE TEST REQUIREMENTS AS SPECIFIED IN THE CONTAINER MARKINGS.

FITTINGS	TORQUE
2"	20 (FOOT LBS)
3/4"	9 (FOOT LBS)

FIBER DRUM

3.0 GALLON FIBERPAK 1G/X30/S
3.5 GALLON FIBERPAK 1G/Y30/S
6.0 GALLON FIBERPAK 1G/X15/S
10.0 GALLON FIBERPAK 1G/Y30/S
16.0 GALLON FIBERPAK 1G/Y30/S

THE COVER SUPPLIED WITH THE DRUM MUST BE FASTENED IN PLACE BY AT LEAST TWO WRAPS OF 2" WIDE, STRONG, PRESSURE-SENSITIVE TAPE OF A TYPE AS NOTED BELOW, OR EQUIVALENT:

NET WEIGHT: LESS THEN 250 LBS 250 LBS OR MORE
TAPE TYPE: TESA TT 891-2 DUCT TAPE PERMACEL 167 FIBERGLASS REINFORCED TAPE

THE SHIPMENT OF HAZARDOUS MATERIALS IN THIS DRUM REQUIRES THE USE OF PLASTIC BAGS. IF THE BAG IS NOT SUPPLIED WITH THE DRUM, THE FILLER MUST SUPPLY A PLASTIC BAG.

3.5 GALLON RO-CON WITH 2 MIL P/E BAG 1G/Y55/S
8.5 GALLON RO-CON WITH 2 MIL P/E BAG 1G/Y55/S
16 GALLON RO-CON WITH 2 MIL P/E BAG 1G/X71/S
30 GALLON RO-CON WITH 2 MIL P/E BAG 1G/Y120/S

TO CLOSE:

1. TELESCOPING COVER MUST FIT SECURELY ON DRUM. COVER MUST BE PUSHED ONTO DRUM UNTIL THE TOP EDGE OF THE DRUM BODY TOUCHES THE INSIDE TOP OF THE COVER.
2. THE COVER MUST BE SECURED TO THE DRUM BODY USING ADHESIVE BACKED TAPE, AMERICAN TAPE CO. MODEL RG3, 3 INCH WIDE FIBERGLASS REINFORCED TAPE OR EQUIVALENT. THE TAPE MUST WRAP AROUND THE DRUM BODY TWO TIMES. PRESS AND RUB THE TAPE FIRMLY INTO PLACE AROUND THE ENTIRE DRUM.
3. DRUMS CLOSED IN THIS MANNER HAVE MET UN PERFORMANCE TEST REQUIREMENTS AS SPECIFIED IN THE CONTAINER MARKINGS.

20.0 GALLON LEVERPAK 1G/Y60/S
30.0 GALLON LEVERPAK 1G/Y60/S
55.0 GALLON LEVERPAK 1G/Y120/S

THE LEVER LOCKING CLOSURE SYSTEM USED ON THESE DRUMS MUST BE CLOSED WITH A COVER AS SPECIFIED ABOVE AND A TOGGLE ACTION LOCKING BAND, OF NOMINAL DIAMETER EQUIVALENT TO THAT OF THE DRUM, ALSO AS SPECIFIED ABOVE.

THE SHIPMENT OF HAZARDOUS MATERIALS IN THIS DRUM REQUIRES THE USE OF PLASTIC BAGS. IF THE BAG IS NOT SUPPLIED WITH THE DRUM, THE FILLER MUST SUPPLY A PLASTIC BAG.

30.0 GAL LIQUIPAK 1G/Y200/S

THE LEVER LOCKING CLOSURE SYSTEM USED ON THESE DRUM MUST BE CLOSED WITH A STEEL COVER, PLAIN FLAT, 24 GAUGE AND A TOGGLE ACTION LOCKING BAND, OF NOMINAL DIAMETER EQUIVALENT TO THAT OF THE DRUM.

THE SHIPMENT OF HAZARDOUS MATERIALS IN THIS DRUM REQUIRES THE USE OF PLASTIC BAGS. IF THE BAG IS NOT SUPPLIED WITH THE DRUM, THE FILLER MUST SUPPLY A PLASTIC BAG.

51.9 GALLON APAK 1G/Y60/S

THE COVER SUPPLIED WITH THE DRUM MUST BE FASTENED IN PLACE BY AT LEAST TWO WRAPS OF 2" WIDE, STRONG, PRESSURE-SENSITIVE TAPE OF A TYPE AS NOTED BELOW, OR

EQUIVALENT:

NET WEIGHT: LESS THEN 250 LBS

250 LBS OR MORE

TAPE TYPE: TESA TT 891-2 DUCT TAPE

PERMACEL 167 FIBERGLASS REINFORCED TAPE

THE SHIPMENT OF HAZARDOUS MATERIALS IN APAK DRUMS REQUIRES THE USE OF PLASTIC BAGS. IF THE BAG IS NOT SUPPLIED WITH THE DRUM, THE FILLER MUST SUPPLY A PLASTIC BAG.

**39.2 GALLON AAPAK 1G/Y60/S
65.3 GALLON AAPAK 1G/Y40/S**

END TAPE ONE END; GAFFER'S DUCT TAPE EQUIVALENT

THE SHIPMENT OF HAZARDOUS MATERIALS IN THIS DRUM REQUIRES THE USE OF PLASTIC BAGS. IF THE BAG IS NOT SUPPLIED WITH THE DRUM, THE FILLER MUST SUPPLY A PLASTIC BAG.

130.0 GALLON AAPAK 11G/Y/(MM)

END TAPE ONE END: CLAYFILLED BBM UN STAMP ON SIDEWALL.

THE SHIPMENT OF HAZARDOUS MATERIALS IN THIS DRUM REQUIRES THE USE OF PLASTIC BAGS. IF THE BAG IS NOT SUPPLIED WITH THE DRUM, THE FILLER MUST SUPPLY A PLASTIC BAG.

PLASTIC OPEN HEAD Mallet/Hammer Method
5 GALLON OPEN TOP 1H2/Y

A Mallet/Hammer can be used to install covers on open-head 5 gallon plastic pails. Check covers to be sure a gasket is installed. Place the cover on top of the pails and use a mallet or hammer. Hitting the cover on opposite sides to insure a uniform fit until the cover is all the way secured to the pail. Care must be taken not to damage the gasket on the lid in this method.

PLASTIC DRUM OPEN HEAD Twist Top
5 GAL OPEN TOP 1H2/Y28/S

1. LIFE LATCH CONTAINERS ARE CERTIFIED FOR UN PACKAGING PERFORMANCE ORIENTED PACKAGING AND IS MARKED WITH THE APPROPRIATE U.N. MARKINGS ON THE BOTTOM OF THE CONTAINER
2. THE LIFE LATCH PAIL MUST ALWAYS BE USED WITH THE LIFE LATCH LID TO MEET UN APPROVAL.
3. TO CLOSE THE CONTAINER, SEAT COVER ONTO TOP OF CONTAINER. TORQUE COVER SO THREAD CONTACT IS A FULL 180-DEGREE TURN.
4. APPROPRIATE MARKINGS MUST BE MAINTAINED SO THAT THE PRODUCT FILLED INSIDE THE LIFE LATCH PAIL MATCHES THE INTENDED HAZARDOUS COMMODITY RANKING WHICH UN CERTIFIED FOR THAT PACKAGE.

PLASTIC DRUMS OPEN HEAD WITH CLAMP BAND
16 GAL OPEN HEAD 1H2/Y100/S
30 GAL OPEN HEAD 1H2/Y200
55 GAL OPEN HEAD 1H2/Y140/S

1. PLACE DRUM LID WITH GASKET AND SELECTED CLAMP BAND AS SUPPLIED ON THE TOP OPENING OF THE DRUM BODY.
2. FIRMLY PRESS LID ONTO TOP OPENING BY APPLYING DOWNWARD PRESSURE TO LID ABOVE DRUM SIDEWALL.
3. WHILE PRESSING DOWN ON LID ENGAGE LOCKING MECHANISM OF CLAMP BAND TO SECURE LID IN PLACE. MAKE SURE LOCKING MECHANISM IS LATCHED.

POLY-OVERPACK® SALVAGE DRUM	
65 GALLON YELLOW	1H2/X200/S
95 GALLON YELLOW	1H2/X/295/S
95 GALLON GREEN	1H2/Y/318/S
110 GALLON YELLOW	1H2/X/295/S

LIMITATIONS:

1. DO NOT FILL CONTAINER ABOVE THE BOTTOM OF THE THREAD.
2. DO NOT PLACE MATERIALS INTO A POLY-OVERPACK® SALVAGE DRUM WHICH ARE INCOMPATIBLE WITH THE POLYETHYLENE.
3. GROSS PACKAGE WEIGHT OF THE POLY-OVERPACK® SALVAGE DRUM AND LID IS NOT TO EXCEED 650LBS. (295KILOGRAMS) FOR PACKAGING GROUP 1 MATERIALS. **NOTE:** THE TARE WEIGHT OF THE DRUM AND LID IS APPROXIMATELY 53 LBS.
4. NO FREE LIQUIDS ARE TO BE TRANSPORTED. THIS DRUM HAS BEEN QUALIFIED TO SHIP SOLIDS ONLY.
5. NOT APPROVED FOR AIR TRANSPORT.
6. DO NOT REUSE DRUM. SINGLE TRIP PACKAGING ONLY.

CLOSURE INSTRUCTIONS:

1. PLACE CONTENTS INTO DRUM. MAKE SURE TOP SEALING EDGE OF DRUM IS FREE FROM DEBRIS, CUTS OR GOUGES.
2. PLACE LID ONTO DRUM AND TWIST THE LID IN A CLOCKWISE DIRECTION TWO COMPLETE REVOLUTIONS UNTIL THE LID IS TIGHT. APPLY ADDITIONAL TORQUE TO CONTINUE TWISTING THE LID UNTIL THE ARROW ON THE SIDE OF THE LID MATCHED UP WITH THE ALIGNMENT BAR ON THE SIDE OF THE DRUM. IF THE ARROW WILL NOT MATCH UP SOME PORTION OF THE ALIGNMENT BAR, DO NOT SHIP THE DRUM.
3. THE CLOSURE PROCESS MAY BE PERFORMED BY HAND OR WITH THE USE OF A SUBSTRATE, SUCH AS A LONG 2' X 4' BOARD OR A SHOVEL HANDLE. THE SUBSTRATE SHOULD BE PLACED BETWEEN THE SLOTS ON THE LID TO ALLOW PROPER TORQUE TO TIGHTEN THE ARROW TO THE ALIGNMENT BAR.

NOTE: DO NOT EXCEED THE LIMITATIONS. DO NOT SHIP THE DRUM IF THE CLOSURE INSTRUCTIONS CANNOT BE PROPERLY PERFORMED.

PLASTIC DRUM CLOSED TOP

3 GALLON	3H1/Y1.8/100 JERICAN	
5 GALLON	1H1/Y1.8/170/S	
15 GALLON	1H1/X1.2/250	
30 GALLON	1H1/Y1.8/150	
55 GALLON	1H1/Y1.9/150/S	1H1/X1.2/250

FOR PROPER INSTALLATION OF THE SCREW CAP, THE MANUFACTURERS' RECOMMENDED TORQUE APPLICATION MUST BE UTILIZED. TO ENSURE PROPER TORQUE, A TORQUE WRENCH IS REQUIRED.

CLOSURE:

RIEKE FS-60...70MM SCREW CAP WITH FLEXSPOUT BODY AND CAP
RIEKE FS-70...70MM SCREW CAP WITH 3/4" THREAD REDUCER
RIEKE FS-80...70MM SCREW CAP WITH PLAIN CAP

CLOSURE DIMENSIONS:

	<u>HEIGHT</u>	<u>DIAMETER</u>
FS-60...	.985"	3.280"
FS-70...	.740"	3.280
FS-80...	.740	3.280"

CLOSURE GASKET:

EPDM-VITON

CAP/PLUG CLOSURE TORQUE:

MINIMUM 175 IN-LBS

TRI-SURE POLYETHYLENE NYLON PLUGS

RUBBER GASKETS - 3/4" 8 FOOT/POUNDS 2" 20 FOOT/POUNDS
POLYETHYLENE GASKETS - 3/4" 8 FOOT/POUNDS 2" 30 FOOT/POUNDS

TRI-SURE POLYETHYLENE PLUG, HIGH DENSITY

SELF SEALING NO GASKET REQUIRED - 3/4" 8 FOOT/POUNDS 2" 12 FOOT/POUNDS

RIEKE POLYETHYLENE POLYPROPYLENE NYLON

GASKETS MADE OF RUBBER WHITE BUNA, EPT BLACK, EPT WHITE DAPON -
3/4" 9 FOOT/POUNDS 2" 20 FOOT/POUNDS

RIEKE POLYETHYLENE POLYPROPYLENE NYLON

SELF SEALING NO GASKET REQUIRED - 3/4" 9 FOOT/POUNDS 2" 20 FOOT/POUNDS

CUBIC YARD BOX COMPLETE WITH PALLET AND LINER

11G/X/2045/1136 09-98

CLOSURE (TOP) - DUCT TAPE, MULTIPLE STRIPS (BAG AND BOX)