

# ACN-CLEVELAND, LLC

## CLOSURE NOTIFICATION ADVICE STEEL DRUMS

Pursuant to the requirements of the U.S. Department of Transportation at 49 CFR 178.2(c)(1), we hereby provide this notification of the closing method used for the containers sold to you. This method of closure should be used to ensure that your containers have been closed in the same manner as when they were initially tested. Under the applicable DOT regulations, any changes made to (a) the type, materials or dimensions of closures or (b) the method of closure **may constitute a change to the design type of these containers, voiding the UN certification we have marked on them.** If there are any questions regarding proper closing methods, please contact our Customer Service Department at 216-431-5346.

To include Questar part #'s as follows:

EDD317FE-A.C.N, EDD317FE, EDD317F, EDD317T

### TO CLOSE OPEN HEAD DRUMS:

1. Place cover on drum, using only the cover gasket we have supplied.
2. Snap the closing ring over the cover and the bead of the drum. Make sure the ring's lugs point down, toward the floor. Also, make sure that sufficient downward pressure is applied to the cover so that the bottom edge of the closing ring is fully engaged under the bottom edge of the drum bead.
3. Insert the bolt through the lug without threads. If your specifications included lock nuts, screw on the lock nut. Finally, screw the bolt into the threaded lug.
4. Tighten the bolt in the locking ring lugs, to 65 ft. lbs. of torque. **While tightening the bolt, pound the entire perimeter of the locking ring with either a non-sparking brass/beryllium or rawhide mallet until there is no further ring movement. Do not rely on wrench tightening to bring closure without pounding ring as stripping of nut and/or lug will occur.** Begin each pounding cycle 180° across the drum head from the locking ring lugs. Check to ensure that the ring is seated tightly against the bottom edge of the drum bead and cover. "Note: For UN drums which do not utilize a 12-gauge bolt ring tighten bolt to 10 ft. lbs. while pounding ring to minimize lug deformation. Bottom of ring should be snug against drum body.
5. If your specifications included lock nuts, the lock nut must be tightened against the threaded lug of the bolt ring - not against the unthreaded lug. Tighten lock nut to 25-30 ft. lbs. of torque. We advise all customers to recheck the torque on all fittings and bolts before your full container of product leaves your facility.

Drums closed in the above manner meet the UN performance-oriented packaging standards test requirements for the container markings shown on the drum.

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### TO CLOSE FITTINGS IN HEADS OR COVERS:

1. Insert and tighten all plugs into their appropriate threaded flanges until snug.
2. Using a torque wrench, tighten each fitting to the correct torque. See below for correct torques. Torques are based on the closure manufacturers' recommendations.

### REQUIRED TORQUE

SIZE & FITTING STYLE	STEEL PLUGS		NYLON OR POLY PLUGS	
	Buna Rubber Gasket	Poly Gasket	Buna Rubber Gasket	Poly Gasket
2" Rieke Type	30 ft. lbs.	40 ft. lbs.	20 ft. lbs.	20 ft. lbs.
3/4" Rieke Type	15 ft. lbs.	20 ft. lbs.	9 ft. lbs.	9 ft. lbs.
2" Trisure Type	20 ft. lbs.	30 ft. lbs.	20 ft. lbs.	30 ft. lbs.
3/4" Trisure Type	12 ft. lbs.	20 ft. lbs.	8 ft. lbs.	8 ft. lbs.

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