



FORM 501

Proper Closing of A Steel Drum

How To Close A Tight Head Drum

CHECK THE PLUGS TO MAKE CERTAIN THAT THE GASKET IS PROPERLY SEATED.

CAREFULLY SCREW IN THE PLUGS TO INSURE NO CROSS THREADING.

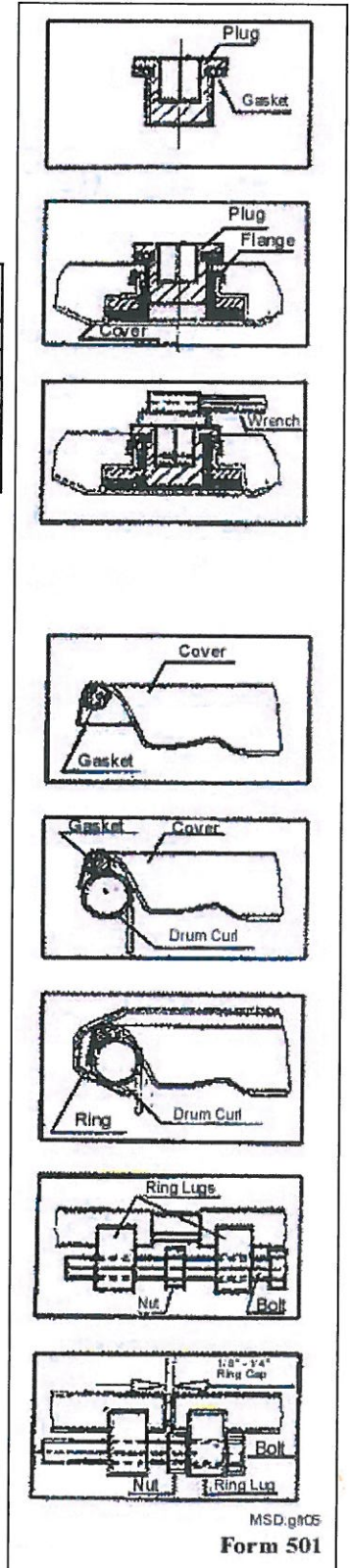
USING THE PROPER FT/LBS. TORQUE WRENCH, TIGHTEN THE PLUGS TO THE RECOMMENDED TORQUE. INSTALL CAP SEAL IF REQUIRED.

TORQUE SPECIFICATION CAN ALSO BE OBTAIN FROM THE VENDOR

Technocraft (Tight Seal) 504-523-4785	
Steel	
3/4 Inch	2 Inch
7-14 Ft-lb's	8-14 Ft-lb's
Plastic	
3/4 Inch	2 Inch
8-12 Ft-lb's	10-20 Ft-lb's

Rieke Closures 260-925-3700		
Steel		
3/4 Inch	1-1/2" AG	2 Inch
15-20 Ft-lb's	Buna & EPDM	30-40 Ft-lb's
Plastic		Plastic
3/4 Inch	Poly Irr.	2 Inch
9-15 Ft-lb's	20-40 Ft-lb's	20 Ft-lb's

Tri-Sure Closures 630-260-8643	
Steel	
3/4 Inch	2 Inch
8-15 Ft-lb's	15-22 Ft-lb's
Plastic	
3/4 Inch	2 Inch
8-11 Ft-lb's	15-22 Ft-lb's



How To Close An Open Head Drum

- A** INSTALLING ORIGINAL COVER, GASKET, PLUGS AND CLOSING RING IS IMPERATIVE TO MEET ALL MANUFACTURING CERTIFICATION AND DOT REQUIREMENTS. THIS IS CRITICAL NOT ALL DRUMS ARE THE SAME IN SIZE AND TOLERANCES. MISMATCH PARTS WILL VOID ANY MANUFACTURING CERTIFICATIONS AND CAUSE FAILURE IN THE FIELD
- B** INSPECT THE COVER GASKET. THE GASKET SHOULD BE SEATED PROPERLY IN ITS GROOVE ON THE COVER.
- C** CAREFULLY PLACE THE COVER ONTO THE DRUM CURL WITH OUT DISTURBING THE GASKET.
- D** INSTALL DRUM RING. ASSURING THE TOP AND BOTTOM EDGES OF RING CONTACT UPPER CURL OF COVER AND LOWER SECTION OF DRUM CURL, RESPECTIVELY.
- E** INSTALL THE BOLT AND NUT THROUGH THE RING LUGS.
- F** USE A PNEUMATIC IMPACT WRENCH OR OTHER DEVICE TO TIGHTEN THE BOLT. WHILE TIGHTENING RING, USING A MINIMUM 24oz. HAMMER OR COMPARABLE DEVICE, START BRISKLY TAPPING THE RING AT THE OPPOSITE POSITION (BACK) OF BOLT ALTERNATE FROM SIDE TO SIDE, WORKING FROM BACK SIDES TOWARD THE BOLT.
- G** **FOR NEW DRUMS ONLY** WHILE TAPPING THE CLOSURE RING, TORQUE THE BOLT TO 65-70 FT/LBS.
- H** CHECKING CLOSING RING GAP. **NEW DRUMS ONLY**, RING GAP MIN 1/8" MAX 1/4" **RECONDITION DRUMS ONLY**, CLOSURE RING GAP MIN 1/32" MAX 5/8" THE EDGE OF RINGS SHOULD NOT TOUCH.
- I** REPEAT STEPS E & F MINIMUM OF 3 TIMES.
- J** SECURELY TIGHTEN THE JAM NUT TO THE HEAD SIDE OF THE BOLT.

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