



Form Date: Sept. 1, 2004
Rev.: A (10-26-11)
Prepared By: P. Strauss

**ASSEMBLY INSTRUCTIONS FOR
CLOSURE OF STEEL CONTAINERS
USING A FORGED LUG CLOSING RING**

PARTS LIST:

- 1.0 Drum Body
- 2.0 Cover with Gasket
- 3.0 Closing Ring
- 4.0 Bolt
- 5.0 Jam Nut (If Supplied)

1.0 OPEN HEAD CONTAINER

- 1.1 Place contents into the container per applicable filling specification.
- 1.2 Place the cover on the container.
- 1.3 Place the closing ring around the cover and container curl.
 - 1.3.1 Assure the ring lugs face in a downward position.
 - 1.3.2 Place the bolt through the non-threaded lug and thread into the threaded lug.
 - 1.3.2.1 If jam nut is supplied, place nut on bolt before threading the bolt into the threaded lug and tighten against non-threaded lug.
 - 1.3.3 While tightening the bolt, tap the ring in several locations with a rubber mallet to assure the ring is set.



PACKAGING SPECIALTIES, INC.

- 1.3.4 Torque the bolt to a minimum of 40 ft. lbs.
 - 1.3.5 Visually inspect to assure there was no movement of the gasket which would produce a poor seal.
 - 1.4 If any components are missing or damaged, or if further instruction is desired, notify the supplier for proper replacement or instruction.
 - 1.5 Any substitution or deviation from this procedure will negate the certification.
-

PMWI005

Pg. 2 of 2



PACKAGING
SPECIALTIES, INC.

CERTIFICATION OF CONFORMANCE

CUSTOMER: QUESTAR, INC.

CONTRACT/PURCHASE ORDER NUMBER: 6021590

PACKAGING SPECIALTIES, INC. ORDER NUMBER: 1025471

SPECIFICATION: U.N. TESTING, PARA. 6.1.5, REV. 10

PACKAGING SPECIALTIES, INC. PART NO.: 300042SD11BC

CUSTOMER PART NUMBER: N/A

We hereby warrant and certify the referenced containers were manufactured and tested in accordance with:

U.N. TESTING, PARA. 6.1.5, REV. 10

Copies of relevant documentation are on file at Packaging Specialties, Inc. and shall remain on file for a period of seven years.

PACKAGING SPECIALTIES, INC.

Philip Strauss, Q.A. Manager

Date

PQAF008