

CLOSURE INSTRUCTIONS

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

OPEN HEAD DRUM - BOLT RING CLOSURE

- CHECK GASKET** – to ensure cover gasket is properly fitted into cover groove (see Fig. 1 or Fig. 2).
- PLACE COVER ON DRUM** – being careful to properly seat the 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 non-sparking dead-blow mallet to further seat cover and drum curl into the inner channel of the ring.
- 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".
- 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.
- LOCK RING** – by tightening the nut against the unthreaded lug (see Fig. 6).

OPEN HEAD DRUM - LEVERLOCK CLOSURE

- CHECK GASKET** – to ensure cover gasket is properly fitted into cover groove (see Fig. 1 or Fig. 2).
- PLACE COVER ON DRUM** – being careful to properly seat the gasket around curl (see Fig. 3).
- OPEN LEVERLOCK** – and place the expanded ring on to the drum cover with the vertical-skirt hugging the drum cover with the
- CLOSE LEVERLOCK** – by slowly and cautiously 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 and Fig. 9).
- ENGAGE LOCK** – to complete closure (see Fig. 10).

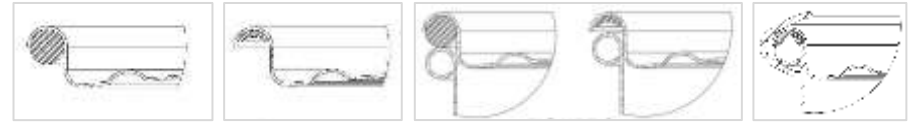


Fig. 1

Fig. 2

Fig. 3

Fig. 4

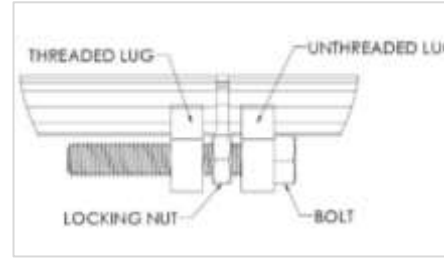


Fig. 5 (Photo & Sketch)

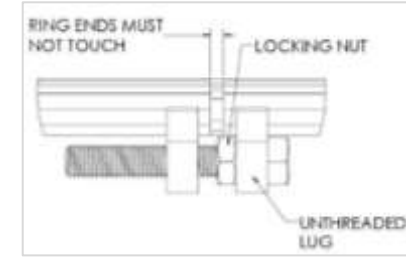


Fig. 6 (Photo & Sketch)



Fig. 7



Fig. 8



Fig. 9



Fig. 10

DRUMS WITH FITTINGS

- CHECK GASKETS** – and ensure gasket is properly seated on the plug.
- TIGHTEN** – to specifications listed in the table (right). Do not cross thread.

PLUG TYPE	Tri-Sure or Tite Seal Type			Rieke Style (Plastic)		Rieke Style (Steel)
	Buna/EPDM	Poly, Poly Irradiated (PI) or Teflon	PE / PP (Composite Drums)	—	Poly or Poly Irradiated (PI)	All Others
¾" PLUG	12 ft-lbs	10 ft-lbs	10 ft-lbs	9 ft-lbs	20 ft-lbs	15 ft-lbs
2" PLUG	20 ft-lbs	18 ft-lbs	10 ft-lbs	20 ft-lbs	40 ft-lbs	30 ft-lbs

IMPORTANT NOTES:

- Closure Instructions Rev. F. are valid to close all product tested with and / or manufactured under Closure Instructions Rev. E., Rev. D, Rev. C. & Rev. B. Revisions are clerical and do not affect the actual closing of product.
- Closure Instruction Rev F. Replace: PQ VOL01 Closure instructions for VOL drums, PQ 081ALDR. Revisions are clerical and do not affect the actual closing of product
- 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 Industries for further instruction.
- 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.
- 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.
- Drums (other than the composites) are tested at room temperature.