



B. Stephen Cooperage, Inc.

CLOSURE INSTRUCTIONS FOR IBC

In accordance with the Department of Transportation Title 49, Code of Federal Regulations (49 CFR), container manufacturers are required to notify each person to whom the container is transferred of all requirements not met at the time of transfer and of all the necessary materials and procedures to prepare the containers that when closed for shipment are capable of meeting the performance standards indicated by the UN marking on the side of the container.

The following instructions and guidelines are given to purchasers of containers made or re-manufactured by our company in accordance with the requirements of 49 CFR 178.2c and 178.601b.

IBC Closing Statement

All IBC's should be closed after filling and before transportation in accordance with the recommended plug cap torque as stated below.

Correct Closing Torque For 6" and 9" Caps

<u>Cap Type</u>	<u>Gasket</u>	<u>Tightening Torque</u>
6" Polyethylene	EPDM	54 FT. LB
6" Polyethylene	VITON	58 FT. LB
9" Polyethylene	EPDM	60 FT. LB.

<u>Cap/2" Plugs</u>	<u>Gasket</u>	<u>Tightening Torque</u>
2" Polyethylene	EPDM	20 FT. LB.
	Santoprene Rubber	20 FT. LB.
	Polyethylene	20 FT. LB.

Unit of Measurement

FT. LB. = Foot Pound Torque
1 FT. LB. = .7736 Joule/M (Newtons)