



B. Stephen Cooperage, Inc.

CLOSURE INSTRUCTIONS FOR POLY DRUMS

DOT Required Notification Statement

The DOT's Hazardous Materials Regulations (HM-181) requires that manufacturers of the packaging for hazardous material notify their customers in writing of:

- 1) Any packaging specification requirements that are not met when the empty packages are shipped, and
- 2) Information on closures needed to satisfy the performance test requirements.

The following NOTIFICATION STATEMENT is intended to comply with the regulatory requirement.

TIGHTHEAD PLASTIC DRUMS

- Openings in Tighthead plastic drums **MUST BE FITTED WITH BUNGS** bearing National Pipe Thread (NPS) and/or American Buttress (BTR) threads [Rieke ## PPA55-2 (2" NPS), PPS 53-b-5 (2" BTR), or PPA 11 (3/4" NPS), or equivalent.]
- **BUNGS MUST BE FITTED WITH GASKETS** appropriate to the bung size and design [Rieke ## G93 (2"EPT) and g91 (3/4" EPT) or equivalent.]
- **BUNGS MUST BE PLACED INTO THE APPROPRIATE OPENINGS AND TIGHTENED** to a torque level of 25 lb-ft for 2" tamperproof bungs, 20 lb-ft for other 2" bungs, and 9 lb-ft for all 3/4" bungs.
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OPENHEAD PLASTIC DRUMS

- **COVERS** supplied with the drums **MUST BE ATTACHED TO THE DRUMS WITH LEVER-ACTION**, as supplied with the drums.
- For drums with bolt ring, insert the bolt through the lug without threads. Next, screw on the locking nut. Finally, screw bolt into the thread lug. A: Torque 60 ft, - lbs.
- **WITH BUNGS** bearing NPS threads [Rieke # PPA 51(2" NPS) or equivalent], **WHICH MUST BE TIGHTENED** to a torque level of 15 lb-ft.
- Gaskets are not required on closures intended for use on drums for the packaging of dry products.