



B. Stephen Cooperage, Inc.

CLOSURE INSTRUCTIONS FOR TIGHT HEAD STEEL DRUMS

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.

Closed Top Steel Drums with Fitting

In order that the reconditioned drum supplied to you performs to the UN designation specified and your contents are packaged in a safe and responsible manner the following closure instructions need to be specifically followed. The substitution and use of any other drum components (rings, gaskets, or fittings) not supplied with this product, or the use of any other method of assembly or closure is not recommended since it may negatively affect the performance of your drum.

1. Insure gaskets are flat and properly seated against the base of the fitting. This will assist in maintaining gasket integrity.
2. Gently screw in fitting (to avoid cross threading) until fitting is snug.
3. Using a torque wrench, tighten each fitting to the torque below.

Fitting type	Trisure©			Rieke©		
	Steel		Poly	Steel		Poly
Fitting Material	Rubber	Poly	12	Rubber	Poly	20
Size of fitting						
2"	20	22	12	30	40	20
¾"	12	18	5	15	20	9

All measurements are in foot-pounds