



**B. Stephen Cooperage, Inc.**

**CLOSURE INSTRUCTIONS FOR OPEN HEAD STEEL DRUMS**

Pursuant to the requirements of the Department of Transportation in CFR 49 Part 178.2 (c)(1), this is your notification of the closing method used for the containers sold to you on the attached delivery ticket or bill of lading. This method of closure should be used to ensure that your containers have been closed in the same manner as when they were initially tested. If there is any question regarding proper closing methods, contact your B. Stephen Cooperage Inc. salesperson or manufacturing facility.

**OPEN HEAD DRUM ASSEMBLY:**

1. Place cover on drum
2. Snap the closing ring over the cover and top lip of the drum. Make sure the ring’s lugs point down below the ring. Also make sure the bottom edge of the closing ring engages under the lip of the drum.
3. 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.
4. While tightening the bolt, tap the entire perimeter of the ring with a mallet, starting directly across from the bolt.
5. Tighten bolt until snug. The cover and ring should not spin but the free ends of the rim should not touch.
6. Locking procedure:
  - a. Tighten locking nut against lug without threads. This prevents the bolt from backing out of closing ring. On rings supplied with a jam nut between the lugs, tighten the nut securely against the unthreaded lug. The closing ring ends should not touch when the ringbolt has been full torqued.
  - b. **Rings supplied without a jam nut may look very similar to those supplied with a jam nut. However, these are not interchangeable.** It is important that jam nuts not be used with rings for which they are not supplied. Thread the bolt into the ringnut and tighten until the threaded portion is through the nut. The smooth unthreaded portion will not engage the threads and tightening stops at the prescribed gap.

**Drums closed in this manner have met the UN performance test requirements as specified in the container markings.**

**FITTING INSTALLATION:**

1. Insert and tighten all fittings into their appropriate threaded flanges until snug.
2. Using a torque wrench, tighten each fitting to the correct torque. See the list below for correct torque. Torques are based on closure manufacturers recommendations.

TRISURE				RIEKE		
STEEL PLUGS		POLY PLUGS		STEEL PLUGS		POLY PLUGS
PLUG SIZE	POLY GASK	OTHER GASKE		POLY GASKE	OTHER GASKETS	
2"	30	20	30	40	30	20
3/4"	20	12	12	20	15	9