

**Closure Systems Components**

**1A2 Open Head Drum Closure Procedure**

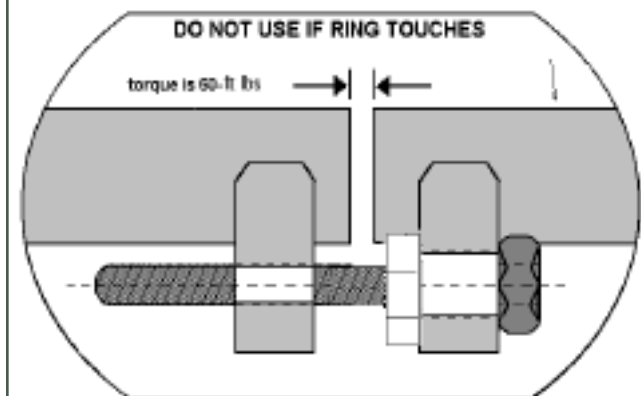
To ensure compliance to the UN marking, the filler must inspect and re-tighten as necessary all applicable closures prior to shipping.

Damaged gaskets (either on the plugs for 1A1 and 1A2 drums or the cover on 1A2 drums) must be replaced prior to shipment. Damage includes, but is not limited to, tearing, twisting, or deterioration.

This Procedure is for new steel drums manufactured by Myers Container and drums reconditioned by CMS, LLC only!

**Do Not Mix Different Drum Manufacturers Components**

For drums manufactured / re-manufactured by others suppliers, consult your specific supplier for torque and closing requirements.



1. Inspect gasket for proper seating and remove any residue from curl prior to cover installation.
2. Place the cover on the drum, making sure the cover gasket is seated against the lip of the drum opening (the curl) and the gasket recess on the cover. The gasket should not protrude beyond the cover or the drum curl.
3. Place the bolt ring onto the drum. Make sure that the bolt ring is oriented so that the lugs are positioned below the top surface of the drum. You will be required to pound on the cover with a rubber or other non-sparking mallet, or use a head press to make sure it is centered on the drum curl. Check to see that the cover and drum curl are pinched together and within the recess of the ring.
4. Thread the jam nut onto the bolt and then into the threaded lug, and tighten the bolt to 60 ft-lb of torque. Hammer around the circumference of the ring while torquing in order to further seat the head onto the drum. Continue hammering on the ring circumference and torquing the bolt until the torque is stabilized at 60 ft-lb, and does not loosen when further hammering on the ring circumference is performed. Tighten the jam nut against the unthreaded lug, (unless using a shoulder bolt where jam nut is not required). The ring ends must not touch when the ring has been torqued. It is the shipper responsibility to verify that the container has been properly closed prior to shipping.

**It is the shipper responsibility to verify that the container has been properly closed to shipping**



**Routing Instructions:** This document must be passed along with the container within your facility, or to whom the packaging is transferred, and ultimately to the personnel responsible for shipping and closure. It must be used as a training document to complete closure of your container.

- For 7A/Type A tested packages – please refer to the test document for additional requirements
- In order for your Myers Container or Container Management Services, LLC drum to safely perform to its rated ability, these assembly instructions must be strictly adhered to. Any other method of assembly will immediately invalidate the UN and DOT performance rating of the drum.
- The shipper must verify the appropriate use of a liner. A liner which extends between the gasket and the curl may only be used if UN Performance tests indicate a liner was used in testing.

**BUNG CLOSING PROCEDURES - 1A1 and 1A2( when fittings are present)**

1. Inspect all bungs to ensure gaskets are in place and not twisted or damaged
2. Insert all bungs and hand thread in a clockwise direction until hand tight. Do Not cross thread
3. Utilizing a CALIBRATED TORQUE WRENCH confirm and/or torque all bungs to required minimum specification. Do not over tighten. **All measurements are in foot pounds.**
4. Wipe clean any spillage or debris.
5. If required, apply applicable cap seals.

**Note:**The format of this instruction has changed, closure methods used to qualify the drums have not changed.  
 As tested torque settings are listed. Acceptable range +10% / -0%

Plug Types	Type 1: Octagon with Round Thread Bung					Type 2: Serrated Base, Hexagon Bung			
	Steel	Steel	Poly or Nylon	Poly or Nylon	Self-Gasketing Polyethylene	HDPE	Steel	Steel	Nylong
Plug Material	Steel	Steel	Poly or Nylon	Poly or Nylon	Self-Gasketing Polyethylene	HDPE	Steel	Steel	Nylong
Gasket Type	Rubber	Poly	Poly	Rubber	Integral (Gasket)	Rubber	Rubber	Poly	Rubber
2" Plug	20	30	20	20	12	15	30	40	20
3/4" Plug	12	20	8	8	5	8	15	20	9