

**Our Vision Is To Be Our Customers Preferred Container Supplier**



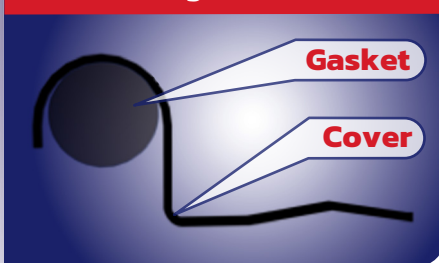
## **Steel Drum Closure & Assembly Instructions**

In compliance with DOT 49 CFR§178.2, persons shipping North Coast Container drums must comply with the following closure instructions.

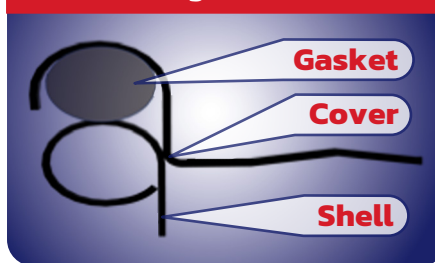
### **Bolt Ring Closure For Open Head Drums**

- 1 Check Gasket** to ensure the cover gasket is properly fitted into the curl of cover. **(Fig. 1)**
- 2 Place Cover On Drum** being careful to properly seat cover gasket all around the drum bead. **(Fig. 2 and Fig. 3)**
- 3 Attach Ring** (with ring lugs down) around the entire drum bead and cover. **(Fig. 4)**
- 4 Insert Bolt** through the unthreaded lug of the ring. Apply nut to bolt while tightening bolt through threaded ring lug. Continue to tighten the bolt until the ends of the ring are drawn to about a ½" gap. **(Fig. 5)**
- 5 Tighten The Bolt/Ring** with a calibrated torque wrench while applying downward pressure on the cover and striking around the ring with a non-sparking mallet. Continue to tighten the bolt to a 55 to 60 ft.-lbs. range without distorting the ring or stripping the bolt threads. Optimum final ring gap should be about ¼". Ring ends should never touch. **(Fig 6.)**
- 6 LOCK RING** by tightening the nut against the unthreaded lug. **(Fig 6)**

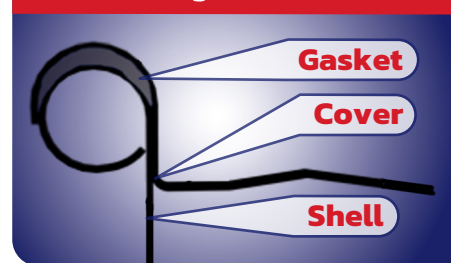
**Figure 1**



**Figure 2**



**Figure 3**



Please see page 2 for Figures 4-6 for Steps 3-6 of the Steel Drum Closure and Assembly Instructions document.

## Our Vision Is To Be Our Customers Preferred Container Supplier

### Plug/Gasket Tightening

Figure 4

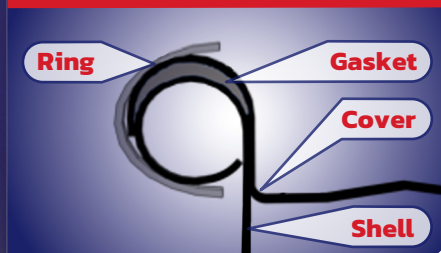


Figure 5

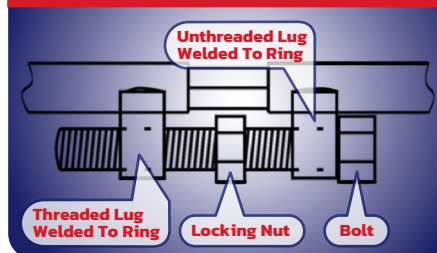
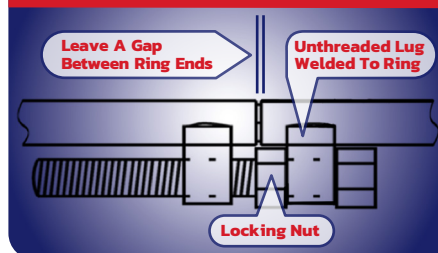


Figure 6



Tri-Sure Type	Gasket Type	$\frac{3}{4}$ " Closure	2" Closure
		Ft-lbs	Ft-lbs
Steel	BUNA	8-15	15-22
	All-Others	11-18	15-22
Plastic	BUNA	8-11	15-22
	All-Others	8-11	15-22

Reike Type	Gasket Type	$\frac{3}{4}$ " Closure	1 $\frac{1}{2}$ " Closure	2" Closure
		Ft-lbs	Ft-lbs	Ft-lbs
Steel	BUNA	14-17	27-33	27-33
	PE	18-22	36-44	36-44
	Papon or Visecar	14-17	27-33	27-33
Nylon	Poly	8-11	NA	18-22
	EPT or EPDM	8-11	NA	18-22

### Drums With Fittings

- 1 Check Gaskets** – and ensure the gasket is properly seated on the plug.
- 2 Tighten** – to specifications listed in the table, and do not cross thread.