

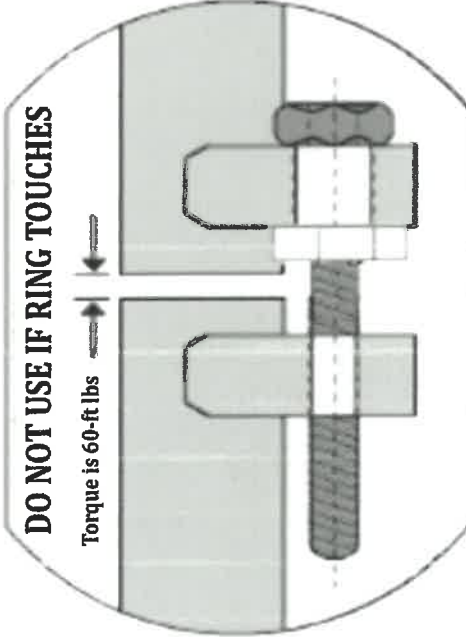
CLOSURE SYSTEM COMPONENTS

To ensure compliance to the UN marking, the filler must inspect and re-tighten as necessary all applicable closures prior to shipping. Damaged gaskets must be replaced prior to shipment. Damage includes, but is not limited to tearing, twisting, and deterioration.

This Procedure is for new steel drums manufactured by Myers Container and drums reconditioned/remanufactured 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



1A2 OPENHEAD DRUM CLOSURE PROCEDURE (5/8-inch Bolt)

1. Inspect gasket for proper seating and remove any residue from curl prior to cover installation.
2. Place the ring 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 ahead press to compress gasket. 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 jam nut onto bolt and then into threaded lug, and tighten bolt to 60 ft-lb of torque. Hammer around the circumference of the ring while torque is applied to further seat the head onto the drum. Continue hammering on the ring circumference and torque 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. The ring ends must not touch when 60 ft-lb of torque is applied.

It is the filler responsibility to verify that the container has been properly closed prior to shipping filled drums



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

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

4. Wipe clean any spillage or debris.
5. If required, apply applicable cap seals.

As tested torque settings are listed. Acceptable tolerance +/-2 ft-lbs

Plug Type	Type I Octagon Base With Round Threaded Bung				Type II – Serrated Base, Hexagon Bung			
	Steel	Poly	Poly or Nylon	Poly or Nylon	Steel	Poly	Nylon	Poly or Nylon
Plug Material	Steel		Poly or Nylon	Poly or Nylon	Steel		Nylon	Poly or Nylon
Gasket Type	Rubber		Rubber	Rubber	Rubber		Rubber	Rubber
2" Plug	20 ft-lb	13 ft-lb	20 ft-lb	20 ft-lb	30 ft-lb	40 ft-lb	20 ft-lb	20 ft-lb
3/4" Plug	16 ft-lb	16 ft-lb	9 ft-lb	9 ft-lb	15 ft-lb	20 ft-lb	9 ft-lb	9 ft-lb

For more information, contact your Account Manager or, call (800) 406-9377

www.myerscontainer.com