

Williamsport Steel Container Co., Inc.

STEEL DRUM CLOSING STATEMENT CFR 49 PART 178-178.2 (c) (1) NOTIFICATION

All steel containers should be closed after filling and before transportation in accordance with the tightening torque's in Appendix 1.

Containers fitted with crimped over seals over the closures will be fully torqued at the plant of manufacture.

APPENDIX 1

Closing Torques for Plug/Gasket Combinations

PLUG TYPE	GASKETS	Tightening Torque	
		¾" Dia Plugs	2" Dia Plug
Tri-Sure Steel	Rubber-Black Buna, White Buna, Butyl, White Neoprene, Viton, Silicone & EPDM	12 Ft. lbs	20 Ft lbs
	Polyethylene, Irradiated Polyethylene & Teflon	20 Ft. lbs	30 Ft lbs
Tri-Sure Polyethylene Polypropylene/Nylon	Rubber-Black Buna, White Buna, Butyl, White Neoprene, Viton, Silicone & EPDM	12 Ft lbs	20 Ft lbs
	Polyethylene, Irradiated Polyethylene & Teflon	8 Ft lbs	30 Ft lbs
Rieke Steel	Rubber-Quartermaster Hycar, White Buna, White Asbestos, White Dapon, EPT Wht&Black	15 Ft lbs	30 Ft lbs
	Poly Seal (Plastic) Irradiated & Non-irradiated	20 Ft lbs	40 Ft lbs
Rieke Polyethylene Polypropylene/Nylon	Rubber-White Buna EPT Black& White Dapon, Irradiated & Non-Irradiated	9 Ft lbs	20 Ft lbs

Open Head Containers

14" diameter, 16" diameter, 18 ¼" diameter

All Open Head containers should have the Locking Ring Bolt torque's checked after filling & before transportation in accordance with Appendix 2 Procedure for checking bolt tightening torque's:

- 1) Release the Jam Nut
- 2) Tighten the locking ring bolt to torque's stated in Appendix 2.
While torquing, bump the ring with a mallet directly opposite the lugs, and on both sides.
Note: Bump the ring at a 30-degree downward angle.
- 3) Retighten the Jam Nut to 20-25 Ft-lbs torque, against the unthreaded lug.

APPENDIX 2

Closing Torques for locking rings for 14", 16", 18 ¼" diameter drums

14" diameter rings	GASKET TYPES	BOLT TIGHTENING TORQUE
12 GA BOLT TYPE	Flow-in gaskets, 5/16 EPDM	45 Ft lbs.-Ring gap 1/8" to 5/8"
13 GA BOLT TYPE	Flow-in gaskets	35-40 Ft lbs-Ring gap 1/8" to 5/8"
13 GA BOLT TYPE	Neoprene, EPDM, & Tubular gaskets	35-40 Ft lbs-Ring gap 1/8" to 5/8"
18 GA BOLT TYPE	Flow-in gaskets	8-15 Ft lbs-Ring gap 1/8" to 5/8"
18 GA BOLT TYPE	Neoprene, EPDM, & Tubular gaskets	8-15 Ft lbs-Ring gap 1/8" to 5/8"
16" diameter rings		
	GASKET TYPES	BOLT TIGHTENING TORQUE
18 GA BOLT TYPE	Flow-in gaskets	8-15 Ft lbs-Ring gap 1/8" to 5/8"
18 GA BOLT TYPE	Neoprene, EPDM, & Tubular gaskets	8-15 Ft lbs-Ring gap 1/8" to 5/8"
18 ¼" diameter rings		
	GASKET TYPES	BOLT TIGHTENING TORQUE
12 GA FORGED LUG	3/8" square sponge 5/16" Round solid black rubber 3/8" Round White Tubular Neozan	30 to 35 Ft lbs Ring Gap 9/16" to ¼"
	Body Gasket EPDM Sponge Pinochio gasket	50 to 60 ft lbs 9/16" to 1/8"
16 GA BOLT RING	3/8" square sponge 3/8" round white tubular ½" Dia Tan sponge	15 Ft lbs Ring Gap 5/8" to 3/8"

Note: For Lever Locking rings; Rings should be closed securely and latched.
A stiff wire should be placed thru eyelet of latch and twisted for security purposes.

Revised 10/26/15