



MAUSER CORP.
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PLEASE GIVE THESE INSTRUCTIONS
TO THE PERSON RESPONSIBLE FOR
FILLING AND CLOSING THESE
CONTAINERS FOR SHIPMENT.

Rancho Cucamonga Plant Closure / Torque Instructions

In accordance with the Department of Transportation Title 49, Code of Federal Regulations (49 CFR), as of October 1, 1994 new packagings are to be made and marked in accordance with the UN performance oriented packaging standards as given in 49 CFR 1994 and as revised to date through rule-making published in the Federal Register.

The section of 49 CFR cited above requires plastic drum manufacturers to notify each person to whom the packaging is transferred of all requirements not met at the time of the transfer and of all necessary materials and procedures to prepare the drum so that when closed for shipment it is capable of meeting the performance standards indicated by the UN markings on the container.

The following instructions and guidelines are given to purchasers of plastic drums made by the Mauser Corporation in accordance with the requirements of 49 CFR 178.2 (c).

1 All non-removable head, UN 1H1 plastic drums supplied with plugs. Please locate the non-removable (tight head) drum by size, style, and filling type from the attached list and select the appropriate torque rating for your style of drum. Tighten all drum fittings to the appropriate rating using a pre-set torque wrench or a variable range torque wrench. Threads, both male and female should be dry and as free of moisture as possible before fitting is seated.

2 All removable head, UN 1H2, Plastic Drums (open heads) 49 CFR paragraph 178.509 (a) (2) of rated capacity 30 to 57 U.S. gallons supplied with plastic lids and gaskets plus associated clamp bands or locking rings must be closed for shipment using only the components supplied and specified in the design qualification tests according to the following instructions:

Closing Instructions for Mauser Corporation UN 1H2 Removable Head Plastic Drums. **(30 - 57 gallon)**

- 1 Place drum lid with gasket and selected clamp band as supplied on the top opening of the drum body.
- 2 Firmly press lid onto top opening by applying downward pressure to lid above drum side wall.
 - A FOR LEVER LOCK: Place lid on drum and place lever lock ring on drum and pull handle on ring to close. Ring is closed when handle is along contour of ring. NOTE: Make sure top lip of ring is over lid and the bottom lip of ring is under top lip of drum. Rotate locking tab thru window in end of handle until it is completely engaged. Make sure a locking device is placed into the opening to prevent premature release of the locking tab.
 - B FOR BOLT RING: Place lid on drum and place nut and bolt ring on drum and tighten bolt to close. Ring is closed when the end of the ring has a gap of 3/8" or less. NOTE: Make sure top lip of ring is over lid and the bottom lip of ring is under top lip of drum.
 - C LID CLOSURES: The plugs must be installed in the corresponding opening and tightened using a pre-set torque wrench or a calibrated machinists-type torque wrench to specified torque. See the attached list and select the appropriate torque rating for the plugs on your style of drum.

NOTE: 1) If drums are intended to be reused as defined in 49 CFR Para. 173.28 be advised that any replacement of parts such as gaskets and / or plugs is reconditioning according to this paragraph and drums for liquids are subject to the leak-proof test requirements unless reuse is in accordance with Para. 173.28 (b) (7).

2) Replacement of Mauser Corporation components listed above with different gaskets and / or plugs requires qualification testing as described in Para. 178.601 (g) to ensure that the drum can still meet the performance indicated by the UN marking.

3) If any special changes to the drums as supplied, such as vented closures authorized in accordance with 49 CFR Para. 173.24 (i) are required, please contact your Mauser Corporation sales representative for assistance.

NOTE: Plugs must be tightened to the correct torque using pre-set or variable range torque wrenches calibrated to indicated value after filling.



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Closure / Torque Instructions

Drum Configuration	*U/N MARK*	Torque (ft/lbs)
15 Gallon Delex Double Handle		
STD. Plugs (L10 & L16)	1H1/Y1.8/150/YR USA/M-4602/1.8MM	25
Heavy Wall (L10 & L10)	1H1/Y1.9/250/YR USA/M-4602/1.8MM	25
15 Gallon Commodity Single Handle		
2" & 3/4" NPS (L16 & C-34)	1H1/Y1.9/100/YR USA/M-4602/1.8MM	20 & 9
15 Gallon Commodity Single Handle Vented		
2" & 3/4" NPS (L16 or L16V & C-34 or C39-9)	1H1/Y1.4/100/YR USA/M-4602/1.8MM	20 & 9
15 Gallon Delex Double Handle Vented		
2" & 3/4" NPS (L16 or L16V & C-34 or C39-9)	1H1/Y1.4/100/YR USA/M-4602/1.8MM	20 & 9
30 Gallon L-1		
Standard Plugs (L10 & L16)	1H1/Y1.8/100/YR USA/M-4602/2.2MM	20 & 20
30 Gallon L-1 Vented		
Standard Plugs (L10 or L10V & L16 or L16V)	1H1/Y1.4/100/YR/ USA/M-4602/2.2MM	20 & 20
30 Gallon ACT Open Top		
Lid (SA-42) P-Ring	1H2/Y200/S/YR USA/M-4602/2.2MM	N/A
55 ACT II Standard		
Standard Plugs (SA10B & SA10B)	1H1/Y1.8/150/YR USA/M-4602/2.2MM	30

Drum Configuration	*U/N MARK*	Torque (ft/lbs)
55 ACT II - Standard Vented		
Standard Plugs (SA10B & SA10B and C39-9)	1H1/Y1.4/100/YR USA/M-4602/2.2MM	30 & 9
55 ACT II Heavy Wall		
Standard Plugs (SA10B & SA10B)	1H1/Y1.9/250/YR USA/M-4602/2.2MM	30
55 Gallon L-1		
Standard Plugs (L10 & L16)	1H1/Y1.8/100/YR	20 & 20
Double Buttruss (L10 & L10)	USA/M-4602/2.2MM	20 & 20
55 Gallon L-1 Vented		
Standard Plugs (L10 or L10V & L16 or L16V)	1H1/Y1.4/100/YR USA/M-4602/2.2MM	20 & 20
55 Gallon Delcon		
Flat Lid and Nut / Bolt Ring		<3/8" gap
Flat Lid and Ring	1H2/Y250/S/YR USA/M-4602/2.2MM	N/A
Bung Lid 2" & 3/4" NPS		20 & 9
57 Gallon R-S OH		
Bung Lid 2" & 3/4" NPS	1H2/Y200/S/YR USA/ M-4602/2.2MM	20 & 9
Lid and Ring		N/A
57 Gallon ACT Open Top		
Lid / (SA-42) P-Ring	1H2/Y380/S/YR USA/M-4602/2.2MM	N/A

United States Department of Transportation regulations state that packaging manufacturers are required to notify each person to whom the packaging is transferred of all requirements not met at the time of transfer. This requirement is given in Title 49, Code of Federal Regulations (49 CFR), Part 178 Specifications for Packagings, § 178.2 (c). In addition this Paragraph requires the closing information to be provided to any person to whom this package is transferred who may need to close the packaging prior to re-shipment. Furthermore, it is the shipper's responsibility as set forth in §173.22(a)(4) to ensure that these closing instructions are carried out as described. In order to ensure the instructions are followed in a manner to result in safe transport of hazardous materials the shipper is obligated, as set forth in § 172.704(a)(4), namely - function specific training - to train his/her employees in the correct way to close the packaging for shipment. In order to fulfill this obligation the shipper often turns to the packaging manufacturer for this training since the manufacturer has designed, produced and tested the packaging to meet UN performance standards. MAUSER is prepared to provide this training in addition to supplying closing instructions. It has been the practice of MAUSER to send closing instructions attached to the shipping documents with each shipment of drums. This document provides specific information on closing MAUSER packagings.

These closing instructions must be given to the individuals responsible for closing the packagings prior to shipment. Many companies use electronic copies as site specific work instructions and/or use laminated hard copies posted at the fill lines for reference by the fill line operators. A hard copy (printed) must be maintained by the filler or offeror for shipment.

The following tables and text give examples of the parts and closing torque required to prepare the drum for shipment so that it is capable of meeting the performance standards indicated by the UN marking on the side or top of the packaging. MAUSER recommends that only parts that have been tested and certified by MAUSER be used to close the packagings for shipment. Each closure is supplied with the proper gasket in accordance with the UN design type tests for the packaging supplied. In the case of removable head drums the lids, gaskets and locking rings are supplied as tested.

PRIOR TO CLOSING:

Inspect each closure to ensure that the closure has the proper gasket and that both closure and gasket are in good condition. Inspect the sealing surface for damage and make sure the threads and sealing surfaces are dry. Replace any defective gaskets, plugs or lids with new, defect free parts as sold with the original packaging.

CLOSING PROCEDURES FOR PLUGS AND CAPS:

The plug or cap is inserted into the appropriate opening and screwed down hand tight until the gasket is in contact with the sealing surface. A torque wrench capable of applying the proper torque to the fitting as specified by the closing instructions following is then used to tighten the plug or cap until it reaches the pre-set torque as indicated by a release or click. These wrenches should be calibrated at least annually.

PLASTIC NON-REMOVABLE HEAD DRUMS

All non-removable head, UN 1H1, Plastic Drums, 49 CFR § 178.509(a)(1), 15 gallon to 65 gallon nominal capacity supplied with plug or screw cap closures with gaskets must be closed for shipment using only the closures and gaskets supplied and specified in the design qualification test for the drum as indicated below:

Part Size / Part Number (Plug number with gasket)	Torque
A 2-inch buttress: L10 EPDM; L10B Buna; L10VT FPM	20-25 ft.-lbs.
B 2-inch NPS: L16 EPDM; L16B Buna; L16VT FPM; L16RVCLG	20-25 ft.-lbs.
C 2-inch buttress: L10V Vented EPDM; L10V-B Buna; L10V-VT FPM	20-25 ft.-lbs.
D 2-inch NPS: L16 Vented EPDM; L16V Buna; L16VT FPM	20-25 ft.-lbs.
E 2-inch NPS: L16RFCPP-RK faucet carrier with L12RPE-53RK	20-25 ft.-lbs.
F 2-inch NPS: L16R with L12EP	20-25 ft.-lbs.
G 2-inch ACT buttress: SA10B with A72	30-40 ft.-lbs.
H 3/4-inch NPS: C34 or C39 (S) AD with C31 EPDM; C31 Silicone	6-9 ft.-lbs.
I 2-inch Tamper-Evident: L10TEG-RK with L11EP-RK	25-30 ft.-lbs.
J 2-inch Tamper-Evident: L16TEG-RK with L12EP-RK	25-30 ft.-lbs.
K L10R-HD with L11F-HD; L16RHD	25-30 ft.-lbs.
L 70x6 BCS LR10W with LR11EP; 70x6 BCS LR10W with LR11VT	35-40 ft.-lbs.
M 56x4 BCS LR17 with LR12EP	20-25 ft.-lbs.

PLASTIC REMOVABLE HEAD DRUMS

	Part Size / Part Number (Plug number with gasket)	Plug Torque
A	Vanguard Lid with 2-inch Self-seal type NPS plug:	7-9 ft.-lbs.
B	Vanguard Lid with ¾ inch Self-seal type NPS plug:	5-7 ft.-lbs.
C	Standard lid with 2 inch NPS plug	15-20 ft-lbs
D	Standard lid with ¾ inch NPS plug	7-9 ft-lbs

1. All removable head, UN 1H2, Plastic Drums, 49 CFR § 178.509(a)(2), of nominal capacity 15 to 60 U.S. gallons supplied with plastic lids, gaskets and associated clamp bands, or locking rings, or bolt rings, must be closed for shipment using only the components supplied and specified in the design qualification tests according to the following installation instructions:

- Place drum lid with gasket and selected clamp band as supplied on the top opening of the drum body.
- Firmly place lid onto top opening by applying downward pressure to lid above drum sidewall.
- While pressing down on lid, engage locking mechanism of clamp band to secure the lid in place. Make sure the locking mechanism is completely latched. Insert locking tab into slots in lever lock handle.

2. Please note that the Vanguard 57 gallon HLR drum carries a liquid rating Y1.2/100 with a bolt ring or lever lock closure. This is valid when the lid is factory installed with a lid press. This drum should be filled through the 2-inch opening in the lid and closed as in the steps listed above. If the lid is removed the liquid rating is no longer valid unless a new lid is installed with a lid press and a MAUSER bolt ring or lever lock is used for closure.

3. The MAUSER removable head plastic drum may be provided with a bolt ring closing device. This bolt ring is closed as follows:

- Place lid with gasket in place, as supplied, on the curl at the top of the drum body.
- Place bolt ring around the drum head and curl.
- Using a head compressor, apply force to the top of the drum head assembly to compress head gasket.
- Drive bolt into ring until the ends of the bolt ring are at a 3/8-inch or less ring gap.
- If a head compressor is not available, start bolt into threaded eye, alternating tapping of ring with a mallet and drive bolt with a wrench, until bolt ring ends meet the above requirements.
- When ring has been tightened as required, the jam nut, if supplied, must be tightened against the left threaded eye.
- In the case of the Vanguard V57 HLR drum supplied with a bolt ring for liquid service, the bolt has no jam nut but uses a shoulder type bolt. Follow the previous steps to tighten the bolt until the shoulder meets the threaded eye.

Note: MAUSER uses various buttress and NPS plugs under the generic part numbers L10 and L16 respectively. They are supplied with the drum with gasket installed ready for final closing for shipment. The plug and gasket are specific to the drum as tested. Likewise the screw caps are supplied with gasket as tested. The closures must be properly installed and tightened to the torque shown or specified on the particular closing instructions for the drum supplied. Closures must be tightened to recommended torque using pre-set or variable-range machinist torque wrenches calibrated to the indicated value.