

**ACKNOWLEDGMENT  
OF RECEIPT OF  
NORTH AMERICA PACKAGING CORPORATION  
UN 1H1 AND 3H1 CLOSED-HEAD  
PACKAGING NOTIFICATION**

I acknowledge receipt of this manual for North America Packaging Corporation (NAMPAC). I understand that the material contained in this manual is provided as a courtesy for general information only, and it SHOULD NOT BE USED TO DETERMINE COMPLIANCE with the U.S. Department of Transportation hazardous materials regulations.

\_\_\_\_\_  
Signature Date

Please Print

\_\_\_\_\_  
Name

\_\_\_\_\_  
Title

\_\_\_\_\_  
Company

\_\_\_\_\_  
Street Address City State Zip Code

\_\_\_\_\_  
Mailing Address City State Zip Code

Please acknowledge receipt of this document to NAMPAC, Compliance Office.  
Fax# 317-387-0943  
Address: 6047 Guion Road, Indianapolis, IN 46254  
  
Retain a copy of this sheet for your records.

Thank You

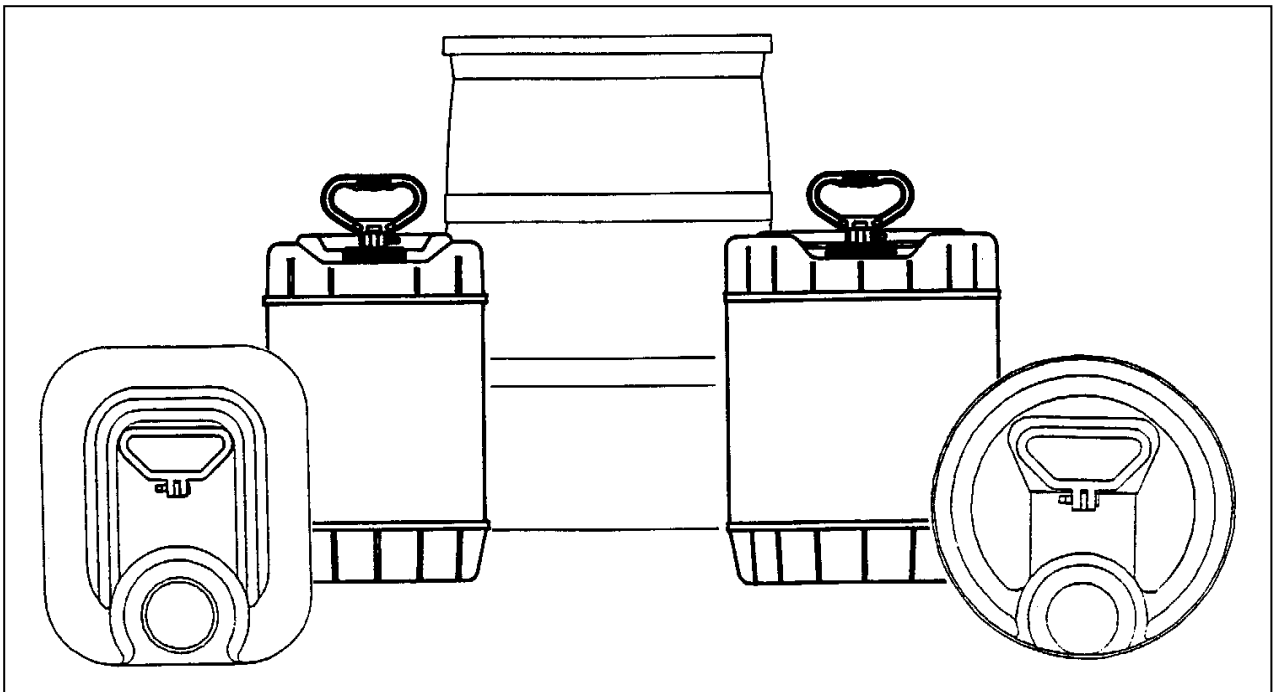


**North America Packaging Corporation**

# **UN 1H1 AND 3H1 CLOSED-HEAD PACKAGING NOTIFICATION**

**Revised 12/01/01**

*Name Change: from Southcorp to NAMPAC, Previous issue date 5/10/01*



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## NAMPAC UN PACKAGING NOTIFICATION

**Packaging manufacturers are required by the Code of Federal Regulations (CFR), Title 49-TRANSPORTATION, Parts 100 to 177 and 178 to 199, to notify their customers and distributors in writing of any requirement not met at the time of transfer, or steps that the user must take (such as the procedure for closing a packaging after filling) and the type and dimensions of any closure, including gaskets, needed to satisfy performance test requirements.**

Title 49 CFR 178.2

(c) Notification

...the manufacturer or other person certifying compliance with the requirements of this part, **and each subsequent distributor of that packaging** shall--

(1) Notify in writing each person to whom that packaging is transferred--

(i) Of all requirements in this part not met at the time of transfer, and

(ii) Of the type and dimensions of any closure, including gaskets, needed to satisfy performance test requirements.

(2) Retain copies of each written notification for at least one year from date of issuance; and

(3) Make copies of all written notification available for inspection by a representative of the Department.

## OVERVIEW OF THE HAZARDOUS MATERIALS REGULATIONS

The Code of Federal Regulations (CFR) is a codification of the general and permanent rules of the Federal Government, which is published in the Federal Register. The Code is divided into 50 titles that represent broad areas subjected to Federal Regulations. Each title is divided into chapters that usually bear the name of the issuing agency. Each chapter is further subdivided into parts covering specific regulatory areas.

Hazardous Materials Regulations (HMR) govern the safety aspects of transportation of hazardous materials in commerce. The Hazardous Materials Regulations are administered by the Department of Transportation (DOT), and are found in the Code of Federal Regulations (CFR), Title 49 - TRANSPORTATION, Parts 100 to 177 and 178 to 199. These regulations contain detailed instructions on how hazardous materials have to be identified, packaged, marked, labeled, documented, and placard. Shipments not in compliance with the applicable regulations may not be offered or accepted for transportation.

Within the regulatory process, the CFR is used to determine packaging that can be used for shipping regulated products, such as flammable, toxic, and corrosive products.

The general requirements in Title 49 CFR 173.24 and the test requirements outlined in Title 49 CFR 178.601 are intended to ensure that packaging containing hazardous materials can withstand the normal rigorous conditions of transportation. **The test requirements in Title 49 CFR 178.601 are MINIMUM REQUIREMENTS.** Each packaging must be manufactured and assembled to successfully pass the prescribed test and conform to the general requirements of Title 49.

**It is the responsibility of the person offering a hazardous material for transportation to ensure that such packaging are compatible with their lading and comply with the standards and test requirements in the CFR.**

The DOT monitors all container manufacturers and shippers of hazardous materials. Manufacturers and shippers are routinely inspected for compliance in such areas as record keeping and container performance.

If a shipment is found within the transportation system not to be in compliance with the applicable regulations, it will be delayed. **In addition, non-compliance with the applicable regulations can subject the shipper, forwarder, and carrier, as appropriate, to *Civil Penalties* - fines up to \$27,500 <sup>(1)</sup> per violation <sup>(2)</sup> OR *Criminal Penalties* - fines, imprisonment of up to five (5) years, or both.**

A **Civil Penalty** is generally imposed when hazardous materials regulations are not followed. This can result when something is not done that the regulations require to be done, such as marking the proper shipping name on a package, or when something is done that the regulations prohibit, such as putting a placard on a vehicle that does not contain hazardous materials.

A **Criminal Penalty** is imposed when the hazardous materials regulations are violated intentionally. A typical violation would be offering a hazardous material package requiring a POISON label for shipment without the label because the carrier will not accept POISON labeled packages.

(1) Title 49 CFR 107.329(a)

(2) Title 49 CFR 107.333

## PERFORMANCE-ORIENTED PACKAGING SELECTION

Performance Oriented Packaging describes minimum performance levels a packaging must achieve. The performance level required is based on the hazardous material to be packaged. The selection of a packaging must also be based on chemical compatibility.

Therefore, the packaging requirements for a hazardous material are based on the following:

- the determination of the hazard class of a product,

Packaging Group I	Great Danger	Standard "X"
Packaging Group II	Medium Danger	Standard "Y"
Packaging Group III	Minor Danger	Standard "Z"

- the specific gravity of a product,
- the vapor pressure of a product,
- and the chemical compatibility of a product with its lading.

**Shippers and manufacturers are jointly responsible for packaging design and construction to the extent that the package is determined to be suitable for its lading and that it complies with the standard and test requirements in the CFR.**

To determine if you may package your product in one of NAMPAC's closed-head containers, use the Packaging Selection Guide on page 10.

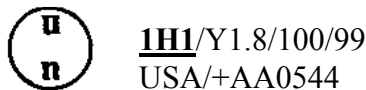
## UN MARKING DESCRIPTION

The following is an example of a typical NAMPAC UN Certification marking:

1. **UN INDICATION** - the package must be marked with the "UN Symbol" (the letter "u" over the top of the letter "n" inside a circle).



2. **PACKAGING IDENTIFICATION CODE** - The Packaging Identification Code consists of the type of packaging, material of construction, and a category within the type. A Number, such as the number 1 for a drum, will indicate the type of packaging. An Upper Case Letter, such as the letter H for plastic, will indicate the material of which the packaging is constructed. In some cases, such as drums and jerricans, there is a number which indicates the Category of a container within a certain type and material. In marking drums and jerricans, a closed-head container would be indicated by a 1, and an open-head container would be indicated by a 2 marked immediately after the code letter for the material of construction.



**1 = Drum (round in cross section)**

**H = Plastic**

**1 = Closed-head container**

### TYPE-MATERIAL-CATEGORY TABLE

<u>TYPE</u>	<u>MATERIAL</u>	<u>CATEGORY</u>
1 DRUMS	A STEEL	<u>A, B</u> OR <u>H</u> DRUMS-JERRICANS
2 BARRELS	B ALUMINUM	<u>1</u> CLOSED-HEAD <u>2</u> OPEN-HEAD
3 JERRICANS	C NATURAL WOOD	<u>A</u> OR <u>B</u> BOXES
4 BOXES	D PLYWOOD	<u>1</u> ORDINARY A OR B
5 BAGS	F RECONSTITUTED WOOD	<u>2</u> A OR B W/ INNER LINER OR COATING
6 COMPOSITE PACKAGINGS	G FIBERBOARD	<u>C</u> BOXES
7 PRESSURE RECEPTACLE	H PLASTIC	<u>1</u> ORDINARY <u>2</u> W/ SIFT-PROOF WALLS
	L TEXTILE	<u>H</u> BOXES
	M PAPER, MULTIWALL	<u>1</u> EXPANDED PLASTIC <u>2</u> SOLID PLASTIC
	N METAL, OTHER THAN STEEL OR ALUMINUM	<u>L</u> BAGS
	P GLASS, PORCELAIN, OR STONEWARE	<u>2</u> SIFT-PROOF
		<u>M</u> BAGS
		<u>2</u> MULTIWALL, WATER RESISTANT

3. **UN PACKING GROUPS/PERFORMANCE STANDARD CODES** - Dangerous goods are assigned to a Packing Group that indicates their relative degree of danger.

PACKING GROUP I	Great Danger
PACKING GROUP II	Medium Danger
PACKING GROUP III	Minor Danger

An upper case **X**, **Y**, or **Z** indicates the performance standard for which the package has been successfully tested.

X	Meets Packing Groups I, II, and III
Y	Meets Packing Groups II, and III
Z	Meets Packing Group III only

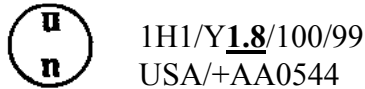


1H1/Y1.8/100/99  
USA/+AA0544

**Y = Medium Danger**

4. **SPECIFIC GRAVITY** - A number designating the Specific Gravity should come right after the Performance Standard Code. The specific gravity must be rounded down to the first decimal place for which the packaging has been successfully tested. For packaging intended to contain liquids, the Specific Gravity may be omitted when it does not exceed 1.2.<sup>(3)</sup>

A single or composite non-bulk packaging, that is tested and marked for liquid hazardous materials, may be filled with a solid hazardous material to a gross mass, in kilograms, not exceeding the rated capacity of the packaging in liters, multiplied by the Specific Gravity marked on the packaging or 1.2, if not marked.<sup>(4)</sup>



**1.8 = The product being packaged must not exceed 1.8 Specific Gravity.**

5. **HYDROSTATIC TEST PRESSURE IN KILOPASCALS (kPa)**

For a single or composite packaging, intended to contain liquids, the Hydrostatic Test Pressure in kilo-pascals (kPa), must be rounded down to the nearest 10 kPa for which the package has been successfully tested.



**100 = The vapor pressure of the product must conform to one of the following:**

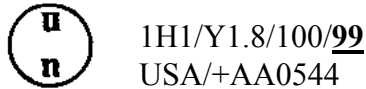
1. The vapor pressure must be such that the total pressure in the packaging (i.e., the vapor pressure of the liquid plus the partial pressure of air or other inert gases, less 100 kPa (15 psi)) at 55 degrees C (131 degrees F), determined on the basis of a maximum degree of filling, and a filling temperature of 15 degrees C (59 degrees F), will not exceed two-thirds of the marked test pressure.
2. The vapor pressure at 50 degrees C (122 degrees F) must be less than four-sevenths of the sum of the marked test pressure plus 100 kPa (15 psi).
3. The vapor pressure at 55 degrees C (131 degrees F) must be less than two-thirds of the sum of the marked test pressure plus 100 kPa (15 psi).<sup>(5)</sup>

(3) Title 49 CFR 178.503(a)(4)(i)

(4) Title 49 CFR 173.24a(b)(3)

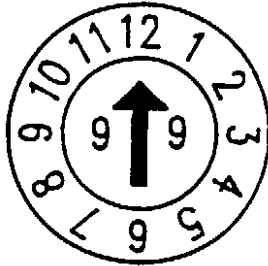
(5) Title 49 CFR 173.24a(b)(4)

6. **YEAR OF MANUFACTURE** - The last two digits of the year during which the packaging was manufactured must be marked next in the sequence.



**99 = The year package was manufactured.**

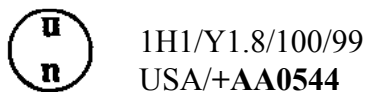
In addition, certain plastic packaging, such as the 1H1, 1H2, 3H1, and 3H2, must also be marked with the month that the packaging was manufactured, which may be marked on the packaging in a place that is different from the remainder of the markings. NAMPAC typically uses a month/year clock embossed on the bottom of our container.



7. **COUNTRY AUTHORIZATION MARK** - A code for the country of manufacture must be marked. Packaging tested, manufactured, and marked in the United States, must indicate the letters USA.



8. **IDENTIFICATION OF MANUFACTURER** - Packaging tested and marked under the authority of the United States must be marked with the Name and Address or Symbol of the manufacturer, or the approval agency certifying compliance with the requirements of Subparts L and M of Part 178 of 49 CFR. If a symbol is used, it must be registered in advance with the Associate Administrator of Hazardous Materials Safety.



**+AA0544 = Third-Party Certification (approval agency)**

## NAMPAC UN DESIGNATION DESCRIPTION

The designation markings of the NAMPAC UN 1H1/Y1.8/100/99/USA/+AA0544 represent the following:



United Nations Certified Packaging

1H1

Closed-Head Plastic Drum

Y

Meets UN Packaging Group II and III

1.8

Liquid with Specific Gravity that does not exceed 1.8

100

Capable of withstanding 100 kPa of Hydrostatic Pressure for 30 Minutes

99

Year of Manufacture

USA

Country of Manufacture

+AA0544

Third Party Certification

## USING THE UN PACKAGING SELECTION GUIDE

NAMPAC's Packaging Selection Guide is intended to assist our customers in determining the proper marking for their container and product.

To obtain the proper markings for your container, complete the enclosed data sheets and forward them to the NAMPAC Compliance Office (Engineering & Technical Service) for a determinization.

Please refer to the product Material Safety Data Sheet, an in-house chemist, a product specification sheet, the UN list of dangerous goods, and/or the Title 49 CFR Hazardous Materials Table to determine the following:

1. the proper **Product Name** and **Packaging Class**

Title 49 CFR 172.101 Hazardous Materials Table must be used to determine if the product to be packaged is classified as a Packaging Group II or III material.

2. the **Specific Gravity** of the product

OR

the **Package Gross Weight** (for solids) in kilograms

3. the **Vapor Pressure** of your product (for liquids)

Per Title 49 CFR 173.24a(b)(4), the product's Vapor Pressure at 55°C, must not exceed two-thirds of the sum of the marked test pressure plus 100 kPa.

4. A history of the product being packaged in high-density polyethylene must be established, or compatibility testing must be conducted. Use CFR 49, 173 Appendix B to make this determination.

In order to help you in determining your proper UN packaging requirements, assistance is available by contacting your NAMPAC Sales Representative or the Compliance Office.

## UN PACKAGING SELECTION GUIDE

For certification and testing, please send copies of the following pages to NAMPAC.

According to the Code of Federal Regulations, Title 49-TRANSPORTATION, 173.22(a), *it is the shipper's responsibility to determine which marking should be applied to his container.*

### **PRODUCT CLASSIFICATION**

NOTE: Product information may be found in the Title 49 CFR 172.101 Hazardous Materials Table.

- (1) I have met all the requirements for properly marking the container for shipment, as required in Title 49 CFR 173.22, "Shipper's Responsibility".

Company: \_\_\_\_\_  
Signature of Person Responsible: \_\_\_\_\_  
Date: \_\_\_\_\_

- (2) Hazardous Materials Description and Proper Shipping Name(s):  
(Column 2 of *Hazardous Material Table*)

\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_

- (3) Hazard Class/Division: \_\_\_\_\_  
(Column 3 of *Hazardous Material Table*)

- (4) UN Identification Number: \_\_\_\_\_  
(Column 4 of *Hazardous Material Table*)

- (5) Packaging Group (I, II, III): \_\_\_\_\_  
(Column 5 of *Hazardous Material Table*)

- (6) Label Required (Flammable, etc.) \_\_\_\_\_

- (7) Special Provisions: \_\_\_\_\_  
(Column 7 of *Hazardous Material Table*)

- (8) Packaging Authorization: Exceptions \_\_\_\_\_  
Non-Bulk Packaging \_\_\_\_\_

- (9) If all three Packaging Groups are listed in column 5, refer to Title 49 CFR 173.121 "Assignment of Packing Group" (e.g., Flammable Liquid Packaging Groups are determined by flashpoint).

Packing Group Assignment: \_\_\_\_\_

### **CONTAINER TESTING/MARKING INFORMATION**

NOTE: Container Testing/Marking information is available from a Material Safety Data Sheet, in-house chemist, or product specification sheets.

- (10) What is the Specific Gravity of your product?: \_\_\_\_\_

Note: Relative density equals Specific Gravity.

- (11) What is the Material Consistency of your product?: (Please check one)

\_\_\_\_\_ Viscous Liquid                  \_\_\_\_\_ Non-Viscous Liquid                  \_\_\_\_\_ Solid

### **LIQUIDS**

- (12) What is the Vapor Pressure of your product in kPa at 55°C?: \_\_\_\_\_ kPa

Note: 1) Vapor Pressure required for liquids only.

2) A 250 kPa minimum test pressure is required for all Packaging Group I (X) containers.

3) For additional information, please reference Title 49 CFR 173.24a(b)(4).

### **SOLIDS**

- (13) What is the Maximum Gross Mass, in kilograms, of your product being shipped?:  
\_\_\_\_\_ kg

### **TYPE OF CONTAINER**

- (14) Drum Style (Please check the following):

\_\_\_\_\_ Open Head                          \_\_\_\_\_ Tight Head

- (15) Drum Size (US gallons or Liters): \_\_\_\_\_

- (16) Fitting Required: \_\_\_\_\_

## PACKAGE COMPLETION INSTRUCTIONS FOR THE NAMPAC UN CLOSED-HEAD PACKAGE

### CLOSURE APPLICATION INSTRUCTIONS

Proper assembly of the fitting to the NAMPAC container opening is **absolutely essential** to the safe containment and transport of hazardous materials.

For proper installation of the screw-on cap, the certified torque application as tested must be utilized (*see table below for specific torque, note: this torque is based on the respective closure manufacture's recommendation*). To ensure proper torque, a torque wrench is required. Closures with the induction seal feature should be induction sealed after the closure is installed.

For proper installation of the crimp-on fitting, any of the manufacturers' recommended crimp tools must be utilized. For detailed installation instructions for the manual crimp tool, see our *"How to Properly Seat A Crimp-on Fitting into a NAMPAC Plastic Container."*

Automatic crimping tools are available. NAMPAC recommends contacting the manufacturer for set-up procedures, maintenance recommendations, and tooling specifications prior to the use of automatic equipment with a crimp-on fitting and the NAMPAC container.

The following packaging completion instructions describe the available closures, the dimension of each closure, the closure gasket, closing/crimp tools, and the proper closing torque.

For additional information and tool pricing, you should contact the respective closure manufacturers.

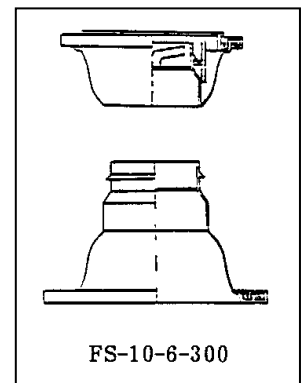
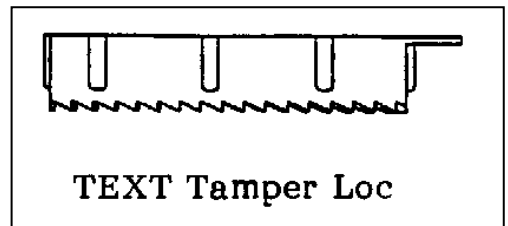
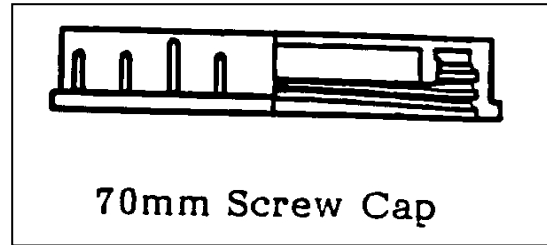
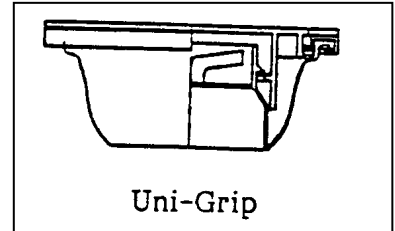
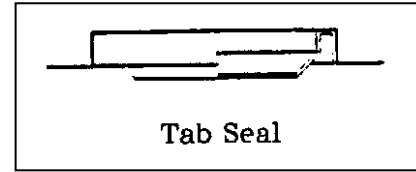
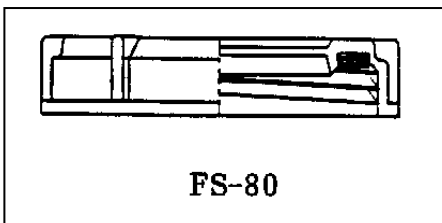
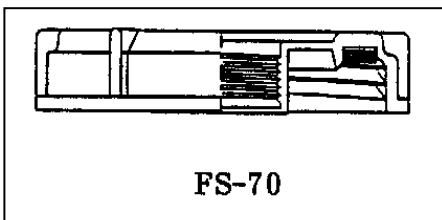
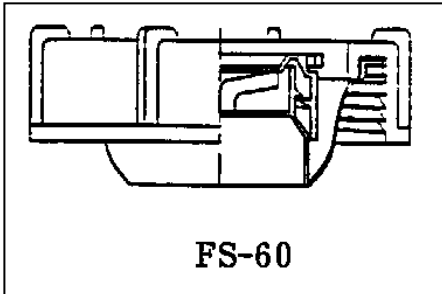
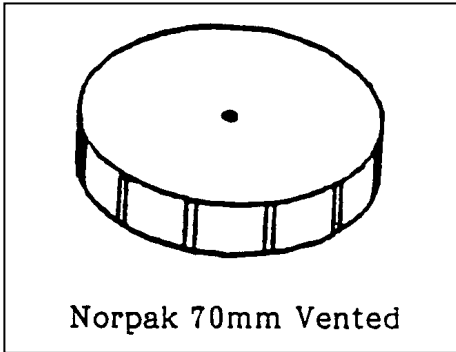
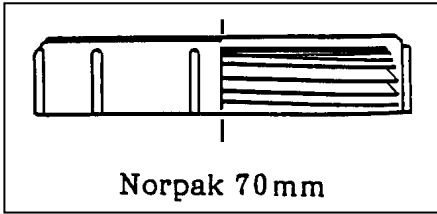
**CLOSURE TABLE**

Manufacturer	Model	Size (mm)	Description	Gasket Material	Height (in)	Diameter (in)	Torque (in-lb)
American Flange	Tri-Sure Tab Seal		Crimp-On with Steel Cap	EPT/EPDM	0.5469	2.8344	--
	Tri-Sure Uni-Grip		Crimp-On		23/64	2-51/64	--
Norpak/Norton	Norcap	70	Foam Lined	EPDM or SBR	0.586	2.926	75
	Norcap Vented		Foam Lined and Vented				
Republic	Comack	70	Screw Cap	EPT/EPDM	0.520	2.980	120
	Comack TEXT		Tamper Loc		0.700	3.080	120
Rieke	FS-550	50	Screw Cap Tamper Evident	EPT/EPDM	0.992	2.600	55
	SC63R	63	Screw Cap with 3/4" Thread Reducer	EPT/EPDM	0.887	2.725	100
	SC63R Vented		Vented Screw Cap with 3/4" Thread Reducer				
	FS-60	70	Screw Cap with Flexspout Body and Cap	EPT/EPDM	0.985	3.280	120
	FS-70		Screw Cap with 3/4" Thread Reducer		0.740	3.280	120
	FS-70 Vented		Vented Screw Cap with 3/4" Thread Reducer				
	FS-80		Screw Cap with Plain Cap				
	FS-80 Vented		Vented Screw Cap with Plain Cap				
	FS-80-T		Screw Cap Tamper Evident		0.906	3.309	120
	FS-10-6-300		Crimp-On Flexspout with Tear-Away Tamper-Evident Seal and Buna Vent	EPT/EPDM	1.20	2.295	--
	FS-10-6-624		Crimp-On Flexspout with Plain Tamper-Evident Seal				
	FS-10-8V-300		Crimp-On Flexspout with Tear-Away Tamper-Evident Seal				
	PPA-53-B-5		Buttress-Thread 2" Plug	EPT/EPDM	1.006	2.855	20
PPA-53-B-5-T		Buttress-Thread 2" Tamper Loc Plug	1.149		3.309	20	
PPA-57-B-5-T		Buttress-Thread 2" Tamper Loc Plug	1.173		3.309	25	
Thoroughbred Plastics	Thoro-Ban	28	Threaded Vent Closure with PE Foam Liner Tamper Evident		0.790	1.253	25
Wheaton		18	Threaded Vent Closure with PE Foam Liner		0.431	0.844	Hand tight
			Threaded Vent Closure with Induction Seal and PE Foam Liner				

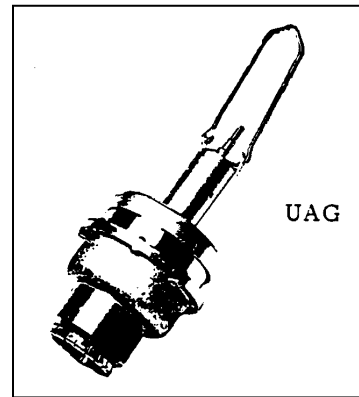
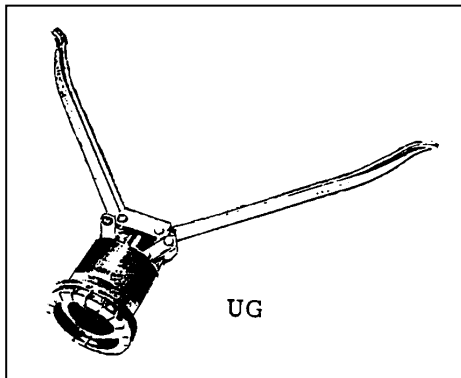
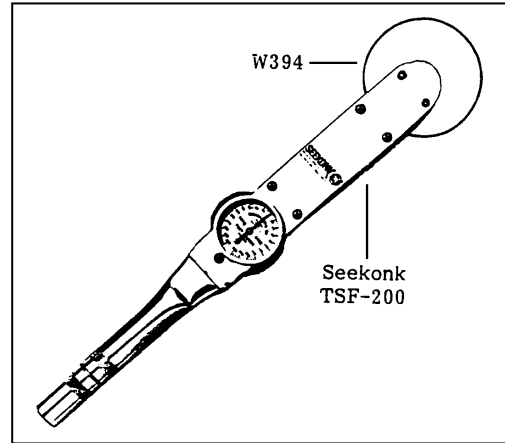
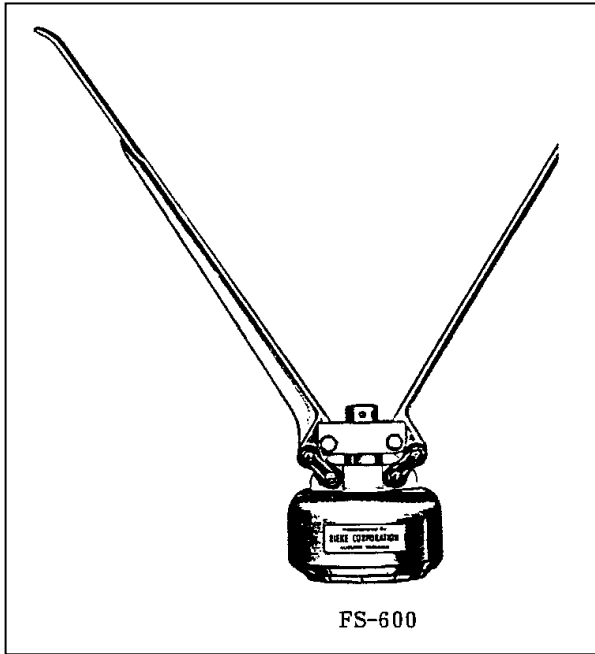
**CLOSURE TOOL TABLE**

Closure Manufacturer	Closure Types	Closure Size (mm)	Closure Tool Model	Closure Tool Description
American Flange	Tri-Sure Tab Seal		UG	Manual Crimping Tool
	Tri-Sure Uni-Grip		UAG	Pneumatic Crimping Tool
Norpak/Norton	Norcap	70		Seekonk Torque Wrench (Gauge) or Equivalent with Rieke Cap Wrench Adapter, W394; or contact your Norpak/Norton representative for equivalent adapter
	Norcap Vented			
Republic	Comack	70		Seekonk Torque Wrench (Gauge) or Equivalent with Rieke Cap Wrench Adapter, W394; or contact your Republic representative for equivalent adapter
	Comack TEXT			
Rieke	FS-550	50		Seekonk Torque Wrench (Gauge) or Equivalent with Rieke Cap Wrench Adapter
Rieke	SC63R	63		Seekonk Torque Wrench (Gauge) or Equivalent with Rieke Cap Wrench Adapter
	SC63R Vented			
Rieke	FS-60	70		Seekonk Torque Wrench (Gauge) or Equivalent with Rieke Cap Wrench Adapter, W394
	FS-70			
	FS-70 Vented			
	FS-80			
	FS-80 Vented			
FS-80-T				
Rieke	FS-10-6-300		FS-600	Manual Flexspout Crimping Tool
	FS-10-6-624		IA-FS-600	Airmatic Flexspout Crimping Tool
	FS-10-8V-300		HFS-600	Airdraulic Flexspout Crimping Head and Hose
Rieke	PPA-53-B-5			W-168PT 20/9 Pre-set Torque Wrench
Rieke	PPA-53-B-5-T			W-126PT-04 Pre-set Torque Wrench
	PPA-57-B-5-T			
Thoroughbred Plastics	Thoro-Ban	28		Seekonk Torque Wrench (Gauge) or Equivalent with Wrench Adapter

# CLOSURE ILLUSTRATIONS

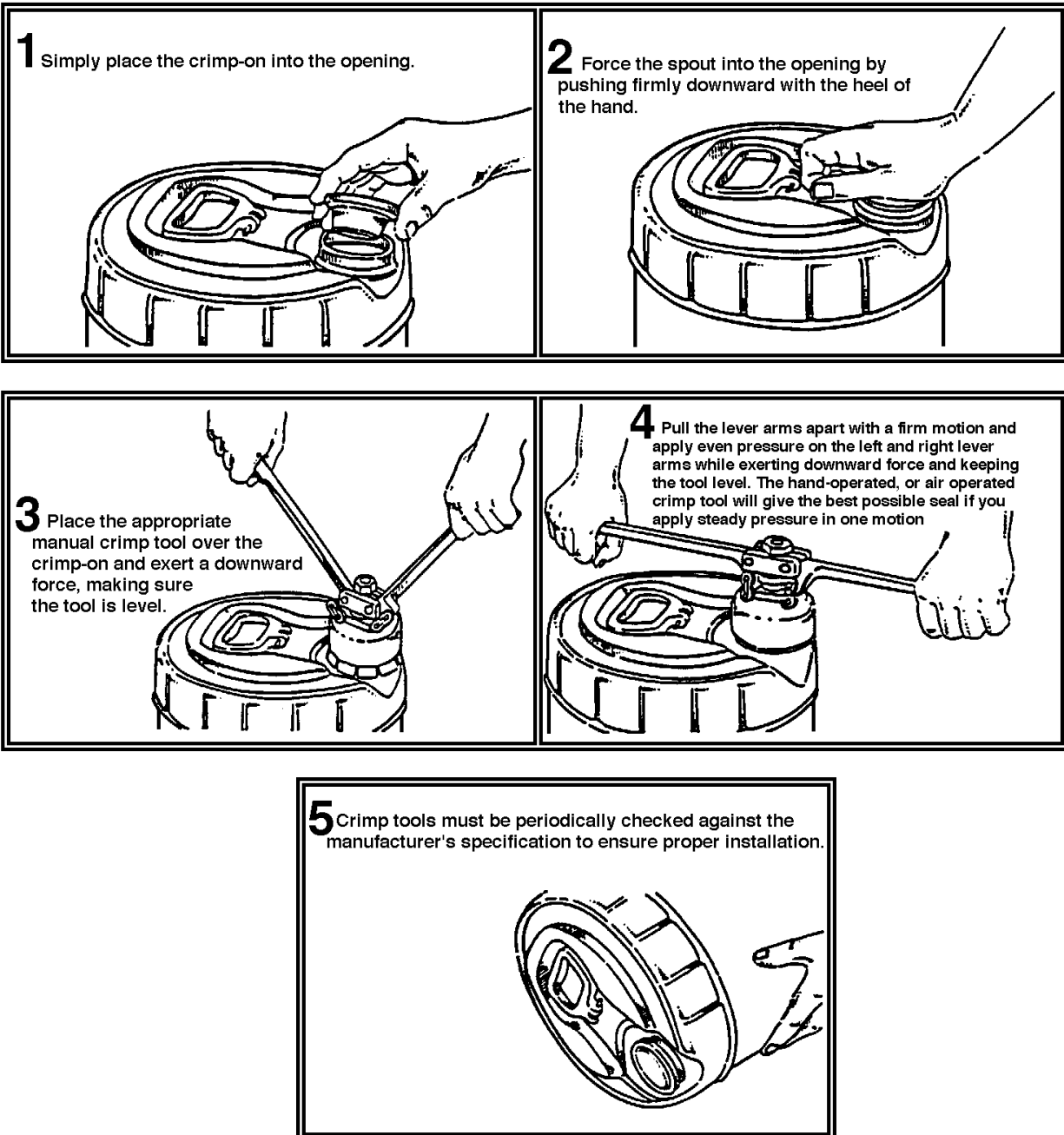


# CLOSURE TOOL ILLUSTRATIONS



## PROPER SEATING OF A CRIMP-ON FITTING

NOTE: The proper seating (assembly) of the crimp-on fitting to the NAMPAC container is absolutely essential to the safe containment and transport of hazardous materials. The following procedure should be used for proper seating.



## NORTH AMERICA PACKAGING CORPORATION - LOCATIONS

<u>CORPORATE HEADQUARTERS:</u>	4101 Lake Boone Trail, Suite 201 Raleigh, NC 27607 919-791-2380	
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<b>MANUFACTURING SITES:</b>		
<u>CALIFORNIA:</u>	620 South Wanamaker Road Ontario, CA 91761 909-937-7599	M-5398
<u>GEORGIA:</u>	6134 Industrial Blvd. Toccoa, GA 30577 706-886-7414	M-4201
	2160 Lithonia Industrial Blvd. Lithonia, GA 30058 770-482-7318	M-4367
<u>INDIANA:</u>	6061 Guion Road Indianapolis, IN 46254 317-297-4638	M-4200
	4002 Montdale Dr. Valparaiso, IN 46383 219-462-8915	M-4604
<u>NEW JERSEY:</u>	7 Wheeling Rd. Dayton, NJ 08810 609-860-0337	M-4202
<u>OHIO:</u>	12735 Kirby Rd. Cleveland, OH 44108 216-249-4700	M-2040
<u>PUERTO RICO:</u>	Road 172 km 13.4 Cidra, PR 00739 787-739-7401	M-4198
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*For more information on NAMPAC, visit website at: [www.nampac.com](http://www.nampac.com)*