

# Russell-Stanley Corp.

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PLEASE GIVE THIS INFORMATION TO THE  
PERSON RESPONSIBLE FOR FILLING AND  
CLOSING THESE CONTAINERS FOR  
SHIPMENT.

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Friday May 31, 2002

Dear Valued Customer;

As you should be aware by now, 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 rulemaking 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 Russell-Stanley Corporation in accordance with the requirements of 49 CFR 178.2 (c).

1. All non-removable head, UN 1H1 plastic drums are supplied with plugs installed. Please locate the non-removable (tight head) drum by size, style, and fitting type from the attached list and select the appropriate torque rating for your style of drum. Please tighten the drum fitting 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.

***Note: Plugs must be tightened to recommended torque using pre-set or variable range machinists torque wrenches calibrated to indicated value.***

Continued.

**Closing Instructions for Russell-Stanley Corp 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 5/8 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.

3. All non-removable head. UN 3H1. plastic jerricans (5 Gallon rated Capacity) 49 CFR paragraph 178.509 (a) (3) that are supplied with closures (plugs or screw caps) and 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 in the attached chart. Threads, both male and female should be dry and as free of moisture as possible before fitting is seated. **The one addition to this is the Rieke Corporation Crimp on Flexspout closure, which must be installed using a Rieke Corporation FS 600 crimping tool according to instructions supplied with the tool.**

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 leakproofness test requirements unless reuse is in accordance with para. 173.28 (b) (7).

2.) Replacement of Rieke or Russell-Stanley 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 (g), are required; please contact your Russell-Stanley Corp. sales representative for assistance.

**NOTE: Plugs must be tightened to recommended torque using pre-set or variable range machinists torque wrenches calibrated to indicated value.**

**CURRENT MANUFACTURERS SYMBOLS**

RS Camilla NJ M-4890  
 RS Niro WV M-4777  
 RS Cuzcoing CA M-4802  
 RS Romasville IL M-4403  
 RS Homestead TX M-4601  
 RS Reserve LA M-4846  
 RS Argenta GA M-4234

RS Wilmington DE M-4231  
 RS Addison IL M-4232  
 RS So. Brunswick NJ M-4233  
 RS Woodlands TX M-4236

*DRUM*	*UN LABEL*	MINIMUM TOLERANCE (FT-LB)
8 GAL	1H1Y1.8/150/YR USA/M-XXXX/1.1MM	25.0
ACT SCREW CAP (A21)	.	25.0
ACT FLEX SPOUT (A87)	.	NA
ACT CRIMP (A27)	.	25.0
ACT BUT 7/8 (L10TEGN)	.	25.0
ACT BUT 7/8 (L10TEGN)	1H1X1.8/280/YR USA/M-XXXX/1.1MM	25.0
8 GAL	1H1Y1.8/150/YR USA/M-XXXX/1.1MM	25.0
ACT BUT 7/8 (L10TEGN)	.	25.0
13 GAL ACT 12 HANDLE(S)	1H1Y1.8/150/YR USA/M-XXXX/1.8MM	30.0
DBL ACT BUT (SA108)	.	30.0 & 5.0
DBL ACT BUT (SA108 W/34" VENTS)	.	20.0
STD. PLUGS (L10 & L18)	.	20.0
18 GAL COMMODITY (1 HANDLE)	1H1Y1.8/100/YR USA/M-XXXX/1.8MM	20.0 & 9.0
2" & 3/4" NPS (L-18FC & C-34VRS)	.	20.0 & 9.0
2" & 3/4" NPS (L-18FC & C-34VRL)	.	20.0 & 9.0
2" NPS & 3/4" TRILNO GASKT (A34)	.	20.0 & 9.0
2" & 3/4" NPS PPL (L-18FCPP & C-34PP)	.	25.0 & 9.0
2" & 3/4" NPS PPL (L-18FCPP & C-34PP) PIPE GSKT (RS)	.	20.0 & 7.0
2" NPS & 3/4" TRI (L-18FC & C-34VRS)	.	20.0 & 7.0
2" NPS & 3/4" TRI (L-18FC & C-34VRS)	.	20.0 & 7.0
15 GAL COMMODITY (1 HANDLE)	1H1Y1.8/100/YR USA/M-XXXX/1.8MM	27.1 & 12.2
2" & 3/4" NPS (L-18V & C-34) VENT/RS	.	27.1 & 12.2
15 GAL DELEX (100 LITER)	1H1Y1.8/250 USA/M-XXXX/1.8MM	25
DBL RIK L-10	.	25
15 GAL DELEX (100 LITER)	1H1Y1.8/160 USA/M-XXXX/1.8MM	25
DBL RIK L-10	.	25
15 GAL OT	1H2Y230/S/YR USA/M-XXXX/1.8MM	NA
3" LID/A42 CLOSING RING	.	NA
20 GAL DELEX	1H1Y1.8/100/YR USA/M-XXXX/2.2MM	20
STD. PLUGS (L10 & L18)	.	20.0
30 GAL L-1	1H1Y1.8/100/YR USA/M-XXXX/2.2MM	20.0
STD. PLUGS (L10 & L18)	.	20.0
STD. BUT. & POLYPROP./ (L10 & L16PP)	.	20.0
30 GAL L-1	1H1Y1.8/100/YR USA/M-XXXX/2.2MM	20.55 & 20
DBL ACT FLG. (L10 A718 & A15PP)	.	20.55 & 20
30 GAL OT	1H2Y230/S/YR USA/M-XXXX/2.2MM	NA
STD. BOTTOM WS. LID (SA-42) S-RING	.	NA
STD. BOTTOM WS. LID (SA-42) P-RING	.	NA
30 GAL OT L-1 BOTTOM	1H2Y230/S/YR USA/M-XXXX/2.2MM	NA
L-1 BOTTOM WS. LID (SA-42) S-RING	.	NA
L-1 BOTTOM WS. LID (SA-42) P-RING	.	NA
L-1 BOT WS LID & FLG/SA-118 & A15IS-RING	.	20.0
32 GAL L-1	1H1Y1.8/100/YR USA/M-XXXX/2.2MM	20.0
STD. PLUGS (L10 & L18)	.	20.0
33 GAL O.T./LID. STEEL RING	1H2Y190/S/YR USA/M-XXXX/2.2MM	8.0 & 3.0
IPCC LID / L.L. (C-44L/2" NPS & 3/4" VENT)	.	8.0 & 3.0
IPCC LID / N.B. (C-44/2" NPS & 3/4" VENT)	.	NA
IPCC LID & GASK. L. RING	.	NA
IPCC LID & GASK. N.B. RING	.	NA
38 ACT I	1H1Y1.8/100/YR USA/M-XXXX/2.2MM	30.0
DBL. ACT BUT (SA-108 & SA-108)	.	30.0
DBL. ACT BUT/FLG. (SA108, A71 & A16)	.	30.60 & 20
38 ACT I	1H1X1.8/280/YR USA/M-XXXX/2.2MM	30.0
DBL. ACT BUT. (SA-108)	.	30.0
38 ACT I POISON	1H1X1.8/280/YR USA/M-XXXX/2.2MM DOT Exmp. # 4354	40.0

*DRUM*	*UN LABEL*	MINIMUM TOLERANCE (FT-LB)
38 ACT II (STD)	1H1Y1.8/180/YR USA/M-XXXX/2.2MM	30.0
DBL. ACT POLY BUTT. (SA-108 & SA108)	.	30.0
38 ACT II (STD)	1H1Y1.8/180/YR USA/M-XXXX/2.2MM	30.0
DBL. ACT BUT /FLG (SA-108, A71 & A16)	.	30.60 & 20
38 ACT II (HEAVY)	1H1Y1.8/250/YR USA/M-XXXX/2.2MM	40.0
DBL. ACT BUT. (SA-108 & SA-108)	.	40.0
38 ACT II (HEAVY)	1H1X1.7/250/YR USA/M-XXXX/2.2MM	40.0
45 ACT II (PIH) (A108 or SA108)	1H1Y1.8/180/YR USA/M-XXXX/2.2MM	20.0
35 GAL L-1	1H1Y1.8/180/YR USA/M-XXXX/2.2MM	20.0
STD. PLUGS (L10 & L18)	.	20.0
STD. T/E (L-10TEGN & L18TEGN)	.	20.0
STD. DBL. BUT. / (L-10 & L10)	.	20.0 & 20.0
STD. BUT. & POLYPROP./ (L10, L16PP)	.	20.0 & 20.0
STD. PLUGS & PE GASK. (L-10 & L-18)	.	20.0 & 20.0
STD. PLUGS & VIT. GASK. (L-10 & L-18)	.	20.0
35 GAL L-1	1H1Y1.8/180 USA/M-XXXX/2.2MM	35.0
DBL. ACT BUT. (SA-108 & SA-108)	.	35.0
35 GAL L-1	1H1Y1.8/100/YR USA/M-XXXX/2.2MM	20.0
STD. PLUGS (L10 & L18)	.	20.0
36 GAL L-1	1H1Y1.8/100/YR USA/M-XXXX/2.2MM	20.0 & 9
STD. PLUGS (L10, L18 & A39) VENT	.	20.0 & 9
38 GAL L-1	1H1Y1.8/100/YR USA/M-XXXX/2.2MM	27.1 & 27.1
STD. PLUGS / (L10 & L18) VENT	.	27.1 & 27.1
35 GAL L-1	1H1X1.8/250/YR USA/M-XXXX/2.2MM	40
DBL. ACT BUT. (A-108 or SA-108)	.	40
35 GAL L-RING PLUS	1H1Y1.8/100/YR USA/M-XXXX/2.2MM	20.0 & 20.0
STD. PLUGS (L10 & L18)	.	20.0 & 20.0
DBL. 70mm PLUGS (LR-10W & LR-10W)	.	35.0
35 GAL L-RING PLUS HEAVY	1H1Y1.8/350/YR USA/M-XXXX/2.2MM	35.0
DBL. 70mm PLUGS (LR-10W & LR-10W)	.	35.0
70mm PLUG & 70mm Vent (LR-10W & LR-10W)	.	35.0
35 GAL L-RING PLUS (PIH)	1H1X1.8/250/YR USA/M-XXXX/2.2MM	35.0
DBL. 70mm PLUGS (LR-10W & LR-10W)	.	35.0
35 GAL L-RING PLUS (PIH) HEAVY	1H1X1.7/330/YR USA/M-XXXX/2.2MM	35.0
DBL. 70mm & VIT. GASK. (LR-10W & LR-10W)	.	35.0
35 GAL L-2 (RS)	1H1Y1.8/100/YR USA/M-XXXX/2.2MM	85.20 & 20
STD. PLUGS & FLANGE (L10, L18 & L-71R)	.	85.20 & 20
35 GAL L-2 (RS)	1H1Y1.8/100/YR USA/M-XXXX/2.2MM	12.27 & 27
STD. PLUGS & VENT/ (L10, L-16 & A-39-S)	.	12.27 & 27
36 GAL L-2 (RS)	1H1Y1.8/100/YR USA/M-XXXX/2.2MM	20.0
STD. PLUGS (L10 & L18)	.	20.0
38 GAL OT/LID. STEEL RING	1H2Y180/S/YR USA/M-XXXX/2.2MM	NA
IPCC LID/L (C-44L)	.	NA
IPCC LID/NB. (C-44NB)	.	NA
IPCC LID / L.L. (C-44 LU/2" NPS & 3/4" VENT)	.	8.0 & 3.0
IPCC LID/NB (C-44NB/2" NPS & 3/4" VENT)	.	8.0 & 3.0
35 GAL DELCON OT	1H2Y130/S/YR USA/M-XXXX/2.2MM	N/A
IPCC LID LL	.	21 & 6
IPCC LID LL. 2" NPS & 3/4" PLUG	.	N/A
IPCC LID NB	1H2Y230/S/YR USA/M-XXXX/2.2MM	N/A
IPCC LID LL	.	N/A
36-37 R-8 OH	1H2Y260/S/YR USA/M-XXXX/2.2MM	N/A
LID	.	N/A
37 GAL OT	1H2Y340/S/YR USA/M-XXXX/2.2MM	NA
WS. LID / (SA-42) S-RING	.	NA
WS. LID / (SA-42) P-RING	.	NA
WS. LID & FLG. (SA-212) A-18 PLUGS/S-RING	.	NA
37 GAL DELCON	1H2Y260/S/YR USA/M-XXXX/2.2MM	NA
FLAT LID AND RING	.	NA
BUNG LID 2" & 3/4" NPS	.	8.3 & 3.0