



TED LEVINE DRUM COMPANY

1817 CHICO AVENUE • SO. EL MONTE, CA 91733

(626) 579-1084 • FAX (626) 579-9176

Drum Closure Instructions

In order that the reconditioned drum supplied to you performs to the UN designation specified and your contents are packaged in a safe and responsible manner, the following closure instructions need to be specifically followed. The substitution and use of any other drum components (rings, gaskets or fittings) not supplied with this product, or the use of any other method of assembly or closure is not recommended since it may negatively effect the performance of your drum.

Open Top Drums with Bolted Ring Closure

1. Place cover on drum.
2. Place the bolt ring over the cover and top lip (the curl) of the drum with the lugs pointed downward. Make sure the bottom edge of the ring engages the drum curl.
3. Insert the bolt through the unthreaded lug then through nut which must be between the lugs. Next, thread the bolt through the threaded lug.
4. Tighten the bolt to 75 foot pound of torque while reducing the gap between the ends of the rings to between 1/8 and 3/8 inch. You may need to tap on the ring while tightening with a soft mallet to attain the correct ring gap.
5. Tighten the nut against the unthreaded lug to prevent the bolt from backing out.

Closed Top Drums and Open Top Drums with Fitting

1. Insure gaskets are flat and properly seated against base of fitting. This will assist in maintaining gasket integrity.
2. Gently screw in fitting (to avoid cross threading) until fitting is snug.
3. Using a torque wrench, tighten each fitting to the torque below.

Fitting Type	Trisure®			Rieke®		
	Steel		Poly	Steel		Poly
Fitting Material						
Gasket Material	Rubber	Poly		Rubber	Poly	
Size of Fitting						
2"	20	30	12	30	40	20
3/4"	12	20	5	15	20	9

All measurements are in foot-pounds



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