



DRUM CLOSURE INSTRUCTIONS

ICS Produced – UN Drum Assembly Instructions

In order that the Industrial Container Services 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) that are not specified in this design type will immediately invalidate the UN and DOT performance of your drum.

Open Top Drums with Bolt Ring Closures

1. Place the cover on the drum, assuring that cover gasket is seated against the "curl" of the drum opening and the gasket curl recess on the drum cover.
2. Place the bolt ring over the cover and top lip (curl) of the drum with the bolt ring lugs pointed down. Make sure the bottom edge of the ring engages the drum curl.
3. Insert the bolt through the unthreaded lug then through the "nut" which must be between the lugs. Next, thread the bolt through the threaded lug.
4. Insure the ring is seated properly around the lid and the curl. Using a torque wrench , tighten the bolt to 75 foot pounds of torque. You may need to tap on the ring with a soft mallet while tightening to assist in seating the ring. The ring ends (and lugs) must not touch when the ring has been torqued.
5. Tighten the nut against the unthreaded lug to prevent the bolt from backing out.
6. It may be necessary to check the torque and tighten if needed prior to shipping.

Fitting Installation

The table below shows the proper that must be applied to each drum fitting to assure proper container performance. (All measurements are in foot-pounds.)

Type I – Trisure Octagon Base, Round Head Plug				Type II – Rieke Serrated Base, Hexagon Head Plug		
Steel Plugs		Steel Plugs	Poly and Nylon Plugs	Poly and Nylon Plugs	Steel Plugs	Plastic Plugs
Plug Size	Rubber (Buna-N) & EPDM Gasket	None Self Gasketing	Poly Gasket	Rubber Gasket	Irradiated LD Poly Gasket	Rubber (Buna-N) Poly & EPT Gask.
2"	20	12	30	20	40	20
3/4"	12	5	8	8	20	9

Note: Gasket compression occurs with the passing of time. Therefore, re-tightening closures immediately prior to shipping (proper torque foot-pounds) is recommended.