

Correct Closing Torque For Plugs and Locking Rings

Dear Valued customer:

The DeWitt Barrel Co. is providing you with remanufactured/reconditioned UN (1A1 or 1A2) steel drums marked in accordance with the U.S. Department of Transportation's regulations on the transportation of hazardous materials, 49 CFR Parts 100-189.

Under 49 CFR 178.2, we are obliged to notify you as purchaser of these drums "of all requirements...not met at the time of transfer, and the type and dimensions of any closures, including gaskets, needed to satisfy performance test requirements." Please note that as delivered, the closures are not tightened for shipment.

When design tested these closures had the following torque specifications:

PLUG TYPE	PLUG GASKETS	CORRECT 3/4" PLUGS	TORQUE 2" PLUGS
Tri-Sure Steel	Rubber – Black Buna, White Buna, EPDM, Butyl, White Neoprene Viton, and Silicone	12 Ft. lbs.	20 Ft. lbs
	Polyethylene, Irradiated Polyethylene, and Teflon	20 Ft. lbs	30 Ft. lbs
Tri-Sure-Polyethylene Polypropylene, Nylon	Rubber – Black Buna, White Buna, EPDM, Butyl, White Neoprene Viton, Silicone	12 Ft. lbs	20 Ft. lbs
	Polyethylene, Irradiated Polyethylene, and Teflon	20 Ft. lbs	30 Ft. lbs
Tri-Sure –Polyethylene	Non (Self Gasketing)	5 Ft. lbs	12 Ft. lbs
Tri- Sure – Polypropylene (Poly Clad)		1/2" PLUGS	2 1/2" PLUGS
	Non (Self Gasketing)	5 Ft. lbs	12 Ft. lbs
Rieke – Steel	Rubber – Black Buna, White Buna, EPDM, Butyl, Black Visecar, White Visecar, White Dapon, White EPT, Black EPT	15 Ft. lbs	30 Ft. lbs
	Poly Seal (Plastic) – Irradiated and Non-Irradiated	20 Ft. lbs	40 Ft. lbs
Rieke – Polyethylene Polypropylene, Nylon	Rubber – White Buna, Black EPDM, White EPDM, Dapon Irradiated and Non-Irradiated	9 Ft. lbs	20 Ft. lbs
Rieke – Polyethylene Polypropylene, Nylon	Non (Self Gasketing)	9 Ft. lbs	20 Ft. lbs

RINGS – 55 AND 30 GALLON

A 12 Gauge ring will require a torque of 60 foot pounds to properly close and seal. Do not apply more than the recommended torque, this could cause the bolt threads to strip making it difficult or impossible to remove.

A 16 Gauge ring will require a torque between 8 and 15 foot pounds

INTERMEDIATE BULK CONTAINERS (IBC)

(Per 49 CFR § 178.2 (c)(ii), the below listed closures were used to qualify IBC's. You must use the approved gasket and closure tightened to the appropriate torque specification to meet DOT requirements.)

	Material	Gasket Type	Outlet Type	Torque Specifications
6" Lid w/ or w/o 2" NPT bung or microporous vent	HDPE	EPDM	N/A	55 foot pounds
1.5" or 2" Ball Valve w/ Plastic Collar and blue or grey handle.	Polypropylene with glass and carbon black	EPDM, Vitron®	NPT or Camlock	45 foot pounds
2" Banjo™ Ball Valve w/ Plastic Collar and yellow handle.	Polypropylene with glass and carbon black	Santoprane	NPT or Camlock	45 foot pounds

Under DOT regulations, any changes made to the type and dimensions of closures or the method of closure may constitute a change in design type of this packaging, voiding the certification we have marked on it and requiring retesting and recertification.