

Patrick J. Kelly Drums, Inc.
6226 Pidcock Creek Road, New Hope, PA 18938
Container Closure Notification
Revised 1-2-2023

Introduction:

Patrick J. Kelly Drums, Inc. sells new containers from other manufacturers as well as a US DOT certified remanufacturer of certain UN and non UN containers. Should you have any questions please contact us at 800 963 1795.

The person responsible for filling and closing these containers for shipment must have a copy of these instructions. Pursuant to US DOT Regulations given in Title 49 CFR Part 178. Specifications for Packagings 178.2(c)(1)(i), Patrick J. Kelly Drum, Inc. must notify each person to whom a package is transferred of the type and dimensions of any closures, including gaskets, needed to satisfy performance test requirements. Paragraph 178.2(c) requires you to provide closing information to any person to whom this package is transferred who may need to close the package prior to reshipment.

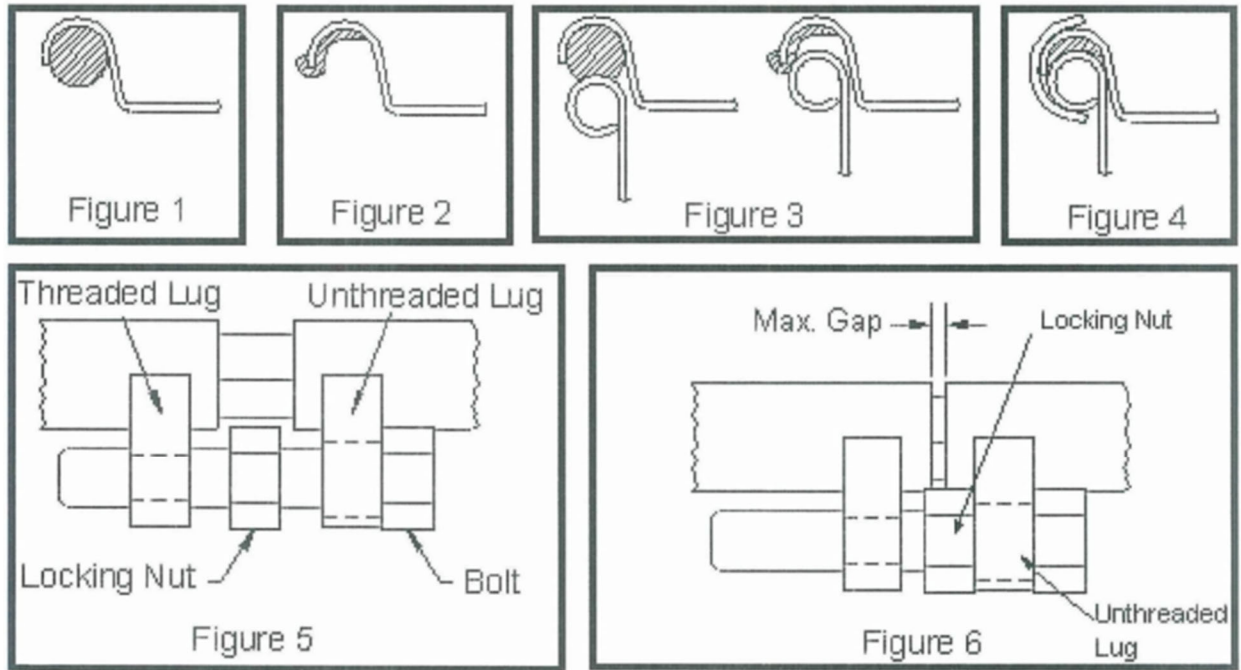
The prescribed method of closure should be used to ensure that the containers have been closed in the same manner as when they were initially tested to comply with the requirements of the US DOT in CFR 49 Part 178.2(c)(1). These instructions for container closure are based upon the closure methods used to enable these containers to pass the qualification test. The closure recommendations do not take into account any hazards present at your facility, or the handling, filling or shipping methods used by your facility. The fillers product may adversely affect container materials or closing devices. Compatibility is the customers / fillers responsibility. Containers with obvious damage or deterioration should not be filled or shipped.

Closure Specifications for 330gal. & 275gal. IBC'S (Tote)

6" & 9" Fill Port Cap at 75 ft.-lbs +/- 5 ft.-lbs.
2" plug in 6" or 9" Fill Port Cap 20 ft.-lbs +/- 2 ft.-lbs
Valve Nut 55 ft.-lbs +/- 5 ft.-lbs

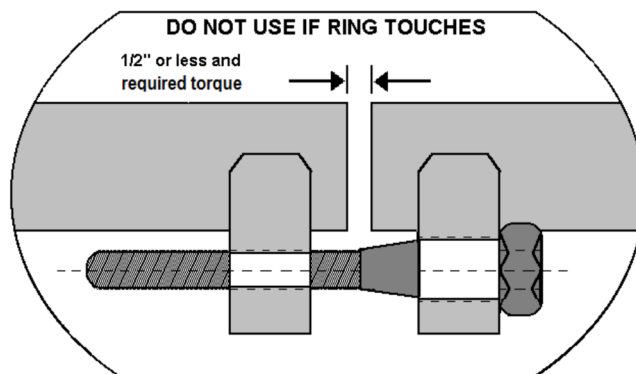
55gal & 85gal Steel Open Head Bolt Ring and Locking Nut Closure (New and Reconditioned)

1. Check the gasket to ensure it is properly fitted into the bottom groove of the drum cover (Figure 1 and 2).
2. Place the cover on the drum, being careful to seat the gasket onto the entire lip (curl) of the drum sidewall (Figure 3).
3. Position the closure ring, with lugs downward, so that it engages the entire circumference of the drum cover and sidewall. Apply pressure on the ring and cover, and tap the circumference of the ring with a non-sparking mallet to further seat the cover and sidewall into the inner channel of the ring (Figure 4).
4. Insert the bolt into the unthreaded lug of the ring. (If the ring is equipped with a locking hex nut, affix the nut onto the bolt.) Direct the end of the bolt into the threaded lug of the ring (Figure 5). Close the ring to an initial gap between the lugs of approximately 1/2 inch.
5. Tighten the bolt while further tapping the edges of the ring with the mallet.
6. When fully assembled, the gap between the free ends of the ring should not exceed 1/4 inch, nor should the ends of the ring touch (Figure 6).
7. Or torque to 90 ftlb or greater as long as the ring ends do not touch.



New Open Head New General Steel Drums With Out Locking Nut:

16 gauge body 15 – 20 ftlbs
 12 gauge body 60 – 70 ftlbs.



Steel Non Removable Head Drum Plug Torque Specifications

Closing Torques in ft.-lbs. (by Type) Gasket Type 3/4" Plug Torque then 2" Plug Torque:

- Rieke: VISE-GRIP II - Plastic Flange Polyethylene 9 ft.-lbs. 20 ft.-lbs.
- Rieke: VISE-GRIP II - Plastic Flange Rubber 9 ft.-lbs. 20 ft.-lbs.
- Rieke: VISE-GRIP II- Steel Flange Polyethylene 9 ft.-lbs. 20 ft.-lbs.
- Rieke: VISE-GRIP II- Steel Flange Rubber 9 ft.-lbs. 20 ft.-lbs.
- Rieke: VISE-GRIP II Plug with built-in gasket – Plastic Flange 9 ft.-lbs. 20 ft.-lbs.
- Rieke: VISE-GRIP II Plug with built-in gasket – Steel Flange 9 ft.-lbs. 20 ft.-lbs.
- Rieke: Steel Plug - Steel Flange Polyethylene 20 ft.-lbs. 40 ft.-lbs.

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Rieke: Steel Plug - Steel Flange Rubber 15 ft.-lbs. 30 ft.-lbs.
TS Typeii: Polypropylene and Nylon Plugs Polyethylene 8 ft.-lbs. 15 ft.-lbs.
TS Type: Polypropylene and Nylon Plugs Rubber 8 ft.-lbs. 15 ft.-lbs.
TS Type: Polyethylene Plugs (high-density) Rubber 8 ft.-lbs. 15 ft.-lbs.
TS Type: Self-Gasketing, polyethylene plug 5 ft.-lbs. 12 ft.-lbs.
TS Type: Steel Plugs Polyethylene, Teflon 20 ft.-lbs. 30 ft.-lbs
TS Type: Steel Plugs Rubber, 10 ft.- lbs. 20 ft.- lbs.

Poly Non Removable Head Drum Plug Torque Specifications

Part Size / Part Number (Plug number with gasket) Torque Spec.

2-inch buttress: L10 EPDM; L10B Buna; L10VT FPMii 20-25 ft.-lbs.
2-inch NPS: L16 EPDMii; L16B Buna; L16VT FPM; L16RVCLG 20-25 ft.-lbs.
2-inch buttress: L10V Vented EPDM; L10V-B Buna; L10V-VT FPM 20-25 ft.-lbs.
2-inch NPS: L16 Vented EPDM; L16V Buna; L16VT FPM 20-25 ft.-lbs.
2-inch NPS: L16R with L12EP 20-25 ft.-lbs.
2-inch ACT buttress: SA10B with A72 30-40 ft.-lbs.
3/4-inch NPS: C34 or C39 (S) AD with C31 EPDM; C31 Silicone 6-9 ft.-lbs.
L10R-HD with L11F-HD; L16RHD; and Santoprene® gaskets 25-30 ft.-lbs.
Metric: 70x6 BCS LR10W with LR11EP; 70x6 BCS LR10W with LR11VT 35-40 ft.-lbs.
Metric: 56x4 BCS LR17 with LR12EP 20-25 ft.-lbs.
Polycon® II : 2-inch NPS L16-6RK/EPDM 37-42 ft.-lbs.
Polycon® II : 3/4-inch NPD C34-6RK/EPDM 8-10 ft.-lbs

New Plastic Removable Head Cover Plugs

Part Size / Part Number (Plug number with gasket) Plug Torque Spec:

A Vanguard ® Lid with 2-inch Self-seal type NPS plug: 7-9 ft.-lbs.
B Vanguard ® Lid with ¾ inch Self-seal type NPS plug: 5-7 ft.-lbs.

New Plastic Removable Head Covers (Lever Lock Ring)

All removable head, UN 1H2, Plastic Drums, 49 CFR § 178.509(a)(2), of nominal capacity 15 to 60 U.S. gallons supplied with plastic lids, gaskets and 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 installation instructions:

Place drum lid with gasket and selected clamp band as supplied on the top opening of the drum body.

Firmly place lid onto top opening by applying downward pressure to lid above drum sidewall.

While pressing down on lid, engage locking mechanism of clamp band to secure the lid in place. Make sure the locking mechanism is completely latched. Insert locking tab into slots in lever lock handle.

NEW COMPOSITE DRUMS (steel shell poly liner)

All non-removable head, UN 6HA1, Composite drums, 49 CFR § 178.522(a)(1), 55 gallon nominal capacity supplied with plug or screw cap closures with 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 below:

Part Size / Part Number (Plug number with gasket) Torque

HDPE Liner 6HA1/X1.8/350 & X1.8/300:

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2" double buttress L-10xx with L11EP-xx 29-32 ft.-lbs
Liner 5506: 2-inch NPS: L16-xx with L12-xx 14-18 ft.-lbs.
Liner 5506: ¾ inch NPS: C39-xx 4-6 ft.-lbs.
HDPE Liner 6HA1/Y1.8/100: 2-inch double buttress: L10-xx with L11EP-xx 21-25 ft.-lbs.
LDPE Liner 6HA1/Y1.8/100 and Y2.0/100:
2-inch combination plug: A16 EPG-TR 14-18 ft.-lbs.
LDPE Liner 6HA1/Y1.8/100 and Y2.0/100: ¾ inch NPS:
C34TR with C31EP-TR gasket 4-6 ft.-lbs.
Liner 5510 :2-inch double buttress: L10-HD with L11-B4F 25-30 ft.-lbs.
Nylon/Polypropylene 2 inch with EPDM Gasket 12-15 ft.-lbs.

Closing Instructions for New Fiber Lok-Rim Head Covers

Place cover on drum. Snap the closing ring over the cover and top lip of the drum. Make sure that the writing on the top closing lever is right side up. Also, make sure that the bottom edge of the closing ring engages under the top lip of the drum. Pull the locking lever closed, at the same time, tap the outside edge of the closing ring, beginning directly opposite the closing lever, with a mallet until the lever is fully closed against the edge of the ring. Snap the latch into the lever until it locks, then apply a sealing wire or other sealing device through the holes in the latch lever.

Closing Instructions for Fiber Telescoping Head Covers

Drum must be lined with a 3 mil poly bag prior to filling. Bag must be long enough that 12 inches minimum of poly extends over the top after filling. End of bag must then be sealed with poly wire tie or equivalent wire seal. Excess liner must then be tucked into top of drum. Bags should be Champion Plastics Chamotuf polyethylene bags or of equivalent strength. Customers choosing to use a lighter gauge bag must submit those bags for separate testing.

Telescoping cover must fit securely on drum. Push cover down until top edge of drum touches inside top of cover. The cover must be attached to the drum body using adhesive backed tape. The Hollander Co. 150# 2 mil prt. Red 3 in. 110 Ft. or its equivalent should be used. For drums rated UN Y/90 or less, the tape should be wrapped around the drum body a minimum of 4 times. There should be approximately 2 inches of tape on the cover and 2 inches on the body. For drums rated greater than UN Y/90, the tape should be wrapped a minimum of 8 times with approximately 4 inches on both the cover and the body. Press and rub the tape into place around the entire drum.

Closing Instructions for New Plastic Pail Head Covers

Place the cover over the pail. Using a large faced plastic dead blow hammer squarely and uniformly hammer the edges around the edge of the cover until the cover snaps onto the pail leaving up to approximately 1/8" clearance between the lower edge of the cover and the top satellite ring on the pail body.

Closing Instructions for Cubic Yard Corrugated Container

Square up the corrugated outer pack. Lay squared up unit on its side flush against pallet with the fold of one flap lined up against the top edge of pallet, and the flap extended over the top of the pallet. Nail the flap to the pallet, one nail in each corner of the flap and two nails in the center. Fold in the flap opposite the nailed flap, then fold the remaining two flaps over them. Raise the corrugated outer pack onto the pallet. Fold the four top flaps back and insert the black poly liner. Expand the top of the liner and pull it down over the outside of the corrugated outer pack, over the four top flaps, to the level of the pallet. Make sure the liner is fully expanded inside the outer pack with the bottom of the liner resting on the inside bottom of the outer pack. After filling the container, gather the open end of the liner and seal with the plastic cable tie. Fold the four top flaps and secure the seam with reinforced tape at least 2" wide. Make sure the tape extends at least 6" down the sides of the container.

I acknowledge the receipt of the Container Closure Notification as prescribed in HMR: 49 CFR Parts 171 – 180 from Patrick J. Kelly Drums, Inc.

COMPANY _____ NAME _____ Date _____

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