



**ASSEMBLY INSTRUCTIONS FOR
CLOSURE OF STEEL CONTAINERS
WITH DRILLED LUG CLOSING RINGS**

PARTS LIST:

- 1.0 Drum Body
- 2.0 Cover with Gasket
- 3.0 Closing Ring
- 4.0 Bolt and Nut

1.0 OPEN HEAD CONTAINER

- 1.1 Place contents into the container per applicable filling instructions.
- 1.2 Place the cover on the container.
- 1.3 Place the closing ring around the cover and container curl.
 - 1.3.1 Assure the ring lugs face in a downward position.
- 1.4 Place the bolt through the lugs and affix the nut to the bolt.
 - 1.4.1 Tighten the nut and bolt to required torque while tapping the ring to assure the ring is set.
 - 1.4.2 Torque the bolt and nut to 6 +/- .5 ft. lbs.
 - 1.4.3 Visually inspect to assure there was no movement of the gasket, which would produce a poor seal.
- 1.5 If any components are missing or damaged, or if further instruction is desired, notify the supplier for proper replacement or instruction.
- 1.6 Any substitution or deviation from this procedure will negate the certification.