



FORM 501

## Proper Closing Of A Steel Drum

### How To Close A Tight Head Drum

CHECK THE PLUGS TO MAKE CERTAIN THAT THE GASKET IS PROPERLY SEATED.

CAREFULLY SCREW IN THE PLUG TO INSURE NO CROSS THREADING.

USING THE PROPER FT/LBS. TORQUE WRENCH, TIGHTEN THE PLUGS TO THE RECOMMENDED TORQUE.

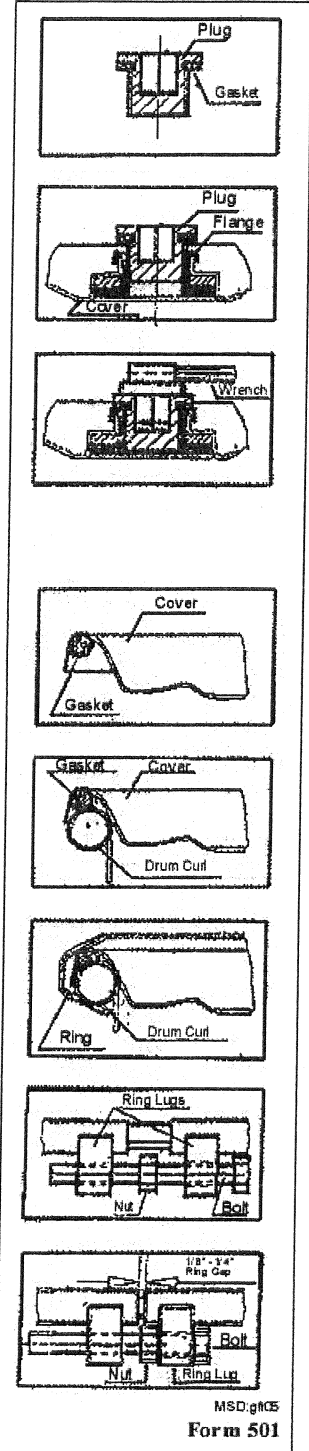
TORQUE SPECIFICATION CAN ALSO BE OBTAIN FROM THE VENDOR

	Technocraft (Tight Seal) 504-523-4785		Rieke Closures 260-925-3700		Tri-Sure Closures 630-260-8643	
	Steel	Nylon	Steel	Nylon	Steel	Nylon
3/4 Inch	25 Ft-lb's	8-12 Ft-lb's	15 Ft-lb's	10 Ft-lb's	8-15 Ft-lb's	8-11 Ft-lb's
2 Inch	50 Ft-lb's	10 Ft-lb's	30 Ft-lb's	20 Ft-lb's	8-15 Ft-lb's	8-15 Ft-lb's

INSTALL CAP SEAL IF REQUIRED.

### How To Close An Open Head Drum

- A** INSPECT THE COVER GASKET. THE GASKET SHOULD BE SEATED PROPERLY IN ITS GROOVE ON THE COVER.
- B** CAREFULLY PLACE THE COVER ONTO THE DRUM CURL WITH OUT DISTERBING THE GASKET.
- C** INSTALL DRUM RING. ASSURING THE TOP AND BOTTOM EDGES OF RING CONTACT UPPER CURL OF COVER AND LOWER SECTION OF DRUM CURL, RESPECTIVELY.
- D** INSTALL THE BOLT AND NUT THROUGH THE RING LUGS.
- E** USE A PNEUMATIC IMPACT WRENCH OR OTHER DEVICE TO TIGHTEN THE BOLT. WHILE TIGHTENING RING, USING A MINIMUM 24oz. HAMMER OR COMPARABLE DEVICE, START BRISKLY TAPPING THE RING AT THE OPPOSITE POSITION (BACK) OF BOLT ALTERNATE FROM SIDE TO SIDE, WORKING FROM BACK SIDES TOWARD THE BOLT.
- F** **FOR NEW DRUMS ONLY:** WHILE TAPPING THE CLOSURE RING, TORQUE THE BOLT TO 65-70 FT/LBS.
- G** CHECKING CLOSING RING GAP. **NEW DRUMS ONLY,** RING GAP MIN 1/8" MAX 1/4" **RECONDITION DRUMS ONLY,** CLOSURE RING GAP MIN 1/32" MAX 3/8" THE EDGE OF RINGS SHOULD NOT TOUCH.
- H** REPEAT STEPS E & F MINIMUM OF 3 TIMES.
- I** SECURELY TIGHTEN THE JAM NUT TO THE HEAD SIDE OF THE BOLT.



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