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.