

American ContainerNet

Please give this information to the person responsible for filling and closing these containers for shipment

Pursuant to Department of Transportation Regulations given in title 49 Code of Federal Regulations Part 178, Specifications for Packaging §178.2 (c)(1)(ii), American Container Net must notify each person to whom a packaging is transferred of the type and dimensions of any closures, including gaskets, needed to satisfy performance test requirements. This notification is to include tightening instructions for closures.

Closing instructions: All steel drums, UN1A1 and 1A2, delivered to a customer should use only the closures supplied by the shipper or closures tested and approved by American Container Net for use in the packaging supplied as follows:

1) All non-removable head, UN1A1 steel Drums, 49 CFR 178.504(a) (1) that are supplied with plugs and gaskets must be closed for shipment using only the plugs and gaskets supplied and specified in the design qualification test for the drum as indicated below:

- a) Tri-Sure™ Plugs, 2 inch and 3/4 inch steel and plastic, installed in Tri-Sure™ steel flanges of corresponding size and tightened to the torque recommended by American Flange & Manufacturing Co., Inc. for the plug gasket used as indicated on reverse.
- b) Rieke © Corporation Plugs, 2 inch and 3/4 inch steel and plastic, installed in the appropriate Rieke steel or plastic flange of corresponding size and tightened to the torque recommended by Rieke as indicated on reverse
- c) Rheem Closures (F.E.) PTE LTD. Plugs, 2 inch and 3/4 inch steel and plastic, installed in the appropriate Rheem steel flange of corresponding size and tightened to the torque recommended by Rheem as indicated on reverse. Note: Rheem plugs and Tri-Sure™ plugs may be interchangeably in the octagonal design fittings.

2) All removable head, UN1A2 steel Drums 49 CFR 178.504(a)(2) supplied with clamp bands, bolts, gaskets and lids must be closed for shipment using only the components supplied and specified in the design qualification tests for the drum as marked according to the installation instructions below:

Note to person receiving this notification: Paragraph 178.2 (c) cited above requires you to provide closing information to any person whom this package is transferred who may need the packaging prior to reshipment.

Closing instructions for American Container Net (see address below for specific facility) UN1A2, Removable Head Steel Drums :

1. Place drum head with gasket in place as supplied on the curl at the top of the drum body. (see figure #2)
2. Place bolt ring around drum head and curl.
3. Using a head compressor apply force to the top of the drum head assembly to compress head gasket.
4. Drive bolt into lug until the ends of the bolt ring are 3/8 inch apart.
Note: If prescribed ring gap can not be achieved, torque ring to 75 +/- 5 ft. lb.
5. If a head compressor is not available, start bolt into lug, alternate tapping of ring with a mallet and drive bolt with wrench, until bolt ring ends meet above requirements
6. When ring has been tightened as required, the jam nut must be tightened against the unthreaded lug.

Open Head Reconv

FIGURE #1

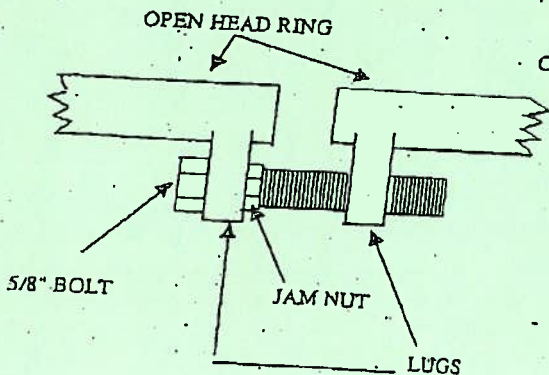
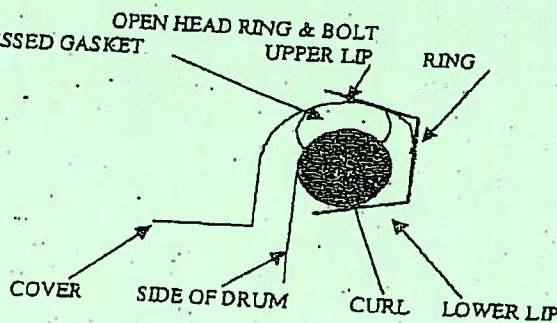


FIGURE #2



PRESCRIBED TRI-SURE STEEL CLOSURE TORQUES, FT/LBS.			
ITEM - WHEN INSERTED INTO TRI-SURE FLANGE		3/4"	2"
TRI-SURE STEEL PLUGS	Rubber Gaskets	12	20
	Polyethylene, Teflon Gaskets	20	30
LEAK LOCK STEEL PLUGS	Rubber Gaskets	8	20
TRI-SURE ZINC DIE CAST PLUGS	Rubber Gaskets	12	20
	Polyethylene, Teflon Gaskets	20	30
TRI-SURE POLYPROPYLENE & NYLON PLUGS	Rubber Gaskets	8	20
	Polyethylene Gaskets	8	30
TRI-SURE POLYETHYLENE PLUG, HIGH DENSITY	Rubber Gaskets	8	15
TRI-SURE SELF-GASKETING POLYETHYLENE PLUG		5	12

Materials classified *"POISONOUS BY INHALATION"* must be sealed with TRI-SURE steel, gasketed Tab-Seal caps

RECOMMENDED TORQUES FOR RIEKE CLOSURES IN FT/LBS		STEEL OPENING		PLASTIC OPENING	
ITEM - WHEN INSERTED INTO RIEKE FLANGE		3/4"	2"	3/4"	2"
RIEKE STEEL PLUG	Rubber Gaskets	15	30	-	-
	Polyethylene Gaskets	20	40	-	-
RIEKE PLASTIC POLY-VISEGRIP PLUG	Rubber Gaskets	9	20	9	20
	Polyethylene Gaskets	9	20	9	20
RIEKE POLY-VISEGRIP PLUG	Plug with Built-in Gasket	9	20	9	20

RECOMMENDED TORQUES FOR RHEEM CLOSURES IN FT/LBS.		
ITEM - WHEN INSERTED INTO FLANGE	3/4"	2"
BLACK BUNA	12-15	15-20
WHITE BUNA	12-15	15-20
POLYETHYLENE	15-20	25-30
IRRADIATED POLY	15-20	25-30
EPDM	12-15	15-20