

Closed-Head Steel Drum (1A1)

1. Check gaskets and ensure that they are properly seated on the plugs.
2. Tighten plugs using a torque wrench to torque specifications presented here.
3. Take care not to cross threads.

Size & Fitting Style	REQUIRED TORQUE			
	STEEL PLUGS		NYLON OR POLY PLUGS	
	Buna Rubber Gasket	Poly Gasket	Buna Rubber Gasket	Poly Gasket
2" Hex Type	30 ft. lbs.	40 ft. lbs.	20 ft. lbs.	20 ft. lbs.
3/4 " Hex Type	15 ft. lbs.	20 ft. lbs.	9 ft. lbs.	9 ft. lbs.
2" Round Type	15 – 22 ft. lbs.	15 – 22 ft. lbs.	15 – 22 ft. lbs.	15 – 22 ft. lbs.
3/4" Round Type	8 – 15 ft. lbs.	11 – 18 ft. lbs.	8 – 11 ft. lbs.	8 – 11 ft. lbs.

Open-Head Steel Drum (1A2)

Bolt-Ring Closure

1. Check the gasket to ensure it is properly fitted into the bottom groove of the drum cover.
2. Place the cover on the drum, being careful to seat the gasket onto the entire lip (curl) of the drum sidewall.
3. Position the closure ring, with the lug 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.
4. Insert the bolt into the unthreaded lug of the ring. (If the ring is equipped with a lock hex nut, affix the nut into the bolt.) Direct the end of the bolt into the threaded lug of the ring. Close the ring and initial gap between the lugs of the approximately 1/2 inch.
5. Tighten the bolt while further tapping the edges of the ring with the mallet .

- When fully assembled, the gap between the free ends of the ring should not exceed ¼ inch, nor should the ends of the ring touch.

“Lever lock” Closure

- Check gasket to ensure cover gasket is properly fitted into cover groove.
- Place cover on drum, being careful to properly seat gasket around curl.
- Open lever lock and place expanded ring on to the drum cover with the vertical-skirt hugging the drum body.
- Close the lever lock by slowly and cautiously pulling the lever lock so that the outer ring engages the cover / body juncture. Applying downward pressure, along with tapping the outside of the ring with non-sparking mallet, may assist with an even closure.

Engage lock to complete closure

Closed-Head Plastic Drum (1H1)

- Place Plugs (with gasket) into the corresponding drum opening of corresponding size and thread pattern.
- Place Plugs (with gasket) into the corresponding drum opening of corresponding size and thread pattern.
- Tighten to Torque values as follows:

Tighten to Torque values as follows:

Size & Fitting Style	REQUIRED TORQUE
	Plastic Plugs
2" NPT Type	20 - 25 ft. lbs.
2" Buttress Type	20 - 25 ft. lbs.
3/4" NPT Type	6 - 9 ft. lbs.

