

PDC0015SC00001 - 15 GAL NAT T/H HDPE W/ 2" & 3/4" PLUG #RS1360 UN EMBOSSED



15 Gallon RS Style Tighthhead Closure Instructions	
Form Number: RD-ETS-1002	Version: 1
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- PURPOSE:** To ensure the 2" Fine and Buttress Closure is properly sealed when assembled on a Tighthhead Container.
- SIGNIFIGANCE:** The DOT/UN Performance Certification only applies to a Tight Head Container that is closed per this procedure. The sealing performance of the 2" Fine & Buttress Plug Closure is compromised if the top surface of the neck is rough, has excessive burr, or is not clean; in addition to, if the gasket is damaged, twisted, not clean or not properly seated against the bung plug flange. The Closures are only to be assembled on the container after all sealing surfaces pass inspection.
- APPARATUS:** 2" Fine & Buttress Plug Head Fixtures
Torque Wrench (Set to 20 ft-lbs or 240 in-lbs)
- PROCEDURE:**
1. Inspect the top surface of the 2" fine & buttress threaded holes of the containers to wnsure an acceptable sealing surface.
 2. Inspect the closure to ensure the gasket is properly assembled and is clean.
 3. Start the closure on the neck by hand, rotating the closure in a clock-wise direction. Take care not to cross thread the closure; this will result in damage to the closure or to the neck finish.
 4. Using the 2" Fine & Buttress Plug Torque Head Fixture mounted onto a torque wrench, tighten the closures to 20 ft-lbs (240 in-lbs).
- APPARATUS:** 3/4" Fine Thread Bung
Torque Wrench (Set to 7 ft-lbs or 84 in-lbs)
- PROCEDURE:**
1. Check to ensure the 3/4" fine thread bungs have been fitted with gaskets.
 2. Prior to installing the bung plug into the container, be sure the gasket has been properly seated against th bung plug flange
 3. With the gasket properly seated, install the bung plug, with a clockwise rotation, into the 3/4" NPS hole of the container.
 4. Be careful not to cross thread the bung plug or damage to the thread may occur.
 5. Torque of 7 ft-lbs (84 in-lbs) for all 3/4" NPS bungs plugs are required.
- NOTE:** Substitution of any of the components listed above may render the UN Certification Invalid.