

## DOT 178 Notice Closure Requirements for Plastic Drums

In Regulation 49 CFR 178.2(c), the Department of Transportation (DOT) requires drum manufacturers to inform their customers of how to close drum fittings and closure rings in order to return drums to their UN marking performance levels after filling.

### Closing Torques for Fittings

Below are recommended closing torques for plastic drum plugs. Closing plastic drums to these torques after filling will return your drums to full performance levels for their UN markings, which is required for shipping. (Note: Torque values assume clean, dry plugs and openings. Avoid over torqueing.)

#### Closing Torques for Drums Marked 1H1 (Tight Head), Packing Group Y (ft.-lbs.)

Plastic plug	3/4"	2"
Buttress	n/a	20
NPT	9	20

#### Closing Torques for Drums Marked 1H2 (Open Head), Packing Group Y (ft.-lbs.)

Plastic plug	3/4"	2"
NPT	5	8

#### Closing Torques for High Performance Drums Marked 1H1 (Tight Head), Packing Group X (ft.-lbs.)

American Buttress	25
Euro-Buttress	55

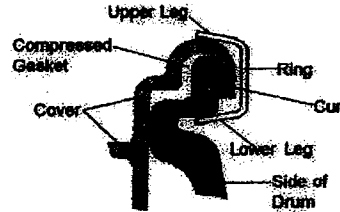
#### Closing Torques for Steel/Plastic Composite Drums Marked 6HA1 (Tight Head) or 6HA2 (Open Head), Packing Group Y (ft.-lbs.)

Plastic plug	3/4"	2"
NPT with gasket	5-8	10-15

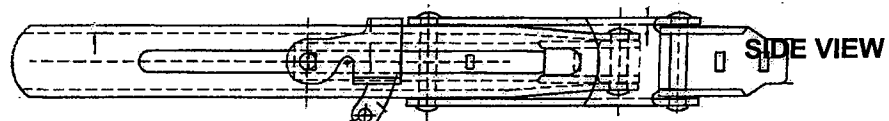
### OPEN HEAD RING CLOSURE REQUIREMENTS

Close drums for shipment by placing ring around drum head and lip. Compress gasket between drum body lip and cover by pressing downward on the drum cover or by tapping ring with mallet while tightening. Use only rings, covers and gaskets supplied with drums.

To ensure components meet performance level requirements, ring is installed right side up when locking tab closes in a down position. Be sure locking tab is secured through slot in ring handle.

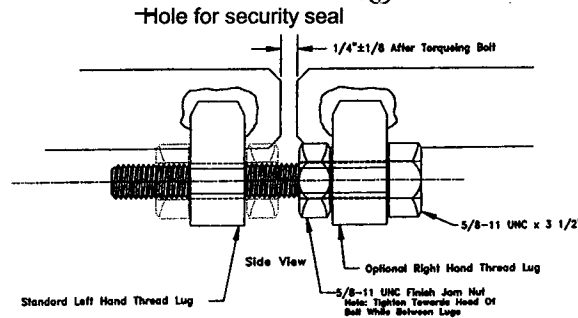


### LEVER LOCK



### BOLT RING CLOSURE

1/4" ± 1/8"



To ensure proper closure, do not exceed ring closure gap.

### SIDE VIEW

**NOTE: Use of other than manufacturer-specified components may void certification and warranty.**

Drums bear a DOT/UN specification mark solely on the basis of use with components specified in design qualification tests. Drums were tested with water or according to specific gravity as marked on the drums and were closed according to closure manufacturer's recommendations. All customers are advised that use of these drums and any components supplied in respect to relevant compatibility is the sole responsibility of the user.