



Rieke® Drum Fitting Closing Instruction

CSC Form # QA-FM-L255

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Manual Hand Tool:

- I. Place the fitting on the top of the container in the threaded opening.
- II. Start turning the fitting to the right, till the threads have started to engage.
- III. Finish installing the fitting with the manufacturers suggested wrench.
- IV. Make sure that the fitting is torqued to the proper specification. (see chart below.)

Pneumatic Hand Tool:

- I. Place the fitting on the top of the container in the threaded opening.
- II. Start turning the fitting to the right, till the threads have started to engage.
- III. Finish installing the fitting by using the pneumatic tool.
- IV. Make sure that the fitting is torqued to the proper specification. (see chart below.)

2" Plugs

<u>Gasket</u>	<u>Material</u>	<u>Plastic Plug</u>	<u>Steel Plug</u>	<u>Oven Temp</u>
G-43	Buna	20 ft-lbs	30 ft-lbs	450 F
G-43w	White Buna	20 ft-lbs	30 ft-lbs	450 F
G-73-2	L. D. Polyethylene	9 ft-lbs	30 ft-lbs	120 F
G-73-3	Irradiated L. D. Polyethylene	9 ft-lbs	30 ft-lbs	375 F
G-79	L. D. Polyethylene	20 ft-lbs	Not Available	Not Available
G-83	Dapon	20 ft-lbs	30 ft-lbs	450F
G-93	E.P.T	20 ft-lbs	30 ft-lbs	450 F
G-93w	White EPT	20 ft-lbs	30 ft-lbs	450 F
G-99w	White EPT	20 ft-lbs	Not Available	Not Available

3/4" Plugs

G-41	Buna	9 ft lbs	15 ft lbs	450 F
G-41w	White Buna	9 ft lbs	15 ft lbs	450 F
G-71-2	L. D. Polyethylene	9 ft lbs	20 ft lbs	120 F
G-71-3	Irradiated L. D. Polyethylene	9 ft lbs	20 ft lbs	375 F
G-81w	Dapon	9 ft lbs	15 ft lbs	450 F
G-91	E.P.T	9 ft lbs	15 ft lbs	450 F
G-91w	White EPT	9 ft lbs	15 ft lbs	450 F

Signature: _____