



## Rieke® Drum Fitting Closing Instructions

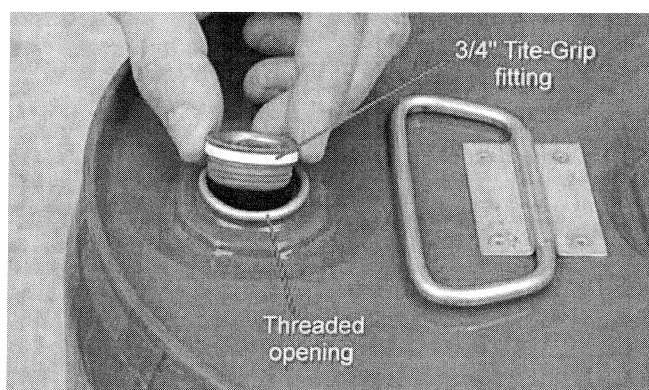
Document: QA-FM-L255 Date: 4/5/13 Rev: 6 Page: 1 of 4

### Rieke® Tite-Grip and Vice-Grip Drum Fitting Closing Instructions

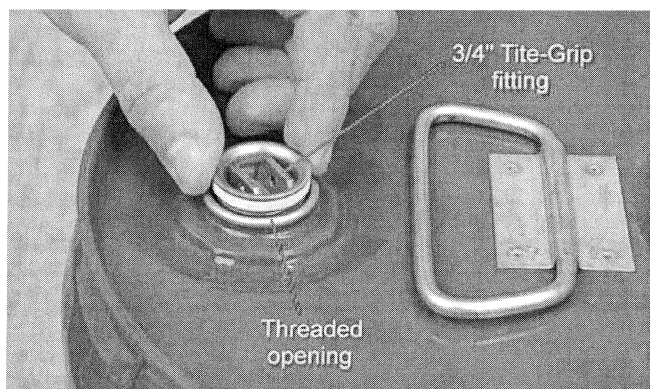
#### 3/4" Rieke® Tite-Grip Fitting (Steel)

*Step 1*--Place the pail on a flat surface.

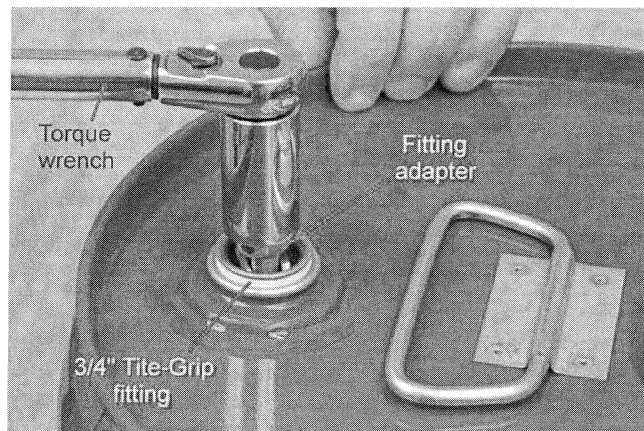
*Step 2*-- Place the fitting on the top of the pail in the threaded opening.



*Step 3*--Rotate the fitting clockwise to engage the threads in the opening.



*Step 4*--Thread the fitting into the opening and tighten it using a (1) custom-made fitting adapter for a torque wrench, or a (2) pre-set torque wrench from the manufacturer.

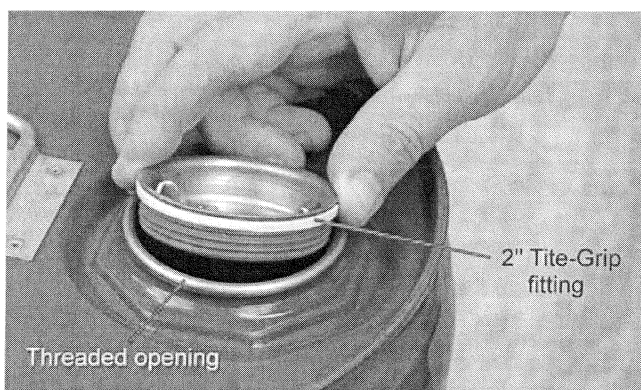


*Step 5*--Be sure the fitting is tightened to the proper specification (refer to the table on page 4).

#### 2" Rieke® Tite-Grip Fitting (Steel)

*Step 1*--Place the pail on a flat surface.

*Step 2*-- Place the fitting on the top of the pail in the threaded opening.

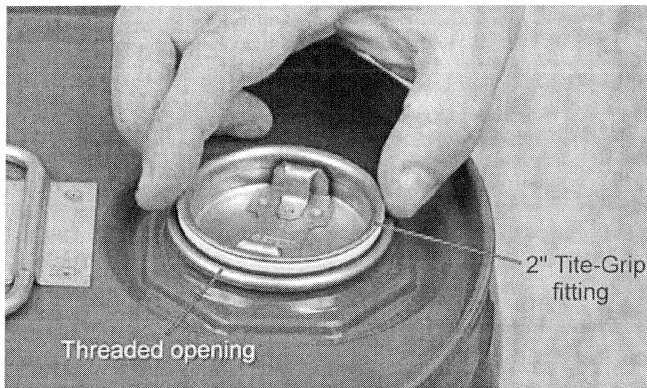


*Step 3*--Rotate the fitting clockwise to engage the threads in the opening.

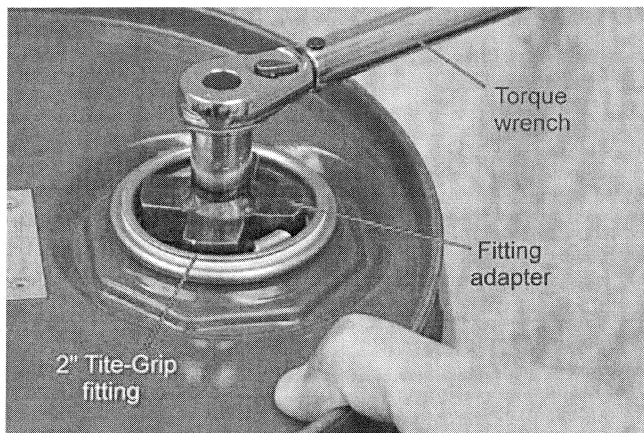


## Rieke® Drum Fitting Closing Instructions

Document: QA-FM-L255 Date: 4/5/13 Rev: 6 Page: 2 of 4

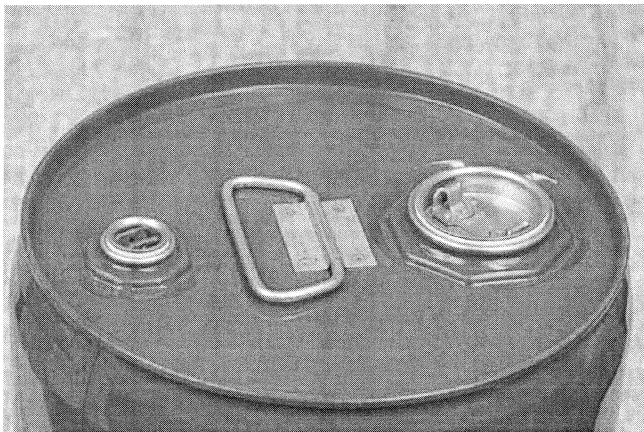


**Step 4**--Thread the fitting into the opening and tighten it using a custom-made fitting adapter for a torque wrench.



**Step 5**--Be sure the fitting is tightened to the proper specification (refer to the table on page 4).

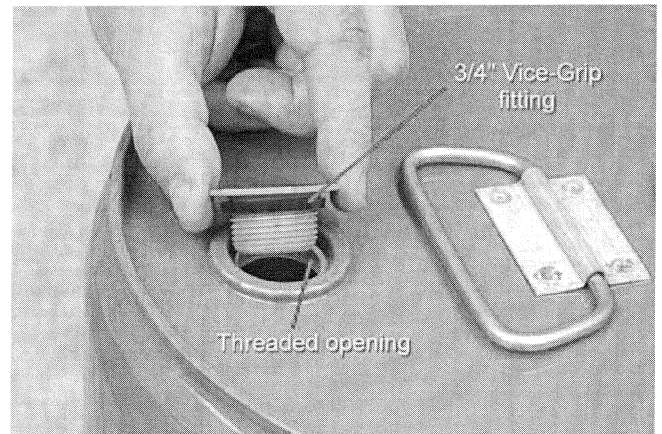
**Note:** The photograph below illustrates both fittings correctly installed in the pail cover



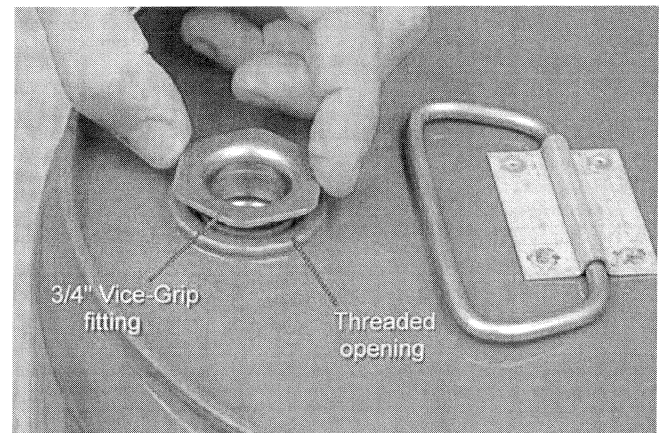
### 3/4" Rieke® Vice-Grip Fitting (Steel)

**Step 1**--Place the pail on a flat surface.

**Step 2**-- Place the fitting on the top of the pail in the threaded opening.



**Step 3**--Rotate the fitting clockwise to engage the threads in the opening.

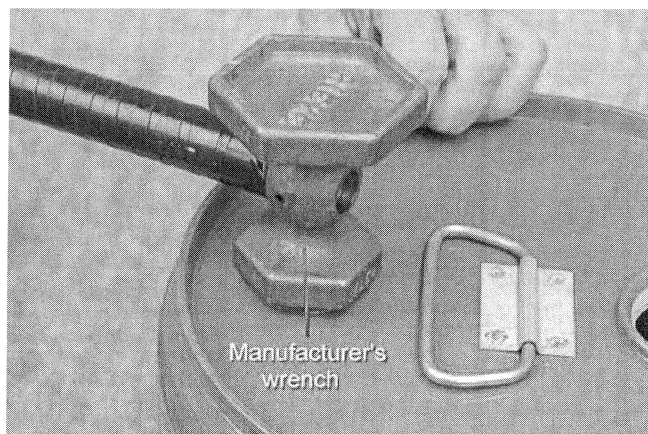


**Step 4**--Thread the fitting into the opening and tighten it using a pre-set torque wrench from the manufacturer.



## Rieke® Drum Fitting Closing Instructions

Document: QA-FM-L255 Date: 4/5/13 Rev: 6 Page: 3 of 4

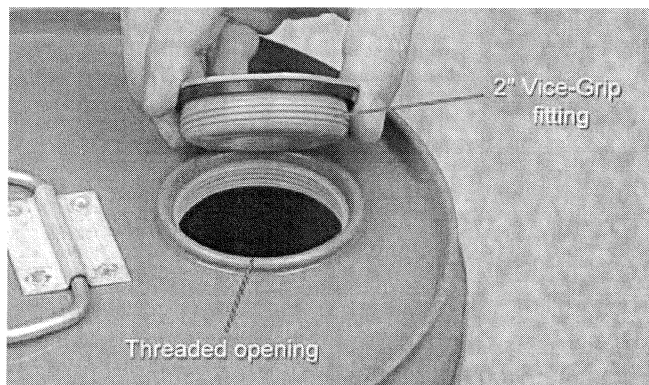


*Step 5*--Be sure the fitting is tightened to the proper specification (refer to the table on page 4).

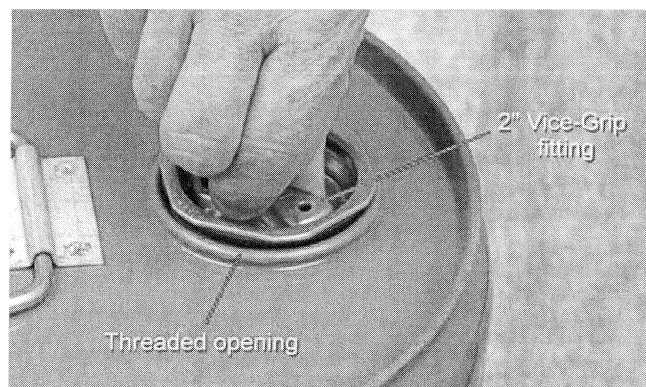
### 2" Rieke® Vice-Grip Fitting (Steel)

*Step 1*--Place the pail on a flat surface.

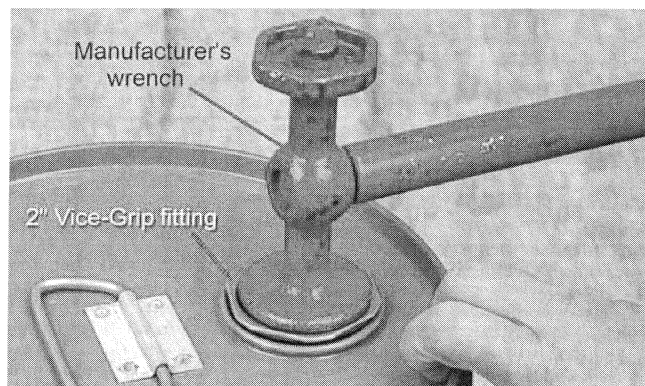
*Step 2*-- Place the fitting on the top of the pail in the threaded opening.



*Step 3*--Rotate the fitting clockwise to engage the threads in the opening.

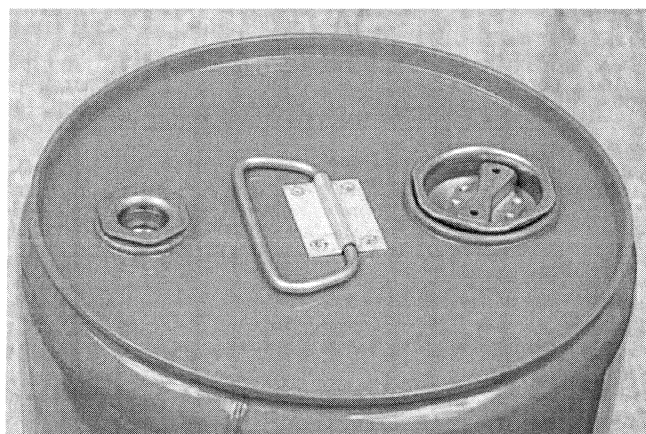


*Step 4*--Thread the fitting into the opening and tighten it using a pre-set torque wrench from the manufacturer.



*Step 5*--Be sure the fitting is tightened to the proper specification (refer to the table on page 4).

**Note:** The photograph below illustrates both fittings correctly installed in the pail cover





**Rieke® Drum Fitting Closing Instructions**

Document: QA-FM-L255 Date: 4/5/13 Rev: 6 Page: 4 of 4

**2" Plugs**

<b>Gasket</b>	<b>Material</b>	<b>Plastic Plug</b>	<b>Steel Plug</b>	<b>Oven Temp</b>
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	LD Polyethylene	9 ft-lbs	30 ft-lbs	120° F
G-73-3	Irradiated LD Polyethylene	9 ft-lbs	30 ft-lbs	375° F
G-79	LD Polyethylene	20 ft-lbs	N/A	N/A
G-83	Dapon	20 ft-lbs	30 ft-lbs	450° F
G-93	EPT / EPDM	20 ft-lbs	30 ft-lbs	450° F
G-93w	White EPT / EPDM	20 ft-lbs	30 ft-lbs	450° F
G-99w	White EPT / EPDM	20 ft-lbs	N/A	N/A

**3/4" Plugs**

<b>Gasket</b>	<b>Material</b>	<b>Plastic Plug</b>	<b>Steel Plug</b>	<b>Oven Temp</b>
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	LD Polyethylene	9 ft-lbs	20 ft-lbs	120° F
G-71-3	Irradiated LD Polyethylene	9 ft-lbs	20 ft-lbs	375° F
G-81w	Dapon	9 ft-lbs	15 ft-lbs	450° F
G-91	EPT / EPDM	9 ft-lbs	15 ft-lbs	450° F
G-91w	White EPT / EPDM	9 ft-lbs	15 ft-lbs	450° F





## Tri-Sure® Drum Fitting Closing Instructions

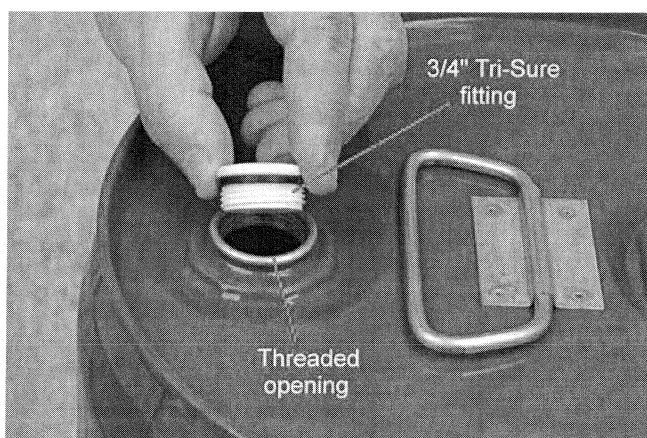
Document: QA-FM-L256 Date: 4/5/13 Rev: 7 Page: 1 of 3

### Tri-Sure® Drum Fitting Closing Instructions

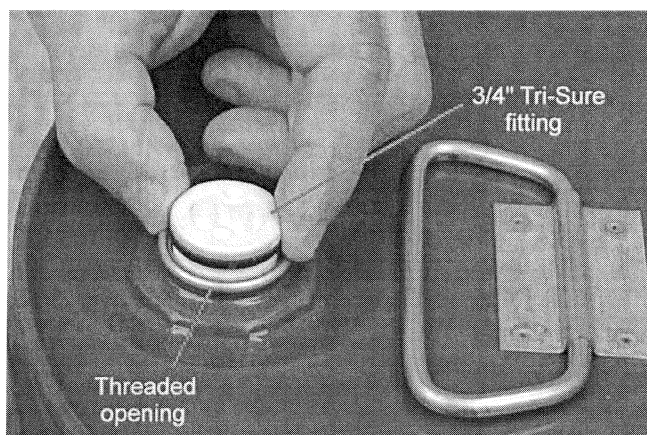
#### 3/4" Tri-Sure® Fitting (Plastic)

*Step 1*--Place the pail on a flat surface.

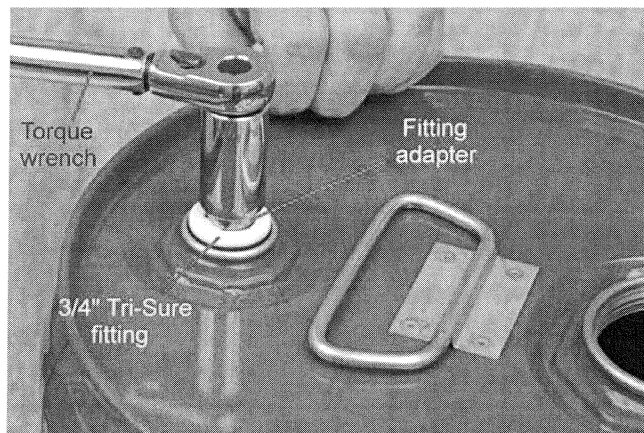
*Step 2*-- Place the fitting on the top of the pail in the threaded opening.



*Step 3*--Rotate the fitting clockwise to engage the threads in the opening.



*Step 4*--Thread the fitting into the opening and tighten it using a (1) custom-made fitting adapter for a torque wrench, or a (2) pre-set torque wrench from the manufacturer.

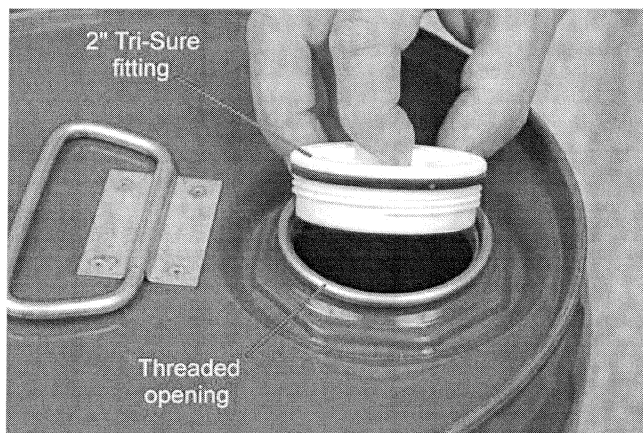


*Step 5*--Be sure the fitting is tightened to the proper specification (refer to the table on page 3).

#### 2" Tri-Sure® Fitting (Plastic)

*Step 1*--Place the pail on a flat surface.

*Step 2*-- Place the fitting on the top of the pail in the threaded opening.

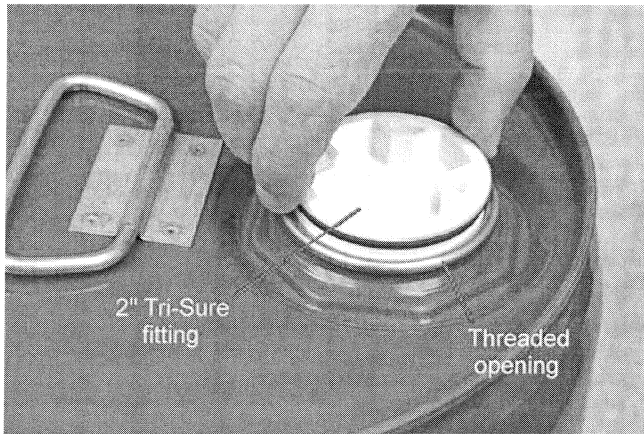


*Step 3*--Rotate the fitting clockwise to engage the threads in the opening.

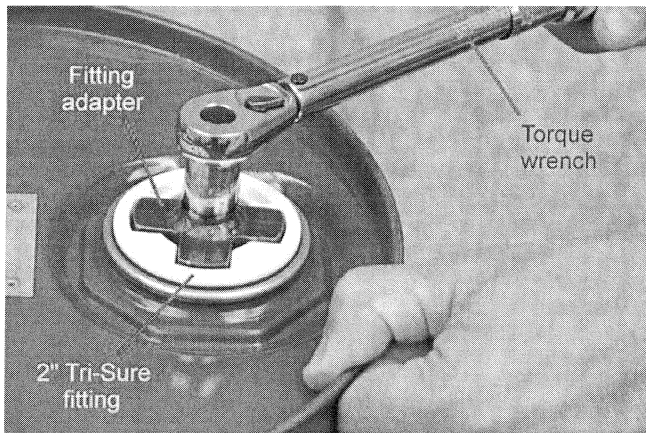


## Tri-Sure® Drum Fitting Closing Instructions

Document: QA-FM-L256 Date: 4/5/13 Rev: 7 Page: 2 of 3

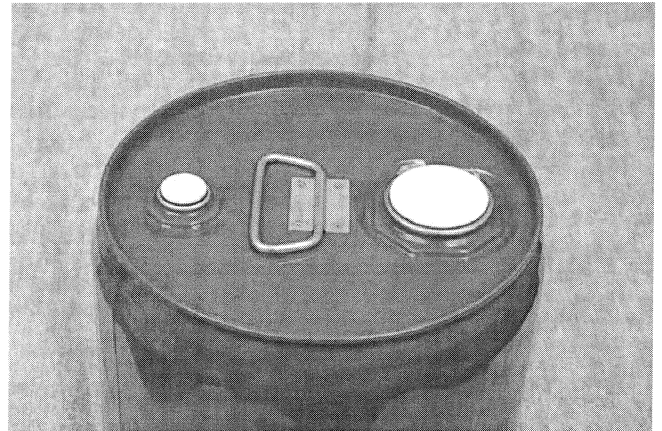


**Step 4--**Thread the fitting into the opening and tighten it using a (1) custom-made fitting adapter for a torque wrench, or a (2) pre-set torque wrench from the manufacturer.



**Step 5--**Be sure the fitting is tightened to the proper specification (refer to the table on page 2).

**Note:** The photograph below illustrates both fittings correctly installed in the pail cover



### 2" Plugs

Material	Plastic Plug	Steel Plug	Oven Temp
Black Buna	20 ft-lbs	30 ft-lbs	450° F
White Buna	20 ft-lbs	30 ft-lbs	450° F
Irradiated LD Polyethylene	20 ft-lbs	30 ft-lbs	375° F
LD Polyethylene	20 ft-lbs	30 ft-lbs	120° F
Dapon	20 ft-lbs	30 ft-lbs	450° F
EPT / EPDM	20 ft-lbs	30 ft-lbs	450° F
White EPT / EPDM	20 ft-lbs	30 ft-lbs	450° F

**Tri-Sure® Drum Fitting Closing Instructions**

Document: QA-FM-L256 Date: 4/5/13 Rev: 7 Page: 3 of 3

**3/4" Plugs**

Material	Plastic Plug	Steel Plug	Oven Temp
Black Buna	9 ft-lbs	15 ft-lbs	450° F
White Buna	9 ft-lbs	15 ft-lbs	450° F
Irradiated LD Polyethylene	9 ft-lbs	15 ft-lbs	375° F
LD Polyethylene	9 ft-lbs	15 ft-lbs	120° F
Dapon	9 ft-lbs	15 ft-lbs	450° F
EPT / EPDM	9 ft-lbs	15 ft-lbs	450° F
White EPT / EPDM	9 ft-lbs	15 ft-lbs	450° F