

CLOSING INSTRUCTIONS

CARBON & STAINLESS STEEL DRUMS with BOLT RING CLOSURES
— READ ALL INSTRUCTIONS COMPLETELY —

OPEN HEAD DRUM - BOLT RING CLOSURE

- In compliance with **DOT 49 CFR §178.2 (c)**, persons shipping Skolnik drums must comply with the following closure instructions. Failure to do so will invalidate the UN and 7A ratings of Skolnik drums.
- Use of components other than those supplied with the drum (or identical replacement parts from Skolnik) will also invalidate the UN rating.

STEP 1: CHECK GASKET – inspect cover gasket is properly fitted in cover groove (fig 1 or 2).

STEP 2: PLACE COVER ON DRUM – (fig 3) being careful to properly seat gasket around curl.

STEP 3: POSITION & SEAT RING – with lugs downward. Ensure the inner channel of the closure ring engages entire drum curl and cover (fig 4). Apply downward pressure on cover, use a rubber mallet to hammer ring to further seat ring, cover & drum curl into inner channel of ring.

STEP 4: INSTALL BOLT – insert bolt through unthreaded lug, screw bolt into locking nut, then into threaded lug (fig 5).

STEP 5: CLOSE DRUM – tighten bolt (using downward pressure on the cover and hammering outside of ring with a rubber mallet will assist closing process). Continue tightening and hammering ring until the ends of the ring reaches the maximum gap shown in the chart below.

NOTE: Ring ends **should not touch** and ring must be in a fixed position. The lock nut must be tightened against the un-threaded lug. (fig 6)

RING GAP REQUIREMENTS		
DRUM SIZE	U.N. MARKINGS	MAX GAP
5 – 16 gal	liquid & solid	.500" (12.70 mm)
20 – 110 gal	liquid & solid	.125" (3.175 mm)
5 – 110 gal	solids only	1.00" (25.4 mm)
55 gal composite	liquid	.850 (21.95 mm)
55 gal 7A rating	solids only	OPTION A: close to 1" gap, then torque to 25 ft-lbs OPTION B: close to .125" gap

PERFORMANCE NOTICE:

Ring gap compliance is critical for the performance of Skolnik drums. Closure is assured by compressing the cover and gasket to the drum body. This is achieved when the final tightened ring gap (therefore final ring diameter) meets the specifications listed.

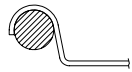


Figure 1



Figure 2

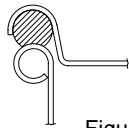


Figure 3

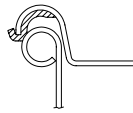


Figure 4

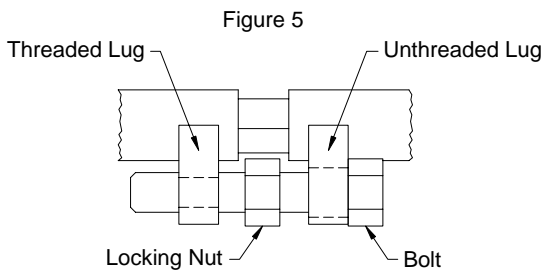


Figure 5

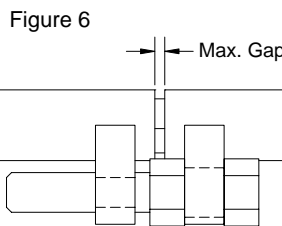


Figure 6

IMPORTANT:

Please contact Skolnik Industries for further instructions if encountered with difficulties in meeting the above requirements.

Do not ship the drum.

OPEN AND CLOSED HEAD DRUMS WITH FITTINGS

STEP 1: CHECK GASKETS – inspect plugs for proper gasket seating

STEP 2: INSTALL PLUG – do not cross thread

STEP 3: TIGHTEN – use specification listed below:

PLUG TYPE GASKET TYPES	Tri-Sure		Rieke (plastic)	Rieke (steel)		Nuc-Fil filters
	Buna	poly or Teflon	—	poly	all other	
¾" plug	12 ft-lbs	20 ft-lbs	9 ft-lbs	20 ft-lbs	15 ft-lbs	8 - 12 ft-lbs
2" plug	20 ft-lbs	30 ft-lbs	20 ft-lbs	40 ft-lbs	30 ft-lbs	—

NOTE:

Skolnik Industries can supply torque wrenches for plugs.

IMPORTANT

- 1 Under the applicable DOT regulations, any changes made to the method of closure or closure components constitute a change in the design type of this packaging, and invalidate the embossed certification.
- 2 After filling and prior to transport, the shipper should check the tightness of closures to determine if the effects of heating, cooling or gasket relaxation have resulted in the need to tighten the closure.
- 3 Drums (other than the composites) are tested at room temperature.

Please contact Skolnik Industries with questions regarding this information.

Revised February 18, 2005 by Skolnik Industries

CLOSING INSTRUCTIONS

CARBON & STAINLESS STEEL DRUMS
with LEVERLOCK RING CLOSURES
— READ ALL INSTRUCTIONS COMPLETELY —

OPEN HEAD DRUM - LEVERLOCK CLOSURE

- Step 1 CHECK GASKET** - ensure gasket is properly fitted into cover groove.
- Step 2 PLACE COVER ON DRUM** - (Fig 3) being careful to properly seat gasket around curl.
- Step 3 OPEN LEVERLOCK** - place expanded ring on to the drum cover with the vertical-skirt hugging the drum body.
- Step 4 CLOSE LEVERLOCK** - slowly and cautiously close the LEVERLOCK so that the outer ring engages the cover / body juncture. Downward pressure along with tapping the outside of the ring may assist in an even closure
- Step 5 ENGAGE LOCK** - engage latch to lock into place.



OPEN AND CLOSED HEAD DRUMS WITH FITTINGS

- STEP 1: CHECK GASKETS** – inspect plugs for proper gasket seating
- STEP 2: INSTALL PLUG** – do not cross thread
- STEP 3: TIGHTEN** – use specification listed below:

PLUG TYPE GASKET TYPES	Tri-Sure		Rieke (plastic)	Rieke (steel)		Nuc-Fil filters
	Buna	poly or Teflon	—	poly	all other	
¾" plug	12 ft-lbs	20 ft-lbs	9 ft-lbs	20 ft-lbs	15 ft-lbs	8 - 12 ft-lbs
2" plug	20 ft-lbs	30 ft-lbs	20 ft-lbs	40 ft-lbs	30 ft-lbs	—

NOTE:
Skolnik Industries
can supply torque
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IMPORTANT

- 1** Under the applicable DOT regulations, any changes made to the method of closure or closure components constitute a change in the design type of this packaging, and invalidate the embossed certification.
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