



DOT/UN performance certification specification for HDPE plastic 275 and 330 gallon Intermediate Bulk Containers, and poly open-head and tight-head drums, as provided by the manufacturers in compliance with 49 CFR 178.2(c).

## Intermediate Bulk Container (IBC) Closure Instruction

Manufacturer	2" Bung NPT/Buttress	3/4" NPT	IBC 6" Lid
GNX	18	9	80
Greif	20	9	45
Encore	20	9	70
Mauser	20	9	70
Schuetz	30	9	75

**Torque specifications in foot-pounds**

## Poly Drum Closure Instruction

For plastic (poly) open-head and tight-head drums with poly bungs, specifications are as follows:

2" NPT or buttress thread: 30 foot-pounds

¾" NPT: 9 foot-pounds

**Note: All bungs must have gaskets to seal properly.**

For open-head drums with closure rings and covers:

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

For open-head drums with lever lock style rings:

Ring is installed right side up when the locking tab closes in down position. Be sure locking tab is secured through slot in ring handle.

For open-head drums with bolt style ring:

To ensure proper closure, do not exceed ring gap closure of ¼" after tightening.