

UN/DOT CLOSURE REQUIREMENTS

DOT CLOSURE REQUIREMENTS FOR THE 22" DRUM RINGS WITH MULTISEAL GASKET

Per 49 CFR 178.2(c)(1)(ii), the below listed closure and gasket information should be followed:

Metal 31A and 31B Closure Descriptions

<p>2" and 3" threaded fittings with all gasket materials except Teflon</p>	<p>3/8-1/2 rotations beyond full/solid gasket contact or minimum torque value of 30 ft-lbs</p>
<p>2" and 3" threaded fittings with Teflon gasket</p>	<p>1/8-3/16 rotations beyond full/solid gasket contact or minimum torque value of 60 ft-lbs</p>
<p>22" drum rings with multiseal gasket Seat the ring by striking with non sparking mallet such as a rubber mallet around the circumference of the ring. Tighten the 5/8" bolt and then restrike the ring with the mallet. Alternate between tightening and striking until the bolt tightening resistance does not change</p>	<p>3/8-1/2" gap between clamp ring ends or minimum torque value of 40 ft-lbs</p>

Poly and Composite IBCs and Non-bulk Containers

<p>6.5" Cap (includes all gaskets and version of cap)</p>	<p>1/8-1/6 rotations beyond full/solid gasket contact or minimum torque value of 120 ft-lbs</p>
<p>6" Heavy Duty Cap and 7" cap (includes all gaskets and version of caps)</p>	<p>1/8-1/6 rotations beyond full/solid gasket contact or minimum torque value of 75 ft-lbs</p>
<p>2" NPS (NPT) Threaded Closure (includes all gaskets and NPS (NPT) plugs, manual or automatic pressure/vacuum vents, and drum/macro valves)</p>	<p>3/8-1/2 rotations beyond full/solid gasket contact or minimum torque value of 20 ft-lbs</p>

2" Buttress Threaded Closure
(includes all gaskets and Reike buttress or
Entegris buttress threaded plugs, draw tubes,
dry breaks, drum valves, and macro-valve)

1/8-3/16 rotations beyond full/solid gasket
contact or minimum torque value of 25 ft-lbs

Bottom drain valves

Screw in until 0-3 threads remain visible.
The exterior compression clamp should be
tightened until it cannot be rotated around the
tabulation. A leak test per 49 CFR 178.813 is
required after valve installation

The IBC manufacturer does not recommend using torque values as a reliable method to install fittings and caps. They recommend using closure instructions that specify solid gasket contact plus a set amount for more rotation of the fitting. If you are going to use torque valves to minimize your chance of a leak, please reference the manufacturer closure instructions.