

Elkhart Plastics Closure Notification for U.N. Marked Container

In compliance with Title 49 Code of Federal Regulations [CFR 49 §178.22-Shipper’s responsibility] the Department of Transportation (DOT) requires the closing information to be provided to any person to whom this container is transferred to and who may need to close the container prior to shipment. It is the shipper’s responsibility as set for in CFR 49 §173.22(a)(4) to ensure that the closing instructions are carried out as specified. The following information on closure specification is utilized by Elkhart Plastics in the sealing and torque specification for the Elkhart Plastics IBC tanks only and not intended for use on other packaging manufactures.

Prior to Closing:

Inspect each closure to ensure the closure has the proper gasket and that both the closure and gasket are in good working condition. You should inspect the sealing surface for any damages and make sure the threads and sealing surfaces are dry. Replace any defective gaskets, plugs or lids with new, defect free parts as sold with the original packaging.

Closure Procedure for Lids, Caps, Fittings & Plugs:

All UN 31H2 IBC's [49CFR § 178.706(a)(6)] containers that are supplied with lids and service equipment must be closed for shipment using only the components supplied and specified in design qualification tests for that IBC.

- a. After closure, gaskets and sealing surface are inspected, position the enclosure with gasket in place.
- b. Thread the closure by hand until the gasket is in contact with the sealing surface.
- c. Using the appropriate closure adaptor and torque wrench, tighten closure to the recommended torque. Pre-set recommended torque requirement and tighten until torque is reached when the wrench releases or clicks.

Closing Procedures for outlet valve:

- a. After inspection, position the valve with gasket in place on the bottom threaded opening of the IBC.
- b. Thread the valve on by hand until the gasket is in contact with the sealing surface.
- c. Valve handle orientation should be positioned to allow handle to be full open and full closed position
- d. Using the valve tool and torque wrench, tighten valve to the recommended torque. Recommended torque is reached when the wrench releases or clicks.
- e. **ALL VALVES MUST HAVE A SECONDARY SEAL CAP INSTALLED ON OUTLET PRIOR TO SHIPMENT.**

The chart below contains recommended torque levels for Elkhart Plastics U.N. marked IBC components and fittings.	
6" Heavy Duty Threaded Closure Lid (includes all gaskets & other cap variations)	75 Ft-Lbs torque
9" Heavy Duty Threaded Closure Lid (includes all gaskets & other cap variations)	75 Ft-Lbs torque
2" Buttress thread port fittings (includes all gaskets & closures fittings)	25 Ft-Lbs torque
2" NPS (NPT) thread port fittings (includes all gaskets and closures, except for the 2" NPS drum bung plug fittings)	5 Ft-Lbs torque
2" NPS drum bung plugs (includes all gaskets)	12.5 Ft-Lbs torque
2" NPS Relief Vents (includes all gaskets)	35 In-Lbs torque
1" NPS Vent Plugs (includes all gaskets)	35 In-Lbs torque
1" to 3" Cam-Lock Components (includes all gaskets and closures types)	Rotate lever arms in the locked position, check for positive connection

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Replacement or removal of the following components is to be considered a repair and container(s) should to be tested, inspected and marked in accordance to CFR 49 §178.352	
2" Replaceable NPS Adapters <i>(includes all gaskets)</i>	50 Ft-Lbs torque
2" Bottom Tuff LinQ Ball Valve <i>(includes all gaskets)</i>	50 Ft-Lbs torque
2" Bottom Split-Ring Ball Valve <i>(includes all gaskets)</i>	20 Ft-Lbs torque
Bottom drain valve orientation	45° handle orientation
Bottom drain valve anti-rotation	700351 (3M 4693) adhesive applied to female valve threads, (3) threads wide minimum, 360° full thread depth

Note: P-80® IFC Temporary Lubricant *(FDA & NSF Compliant)* is recommended on all elastomeric gaskets and O-rings prior to assembly.

The most current revision of Elkhart Plastics Closure Instructions can be viewed and download from our website at: <https://www.epi-roto.com/tuff-series-ibcs/>