

**IBC CLOSING INSTRUCTIONS FOR REBOTTLED & RECONDITIONED TOTES**

**“ REPAIRED REMANUFACTURED, AND RECONDITIONED”**

All rebottled totes must be closed in the same manner as they were closed when initially design tested.

All UN3HA1 Composite IBC'S 49 CFR 178.707 (a)(5) that are supplies with lids, cages, pallets and service equipment must be closed for shipment using only the components supplies and specified in the design qualification test fir that IBC.

Below are the closing instructions, as provided by Mauser, Schuetz, Greif, and Ten-Labs the third party department of Transportation approved laboratory who performed the initial design qualification and periodic testing.

**Prior to Closing:** Inspect each closure to ensure that the closure has the proper gasket and that both closure and gasket are in good condition. Inspect the sealing surface for damage and make sure that threads are sealing surfaces are dry. Replace any defective gaskets, plugs, or lids with new defect free parts.

- a. Place the lid with gasket in place on top opening of the IBC.
- b. Screw the lod by hand until the gasket is in contact with the sealing surface.
- c. Using a lid adaptor and torque wrench tighten the lid to the recommended torque valves in the chart below. Recommended torque is reached when the wrench releases or clicks.
- d. Place the plug or cap with the gasket in place into the lid.
- e. Screw the plug or cap by hand until the gasket is in contact with the sealing surface.
- f. Using a cap or plug adaptor and torque wrench tighten the lid to the recommended torque values in the cart below. Recommended torque is reached when the wrench releases or clicks.
- g. Preset torque wrenches or adjustable wrenches are suitable for these procedures.

**SCHUETZ, MASTER AND Greif COMBINATIONS:**

	<u>Mauser</u>	<u>Schuetz</u>	<u>GREIF</u>
Lid with Sabtoprene, natural rubber, Viton or Epdm gaskets.... after gasket contact, then torque to 45 'ft./lbs	70 ft lbs	75 ft lbs	Tighten ½ turn
2" inch plug or cap with EPDM or Viton gasket.....	20-25 ft-lbs	15 ft-lbs	20'ft/lbs.
¾ inch plug inserted into center of 6" in head cap.....	20 ft lbs.	15 ft-lbs	9'ft./lbs