

# The PolyCube Company

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**Closure Instructions**  
**March 2015**  
**Updated July 23, 2015**  
**Updated November 30, 2015**  
**Updated December, 2015**

Pursuant to the requirements of the Department of Transportation in CFR 49 Part 178.2 (c), this is your notification of the closing method used for the containers sold to you. This method of closure should be used to ensure that your containers have been closed in the same manner as when they were initially tested. If there is any question regarding proper closing methods, contact your local PolyCube salesperson or manufacturing facility. Retain this form for your records; Department of Transportation requires one year retention of this record (CFR49.178.2 (c) (2)).

**PRIOR TO CLOSING ALL PACKAGES BELOW:**

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 the threads and sealing surfaces are dry and in good condition.

**SCREW CAP TYPES:**

Regulated PolyCube containers have been designed and tested to accept the following Calico Closures as well as all acceptable "like" substitution closures as defined in the Department of Transportation Title 49 CFR; Performance Oriented Packaging Standards Section 178 : Calico 70mm, 70MEM, 70TE, 80, 80MEM, 80TE, 76, 76TE, 76MEM, 86, 86MEM, 86TE

**TO CLOSE:**

- 1) With the cap in good condition and gasket properly seated, apply the cap by hand, by pressing cap down over the neck finish and rotating in a clockwise rotation to engage cap to neck finish threads.
- 2) Once thread engagement is started, tighten to 12 foot pounds using a calibrated and proper torque wrench with a proper fitting cap adapter.

## **CRIMP CLOSURE TYPES:**

Regulated PolyCube containers have been designed and tested to accept the following Rieke and acceptable “like” substitution closures as stated in the Department of Transportation Title 49 CFR; Performance Oriented Packaging Standards Section 178 : FS10-6-300 Flex Spout Crimp On Closure

*TO CLOSE:* The Rieke Closure mentioned above is a Crimp On style closure that requires the use of a Rieke FS-600 Manual Crimp Tool, or a Rieke IAFS-600 Pneumatic Crimp tool to properly crimp the closure.

- 1) With the cap in good condition, apply the cap by hand, by pressing cap down over the neck finish evenly and flat.
- 2) Place the Crimp Tool over the closure and with an even downward pressure.
- 3) If using the FS-600 Manual Crimp tool, push the crimping levers of the crimp tool down and crimp the closure to the container. If using the IAFS-600 Pneumatic Crimp tool, push the trigger button on the unit to crimp the closure to the container. Be sure not to cock the closure on the neck of the container. This will result in an insufficient seal.
- 4) Inspect the closure after crimping to ensure it was properly crimped under the locking bead of the neck finish. If the closure has been crimped across or over the locking bead, it has an improper crimp.
- 5) If an improper crimp occurs, the locking bead on the neck will most likely be damaged. PolyCube recommends that a container which has been improperly crimped not be used and should be discarded.

## **2 INCH BUTRESS INTERNAL TYPES:**

Regulated PolyCube containers have been designed and tested to accept the following Rieke Closure as well as all acceptable “like” substitution closures as defined in the Department of Transportation Title 49 CFR; Performance Oriented Packaging Standards Section 178 : Rieke

*TO CLOSE:*

- 1) With the cap in good condition and gasket properly seated, apply the cap by hand, by pressing cap down into the neck and rotating in a clockwise rotation to engage cap to neck finish threads.
- 2) Once thread engagement is started, tighten to 25 foot pounds using a calibrated and proper torque wrench with a proper fitting cap adapter.

## **24 MM VENT STEM CLOSURE TYPES:**

Regulated PolyCube containers have been designed and tested to accept the following BeriCap Closure as well as all acceptable “like” substitution closures as defined in the Department of Transportation Title 49 CFR; Performance Oriented Packaging Standards Section 178 : BeriCap

### *TO CLOSE:*

- 1) With the cap in good condition and gasket properly seated, apply the cap by hand, by pressing cap down over the neck and rotating in a clockwise rotation to engage cap to neck finish threads.
- 2) Once thread engagement is started, tighten to 3.5 foot pounds using a calibrated and proper torque wrench with a proper fitting cap adapter.

**\*\* For containers with 2 inch internal buttress type closures the torque requirement is 4 foot pounds\*\***

## **55 - 30 Gallon Open Head**

### *TO CLOSE:*

- 1) Place cover on drum.
- 2) Firmly apply downward pressure on the lid to snap the cover into the drum opening.
- 3) Snap the closing ring over the cover and top lip of drum. Make sure that the writing on the closure lever is right side up. Also make sure that the bottom edge of the closing ring engages under the top lip of the drum.
- 4) Pull the locking lever closed, at the same time, tap the outside edge of the closing ring, beginning directly opposite the closing lever, with a rubber mallet until the lever is fully closed against the edge of the ring.
- 5) Snap the latch into the lever until it locks.
- 6) Drums closed in the manner have met the UN performance test requirements as specified in the container markings.
- 7) If the Flat Container Accessories cover has bung openings the bungs must be torque as follows: 2 inch to 20 foot -pounds – ¾ inch 9 foot - pounds.
- 8) If the Ribbed IPCC cover has bung openings the bungs must be torque as follows: 2 inch to 20 foot pounds and the ¾ inch to 7 foot pounds.