

Varicon, LLC

Plastic Container Closing Instructions

All Containers identified and marked as found below must be closed for shipment using only the components supplied and specified in the design qualification tests according to the following installation instructions.

Instructions should be observed for all Regulated and Non-Regulated material fills.

30 - 55 Gallon Non-Removable Head Drums: UN 1H1, 49 CFR 178.509(a)(1)

Drum Mfg.	Plug Description*	2" Plug Torque (Ft. Lbs.)
Varicon	2" Buttress and 2" NPT plug (solid or vented)	25
Mauser	2" Buttress and 2" NPT plug (solid)	20

Ensure closure threads are dry prior to insertion of plugs.

30 - 60 Gallon Removable Head Drums: UN 1H2, 49 CFR 178.509(a)(2)

Drum Body Mfg.	Lid / Plug Description*	2" Plug Torque (Ft. Lbs.)	3/4" Plug Torque (Ft. Lbs.)
Varicon	Solid Lid (no openings for plugs)	n/a	n/a
Varicon	2" NPT plug (solid) and 3/4" NPT plug (vented) self-seal	see (4)	see (4)
Mauser	2" NPT plug (solid) and 3/4" NPT plug (vented) self-seal	see (4)	see (4)
Greif	2" NPT plug (solid) and 3/4" NPT plug (vented) self-seal	see (4)	see (4)

- 1) Place lid with gasket on sealing surface of drum body.
- 2) With steel locking ring over lid, press down on lid and close ring lever and flip latch to secure lid on drum body.
- 3) Ensure lid is uniformly covered by locking ring and ring has proper fit with drum body.
- 4) **Tighten any plugs an additional quarter turn after gasket contact or plug contact is made with lid sealing surface.**

275 - 330 Gallon Intermediate Bulk Containers : UN 31HA1, 49 CFR 178.702

Bottle Mfg.	Cap / Plug Description*	6" Cap Torque (Ft. Lbs.)	2" Plug Torque (Ft. Lbs.)	3/4" Plug Torque (Ft. Lbs.)	Valve Nut Torque (Ft. Lbs.)
Varicon	6" solid cap (M5568 embossed on bottle)	50	n/a	n/a	50
Varicon	6" cap w/ 2" NPT plug w/ 3/4" NPT vented plug	50	20	9	50
Varicon	6" cap with 2" NPT plug	50	20	n/a	50
Mauser	6" solid cap (Mauser logo embossed on cap & bottle)	70	n/a	n/a	50
Mauser	6" cap with 2" NPT plug	70	20	n/a	50
Schuetz	6" solid cap (Schuetz logo embossed on cap & bottle)	75	n/a	n/a	55 (old style)**
Schuetz	6" cap with 2" NPT plug	75	20	n/a	55 (old style)**

- 1) Ensure closure thread is dry prior to applying caps and plugs.
- 2) Turn 6" cap clockwise to engage threads and torque all plugs to values on table.
- 3) Ensure Valve w/ Gasket remains torqued to values shown above as assembled by Varicon during processing.
- 4) Ensure Valve Handle remains in the closed position.

****: Schuetz New Style Valves: Two turns & line hole up in valve body and hole on the bottle insert and insert clip.**

*** NOTE: ALL LIDS, CAPS and PLUGS REFERENCED ABOVE HAVE GASKETS EXCEPT "SELF-SEAL" PLUGS.**