

UN MARKED CONTAINER CLOSURE NOTIFICATION

Title 49, Code of Federal Regulations (49 CFR), Part 178 Specifications for Packagings, 178.2(c) requires that manufactures notify each person to whom the packaging is transferred of all requirements not met at the time of transfer. Furthermore, this Paragraph requires that closure instructions/requirements be provided to any person to whom the package is transferred who may need to close the package prior to re-shipment. It is the shipper's responsibility, per 173.22(a)(4) to ensure that all closing instructions are followed.

These closure instructions must be provided to the individual(s) responsible for closing the IBCs prior to shipment. A hard copy must be maintained by the filler or shipper. Copies should be available at the fill lines.

Prior to closing, ensure each closure has the proper gasket and that both closure and gasket are in good condition. Inspect the sealing surface for damages. Replace any defective gaskets, plugs or lids with new defect free parts identical to the original packaging design.

BLOW MOLDED INTERMEDIATE BULK CONTAINER:

CLOSURE	GASKET MATERIAL	MIN. TORQUE VALUE
6" FILL PORT CAP 275 & 330 GALLON IBC	VITON/EPDM	70-75 ft-lbs
PLUG FOR 6" FILL PORT CAP	EPDM & VITON	20-25 ft-lbs

All UN 31HA1 Composite IBCs 49CFR § 178.707 (a) (5) that are supplied with lids, cages, pallets and service equipment must be closed for shipping using only the components supplied and specified in the design qualifications test for that IBC.

1. Place the lid with gasket in place on the top opening of the IBC.
2. Screw the lid by hand until the gasket is in contact with the sealing surface.
3. Using the lid adapter and torque wrench, tighten the lid to the recommended torque. Recommended torque is reached when the wrench releases or clicks.
4. Preset torque wrenches or adjustable torque wrenches are suitable for this procedure, adjustable wrenches are preferred. Either must be calibrated at least annually.

VALVES:

If an IBC valve must be replaced the following procedure should be followed. Only valves specified in the original design qualification are suitable. Replacing an IBC valve constitutes a repair and the person repairing must adhere to the requirements of 49 CFR Part 180 Subpart D 180.350-180.352 Qualification and Maintenance of IBCs.

1. Inspect new unused replacement valve and ensure gasket is clean and free of defects
2. Hand tighten the valve until the threads begin to grip
3. Butterfly and Cylinder Integrated collar valves: using a torque wrench with a valve adapter tighten the valve to a minimum 70 ft-lbs, finishing the installation with the valve in the proper vertical orientation. However, if the wrench reaches 70 ft-lbs and will not orient properly or if 70 ft-lbs cannot be reached, the valve may be cross threaded or have bad threads. Remove valve and repeat with a new valve.
4. Banjo threaded metal collar valves: Holding the valve in a vertical orientation spin the metal collar until hand tight. Using a torque wrench with valve adapter tighten the collar to 50 ft-lbs.
5. Perform leak proof test of empty IBC following 49 CFR 178.813

Note: After filling and prior to transport, it is recommended that the shipper check the tightness of closures to determine if the effects of heating, cooling or gasket relaxation have resulted in the need to tighten the closures.