HM 181 requirements

The Trilla Steel Drum Corporation certifies that the drum(s) we ship meet the requirements stated in part 178, subparts L and M. If, after receiving our drum(s), you, as the filler and most likely the next shipper, alter the drum(s) in any way, you release Trilla Steel Drum Corporation from its responsibilities as the drum manufacturer.

To comply with part 178.2 and to assist the shipper (our customer), we have listed the pertinent information which will enable you (the shipper) to fulfill your responsibility under part 173.22 if the drum(s) we shipped have been altered in any manner from the condition they were at the time of delivery.

		RECOMMENDED MINIMUM TORQUE SPECIFICATION	
TRI-SURE PLUG TYPE –	GASKET TYPE	¾" (20mm)	2" (50mm)
Tri-Sure Steel	Rubber	12 Ft. Lbs.	20 Ft. Lbs.
	Polyethylene & Teflon	20 Ft. Lbs.	30 Ft. Lbs.
Tri-Sure Zinc Die Cast	Rubber	12 Ft. Lbs.	20 Ft. Lbs.
	Polyethylene & Teflon	20 Ft. Lbs.	30 Ft. Lbs.
Tri-Sure Polypropylene & Nylon	Rubber	8 Ft. Lbs.	20 Ft. Lbs.
	Polyethylene	8 Ft. Lbs.	30 Ft. Lbs.
Tri-Sure Polyethylene High Density	Rubber	8 Ft. Lbs.	15 Ft. Lbs.
Tri-Sure Self Gasketing Polypropylene	None(Self-gasketing)	5 Ft. Lbs.	12 Ft. Lbs.

	RECOMMENDED TORQUE SPECIFICATION					
RIEKE CORPORATION	¾"	CODE	2"	CODE	1-1/2"	CODE
Black Visecar	15 Ft. Lbs.	G-41	30 Ft. Lbs.	G-43	30 Ft. Lbs.	G-42
White Visecar	15 Ft. Lbs.	G-41W	30 Ft. Lbs.	G-43W	N/A	N/A
Polyseal	20 Ft. Lbs.	G-71	40 Ft. Lbs.	G-73	40 Ft. Lbs.	G-72
Irradiated Polyseal	20 Ft. Lbs.	G-71-3	40 Ft. Lbs.	G-73-3	N/A	N/A
White Dapon	15 Ft. Lbs.	G-81W	30 Ft. Lbs.	G-83W	N/A	N/A
Black EPT	15 Ft. Lbs.	G-91	30 Ft. Lbs.	G-93	30 Ft. Lbs.	G-91
White EPT	15 Ft. Lbs.	G-91W	30 Ft. Lbs.	G-93W	30 Ft. Lbs.	G-91W
Narrow, Black EPT	N/A	N/A	40 Ft. Lbs.	G-99	N/A	N/A
Narrow, White EPT	N/A	N/A	40 Ft. Lbs.	G-99W	N/A	N/A

When a ring is closed on a drum a ¼" to ½" gap is ideal to allow for the 1/8" plus or minus in the ring length. The two ends should not touch and prevent the ring from closing all the way.

As for torque in foot-pounds required to close a ring, it will vary according to the gasket used or gauge of steel used in a drum.

Tapping on the outside of the ring with a fibre mallet while tightening the bolt will lessen the pressure necessary to close the ring properly.

A 12 gauge or 1A2 ring will take a considerable amount of pressure to close. A torque of Minimum 40 foot-pounds should normally be enough to close the ring. Once the ring is sealed properly and is completely closed, do not apply excessive pressure on the bolt, this could cause the threads of the bolt to tear up making it difficult, if not impossible, to remove the bolt. If locknut is present the locknut should be tight.