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### **IBC Closure Instructions**

**Regulation 49 CFR 178.2C, the Department of Transportation (DOT) requires that we inform our customers of how to properly close container fittings and closure rings in order to return IBC's to their UN marking performance levels after filling.**

#### **Stainless Steel Intermediate Bulk Containers (IBC's)**

Lid installation procedure: All openings must be securely tightened to prevent leakage of materials and vapors. Each UN31A labeled tank is equipped with an emergency vent in the container lid which fits on the top opening. This vent must be inspected before each shipment, and must be replaced if faulty. The container lid and gasket must be inspected for damage and replaced if necessary. The container lid is installed on the top opening with a clamp ring. It may be necessary to tap the clamp ring, around the circumference, with a non-sparking mallet. The mallet should be used to strike in a horizontal position (towards the side of the clamp ring) first starting at the twelve o'clock position, then three o'clock, then nine o'clock, then five o'clock, and then seven o'clock. Using this procedure, will make the bolt pull the clamp ring uniformly around the entire clamp ring, creating a uniform clamping pressure on the gasket and lid. After tightening the bolt to a torque of 30 foot pounds, the lock nut must be firmly tightened into place. The 2" bung plug, and the 3" fill cap, both require a gasket to seal and be tightened to a torque of 30 foot pounds for proper sealing.

**Under the applicable DOT regulation, any changes made to the type and dimensions of closures or method of closure, may constitute a change to the design type of this package, voiding the certification that is marked on the IBC and requiring a retesting and recertification.**

#### **Note:**

**After filling and prior to transport, the shipper is to check the tightness of closures to determine that the closures are sealed in accordance with the above specifications.**

**The items covered above are based on our interpretations of the regulations. This information should be confirmed by your own regulatory personnel.**