



SNYDER INDUSTRIES (SII)

U.N. MARKED CONTAINER CLOSURE NOTIFICATION

The following are the closure instructions utilized by SII in sealing closures of U.N. marked Non-bulk and Intermediate Bulk Containers (IBC) in the completion of applicable testing requirements for qualification and requalification of packagings according to 49 CFR Subparts M and O. The shipper is responsible for applying the closures in a manner consistent with these instructions in the shipment of hazardous materials [49 CFR §173.22(a)(4)]. These instructions are specific to SII packagings and are not intended for use on packagings manufactured by anyone other than SII.

SII recommends the use of only SII verified components in closing packagings for shipment. The shipper assumes responsibility for the use of components that have not been verified by SII.

Procedure:

1. Inspect the closure, gasket and sealing surface for damage.
2. Thread the closure using an appropriate adaptor and torque wrench until appropriate torque is achieved [+3 ft-lb/-0 ft-lb].



PLASTIC CONTAINER CLOSURES	TORQUE/INSTRUCTION
SII GEM CAP (6.5" CAP) [all cap and gasket variations]	120 ft-lb
SII 6" HEAVY DUTY CAP AND 7" CAP [all cap and gasket variations]	75 ft-lb
2" NPS (NPT) CLOSURE W/ GASKET [all closure and gasket variations]	20 ft-lb
2" BUTTRESS CLOSURE W/ GASKET [all closure and gasket variations]	25 ft-lb
2" DRYBREAK FITTING [includes 2" NPS or buttress threaded variations]	10 ft-lb
¾" & 1" NPS/NPT CLOSURE W/ GASKET [all closure and gasket variations]	10 ft-lb
20" ROTO-MOLDED CAP [all gaskets variations]	Rotate until thread on lid completely engages thread on tank
12" CAP [all cap and gasket variations]	This cap is intended for use for solids. Tighten 1/8-1/6 rotation beyond gasket contact
1" - 3" CAMLOCK CLOSURE [all closure and gaskets variations]	Rotate camlock arms until fully engaged
17" ROTO-MOLDED PLUG – this plug is only utilized as a cover	Tighten by hand until snug

CAGEBUSTER CLOSURES	TORQUE/INSTRUCTION
IBC CAP [all cap and gasket variations]	75 ft-lb
COLLARED VALVE [all valve and gasket variations]	55 ft-lb [center adaptor] 45 ft-lb [SII offset adaptor]
2" NPS (NPT) CLOSURE W/ GASKET [all closure and gasket variations]	20 ft-lb
2" BUTTRESS CLOSURE W/ GASKET [all closure gasket variations]	25 ft-lb
SII 2" REPLACEABLE BUNGS [all component and gasket variations]	Contact SII for instructions

STEEL CONTAINERS CLOSURES	TORQUE/INSTRUCTION
2" & 3" NPS (NPT) CLOSURE W/ ELASTOMER GASKET [all closure and gasket variations]	30 ft-lb
2" & 3" NPS (NPT) CLOSURE W/ TEFLON GASKET [all closure and gasket variations]	60 ft-lb
1" - 3" CAMLOCK CLOSURE [all closure and gaskets variations]	Rotate camlock arms until fully engaged
2" & 3" SANITARY CLOSURE AND CONNECTIONS [all closure and gasket variations]	Tighten screw on clamp to 30 in-lb
18" & 22" DRUM LIDS WITH CLAMP RING [all lid and gasket variations]	Seat the ring by striking it around the circumference with a mallet. Tighten the bolt to 40 ft-lb and then restrike the ring with the mallet. Alternate between tightening and striking until the bolt tightening torque does not change.

NON-CLOSURES	INSTRUCTION
SII considers the removal and replacement of the following components a repair and therefore is subject to the testing, inspection and marking requirements of §180.352.	
1/4" - 1" NPT THREAD SEALING CONNECTION [all connection variations]	Using thread sealing paste, tape or both, tighten 2-3 turns beyond hand tight
1" - 3" NPT THREAD SEALING CONNECTION [all connection variations]	Using thread sealing paste, tape or both, tighten 1.5 - 2.5 turns beyond hand tight
SII 2" REPLACEABLE BUNGS [all component and gasket variations]	Contact SII for instructions
BULKHEAD AND BOLTED FITTINGS [all closure and gasket variations]	Contact SII for instructions
2" & 3" NPT VALVE WITH CLAMP [all valve variations]	Contact SII for instructions

Please note:

- Closure instructions for specialty fittings are supplied on the customer approval drawings.
- Current revision of closure instruction can be found at:
http://www.snydernet.com/portals/0/PDF/IBC-PDF/CLOSURES_NOTIFICATION.pdf