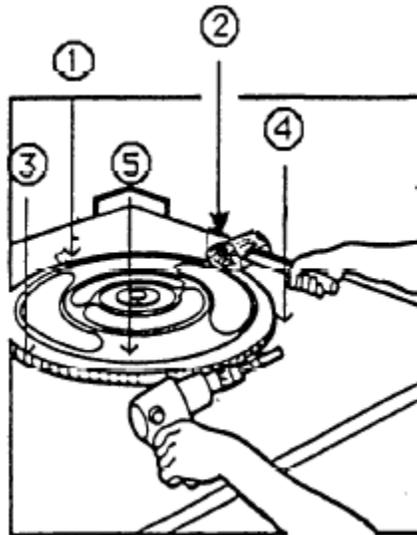


## Stainless Steel IBC Lid Installation Procedure

Here's a handy checklist of essential procedures in closing tote tanks for the shipment of hazardous materials:

1. All openings must be securely tightened to prevent leakage of materials and vapors.
2. Each UN31A labeled tank is equipped with an emergency vent in the drum lid that fits on the top opening. This vent must be inspected before each shipment and must be replaced if faulty.
3. The drum lid and gasket must be inspected for damage and replaced if necessary.



4. The drum lid is installed on the top opening with a clamp ring. It may be necessary to tap the clamp ring, all around, with a non-sparking mallet (see drawing above). The non-sparking mallet should be used to strike in a horizontal position (towards the side of the clamp ring) first starting at position #1 and working your way through #5. This procedure should be repeated twice. Using this procedure you will make the bolt pull the clamp ring uniformly all around the entire clamp ring creating a uniform clamping pressure on the gasket and lid. If the rubber mallet is not used, the clamp ring only gets tight on the side where the bolt and nut are located.
5. After tightening the bolt to a torque of 30 ft – lb., the lock nut must be firmly tightened into place.