



CLOSURE NOTIFICATION COMPOSITE IBCs

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This notification is provided as required in 49 CFR 178.2(c). Instructions below describe procedures for closing packagings prior to shipment. All packaging supplied with lids, gaskets, clamp bands, locking rings, bolt rings, bungs, plugs, caps or other fittings must be closed for shipment using only the components supplied.

Prior to closing:

1. Inspect each closure to ensure: a) proper gasket is in place; b) threads and sealing surfaces are dry; c) both closure and gasket are in good condition.
2. Replace any defective gaskets, plugs or lids with new, defect free parts identical to the original packaging design.

Closing plug and cap fittings:

1. Insert the plug or cap into the appropriate opening and screw down “hand tight” until the gasket is in contact with the sealing surface.
2. Using a torque wrench capable of applying the proper torque as specified below, tighten the plug or cap until it reaches the pre-set torque as indicated by a release or click. Torque wrenches should be calibrated at least annually.

Manufacturer	Fitting/Accessory	Gasket Type	Closing Torque (ft-lbs)
GNX (Core Plastech)	Top 6” threaded closure	Any	80 ft-lbs
	2” plug in 6” lid	Any	18 ft-lbs
	Valve to IBC Body	Any	73 – 75 ft-lbs
GREIF	Top 6” threaded closure	EPDM, SBR or Santoprene	45 ft-lbs min; 55 ft-lbs max
	Top 6” threaded closure	Viton	70 ft-lbs min; 80 ft-lbs max
	Top 9” threaded closure	Any	85 ft-lbs min; 95 ft-lbs max
	NPT/Buttress plugs in 6” cap	Any	20 ft-lbs
	All ¾ “ plugs in 6” cap	Any	9 ft-lbs
	All ¾ “ manual vent plugs on 6” caps from Stainlez	Any	2 ft-lbs
	Valve service equipment – Italy plastic collar valve		40 ft-lbs; orient to level handle
ENCORE	All other plastic collar valves and metal collar valves		50 ft-lbs
	Top 6” threaded closure	Any	50 ft-lbs
	2” plug in 6” cap	Any	20 ft-lbs
MAUSER	All 3/4” plugs in 6” cap	Any	9 ft-lbs
	SM series 275/330 w/6” or 9” lid	Any	70 (6” fill cap)
	2” plug in 6” or 9” lid	EPDM/FKM	20-25(fill cap)
	56 mm plug in 6” or 9” lid, vented and solid	EPDM/FKM	20-25 (fill cap)
SCHÜTZ	2” buttress plug in top of IBC	EPDM/FKM	20 (fill cap)
	Valve service equipment	Not specified	75 (6” and 9” fill cap) 20 (2” fitting); 55 (valve nut) 2 turns and line up the hole in the valve body and the hole in the bottle insert and insert clip