



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 packaging 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)	6" Top Filling Cap	Any	80 – 90 ft-lbs
	G2 Plug	Any	15 – 90 ft-lbs
	Discharge Valve	Any	70 – 75 ft-lbs
GREIF	Top 6" threaded closure	EPDM	65 ft-lbs
	Top 6" threaded closure	SBR & Santoprene	45 ft-lbs
	Top 6" threaded closure	Viton & TPE-S	75 ft-lbs
	Top 9" threaded closure	Any	85 ft-lbs
	2" NPT/Buttress plugs in 6" cap	Any	20 ft-lbs
	All ¾ " plugs inside 2" plugs	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 minimum
	Plastic & Metal collar valves	ULDPE	70 ft-lbs minimum
ECOGREEN	All other plastic collar valves and metal collar valves		50 ft-lbs minimum
	Top 6" threaded closure		90 ft-lbs
	2" G2 Plug		18 ft-lbs
	Q.D. Viton Valve		70 ft-lbs
	Q.D EPDM Valve		70 ft-lbs
	NPT Viton Valve		70 ft-lbs
	AG Check Valve		70 ft-lbs
	Plastic Collar Valve		85 ft-lbs
	Plastic Collar EPDM Valve		85 ft-lbs
	Q.D. Butterfly Valve		80 ft-lbs
	Q.D. Grounded Butterfly Valve		80 ft-lbs
MAUSER	H ₂ O ₂ Hole-in-Ball Valve		70 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