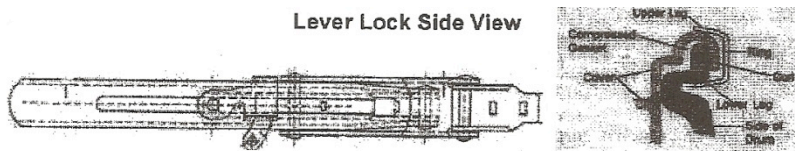


# MAUSER CORPORATION

## PLASTIC OPEN HEAD DRUMS

| PART DESCRIPTION                                 | TORQUE        |
|--|---------------|
| VANGUARD LID WITH 2 INCH SELF-SEAL TYPE NPS PLUG | 2FT.-LBS.     |
| VANGUARD LID WITH ¾ INCH SELF-SEAL TYPE NPS PLUG | 5FT.-LBS.     |
| STANDARD LID WITH 2 INCH NPS PLUG                | 15-20FT.-LBS. |
| STANDARD LID WITH ¾ INCH NPS PLUG                | 9FT.-LBS.     |

1. ALL REMOVABLE HEAD, UN1H2, PLASTIC DRUMS, 49 CFR 178.509(a)(2), OF NOMINAL CAPACITY 15 TO 60 U.S. GALLONS SUPPLIED WITH PLASTIC LIDS, GASKETS AND ASSOCIATED CLAMP BANDS, OR LOCKING RINGS, MUST BE CLOSED FOR SHIPMENT USING ONLY THE COMPONENTS SUPPLIED AND SPECIFIED IN THE DESIGN QUALIFICATION TESTS ACCORDING TO THE FOLLOWING INSTALLATION INSTRUCTIONS:
  - A. PLACE DRUM LID WITH GASKET AND SELECTED CLAMP BAND AS SUPPLIED ON THE TOP OPENING OF THE DRUM BODY.
  - B. FIRMLY PLACE LID ONTO TOP OPENING BY APPLYING DOWNWARD PRESSURE TO LID ABOVE DRUM SIDEWALL
  - C. WHILE PRESSING DOWN ON LID, ENGAGE LOCKING MECHANISM OF CLAMP BAND TO SECURE THE LID IN PLACE. MAKE SURE THE LOCKING MECHANISM IS COMPLETELY LATCHED. INSERT LOCKING TAB INTO SLOTS IN LEVER LOCK HANDLE.



2. THE MAUSER REMOVABLE HEAD PLASTIC DRUM MAY BE PROVIDED WITH A BOLT RING CLOSING DEVICE. THIS BOLT RING IS CLOSED AS FOLLOWS:
  - A. PLACE LID WITH GASKET IN PLACE, AS SUPPLIED, ON THE CURL AT THE TOP OF THE DRUM BODY.
  - B. PLACE BOLT RING AROUND THE DRUM HEAD AND CURL.
  - C. USING A HEAD COMPRESSOR, APPLY FORCE TO THE TOP OF THE DRUM HEAD ASSEMBLY TO COMPRESS HEAD GASKET.
  - D. DRIVE BOLT INTO LUG UNTIL THE ENDS OF THE BOLT RING ARE AT A 3/8 INCH OR LESS RING GAP.
  - E. IF A HEAD COMPRESSOR IS NOT AVAILABLE, START BOLT INTO LUG, ALTERNATING TAPPING OF RING WITH A MALLET AND DRIVE BOLT WITH A WRENCH, UNTIL BOLT RING ENDS MEET THE ABOVE REQUIREMENTS.
  - F. WHEN RING HAS BEEN TIGHTENED AS REQUIRED THE JAM NUT MUST BE TIGHTENED AGAINST LEFT LUG

