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Intermediate Bulk Container (IBC) Closure Instructions

IBC Lid Torque Requirements

- a. 275-gallon and 330-gallon 6" and 9" IBC lids at 75 ft.-lbs for Schuetz, 70 ft.-lbs for Mauser, 50 ft.-lbs for Varicon, 45 ft.-lbs for Greif, and 40-55 ft. lbs for IBCNA.
- b. 2" plug in standard lid, vented at 20 ft.-lbs for Schuetz, Varicon, and Greif; Mauser is 20-25 ft. lbs and IBCNA is 40-55 ft.-lbs

1. All UN 31HA1 and 31HG1 Composite IBCs 49CFR 178.707(a) (5) that are supplied with lids, cages, pallets and service equipment must be closed for shipment using only components supplied and specified in the design qualification tests for that IBC.

- a. Place the lid with gasket in place on the top opening of the IBC.
- b. Screw the lid by hand until the gasket is in contact with the sealing surface
- c. Using the lid adaptor and torque wrench tighten the lid to the recommended torque.
Recommended torque is reached when the wrench releases or clicks.
- d. Preset torque wrenches or adjustable torque wrenches are suitable for this procedure.

Closing Procedure for Plugs and Caps

The plug or cap is inserted into the appropriate opening and screwed down hand tight until the gasket is in contact with the sealing surface. A torque wrench capable of applying the proper torque to the fitting as specified by the closing instructions is then used to tighten the plug or cap until it reached the pre-set torque. All valves must have a cap installed on outlet.

IBC Valve and Cap Torque Requirements

- a. Metal Collar IBC Valves – 275-gallon and 330-gallon 2" IBC Valves to 55 ft.-lbs. for Schutz, 50 ft.-lbs. for Mauser, 50 ft.-lbs for Greif, 50 ft.-lbs for Varicon, 45 ft.-lbs for IBCNA with a Santoprene gasket or 55 ft.-lbs. for IBCNA with a Viton/EPDM gasket
- b. Poly Collar IBC Valves – 275-gallon and 330-gallon 2" IBC Valves to 55 ft.-lbs. for Schutz, 70 ft.-lbs. for Mauser, 50 ft.-lbs for Greif, 50 ft.-lbs for Varicon, 45 ft.-lbs for IBCNA with a Santoprene gasket or 55 ft.-lbs. for IBCNA with a Viton/EPDM gasket

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- a. Place the valve with gasket in place on the bottom opening of the IBC
- b. Screw the valve by hand until the gasket is in contact with the sealing surface.
- c. Using the valve tool and torque wrench tighten the valve to the recommended torque.
Recommended torque is reached when the wrench releases or clicks.
- d. All valves must have a cap installed on outlet
- e. Preset torque wrenches or adjustable torque wrenches are suitable for this procedure.