

	PROCEDURE NO. QP-00352	Quality Assurance	Page 1 of 2
	UN CONTAINER CLOSING INSTRUCTIONS	REV. 8	REV. DATE 05/15/09

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1.0 Purpose:

In compliance with 49 CFR §178.2(c), persons shipping Letica Corporation containers must comply with the following closure instructions.

2.0 Application Methods:

Letica Product	Recommended Mechanism	Material Type Packaged
5UND Container / 5LUND Lid	Pneumatic Press	Liquid Hazardous Materials Group II & III
20UNS Container / 5LUND Lid	Pneumatic Press	Liquid Hazardous Materials Group II & III

The Letica Corporation does not recommend the use of a mallet or roller closure for lid application. A pneumatic press is the recommended equipment for applying lids to Letica Corporation UN designated containers.

3.0 Pneumatic Press:

3.1 Design Criteria:

- 3.1.1 The frame of the pneumatic press and the surface where the container stands must be of significant strength to resist deflection during the application of a lid.
- 3.1.2 The closing plate has to be parallel to the base, within 1/32" (.79 mm), and be of sufficient strength to withstand deflection during the application of a lid (the plate should be made of steel, have a minimum thickness of 1/4", and have a minimum diameter of 13").
- 3.1.3 A burp plug must be installed in the center of the closing plate. Dimensions for the burp plug are 2 3/4" in diameter and 3/4" in depth.

3.2 Press Setup:

- 3.2.1 The size and pressure of the pneumatic cylinder is dependent on the type of lid and pail. The 5 gallon and 20 liter pails meeting the requirements for UN liquid hazardous materials are to utilize a cylinder with a 6" minimum diameter. The air pressure supplied to this cylinder is to be a minimum of 90 psi of uninterrupted air (load = 2545# min) and is not to exceed 110 psi (load = 3110# max).
- 3.2.2 The height of the plate should be set to between 1.5" and 2.5" above the package with the lid positioned for closure.

3.3 Lid Application:

Note: The fill level of the product in the container is not to interfere with the lid when closing.

- 3.3.1 Visually verify the container is undamaged including dents, knicks, scratches, etc.

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3.0 Pneumatic Press (continued):

3.3 Lid Application (continued):

- 3.3.2 Visually verify that the lid is undamaged, that any fittings are properly installed, and that there is a gasket fully installed in the lid.
- 3.3.3 Position the lid on the container with the fitting located between the handle attachment points. Be sure the lid is centered on the container.
- 3.3.4 Center the container / lid under the plate.
- 3.3.5 Confirm that the area is clear of anything that may potentially interfere with the plate travel and engage the closer. *The lid should lock with minimal hesitation (< 2 seconds) and produce an audible "snap".
- 3.3.6 Verify that the lid is fully locked and that the perimeter of the lid skirt is free from bulging or flaring. If the lid skirt is bulged or appears uneven it may indicate that the lid is not fully locked.

Caution: ***Insufficient momentum of plate travel may result in incomplete closure.**

***If difficulties are encountered in the closing process place any affected containers in quarantine and contact The Letica Corporation for further instructions.**

4.0 Applicable Lid Attachments - No substitutes to the below identified attachments may be made.

Lid	Attachments
5LUND	Plain Lid APC 27 Pour Spout APC 27 Pour Spout w/Microporous Vent Rieke Screw Cap FS-70 Rieke Screw Cap FS-70 w/TFE Vent Rieke FS-10 Flexspout Rieke FS-10 Flexspout w/TFE Vent

Application of the lid attachments is as follows:

- 4.1 The APC closures require the use of an APC Installation Press with the following specifications: pneumatic cylinder – air pressure 100 psi, 5 inch stroke, 4 inch diameter bore, floating piston – minimum air pressure of 25 psi.
- 4.2 The Rieke Screw Caps require an application torque of 120 in-lbs. A Rieke preset torque wrench, number W-399PT-01, is the recommended tool for applying screw caps.
- 4.3 A Rieke crimping tool (FS, hand operated tool; ADP-6, Airdraulic Tool, or IAFS; Airmatic Tool) is the recommended method for the application of Rieke Flexspouts. Verification of the crimp must be performed using a Rieke G-101-1 slip gage.

Caution: **Improper installation of an attachment may result in leakage.**