



# ALLIANCE CONTAINER

## GUIDELINE FOR IBC CLOSURE NOTIFICATIONS

The United States Department of Transportation regulates that closure instructions utilized by Alliance Container LLC be shared with any user of the Intermediate Bulk Containers (IBC). Packaging products need to meet and qualify the requirements of 49 CFR 178. These instructions are specific to Alliance Container LLC and are not intended for use on packaging manufactured by anyone other than Alliance Container LLC.

Alliance Container is committed to providing all necessary standard operating procedures which need to be followed while handling and usage of packaging products. It is the shipper's responsibility to ensure that these closing instructions are carried out as described. Closing Instructions and shipment documents will be sent out with each shipment of IBCs.

### INTERMEDIATE BULK CONTAINER (IBC):

Description	Torque (Ft-Lbs.)
6" Fill Port Cap	70 Ft-Lbs.
2" Center Plug	14 Ft-Lbs.
Dispensing Valve	55 Ft-Lbs.

#### 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.

***Please note: The above recommended torque is only applicable for Alliance Container packaging material. Alliance Container is not liable for any consequential or third-party liability.***