



GUIDELINE FOR IBC CLOSURE NOTIFICATIONS

The United States Department of Transportation regulates that closure instructions utilized by Alliance Container 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 products 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 then be sent out by Superior Tote Solutions with each shipment of IBCs.

Alliance Container 275 Gallon Bottle (IBC):

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

Alliance Container Bottle / Schutz Cage:

CLOSING METHODS	
6" Fill Port Cap:	
Application Torque:	70 Ft-Lbs.
Equipment:	Torque Wrench #742
2" Plug:	
Application Torque:	14 Ft-Lbs.
Equipment:	Torque Wrench #740
Dispensing Valve:	
Valve to IBC Body	55 Ft-Lbs.
Closure	Torque Wrench #742

Alliance Container Bottle / Mauser Cage:

CLOSING METHODS	
6" Fill Port Cap:	
Application Torque:	70 Ft-Lbs.
Equipment:	Torque Wrench #742
2" Plug:	
Application Torque:	14 Ft-Lbs.
Equipment:	Torque Wrench #740
Dispensing Valve:	
Valve to IBC Body	55 Ft-Lbs.
Closure	Torque Wrench #742

Alliance Container Bottle / Greif Cage:

CLOSING METHODS	
6" Fill Port Cap:	
Application Torque:	70 Ft-Lbs.
Equipment:	Torque Wrench #742
2" Plug:	
Application Torque:	14 Ft-Lbs.
Equipment:	Torque Wrench #740
Dispensing Valve:	
Valve to IBC Body	55 Ft-Lbs.
Closure	Torque Wrench #742

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.