



# METANO

## Intermediate Bulk Containers:

### The Essential Guide to Closing Stainless and Poly Composites

*For Compliance with Intermediate Bulk Containers 49CFR Sect. 178.2 (c)*

#### *How do I properly close stainless and poly IBCs?*

When transporting intermediate bulk containers from one manufacturer to another, it is essential that lids, fittings and gaskets are properly sealed and in complete compliance with US Department of Transportation federal guidelines. These requirements apply whether using stainless steel or poly composites, and are designed to protect both the shipper and receiver of the container by ensuring the safe transport of regulated materials. Containers transferred under proper regulations are far more likely to resist damage and possible leakage.

Per DOT Title 49, Code of Federal Regulations (49 CFR), Part 178 Specifications for Packaging, the below requirements must be followed prior to shipment.

[See our lid installation closing video.](#)



# Closing IBC Containers

# IBC Proper Closing Instructions

## Prior to Closing

Each closure must be inspected to ensure it contains the proper gasket and that all components are in good condition. The sealing surface and threads must also be checked to ensure they are dry and free from damage. Damaged gaskets, plugs or lids must be replaced (per UN design).

## Procedures for Plugs and Caps

Plugs and caps must be inserted into the appropriate opening and screwed (hand tight) until the gasket comes in contact with the sealing surface. A torque wrench is the preferred tool, and should be tightened until the closure "clicks." Outlet valves must be equipped with a secondary closure, and torque tools should be calibrated regularly.

## Tightening Guidelines for Stainless Steel IBC Containers

Closure	# of Rotations beyond full solid gasket contact	Torque
2" and 3" threaded fittings (non-Teflon)	3/8 to 1/2	30 ft/lbs
2" and 3" threaded fittings with Teflon	1/8 to 3/16	30 ft/lbs
22 1/2" drum lids with clamp ring <i>Seat the ring by striking it around the circumference with a mallet. Tighten the bolt and then restrike the ring with the mallet. Alternate between tightening and striking until bolt tightening resistance does not change.</i>	3/8" to 1/2" gap between clamp ring ends	30 ft/lbs

## Tightening Guidelines for Poly Composite IBC Containers

Closure	# of Rotations beyond full gasket contact	Torque
6" Cap, all gasket material	1/8 to 1/16	55 ft/lbs
2" NPS (NPT) threaded closure	3/8 to 1/2	20 ft/lbs
Valve nut	3/8 to 1/2	30 ft/lbs



For additional closure requirements, please contact Metano.  
Metano IBC Services, Inc.  
Millstone Twp, NJ 08535  
Naples, FL 34109  
(800) 634-4128  
[www.metanousa.com](http://www.metanousa.com)