



Document Title: Closure Instructions  
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## CLOSURE SPECIFICATIONS FOR IBC'S

FILL PORT CAP MUST BE TORQUED TO THE FOLLOWING:

6" FILL PORT CAP RED TAMPER SEAL	60 FT LBS
6" FILL PORT CAP	70 FT LBS
9" FILL PORT CAP	80 FT LBS

2" plug in 6" IPCC type fill port cap must be torqued to 20 ft. lbs.

2" plug in 6" MASCHIO type fill port cap must be torqued to 20 ft. lbs.

2" plug in 6" STAINLEZ type fill port cap must be torqued to 30 ft. lbs.

We do not recommend that you remove this plug. Filling should be done through the 6" opening.

### VALVES:

BANJO one piece ball valve  
&  
MASCHIO PACK one piece butterfly valve

Begin with valve handle starting in the 12:00 position, turn valve three complete rotations with valve handle finishing in the 12:00 position.

**NOTE: After filling and prior to transport, the shipper should check the tightness of closures to determine if the effects of heating, cooling or gasket relaxation have resulted in the need to tighten the closure.**