Document ID: 1A2-Y1.9-100 6 -gal Tpr 2bd 26-26-24 DQ 03-20-26 Certification NA-5312

Design Qualification: Update File

Approved Certification March 20, 2026 **Next Test Date:** March 20, 2027

The sample containers tested have satisfied the testing requirements and are in conformance with the United Nations/DOT, IATA, ICAO and IMO packaging regulations and are eligible to bear the following markings required by 49CFR, section 178.601.

Package Marking: (u n) 1A2/Y1.9/100/*
USA/M4071 (Chicago IL) or M4121 (Homerville GA)
* indicates the year of manufacture, valid one year from the date of certification

Packaging Description

Described as 6- gallon nominal capacity, tapered steel pail – 23.85 L (6.3 gallons) or lower maximum capacities are valid under this certification. 26 Gauge Body, 26 Gauge Bottom, 24 Gauge UN lug cover with flowed-in or tubular gasket. Ears welded to sides of pail body; bail attached. Two beads (rolling hoops) are authorized.

Closures
Rieke FlexSpout, closed per instructions on pg. 3 of this document
Rieke TFS-II Tint Plug
2⅛" screw nozzle and cap, closed per instructions on pg. 3 of this document
(approved for use under Variation 5, §178.601(g))

UN lug cover crimped in accordance with instructions on pg 4 of this document

Packaging Performance Tests

All tests were done in accordance with 49 CFR, Subpart M – Testing of Non-bulk Packagings and Packages.

Test	Spec	Test Level	Result
Drop Test	paragraph 178.603	1.9 meters	pass
Leakproofness Test	paragraph 178.604	20 kPa	pass
Hydrostatic Pressure Test	paragraph 178.605	100 kPa	pass
Stack Test	paragraph 178.606	3 meters	pass
Vibratory Standard	paragraph 178.608	1-hour	passes

All tests were performed at the Mauser manufacturing facility in LaGrange, GA. A copy of this test report can be provided upon request.

Robert Burek

Engineering Test Lab Manager

MANUAL CRIMPING TOOLS

Tool: Rieke FS-600 FLEXSPOUT Crimping Tool

(Rieke automatic crimp heads are approved, but their operation is not described herein)

1. Products
   - a) FS-10-6 FLEXSPOUT
   - b) FS-10-7 FLEXSPOUT
   - c) FS-10-8V FLEXSPOUT
   - d) FS-10-10 FLEXSPOUT
   - e) FS-40 Poly-Flexcap
   - f) FS-41 Poly-Flexcap – Retainer and diaphragm only
   - g) PFA-22 3/4" Flange and plug assembly
   - h) PFA-32 3/4" Flange and crimping ring only
2. Operation
   - a) The closure is to be fully seated on the container opening.
   - b) Place the FS-600 crimping tool over the closure, tool should rest on the container.
   - c) Grasp the handles (one in each hand). Fully depress the handles applying even pressure on each handle to affect a full crimp.
3. Gauging
   - a) Use the G-101-1 gauge to check the crimp. The gauge must pass freely over the crimped closure.

57 mm REL PLASTIC CLOSURE INSERTION

After the container is filled, place the closure in the opening and center it as closely as possible. Apply downward force until the closure is fully seated. The closure will normally snap in with a distinct sound. Do not continue to apply force after the insertion is complete because this could result in damage to the opening.

After the closure has been inserted into the opening, there may be a need to remove the diaphragm and apply the screw cap. The application torque for the screw cap should be 20-25-inch pounds.

DRUM FITTING APPLICATION TORQUE VALUES

Steel Plug with Visecar (Buna N)

2"	30 Foot Lbs.
1-½"	30 Foot Lbs.
¾"	15 Foot Lbs.

Steel Plug with Polyseal or Iradiated Polyseal

2"	40 Foot Lbs.
¾"	20 Foot Lbs.

Nylon or Plastic plug with White EPT or White Visecar

2"	30 Foot Lbs.
¾"	15 Foot Lbs.

Tri-Sure or Rieke Steel plug with Black Buna or EPDM gaskets

2"	30 Foot Lbs.
¾"	15 Foot Lbs.

SCREW NOZZLE AND ASSEMBLIES

Install inner seal if applicable by pressing firmly into the crevice of the nozzle.
The recommended application torque for 2-⅛" and 2-¼" inch screw nozzles is 100-inch pounds. Thread-stripping can occur if the screw cap is over torqued.

OPEN HEAD PAILS WITH LUG COVER

1. Fill the container to the desired level. Do not exceed maximum gross mass or the rated fill volume.
2. Place the UN lug cover on top of the pail curl.
3. Align the eye of one lug over the welded side seam.
4. Lower the closer onto the cover such that the closer jaws are placed over the lugs covering the eyes on the lugs
5. Actuate the closer by pressing the pneumatic levers (pneumatic closer) or pushing the handles down until they stop (manual closer).
6. Remove the closer and ensure that the lugs are crimped under the curl of the pail at least 90° from the starting position.

Lug covers are available in 6½", 8½", and 11¼" diameters.

