Pipeline and Hazardous Materials Safety Administration, DOT § 178.508

1. Body and heads must be constructed of metal (other than steel or aluminum) of suitable type and adequate thickness in relation to the capacity and the intended use of the drum. Minimum thickness and marking requirements in §§173.28(b)(4) and 178.503(a)(9) of this subchapter apply to drums intended for reuse.

2. All seams must be welded. Chime seams, if any, must be reinforced by the application of separate reinforcing rings.

3. The body of a drum of a capacity greater than 60 L (16 gallons) may have at least two expanded rolling hoops or two separate rolling hoops. If there are separate rolling hoops, the hoops must be fitted tightly on the body and so secured that they cannot shift. Rolling hoops may not be spot-welded.

4. Openings for filling, emptying, or venting in the bodies or heads of non-removable head (1N1) drums may not exceed 7.0 cm (3 inches) in diameter. Drums with larger openings are considered to be of the removable head type (1N2). Closures for openings in the bodies and heads of drums must be so designed by the manufacturer to prevent sifting of the contents, lids must be lined with kraft paper or some other equivalent material which must be securely fastened to the lid and extend to the outside along its full circumference.


§ 178.508 Standards for fiber drums.

(a) The identification code for a fiber drum is 1G.

(b) Construction requirements for fiber drums are as follows:

1. The body of the drum must be constructed of multiple plies of heavy paper or fiberboard (without corrugations) firmly glued or laminated together and may include one or more protective layers of bitumen, waxed kraft paper, metal foil, plastic material, or similar materials.

2. Heads must be of natural wood, fiberboard, metal, plywood, plastics, or other suitable material and may include one or more protective layers of bitumen, waxed kraft paper, metal foil, plastic material, or similar material.

3. The body and heads of the drum and their joints must be of a design appropriate to the capacity and intended use of the drum.

4. The assembled packaging must be sufficiently water-resistant so as not to delaminate under normal conditions of transport.