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non-hazardous material, except for chemical compatibility testing or where this would invalidate the results of the tests.

(c) If the material to be transported is replaced for test purposes by a non-hazardous material, the material used must be of the same or higher specific gravity as the material to be carried, and its other physical properties (grain, size, viscosity) which might influence the results of the required tests must correspond as closely as possible to those of the hazardous material to be transported. Water may also be used for the liquid drop test under the conditions specified in §178.603(e) of this subpart. It is permissible to use additives, such as bags of lead shot, to achieve the requisite total package mass, so long as they are placed so that the test results are not affected.

(d) Paper or fiberboard packagings must be conditioned for at least 24 hours immediately prior to testing in an atmosphere maintained—

(1) At 50 percent ± 2 percent relative humidity, and at a temperature of $23^{\circ}\text{C} \pm 2^{\circ}\text{C}$ ($73^{\circ}\text{F} \pm 4^{\circ}\text{F}$). Average values should fall within these limits. Short-term fluctuations and measurement limitations may cause individual measurements to vary by up to ± 5 percent relative humidity without significant impairment of test reproducibility;

(2) At 65 percent ± 2 percent relative humidity, and at a temperature of $20^{\circ}\text{C} \pm 2^{\circ}\text{C}$ ($68^{\circ}\text{F} \pm 4^{\circ}\text{F}$), or $27^{\circ}\text{C} \pm 2^{\circ}\text{C}$ ($81^{\circ}\text{F} \pm 4^{\circ}\text{F}$). Average values should fall

within these limits. Short-term fluctuations and measurement limitations may cause individual measurements to vary by up to ± 5 percent relative humidity without significant impairment of test reproducibility; or

(3) For testing at periodic intervals only (*i.e.*, other than initial design qualification testing), at ambient conditions.

(e) Except as otherwise provided, each packaging must be closed in preparation for testing in the same manner as if prepared for actual shipment. All closures must be installed using proper techniques and torques.

(f) Bung-type barrels made of natural wood must be left filled with water for at least 24 hours before the tests.

[Amdt. 178-97, 55 FR 52723, Dec. 21, 1990, as amended at 56 FR 66286, Dec. 20, 1991; Amdt. 178-106, 59 FR 67522, Dec. 29, 1994; 69 FR 76186, Dec. 20, 2004; 71 FR 78635, Dec. 29, 2006]

§ 178.603 Drop test.

(a) *General.* The drop test must be conducted for the qualification of all packaging design types and performed periodically as specified in §178.601(e). For other than flat drops, the center of gravity of the test packaging must be vertically over the point of impact. Where more than one orientation is possible for a given drop test, the orientation most likely to result in failure of the packaging must be used. The number of drops required and the packages' orientations are as follows:

Packaging	No. of tests (samples)	Drop orientation of samples
Steel drums, Aluminum drums, Metal drums (other than steel or aluminum), Steel Jerricans, Plywood drums, Wooden barrels, Fiber drums, Plastic drums and Jerricans, Composite packagings which are in the shape of a drum.	Six—(three for each drop).	First drop (using three samples): The package must strike the target diagonally on the chime or, if the packaging has no chime, on a circumferential seam or an edge. Second drop (using the other three samples): The package must strike the target on the weakest part not tested by the first drop, for example a closure or, for some 7 cylindrical drums, the welded longitudinal seam of the drum body.
Boxes of natural wood, Plywood boxes, Reconstituted wood boxes, Fiberboard boxes, Plastic boxes, Steel, aluminum or other metal boxes, Composite packagings that are in the shape of a box.	Five—(one for each drop).	First drop: Flat on the bottom (using the first sample). Second drop: Flat on the top (using the second sample). Third drop: Flat on the long side (using the third sample). Fourth drop: Flat on the short side (using the fourth sample). Fifth drop: On a corner (using the fifth sample).
Bags—single-ply with a side seam	Three—(three drops per bag).	First drop: Flat on a wide face (using all three samples). Second drop: Flat on a narrow face (using all three samples). Third drop: On an end of the bag (using all three samples).
Bags—single-ply without a side seam, or multi-ply.	Three—(two drops per bag).	First drop: Flat on a wide face (using all three samples). Second drop: On an end of the bag (using all three samples).

(b) *Exceptions.* For testing of single or composite packagings constructed of stainless steel, nickel, or monel at periodic intervals only (*i.e.*, other than design qualification testing), the drop test may be conducted with two samples, one sample each for the two drop orientations. These samples may have been previously used for the hydrostatic pressure or stacking test. Exceptions for the number of steel, aluminum and other metal packaging samples used for conducting the drop test are subject to the approval of the Associate Administrator.

(c) *Special preparation of test samples for the drop test.* (1) Testing of plastic drums, plastic jerricans, plastic boxes other than expanded polystyrene boxes, composite packagings (plastic material), and combination packagings with plastic inner packagings other than plastic bags intended to contain solids or articles must be carried out when the temperature of the test sample and its contents has been reduced to -18°C (0°F) or lower. Test liquids must be kept in the liquid state, if necessary, by the addition of anti-freeze. Water/anti-freeze solutions with a minimum specific gravity of 0.95 for testing at -18°C (0°F) or lower are considered acceptable test liquids. Test samples prepared in this way are not required to be conditioned in accordance with § 178.602(d).

(d) *Target.* The target must be a rigid, non-resilient, flat and horizontal surface.

(e) *Drop height.* Drop heights, measured as the vertical distance from the target to the lowest point on the package, must be equal to or greater than the drop height determined as follows:

(1) For solids and liquids, if the test is performed with the solid or liquid to be transported or with a non-hazardous material having essentially the same physical characteristic, the drop height must be determined according to packing group, as follows:

- (i) Packing Group I: 1.8 m (5.9 feet).
- (ii) Packing Group II: 1.2 m (3.9 feet).
- (iii) Packing Group III: 0.8 m (2.6 feet).

(2) For liquids in single packagings and for inner packagings of combination packagings, if the test is performed with water:

(i) Where the materials to be carried have a specific gravity not exceeding 1.2, drop height must be determined according to packing group, as follows:

- (A) Packing Group I: 1.8 m (5.9 feet).
- (B) Packing Group II: 1.2 m (3.9 feet).
- (C) Packing Group III: 0.8 m (2.6 feet).

(ii) Where the materials to be transported have a specific gravity exceeding 1.2, the drop height must be calculated on the basis of the specific gravity (SG) of the material to be carried, rounded up to the first decimal, as follows:

- (A) Packing Group I: $\text{SG} \times 1.5 \text{ m}$ (4.9 feet).
- (B) Packing Group II: $\text{SG} \times 1.0 \text{ m}$ (3.3 feet).
- (C) Packing Group III: $\text{SG} \times 0.67 \text{ m}$ (2.2 feet).

(f) *Criteria for passing the test.* A package is considered to successfully pass the drop tests if for each sample tested—

(1) For packagings containing liquid, each packaging does not leak when equilibrium has been reached between the internal and external pressures, except for inner packagings of combination packagings when it is not necessary that the pressures be equalized;

(2) For removable head drums for solids, the entire contents are retained by an inner packaging (*e.g.*, a plastic bag) even if the closure on the top head of the drum is no longer sift-proof;

(3) For a bag, neither the outermost ply nor an outer packaging exhibits any damage likely to adversely affect safety during transport;

(4) The packaging or outer packaging of a composite or combination packaging must not exhibit any damage likely to affect safety during transport. Inner receptacles, inner packagings, or articles must remain completely within the outer packaging and there must be no leakage of the filling substance from the inner receptacles or inner packagings;

(5) Any discharge from a closure is slight and ceases immediately after impact with no further leakage; and

(6) No rupture is permitted in packagings for materials in Class 1 which

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would permit spillage of loose explosive substances or articles from the outer packaging.

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§ 178.604 Leakproofness test.

(a) *General.* The leakproofness test must be performed with compressed air or other suitable gases on all packagings intended to contain liquids, except that:

(1) The inner receptacle of a composite packaging may be tested without the outer packaging provided the test results are not affected; and

(2) This test is not required for inner packagings of combination packagings.

(b) *Number of packagings to be tested—*

(1) *Production testing.* All packagings subject to the provisions of this section must be tested and must pass the leakproofness test:

(i) Before they are first used in transportation; and

(ii) Prior to reuse, when authorized for reuse by §173.28 of this subchapter.

(2) *Design qualification and periodic testing.* Three samples of each different packaging must be tested and must pass the leakproofness test. Exceptions for the number of samples used in conducting the leakproofness test are subject to the approval of the Associate Administrator.

(c) *Special preparation—*(1) For design qualification and periodic testing, packagings must be tested with closures in place. For production testing, packagings need not have their closures in place. Removable heads need not be installed during production testing.

(2) For testing with closures in place, vented closures must either be replaced by similar non-vented closures or the vent must be sealed.

(d) *Test method.* The packaging must be restrained under water while an internal air pressure is applied; the method of restraint must not affect the results of the test. The test must be conducted, for other than production testing, for a minimum time of five

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minutes. Other methods, at least equally effective, may be used in accordance with appendix B of this part.

(e) *Pressure applied.* An internal air pressure (gauge) must be applied to the packaging as indicated for the following packing groups:

(1) Packing Group I: Not less than 30 kPa (4 psi).

(2) Packing Group II: Not less than 20 kPa (3 psi).

(3) Packing Group III: Not less than 20 kPa (3 psi).

(f) *Criteria for passing the test.* A packaging passes the test if there is no leakage of air from the packaging.

[Amdt. 178-97, 55 FR 52723, Dec. 21, 1990, as amended at 56 FR 66286, Dec. 20, 1991; Amdt. 178-106, 59 FR 67522, Dec. 29, 1994; 66 FR 45386, Aug. 28, 2001]

§ 178.605 Hydrostatic pressure test.

(a) *General.* The hydrostatic pressure test must be conducted for the qualification of all metal, plastic, and composite packaging design types intended to contain liquids and be performed periodically as specified in §178.601(e). This test is not required for inner packagings of combination packagings. For internal pressure requirements for inner packagings of combination packagings intended for transportation by aircraft, see §173.27(c) of this subchapter.

(b) *Number of test samples.* Three test samples are required for each different packaging. For packagings constructed of stainless steel, monel, or nickel, only one sample is required for periodic retesting of packagings. Exceptions for the number of aluminum and steel sample packagings used in conducting the hydrostatic pressure test are subject to the approval of the Associate Administrator.

(c) *Special preparation of receptacles for testings.* Vented closures must either be replaced by similar non-vented closures or the vent must be sealed.

(d) *Test method and pressure to be applied.* Metal packagings and composite packagings other than plastic (e.g., glass, porcelain or stoneware), including their closures, must be subjected to the test pressure for 5 minutes. Plastic packagings and composite packagings (plastic material), including their closures, must be subjected to the test