

**UNITED NATIONS / DOT
PERFORMANCE CERTIFICATION**



31HH1 DESIGN QUALIFICATION

**Poly IBC UC 2.0 1000 Liter All Plastic Composite Euro IBC with
AS QC II & QC III Dip Tube and KTJ Vented Bung Closure**

TEST REPORT #: 24-MN40069

 31HH1 / Y / * / USA / +AA11220 / 0 / 2010

* Insert the month and year (last two digits) of manufacture

TESTING PERFORMED FOR:

RIKUTEC AMERICA, INC.
2510-B West Whitner Street
Anderson, SC 29624

ATTN: Alex Pytko

TESTING PERFORMED BY:

TEN-E PACKAGING SERVICES, INC.
1666 County Road 74
Newport, MN 55055
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May 17, 2024

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TEN-E Packaging Services, Inc.

SECTION I: CERTIFICATION

DESIGN QUALIFICATION of the Rikutec America, Inc. Poly IBC UC 2.0 1000 Liter All Plastic Composite Euro IBC with AS QC II & QC III Dip Tube and KTJ Vented Bung Closure

TEN-E Packaging Services, Inc. is a current DOT UN Third-Party Certification Agency under §107.403 and certifies that the Rikutec America, Inc. packaging referenced above has passed the standards of the DEPARTMENT OF TRANSPORTATION'S TITLE 49 CFR; Performance Oriented Packaging Standards, Section 178. This package is also certified under IMDG and the UN Recommendations on the Transport of Dangerous Goods. It is the responsibility of the end user to determine authorization for use under these regulations. The use of other packaging methods or components other than those documented in this report may render this certification invalid.

SUMMARY OF PERFORMANCE TESTS

Table with 6 columns: UN / DOT TEST, 49 CFR REFERENCE, TEST LEVEL, TEST CONTENTS, TEST COMPLETED, TEST RESULTS. Rows include Vibration, Bottom Lift, Leakproofness, Hydrostatic, Drop, and various certification details like UN MARKING, PACKAGING IDENTIFICATION CODE, etc.

ALL OTHER WARRANTIES, EXPRESSED OR IMPLIED, INCLUDING ANY WARRANTY THAT THE PACKAGING TESTED IS MERCHANTABLE OR FIT FOR A PARTICULAR PURPOSE, ARE DISCLAIMED. In no event shall TEN-E Packaging Services, Inc. liability exceed the total amount paid by Rikutec America, Inc. for services rendered. In the event of future changes to the above referenced test standards, it is the responsibility of Rikutec America, Inc. to determine whether additional testing or updating of past testing is necessary to verify that the packaging we have tested remains in compliance with those standards.

MANUFACTURER:

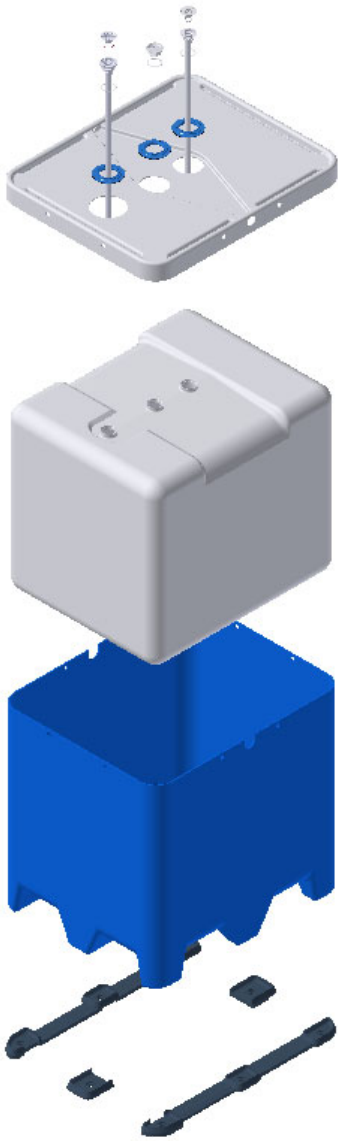
Rikutec America, Inc. 2510-B West Whitner Street Anderson, SC 29624

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SECTIONS II & V: PACKAGING DESCRIPTIONS / COMPONENT DRAWINGS

Poly IBC UC 2.0 1000 Liter All Plastic Composite Euro IBC with AS QC II & QC III Dip Tube and KTJ Vented Bung Closure

ASSEMBLY DRAWING	TEST LEVELS		
	Certification Type:	Design Qualification	
	Packaging Code Designation:	31HH1	
	Packing Group:	II	
	Specific Gravity:	1.9	
	Test Pressure:	100 kPa	
	TEST SAMPLE PREPARATION (Refer to Section IV)		
	Overall IBC Tare Weight: (Sample #1 and Sample #2)	97.0 Kg	213.8 Lbs.
	Net Fill Weight (98% Maximum Capacity):		
	Water (Sample #1)	1,029.0 Kg	2,268.6 Lbs.
	Methanol/Water (Sample #2)	942.8 Kg	2,078.5 Lbs.
	IBC Test Weight:		
	Water (Sample #1)	1,126.0 Kg	2,482.3 Lbs.
	Methanol/Water (Sample #2)	1,039.8 Kg	2,292.3 Lbs.
	Maximum Permissible Gross Mass:	2,052.1 Kg	4,524.0 Lbs.
	CLOSING METHODS		
AS Quick Connect II Dip Tube:			
Application Torque:	25 Ft-Lbs.		
Equipment:	Torque Wrench #740		
AS Quick Connect III Dip Tube:			
Application Torque:	25 Ft-Lbs.		
Equipment:	Torque Wrench #740		
(2) AS Quick Connect Shipping Caps:			
Application Torque:	5 Ft-Lbs.		
Equipment:	Torque Wrench #740		
2" KTJ Vented Bung Closure:			
Application Torque:	25 Ft-Lbs.		
Equipment:	Torque Wrench #740		

COMPONENT INFORMATION

CLOSURE (21310201)		DRAWING
Manufacturer: Kunststofftechnik Jaeger, Braunschweig, Germany		
Description:	2" Vented Buttress Threaded Plug	
Quantity:	1	
Material:	Polypropylene, Natural with Microporous PTFE Vent	
Tare Weight:	33.846 Grams	
Overall Dimensions:		
• Height	34.5 mm (1.358")	
• Diameter	78.7 mm (3.102")	
Thread Dimensions:		
• Major Diameter:	61.9 mm (2.437")	
• Minor Diameter:	54.9 mm (2.162")	
Markings (QC Audit):	1	
POE PROFILE GASKET (22010202):		
Description:	Natural Polyolefin Profile Gasket	
Tare Weight:	2.921 Grams	
Thickness:	3.8 mm (0.15")	
Diameter:	72.5 mm (2.85")	

CLAMPING NUT (2.0)		DRAWING
Manufacturer: Rikutec America, Inc., Whitinsville, MA		
Description:	Outer Buttress Threaded Bulkhead Fitting used on 2.0 IBC designs	
Quantity:	3 (1 on each opening)	
Material:	Polyethylene, Blue, and Black Rubber	
Tare Weight:	60 Grams	
Overall Dimensions:		
• Height	0.758"	
• Diameter	5.905"	
Thread Dimensions:		
• T	3.446"	
• E	3.245"	
Markings (QC Audit):	RIKUTEC 12/23 SPI "2" Recycling Symbol	

CLOSURE (DT-62PE-XXX-1040-TF)		DRAWING
Manufacturer: AS Stromungstechnik, Ostfildern, Germany		
Description:	1-1/2" QC II Threaded Sealing Cap	
Quantity:	1	
Material:	Polyethylene, Natural	
Tare Weight:	17.247 Grams	
Overall Dimensions:		
• Height	25.1 mm (0.99")	
• Diameter	75.7 mm (2.98")	
Thread Dimensions:		
• T	41.2 mm (1.62")	
• E	38.6 mm (1.52")	
Markings (QC Audit):	www.qc-sytem.com AS patented U.S. Pat. No. 6,357,494	
PE GASKET		
Description:	Polyethylene, Natural Gasket	
Tare Weight:	0.519 Grams	
Thickness:	2.8 mm (0.11")	
Diameter:	35.6 mm (1.40")	
DIP TUBE (DT-62PE-XXX-1040-TF)		
Manufacturer: AS Stromungstechnik, Ostfildern, Germany		
Description:	2" QC II Buttress Threaded Insert with Dip Tube (no bellow)	
Quantity:	1	
Material:	Polyethylene, Natural	
Tare Weight:	149 Grams	
Overall Dimensions:		
• Height	1,047.7 mm (41-1/4") (with Dip Tube)	
• Insert Height	34.0 mm (1.34")	
• Diameter	79.0 mm (3.11")	
Thread Dimensions (2" Container - Side):		
• Major Diameter	62.0 mm (2.44")	
• Minor Diameter	54.6 mm (2.15")	
Thread Dimensions (1-1/2" Shipping Cap - Side):		
• Major Diameter	42.7 mm (1.68")	
• Minor Diameter	40.4 mm (1.59")	
Thread Dimensions (3/4" Plug - Side):		
• Major Diameter	26.6 mm (1.05")	
• Minor Diameter	24.0 mm (0.94")	
Markings (QC Audit):	1306B0818 1B2 5C6 3A4	
POE PROFILE GASKET (K12993-811)		
Description:	S62 Seal Ring, Natural Polyolefin Profile Gasket	
Tare Weight:	2.537 Grams	
Thickness:	3.8 mm (0.15")	
Diameter:	72.4 mm (2.85")	

CLOSURE (DT3-62PP-XXX-1040-TF)		DRAWING
Manufacturer: AS Stromungstechnik, Ostfildern, Germany		
Description:	2" QC III Threaded Sealing Cap	
Quantity:	1	
Material:	Polypropylene, Natural	
Tare Weight:	18.114 Grams	
Overall Dimensions:		
• Height	26.14 mm (1.029")	
• Diameter	77.26 mm (3.042")	
Thread Dimensions:		
• T	52.80 mm (2.079")	
• E	49.24 mm (1.939")	
Markings (QC Audit):	Patented U.S. Pat. No. 6,357,494 www.qc-system.com 3/15	
O-RING		
Description:	FEP Encapsulated O-Ring	
Tare Weight:	2.477 Grams	
Thickness:	3.48 mm (0.137")	
Diameter:	48.03 mm (1.891")	
DIP TUBE (DT3-62PP-XXX-1040-TF)		
Manufacturer: AS Stromungstechnik, Ostfildern, Germany		
Description:	2" QC III Buttress Threaded Insert with Dip Tube and Bottom Flexible Bellow	
Quantity:	1	
Material:	Polypropylene, Natural	
Tare Weight:	135 Grams	
Overall Dimensions:		
• Height	908.05 mm (35-3/4") (with Dip Tube)	
• Insert Height	32.56 mm (1.282")	
• Diameter	80.01 mm (3.150")	
Thread Dimensions (2" Container - Side):		
• Major Diameter	61.75 mm (2.431")	
• Minor Diameter	54.79 mm (2.157")	
Thread Dimensions (1-1/2" Shipping Cap - Side):		
• Major Diameter	53.99 mm (2.126")	
• Minor Diameter	50.47 mm (1.987")	
Markings (QC Audit):	1609F351 8	
POE PROFILE GASKET (K12993-811)		
Description:	S62 Seal Ring, Natural Polyolefin Profile Gasket	
Tare Weight:	2.508 Grams	
Thickness:	3.8 mm (0.15")	
Diameter:	72.5 mm (2.85")	

PLASTIC INNER RECEPTACLE (11001047)		DRAWING
Manufacturer: Rikutec America, Inc., Whitinsville, MA		
Description:	Rikutec 1000 Liter (1.0) Rigid Inner Receptacle with (3) 2" Buttnut Threaded Top Fill Port Openings	
Material:	High Density Polyethylene, Natural	
Resin Type:	Two Layer Wall Design: <ul style="list-style-type: none"> • Inside: Lupolen 4261 A Q149 • Outside: Lupolen 4261 AG UV 60005 	
Method of Manufacture:	Blow Molded	
Tare Weight:	50.71 Lbs. (23.0 Kg)	
Capacity:		
• Rated	1,000 Liter	
• Overflow	277.4 Gallons (1,050.0 Liters)	
Overall Dimensions:		
• Length	1,155.7 mm (45.50")	
• Width	962.5 mm (37.88")	
• Height	1,044.7 mm (41.13")	
2" Fill Port Opening Thread Dimensions		
• Major Diameter	64.8 mm (2.55")	
• Minor Diameter	57.1 mm (2.25")	
Dip Tube Opening Thread Dimensions		
• Major Diameter	64.8 mm (2.55")	
• Minor Diameter	57.4 mm (2.26")	
Wall Thickness (Min.):	2.387 mm (0.09")	
Markings (QC Audit):	<div style="display: flex; align-items: center;"> <div style="border: 1px solid black; border-radius: 50%; padding: 2px; margin-right: 10px;">u n</div> <div> <p>31HH1 / Y / 0124 / D /BAM 6808-RIKUTEC</p> <p>RIKUTEC Made in Germany</p> <p>23H245538MD7 14783</p> <p>SPI "2" PE-HD Recycling Symbol</p> </div> </div>	


COVER – POLY BOX (2.0)		DRAWING
Manufacturer: Rikutec America, Inc., Whitinsville, MA		
Description:	Top HUVEX with (3) Access Holes Secured to Tote with (8) Plastic Pins	
Quantity:	1	
Material:	High Density Polyethylene, Natural	
Tare Weight:	10.5 Kg (23.15 Lbs.)	
Overall Dimensions:		
• Length	1,212.9 mm (47.75")	
• Width	1,003.3 mm (39.50")	
• Height	962.2 mm (37.88)	
• Small Hole Diameter	142.0 mm (5.63")	
• Large Hole Diameter	177.8 mm (7.00")	
Markings (QC Audit):	<div style="display: flex; align-items: center;"> <div style="border: 1px solid black; border-radius: 50%; width: 20px; height: 20px; display: flex; align-items: center; justify-content: center; margin-right: 5px;"> u n </div> <div> 31HH1 / Y / 0124 / D / BAM / 6808 RIKUTEC / 3314 / 2070 / TR6F142 POLY-IBC UC 1000 Max Capacity 1060 Liter / Tare 96kg Gauge of Pressure: 100 kPa Hersteller: RIKUTEC Made in Germany SPI "2" PE HD Recycling Symbol </div> </div>	
EURO BASE – POLY BOX		
Manufacturer: Rikutec America, Inc., Whitinsville, MA		
Description:	4-Way Entry Plastic Outer Tote	
Quantity:	1	
Material:	High Density Polyethylene, Blue and Black	
Tare Weight:	63.5 Kg (140.0 Lbs.) (with Bottom Frame)	
Overall Dimensions:		
• Length	1,193.8 mm (47.00")	
• Width	990.6 mm (39.00")	
• Height	1,168.4 mm (46.00")	
EURO PALLET:		
Description:	Molded Pallet Feet and Bottom Detachable Plastic Euro Pallet with (8) Plastic Screws and Bolts	
Markings (QC Audit):		
• Frame	SPI "2" PE-HD Recycling Symbol	
• Box	None	

SECTION III: TEST PROCEDURES AND RESULTS

VIBRATION TEST

TEST INFORMATION		TEST CRITERIA
TEST CONTENTS:	Water	<ul style="list-style-type: none"> An IBC passes the vibration test if there is no rupture or leakage. (§178.819)
SAMPLE PREPARATION:	Refer to Section II	
CONDITIONING:	Ambient	
TABLE DISPLACEMENT:	1"	
TEST FREQUENCY:	3.6 Hz	
TEST DURATION:	1 Hour	
TEST EQUIPMENT:	Vertical motion using L.A.B. 10000 Transportation Simulator	





VIBRATION TEST SET-UP AND RESULTS (SAMPLE #1)

	Results	Comments/Observations
	PASS	The IBC met the criteria for passing the test. No leakage or damage.

BOTTOM LIFT TEST

TEST INFORMATION		TEST CRITERIA
TEST CONTENTS:	Water	<ul style="list-style-type: none"> For all IBC design types designed to be lifted from the base, there may be no permanent deformation which renders the IBC unsafe for transportation and no loss of contents. (§178.811)
SAMPLE PREPARATION:	Refer to Section II	
CONDITIONING:	Ambient	
NUMBER OF LIFTS:	8 (Four-Way Entry with 2 Lifts per Direction of Entry)	
FORK TINE PENETRATION:	Entry 1 & 2: 36" Entry 3 & 4: 30"	
COMBINED GROSS MASS LIFTED:	2,713.6 Kg (5,982.4 Lbs.) (Refer to Section IV)	
TEST EQUIPMENT:	Fork Truck Dead Load Weights	


BOTTOM LIFT TEST SET-UP AND RESULTS (SAMPLE #1)

Direction of Entry #1	Direction of Entry #2	Direction of Entry #3	Direction of Entry #4
			
Results		Comments/Observations	
Lift #1: PASS	Lift #5: PASS	The IBC met the criteria for passing the test. No leakage or damage.	
Lift #2: PASS	Lift #6: PASS		
Lift #3: PASS	Lift #7: PASS		
Lift #4: PASS	Lift #8: PASS		

LEAKPROOFNESS TEST

TEST INFORMATION		TEST CRITERIA
TEST CONTENTS:	Empty	<ul style="list-style-type: none"> For all IBC design types intended to contain solids that are loaded or discharged under pressure or intended to contain liquids, there may be no leakage of air from the IBC. (§178.813)
SAMPLE PREPARATION:	Refer to Section II	
CONDITIONING:	Ambient	
TEST PRESSURE:	20 kPa	
TEST DURATION:	10 Minutes	
AREA OF PRESSURIZATION:	Through Top Head	
TEST EQUIPMENT:	Regulated Air Source #: 2 Pressure Gauge #: 615 & 641	




LEAKPROOFNESS TEST SET-UP AND RESULTS (SAMPLE #1)

Set-Up Photo	Leakproofness Photo	Leakproofness Photo
		
Results	Comments/Observations	
PASS	The IBC met the criteria for passing the test. No leakage.	

HYDROSTATIC PRESSURE TEST

TEST INFORMATION		TEST CRITERIA
TEST CONTENTS:	Water	<ul style="list-style-type: none"> For rigid plastic and composite IBC design types intended to contain solids loaded or discharged under pressure or intended to contain liquids, there may be no leakage and no permanent deformation which renders the IBC unsafe for transportation. (§178.814)
WATER TEMPERATURE:	20.2°C (68.4°F)	
FILL CAPACITY:	Maximum Capacity	
SAMPLE PREPARATION:	Refer to Section II	
CONDITIONING:	Ambient	
TEST PRESSURE:	100 kPa	
TEST DURATION:	10 Minutes	
AREA OF PRESSURIZATION:	Through Top Head	
TEST EQUIPMENT:	Regulated Water Source #: 2 Pressure Gauge #: 641	

HYDROSTATIC PRESSURE TEST SET-UP AND RESULTS (SAMPLE #1)

Set-Up Photo	Hydrostatic Pressure Photo	Hydrostatic Pressure Photo
		
Results	Comments/Observations	
PASS	The IBC met the criteria for passing the test. No leakage.	

DROP TEST

TEST INFORMATION		TEST CRITERIA
TEST CONTENTS:	Methanol/Water Solution (0.963 SG)	<ul style="list-style-type: none"> For all IBC design types, there may be no damage which renders the IBC unsafe to be transported for salvage or for disposable, and no loss of contents. The IBC shall be capable of being lifted by an appropriate means until clear of the floor for five minutes. A slight discharge from closures upon impact is not considered a failure provided that no further leakage occurs. (§178.810)
SAMPLE PREPARATION:	Refer to Section II	
CONDITIONING:	-18°C (0°F) Chamber #202	
TEST CONTENTS TEMP.:	-18.3°C (-0.9°F)	
DROP HEIGHT:	1.9 Meters (75") (Refer to Section IV)	
DROP ORIENTATION:	Most Vulnerable Part of Base	
TEST EQUIPMENT:	Quick Release Hook Mechanism 5 Ton Overhead Hoist	

DROP TEST SET-UP AND RESULTS (SAMPLE #2)

Set-Up Photo	Post Drop Photo	Post Drop Photo
		
Results	Comments/Observations	
PASS	The IBC met the criteria for passing the test. No leakage. All three clamping nuts broke off the bottle and a crack on the bottom left side of the outer shell.	

REGULATORY AND INDUSTRY STANDARD REFERENCES

REGULATORY REFERENCES

TEST	49 CFR ^①	UN ^②	IMDG ^③
	October 2023 Edition	23 rd Edition	2022 Edition
Vibration:	178.819	6.5.6.13	6.5.6.13
Bottom Lift:	178.811	6.5.6.4	6.5.6.4
Leakproofness:	178.813	6.5.6.7	6.5.6.7
Hydrostatic Pressure:	178.814	6.5.6.8	6.5.6.8
Drop:	178.810	6.5.6.9	6.5.6.9

① United States Department of Transportation Code of Federal Regulations (CFR) Title 49, Transportation, Parts 100-185

② The United Nations Recommendations on the Transport of Dangerous Goods – Model Regulations (UN – Orange Book)

③ International Maritime Dangerous Goods Code (IMDG)

INDUSTRY STANDARD REFERENCES

Vibration:	ASTM ^④ D7387:	Standard Test Method for Vibration Testing of IBCs Used for Shipping Liquid Hazardous Materials (Dangerous Good)
	ISO ^⑤ 2247:	Packaging – Complete, Filled Transport Packages – Vibration Test at Fixed Low Frequency
Pressure:	ASTM ^④ D8134:	Standard Guide for Conducting Internal Hydrostatic Pressure Tests on United Nations (UN) IBC Design Types
Drop:	ASTM ^④ D5276:	Standard Test Method for Drop Test of Loaded Containers by Free Fall
	ASTM ^④ D7790:	Standard Test Method for the Preparation of Plastic Packagings Containing Liquids for United Nations (UN) Drop Testing
	ISO ^⑤ 2248:	Packaging – Complete, Filled Transport Packages – Vertical Impact Test by Dropping

④ American Society for Testing and Materials (ASTM)

⑤ International Organization for Standardization (ISO)

EQUIPMENT

All inspection, measuring and test equipment that can affect product quality is calibrated and adjusted at prescribed intervals, or prior to use, and is traceable to NIST, using ANSI Z540 as an overall guide for calibration certification.



TEN-E Packaging Services, Inc.

SECTION IV MATHEMATICAL CALCULATIONS

INFORMATION USED FOR CALCULATIONS

Overall IBC Tare Weight (IBCTW)- Sample 1:	97.0 Kg	213.8 Lbs.
Overall IBC Tare Weight (IBCTW)- Sample 2:	97.0 Kg	213.8 Lbs.
Overflow Capacity (OFC):		
Water	1,050.0 Kg	2,314.8 Lbs.
Methanol/Water	962.0 Kg	2,120.8 Lbs.
Actual Load Applied for Bottom Lift (BLALA):	1,587.6 Kg	3,500.0 Lbs.
Packing Group	II	
Product Specific Gravity (PSG):	1.90	Min Wt To Be Applied
Packing Group Multiplication Factor (MF):	1.00	3,172.7 Lbs. (Btm Lift)
# of IBC Stacked During Transportation (#IBC):	0	

98% OF OVERFLOW

Overflow Capacity (OFC) x 98%

<u>OFC</u>	x	<u>98%</u>					
1,050.0	x	98% =	1,029.0	Kg	2,268.6	Lbs. Water	Sample #1
962.0	x	98% =	942.8	Kg	2,078.5	Lbs. Methanol/Water	Sample #2

IBC TEST WEIGHT (IBCW)

Overall IBC Tare Weight (IBCTW) + 98% Overflow Capacity (OFC)

<u>IBCTW</u>	+	<u>98% OFC =</u>					
97.0	+	1,029.0	1,126.0	Kg	2,482.3	Lbs. Water	Sample #1
97.0	+	942.8	1,039.8	Kg	2,292.3	Lbs. Methanol/Water	Sample #2

AUTHORIZED IBC GROSS MASS (AIBCGM)

Overall IBC Tare Weight (IBCTW) + (Product SG (PSG) x 98% Overflow (OFC))

<u>IBCTW</u>	+	<u>(PSG</u>	x	<u>98% OFC)</u>			
97.0	+	1.90	x	1,029.0			
		2,052.1	Kg	4,524.0	Lbs.		



TEN-E Packaging Services, Inc.

BOTTOM LIFT CALCULATIONS

The IBC must be loaded to 1.25 times the combined maximum permissible gross mass with load being evenly distributed

Minimum Required Load

Authorized IBC Gross Mass x 1.25

<u>ABCGM</u>	x	<u>1.25</u>	=	<u>Minimum Required Load</u>		
2,052.1	x	1.25	=	2,565.1 Kg	5,655.1	Lbs.

Combined Gross Mass Lifted

Actual Load Applied (ALA) + IBC Test Weight (IBCW)

<u>IBCW</u>	+	<u>ALA</u>	=	<u>Total Load Lifted</u>		
1,126.0	+	1,587.6	=	2,713.6 Kg	5,982.4	Lbs.

DROP HEIGHT

Calculation For Product Specific Gravities Exceeding 1.2

Product Specific Gravity (PSG) x Packing Group Multiplication Factor (MF)

<u>PSG</u>	x	<u>MF</u>		<u>Packing Group:</u>	<u>II</u>
1.90	x	1.00		<u>Required Drop Height</u>	<u>Actual Drop Height</u>
		1.90	Meter	74.8 Inches	75 Inches