

Material	Category	Code	Sub-section
HZ. Composite with plastics inner receptacle ^a	for solids, filled or discharged by gravity, with rigid plastics inner receptacle	11HZ1	6.5.5.4
	for solids, filled or discharged by gravity, with flexible plastics inner receptacle	11HZ2	
	for solids, filled or discharged under pressure, with rigid plastics inner receptacle	21HZ1	
	for solids, filled or discharged under pressure, with flexible plastics inner receptacle	21HZ2	
	for liquids, with rigid plastics inner receptacle	31HZ1	
	for liquids, with flexible plastics inner receptacle	31HZ2	
G. Fibreboard	for solids, filled or discharged by gravity	11G	6.5.5.5
Wooden			
C. Natural wood	for solids, filled or discharged by gravity with inner liner	11C	6.5.5.6
D. Plywood	for solids, filled or discharged by gravity, with inner liner	11D	
F. Reconstituted wood	for solids, filled or discharged by gravity, with inner liner	11F	


^a The code shall be completed by replacing the letter Z by a capital letter in accordance with 6.5.1.4.1 (b) to indicate the nature of the material used for the outer casing.

6.5.1.4.4 The letter "W" may follow the IBC code. The letter "W" signifies that the IBC, although of the same type indicated by the code, is manufactured to a specification different from those in 6.5.5 and is considered equivalent in accordance with the requirements in 6.5.1.1.2.

6.5.2 Marking

6.5.2.1 Primary marking

6.5.2.1.1 Each IBC manufactured and intended for use according to ADR shall bear marks which are durable, legible and placed in a location so as to be readily visible. Letters, numerals and symbols shall be at least 12 mm high and shall show:

- (a) The United Nations packaging symbol .

This symbol shall not be used for any purpose other than certifying that a packaging, a flexible bulk container, a portable tank or a MEGC complies with the relevant requirements in Chapter 6.1, 6.2, 6.3, 6.5, 6.6, 6.7 or 6.11. For metal IBCs on which the marks are stamped or embossed, the capital letters "UN" may be applied instead of the symbol;

- (b) The code designating the type of IBC according to 6.5.1.4;
- (c) A capital letter designating the packing group(s) for which the design type has been approved:
- (i) X for packing groups I, II and III (IBCs for solids only);
 - (ii) Y for packing groups II and III;
 - (iii) Z for packing group III only;
- (d) The month and year (last two digits) of manufacture;
- (e) The State authorizing the allocation of the mark; indicated by the distinguishing sign used on vehicles in international road traffic¹;
- (f) The name or symbol of the manufacturer and other identification of the IBC as specified by the

¹ Distinguishing sign of the State of registration used on motor vehicles and trailers in international road traffic, e.g. in accordance with the Geneva Convention on Road Traffic of 1949 or the Vienna Convention on Road Traffic of 1968.

competent authority;

- (g) The stacking test load in kg. For IBCs not designed for stacking, the figure "0" shall be shown;
- (h) The maximum permissible gross mass in kg.

The primary marks required above shall be applied in the sequence of the subparagraphs above. The marks required by 6.5.2.2 and any further mark authorized by a competent authority shall still enable the primary marks to be correctly identified.

Each mark applied in accordance with (a) to (h) and with 6.5.2.2 shall be clearly separated, e.g. by a slash or space, so as to be easily identifiable.

6.5.2.1.2 IBCs manufactured from recycled plastics material as defined in 1.2.1 shall be marked "REC". For rigid IBCs this mark shall be placed near the marks prescribed in 6.5.2.1.1. For the inner receptacle of composite IBCs, this mark shall be placed near the marks prescribed in 6.5.2.2.4.

6.5.2.1.3 *Examples of marking for various types of IBC in accordance with 6.5.2.1.1 (a) to (h) above:*



11A/Y/02 99
NL/Mulder 007
5500/1500

For a metal IBC for solids discharged by gravity and made from steel/for packing groups II and III/ manufactured in February 1999/authorized by the Netherlands/manufactured by Mulder and of a design type to which the competent authority has allocated serial number 007/the stacking test load in kg/the maximum permissible gross mass in kg.



13H3/Z/03 01
F/Meunier 1713
0/1500

For a flexible IBC for solids discharged for instance by gravity and made from woven plastics with a liner/not designed to be stacked.



31H1/Y/04 99
GB/9099
10800/1200

For a rigid plastics IBC for liquids made from plastics with structural equipment withstanding the stack load.



31HA1/Y/05 01
D/Muller 1683
10800/1200

For a composite IBC for liquids with a rigid plastics inner receptacle and a steel outer casing.



11C/X/01 02
S/Aurigny 9876
3000/910

For a wooden IBC for solids with an inner liner authorized for packing groups I, II and III solids.

6.5.2.1.4 Where an IBC conforms to one or more than one tested IBC design type, including one or more than one tested packaging or large packaging design type, the IBC may bear more than one mark to indicate the relevant performance test requirements that have been met. Where more than one mark appears on an IBC, the marks shall appear in close proximity to one another and each mark shall appear in its entirety.

6.5.2.2 Additional marking

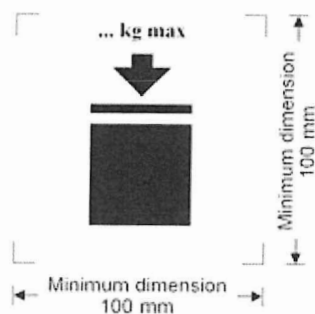
6.5.2.2.1 Each IBC shall bear the marks required in 6.5.2.1 and, in addition, the following information which may appear on a corrosion-resistant plate permanently attached in a place readily accessible for inspection:

Additional marks	Category of IBC				
	Metal	Rigid plastics	Composite	Fibreboard	Wooden
Capacity in litres ^a at 20 °C	X	X	X		
Tare mass in kg ^a	X	X	X	X	X
Test (gauge) pressure, in kPa or bar ^a , if applicable		X	X		
Maximum filling / discharge pressure in kPa or bar ^a , if applicable	X	X	X		
Body material and its minimum thickness in mm	X				
Date of last leakproofness test, if applicable (month and year)	X	X	X		
Date of last inspection (month and year)	X	X	X		
Serial number of the manufacturer	X				

^a The unit used shall be indicated.

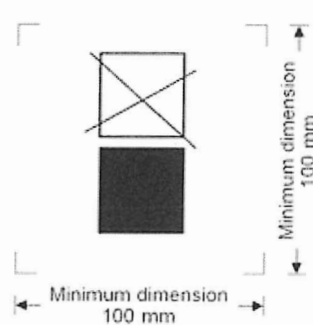
6.5.2.2.2 The maximum permitted stacking load applicable shall be displayed on a symbol as shown in Figure 6.5.2.2.2.1 or Figure 6.5.2.2.2.2. The symbol shall be durable and clearly visible.

Figure 6.5.2.2.2.1



IBCs capable of being stacked

Figure 6.5.2.2.2.2



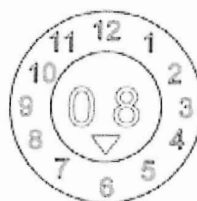
IBCs NOT capable of being stacked

The minimum dimensions shall be 100 mm × 100 mm. The letters and numbers indicating the mass shall be at least 12 mm high. The area within the printer's marks indicated by the dimensional arrows shall be square. Where dimensions are not specified, all features shall be in approximate proportion to those shown. The mass marked above the symbol shall not exceed the load imposed during the design type test (see 6.5.6.6.4) divided by 1.8.

6.5.2.2.3 In addition to the marks required in 6.5.2.1, flexible IBCs may bear a pictogram indicating recommended lifting methods.

- 6.5.2.2.4 Inner receptacles that are of composite IBC design type shall be identified by the application of the marks indicated in 6.5.2.1.1 (b), (c), (d) where this date is that of the manufacture of the plastics inner receptacle, (e) and (f). The UN packaging symbol shall not be applied. The marks shall be applied in the sequence shown in 6.5.2.1.1. They shall be durable, legible and placed in a location so as to be readily accessible for inspection after assembling the inner receptacle in the outer casing. When the marks on the inner receptacle are not readily accessible for inspection due to the design of the outer casing, a duplicate of the required marks on the inner receptacle shall be placed on the outer casing preceded by the wording "Inner receptacle". This duplicate shall be durable, legible and placed in a location so as to be readily accessible for inspection.

The date of the manufacture of the plastics inner receptacle may alternatively be marked on the inner receptacle adjacent to the remainder of the marks. In such a case, the date may be waived from the remainder of the marks. An example of an appropriate marking method is:



NOTE 1: Other methods that provide the minimum required information in a durable, visible and legible form are also acceptable.

NOTE 2: The date of manufacture of the inner receptacle may be different from the marked date of manufacture (see 6.5.2.1), repair (see 6.5.4.5.3) or remanufacture (see 6.5.2.4) of the composite IBC.

- 6.5.2.2.5 Where a composite IBCs is designed in such a manner that the outer casing is intended to be dismantled for carriage when empty (such as for return of the IBC for reuse to the original consignor), each of the parts intended to be detached when so dismantled shall be marked with the month and year of manufacture and the name or symbol of the manufacturer and other identification of the IBC as specified by the competent authority (see 6.5.2.1.1 (f)).

6.5.2.3 **Conformity to design type**

The marks indicate that IBCs correspond to a successfully tested design type and that the requirements referred to in the certificate have been met.

6.5.2.4 **Marking of remanufactured composite IBCs (31HZ1)**

The marks specified in 6.5.2.1.1 and 6.5.2.2 shall be removed from the original IBC or made permanently illegible and new marks shall be applied to an IBC remanufactured in accordance with ADR.

6.5.3 **Construction requirements**

6.5.3.1 **General requirements**

- 6.5.3.1.1 IBCs shall be resistant to or adequately protected from deterioration due to the external environment.
- 6.5.3.1.2 IBCs shall be so constructed and closed that none of the contents can escape under normal conditions of carriage including the effect of vibration, or by changes in temperature, humidity or pressure.
- 6.5.3.1.3 IBCs and their closures shall be constructed of materials compatible with their contents, or be protected internally, so that they are not liable:
- (a) To be attacked by the contents so as to make their use dangerous;
 - (b) To cause the contents to react or decompose, or form harmful or dangerous compounds with the IBCs.

- 6.5.3.1.4 Gaskets, where used, shall be made of materials not subject to attack by the contents of the IBCs.

6.5.3.1.5 All service equipment shall be so positioned or protected as to minimize the risk of escape of the contents owing to damage during handling and carriage.

6.5.3.1.6 IBCs, their attachments and their service and structural equipment shall be designed to withstand, without loss of contents, the internal pressure of the contents and the stresses of normal handling and carriage. IBCs intended for stacking shall be designed for stacking. Any lifting or securing features of IBCs shall be of sufficient strength to withstand the normal conditions of handling and carriage without gross distortion or failure and shall be so positioned that no undue stress is caused in any part of the IBC.

6.5.3.1.7 Where an IBC consists of a body within a framework it shall be so constructed that:

- (a) The body does not chafe or rub against the framework so as to cause material damage to the body;
- (b) The body is retained within the framework at all times;
- (c) The items of equipment are fixed in such a way that they cannot be damaged if the connections between body and frame allow relative expansion or movement.

6.5.3.1.8 Where a bottom discharge valve is fitted, it shall be capable of being made secure in the closed position and the whole discharge system shall be suitably protected from damage. Valves having lever closures shall be able to be secured against accidental opening and the open or closed position shall be readily apparent. For IBCs containing liquids, a secondary means of sealing the discharge aperture shall also be provided, e.g. a blank flange or equivalent device.

6.5.4 Testing, certification and inspection

6.5.4.1 *Quality assurance:* the IBCs shall be manufactured, remanufactured, repaired and tested under a quality assurance programme which satisfies the competent authority, in order to ensure that each manufactured, remanufactured or repaired IBC meets the requirements of this Chapter.

NOTE: ISO 16106:2020 "Transport packages for dangerous goods – Dangerous goods packagings, intermediate bulk containers (IBCs) and large packagings – Guidelines for the application of ISO 9001" provides acceptable guidance on procedures which may be followed.

6.5.4.2 *Test requirements:* IBCs shall be subject to design type tests and, if applicable, to initial and periodic inspections and tests in accordance with 6.5.4.4.

6.5.4.3 *Certification:* in respect of each design type of IBC a certificate and mark (as in 6.5.2) shall be issued attesting that the design type, including its equipment, meets the test requirements.

6.5.4.4 Inspection and testing

NOTE: See also 6.5.4.5 for tests and inspections on repaired IBCs.

6.5.4.4.1 Every metal, rigid plastics and composite IBC shall be inspected to the satisfaction of the competent authority:

- (a) Before it is put into service (including after remanufactured), and thereafter at intervals not exceeding five years, with regard to:
 - (i) conformity to design type including marks;
 - (ii) internal and external condition;
 - (iii) proper functioning of service equipment.

Thermal insulation, if any, need be removed only to the extent necessary for a proper examination of the body of the IBC.

- (b) At intervals of not more than two and a half years, with regard to:
 - (i) external condition;
 - (ii) proper functioning of service equipment.

Thermal insulation, if any, need be removed only to the extent necessary for a proper examination of the body of the IBC.

Each IBC shall correspond in all respects to its design type.

6.5.4.4.2 Every metal, rigid plastics and composite IBC for liquids, or for solids which are filled or discharged under pressure, shall undergo a suitable leakproofness test. This test is part of a quality assurance programme as stipulated in 6.5.4.1 which shows the capability of meeting the appropriate test level indicated in 6.5.6.7.3:

- (a) Before it is first used for carriage;
- (b) At intervals of not more than two and a half years.

For this test the IBC shall be fitted with the primary bottom closure. The inner receptacle of a composite IBC may be tested without the outer casing, provided that the test results are not affected.

6.5.4.4.3 A report of each inspection and test shall be kept by the owner of the IBC at least until the next inspection or test. The report shall include the results of the inspection and test and shall identify the party performing the inspection and test (see also the marking requirements in 6.5.2.2.1).

6.5.4.4.4 The competent authority may at any time require proof, by tests in accordance with this Chapter, that IBCs meet the requirements of the design type tests.

6.5.4.5 *Repaired IBCs*

6.5.4.5.1 When an IBC is impaired as a result of impact (e.g. accident) or any other cause, it shall be repaired or otherwise maintained (see definition of "*Routine maintenance of IBCs*" in 1.2.1), so as to conform to the design type. The bodies of rigid plastics IBCs and the inner receptacles of composite IBCs that are impaired shall be replaced.

6.5.4.5.2 In addition to any other testing and inspection requirements in ADR, an IBC shall be subjected to the full testing and inspection requirements set out in 6.5.4.4, and the required reports shall be prepared, whenever it is repaired.

6.5.4.5.3 The Party performing the tests and inspections after the repair shall durably mark the IBC near the manufacturer's UN design type marks to show:

- (a) The State in which the tests and inspections were carried out;
- (b) The name or authorized symbol of the party performing the tests and inspections; and
- (c) The date (month, year) of the tests and inspections.

6.5.4.5.4 Test and inspections performed in accordance with 6.5.4.5.2 may be considered to satisfy the requirements for the two and a half and five year periodic tests and inspections.

6.5.5 *Specific requirements for IBCs*

6.5.5.1 *Specific requirements for metal IBCs*

6.5.5.1.1 These requirements apply to metal IBCs intended for the carriage of solids and liquids. There are three categories of metal IBCs:

- (a) Those for solids which are filled or discharged by gravity (11A, 11B, 11N);
- (b) Those for solids which are filled or discharged at a gauge pressure greater than 10 kPa (0.1 bar) (21A, 21B, 21N); and
- (c) Those for liquids (31A, 31B, 31N).

6.5.5.1.2 Bodies shall be made of suitable ductile metal in which the weldability has been fully demonstrated. Welds shall be skilfully made and afford complete safety. Low-temperature performance of the material shall be taken into account when appropriate.

6.5.5.1.3 Care shall be taken to avoid damage by galvanic action due to the juxtaposition of dissimilar metals.

6.5.5.1.4 Aluminium IBCs intended for the carriage of flammable liquids shall have no movable parts, such as covers, closures, etc., made of unprotected steel liable to rust, which might cause a dangerous reaction by coming into frictional or percussive contact with the aluminium.

6.5.5.1.5 Metal IBCs shall be made of metals which meet the following requirements:

- (a) For steel the elongation at fracture, in %, shall not be less than $10000/R_m$ with an absolute minimum of 20 %;

where R_m = guaranteed minimum tensile strength of the steel to be used, in N/mm^2 ;

- (b) For aluminium and its alloy the elongation at fracture, in %, shall not be less than $10000/(6 \times R_m)$ with an absolute minimum of 8 %.

Specimens used to determine the elongation at fracture shall be taken transversely to the direction of rolling and be so secured that:

$$L_o = 5d \quad \text{or}$$

$$L_o = 5.65\sqrt{A}$$

where: L_o = gauge length of the specimen before the test

d = diameter

A = cross-sectional area of test specimen.

6.5.5.1.6 *Minimum wall thickness:*

Metal IBCs with a capacity of more than 1500 l shall comply with the following minimum wall thickness requirement:

- (a) For a reference steel having a product of $R_m \times A_o = 10\,000$, the wall thickness shall not be less than:

Wall thickness (T) in mm			
Types 11A, 11B, 11N		Types 21A, 21B, 21N, 31A, 31B, 31N	
Unprotected	Protected	Unprotected	Protected
$T = C/2000 + 1.5$	$T = C/2000 + 1.0$	$T = C/1000 + 1.0$	$T = C/2000 + 1.5$

where: A_o = minimum elongation (as a percentage) of the reference steel to be used on fracture under tensile stress (see 6.5.5.1.5);

C = capacity in litres;

- (b) For metals other than the reference steel described in (a), the minimum wall thickness is given by the following equivalence formula:

$$e_1 = \frac{21.4 \times e_0}{\sqrt[3]{R_{m1} \times A_1}}$$

where: e_1 = required equivalent wall thickness of the metal to be used (in mm);

e_0 = required minimum wall thickness for the reference steel (in mm);

R_{m1} = guaranteed minimum tensile strength of the metal to be used (in N/mm^2) (see (c));

A_1 = minimum elongation (as a percentage) of the metal to be used on fracture under tensile stress (see 6.5.5.1.5).

However, in no case shall the wall thickness be less than 1.5 mm.

- (c) For purposes of the calculation described in (b), the guaranteed minimum tensile strength of the metal to be used (R_{m1}) shall be the minimum value according to national or international material standards. However, for austenitic steels, the specified value for R_m according to the material standards may be increased by up to 15 % when a greater value is attested in the material inspection certificate. When no material standard exists for the material in question, the value of R_m shall be the minimum value attested in the material inspection certificate.

6.5.5.1.7 Pressure-relief requirements: IBCs for liquids shall be capable of releasing a sufficient amount of vapour in the event of fire engulfment to ensure that no rupture of the body will occur. This can be achieved by conventional pressure relief devices or by other constructional means. The start-to-discharge pressure shall not be higher than 65 kPa (0.65 bar) and no lower than the total gauge pressure experienced in the IBC (i.e. the vapour pressure of the filling substance plus the partial pressure of the air or other inert gases, minus 100 kPa (1 bar)) at 55 °C, determined on the basis of a maximum degree of filling as defined in 4.1.1.4. The required relief devices shall be fitted in the vapour space.

6.5.5.2 *Specific requirements for flexible IBCs*

6.5.5.2.1 These requirements apply to flexible IBCs of the following types:

13H1	woven plastics without coating or liner
13H2	woven plastics, coated
13H3	woven plastics with liner
13H4	woven plastics, coated and with liner
13H5	plastics film
13L1	textile without coating or liner
13L2	textile, coated
13L3	textile with liner
13L4	textile, coated and with liner
13M1	paper, multiwall
13M2	paper, multiwall, water-resistant

Flexible IBCs are intended for the carriage of solids only.

6.5.5.2.2 Bodies shall be manufactured from suitable materials. The strength of the material and the construction of the flexible IBC shall be appropriate to its capacity and its intended use.

6.5.5.2.3 All materials used in the construction of flexible IBCs of types 13M1 and 13M2 shall, after complete immersion in water for not less than 24 hours, retain at least 85 % of the tensile strength as measured originally on the material conditioned to equilibrium at 67 % relative humidity or less.

6.5.5.2.4 Seams shall be formed by stitching, heat sealing, gluing or any equivalent method. All stitched seam-ends shall be secured.

6.5.5.2.5 Flexible IBCs shall provide adequate resistance to ageing and to degradation caused by ultraviolet radiation or the climatic conditions, or by the substance contained, thereby rendering them appropriate to their intended use.

6.5.5.2.6 For flexible plastics IBCs where protection against ultraviolet radiation is required, it shall be provided by the addition of carbon black or other suitable pigments or inhibitors. These additives shall be compatible with the contents and remain effective throughout the life of the body. Where use is made of carbon black, pigments or inhibitors other than those used in the manufacture of the tested design type, re-testing may be waived if changes in the carbon black content, the pigment content or the inhibitor content do not adversely affect the physical properties of the material of construction.

6.5.5.2.7 Additives may be incorporated into the material of the body to improve the resistance to ageing or to serve other purposes, provided that these do not adversely affect the physical or chemical properties of the material.

6.5.5.2.8 No material recovered from used receptacles shall be used in the manufacture of IBC bodies. Production residues or scrap from the same manufacturing process may, however, be used. Component parts such as fittings and pallet bases may also be used provided such components have not in any way been damaged in previous use.

6.5.5.2.9 When filled, the ratio of height to width shall be not more than 2:1.

- 6.5.5.2.10 The liner shall be made of a suitable material. The strength of the material used and the construction of the liner shall be appropriate to the capacity of the IBC and the intended use. Joins and closures shall be siftproof and capable of withstanding pressures and impacts liable to occur under normal conditions of handling and carriage.

6.5.5.3 *Specific requirements for rigid plastics IBCs*

- 6.5.5.3.1 These requirements apply to rigid plastics IBCs for the carriage of solids or liquids. Rigid plastics IBCs are of the following types:

- | | |
|------|---|
| 11H1 | fitted with structural equipment designed to withstand the whole load when IBCs are stacked, for solids which are filled or discharged by gravity |
| 11H2 | freestanding, for solids which are filled or discharged by gravity |
| 21H1 | fitted with structural equipment designed to withstand the whole load when IBCs are stacked, for solids which are filled or discharged under pressure |
| 21H2 | freestanding, for solids which are filled or discharged under pressure |
| 31H1 | fitted with structural equipment designed to withstand the whole load when IBCs are stacked, for liquids |
| 31H2 | freestanding, for liquids. |

- 6.5.5.3.2 The body shall be manufactured from suitable plastics material of known specifications and be of adequate strength in relation to its capacity and its intended use. Except for recycled plastics material as defined in 1.2.1, no used material other than production residues or regrind from the same manufacturing process may be used. The material shall be adequately resistant to ageing and to degradation caused by the substance contained or, where relevant, by ultraviolet radiation. Low temperature performance shall be taken into account when appropriate. Any permeation of the substance contained shall not constitute a danger under normal conditions of carriage.

- 6.5.5.3.3 Where protection against ultraviolet radiation is required, it shall be provided by the addition of carbon black or other suitable pigments or inhibitors. These additives shall be compatible with the contents and remain effective throughout the life of the body. Where use is made of carbon black, pigments or inhibitors other than those used in the manufacture of the tested design type, re-testing may be waived if changes in the carbon black content, the pigment content or the inhibitor content do not adversely affect the physical properties of the material of construction.

- 6.5.5.3.4 Additives may be incorporated in the material of the body to improve the resistance to ageing or to serve other purposes, provided that these do not adversely affect the physical or chemical properties of the material.

6.5.5.4 *Specific requirements for composite IBCs with plastics inner receptacles*

- 6.5.5.4.1 These requirements apply to composite IBCs for the carriage of solids and liquids of the following types:

- | | |
|-------|--|
| 11HZ1 | Composite IBCs with a rigid plastics inner receptacle, for solids filled or discharged by gravity |
| 11HZ2 | Composite IBCs with a flexible plastics inner receptacle, for solids filled or discharged by gravity |
| 21HZ1 | Composite IBCs with a rigid plastics inner receptacle, for solids filled or discharged under pressure |
| 21HZ2 | Composite IBCs with a flexible plastics inner receptacle, for solids filled or discharged under pressure |
| 31HZ1 | Composite IBCs with a rigid plastics inner receptacle, for liquids |
| 31HZ2 | Composite IBCs with a flexible plastics inner receptacle, for liquids. |

This code shall be completed by replacing the letter Z by a capital letter in accordance with 6.5.1.4.1 (b) to indicate the nature of the material used for the outer casing.

- 6.5.5.4.2 The inner receptacle is not intended to perform a containment function without its outer casing. A "rigid" inner receptacle is a receptacle which retains its general shape when empty without closures in place and without benefit of the outer casing. Any inner receptacle that is not "rigid" is considered to be "flexible".

- 6.5.5.4.3 The outer casing normally consists of rigid material formed so as to protect the inner receptacle from physical damage during handling and carriage but is not intended to perform the containment function. It includes the base pallet where appropriate.
- 6.5.5.4.4 A composite IBC with a fully enclosing outer casing shall be so designed that the integrity of the inner receptacle may be readily assessed following the leakproofness and hydraulic pressure tests.
- 6.5.5.4.5 IBCs of type 31HZ2 shall be limited to a capacity of not more than 1 250 litres.
- 6.5.5.4.6 The inner receptacle shall be manufactured from suitable plastics material of known specifications and be of adequate strength in relation to its capacity and its intended use. Except for recycled plastics material as defined in 1.2.1, no used material other than production residues or regrind from the same manufacturing process may be used. The material shall be adequately resistant to ageing and to degradation caused by the substance contained or, where relevant, by ultraviolet radiation. Low temperature performance shall be taken into account when appropriate. Any permeation of the substance contained shall not constitute a danger under normal conditions of carriage.
- 6.5.5.4.7 Where protection against ultraviolet radiation is required, it shall be provided by the addition of carbon black or other suitable pigments or inhibitors. These additives shall be compatible with the contents and remain effective throughout the life of the inner receptacle. Where use is made of carbon black, pigments or inhibitors, other than those used in the manufacture of the tested design type, retesting may be waived if changes in carbon black content, the pigment content or the inhibitor content do not adversely affect the physical properties of the material of construction.
- 6.5.5.4.8 Additives may be incorporated in the material of the inner receptacle to improve the resistance to ageing or to serve other purposes, provided that these do not adversely affect the physical or chemical properties of the material.
- 6.5.5.4.9 The inner receptacle of IBCs type 31HZ2 shall consist of at least three plies of film.
- 6.5.5.4.10 The strength of the material and the construction of the outer casing shall be appropriate to the capacity of the composite IBC and its intended use.
- 6.5.5.4.11 The outer casing shall be free of any projection that might damage the inner receptacle.
- 6.5.5.4.12 Metal outer casings shall be constructed of a suitable metal of adequate thickness.
- 6.5.5.4.13 Outer casings of natural wood shall be of well seasoned wood, commercially dry and free from defects that would materially lessen the strength of any part of the casing. The tops and bottoms may be made of water-resistant reconstituted wood such as hardboard, particle board or other suitable type.
- 6.5.5.4.14 Outer casings of plywood shall be made of well seasoned rotary cut, sliced or sawn veneer, commercially dry and free from defects that would materially lessen the strength of the casing. All adjacent plies shall be glued with water-resistant adhesive. Other suitable materials may be used with plywood for the construction of casings. Casings shall be firmly nailed or secured to corner posts or ends or be assembled by equally suitable devices.
- 6.5.5.4.15 The walls of outer casings of reconstituted wood shall be made of water-resistant reconstituted wood such as hardboard, particle board or other suitable type. Other parts of the casings may be made of other suitable material.
- 6.5.5.4.16 For fibreboard outer casings, strong and good quality solid or double-faced corrugated fibreboard (single or multiwall) shall be used appropriate to the capacity of the casing and to its intended use. The water resistance of the outer surface shall be such that the increase in mass, as determined in a test carried out over 30 minutes by the Cobb method of determining water absorption, is not greater than 155 g/m² (see ISO 535:2014). It shall have proper bending qualities. Fibreboard shall be cut, creased without scoring, and slotted so as to permit assembly without cracking, surface breaks or undue bending. The fluting of corrugated fibreboard shall be firmly glued to the facings.
- 6.5.5.4.17 The ends of fibreboard outer casings may have a wooden frame or be entirely of wood. Reinforcements of wooden battens may be used.
- 6.5.5.4.18 Manufacturing joins in the fibreboard outer casing shall be taped, lapped and glued, or lapped and stitched with metal staples. Lapped joins shall have an appropriate overlap. Where closing is effected by gluing or taping, a water-resistant adhesive shall be used.

- 6.5.5.4.19 Where the outer casing is of plastics material, the relevant requirements of 6.5.5.4.6 to 6.5.5.4.8 apply, on the understanding that, in this case, the requirements applicable to the inner receptacle are applicable to the outer casing of composite IBCs.
- 6.5.5.4.20 The outer casing of an IBC type 31HZ2 shall enclose the inner receptacle on all sides.
- 6.5.5.4.21 Any integral pallet base forming part of an IBC or any detachable pallet shall be suitable for mechanical handling with the IBC filled to its maximum permissible gross mass.
- 6.5.5.4.22 The pallet or integral base shall be designed so as to avoid any protrusion of the base of the IBC that might be liable to damage in handling.
- 6.5.5.4.23 The outer casing shall be secured to any detachable pallet to ensure stability in handling and carriage. Where a detachable pallet is used, its top surface shall be free from sharp protrusions that might damage the IBC.
- 6.5.5.4.24 Strengthening devices such as timber supports to increase stacking performance may be used but shall be external to the inner receptacle.
- 6.5.5.4.25 Where IBCs are intended for stacking, the bearing surface shall be such as to distribute the load in a safe manner. Such IBCs shall be designed so that the load is not supported by the inner receptacle.
- 6.5.5.5 *Specific requirements for fibreboard IBCs***
- 6.5.5.5.1 These requirements apply to fibreboard IBCs for the carriage of solids which are filled or discharged by gravity. Fibreboard IBCs are of the following type: 11G.
- 6.5.5.5.2 Fibreboard IBCs shall not incorporate top lifting devices.
- 6.5.5.5.3 The body shall be made of strong and good quality solid or double-faced corrugated fibreboard (single or multiwall), appropriate to the capacity of the IBC and to its intended use. The water resistance of the outer surface shall be such that the increase in mass, as determined in a test carried out over a period of 30 minutes by the Cobb method of determining water absorption, is not greater than 155 g/m² (see ISO 535:2014). It shall have proper bending qualities. Fibreboard shall be cut, creased without scoring, and slotted so as to permit assembly without cracking, surface breaks or undue bending. The fluting or corrugated fibreboard shall be firmly glued to the facings.
- 6.5.5.5.4 The walls, including top and bottom, shall have a minimum puncture resistance of 15 J measured according to ISO 3036:1975.
- 6.5.5.5.5 Manufacturing joins in the body of IBCs shall be made with an appropriate overlap and shall be taped, glued, stitched with metal staples or fastened by other means at least equally effective. Where joins are effected by gluing or taping, a water-resistant adhesive shall be used. Metal staples shall pass completely through all pieces to be fastened and be formed or protected so that any inner liner cannot be abraded or punctured by them.
- 6.5.5.5.6 The liner shall be made of a suitable material. The strength of the material used and the construction of the liner shall be appropriate to the capacity of the IBC and the intended use. Joins and closures shall be siftproof and capable of withstanding pressures and impacts liable to occur under normal conditions of handling and carriage.
- 6.5.5.5.7 Any integral pallet base forming part of an IBC or any detachable pallet shall be suitable for mechanical handling with the IBC filled to its maximum permissible gross mass.
- 6.5.5.5.8 The pallet or integral base shall be designed so as to avoid any protrusion of the base of the IBC that might be liable to damage in handling.
- 6.5.5.5.9 The body shall be secured to any detachable pallet to ensure stability in handling and carriage. Where a detachable pallet is used, its top surface shall be free from sharp protrusions that might damage the IBC.
- 6.5.5.5.10 Strengthening devices such as timber supports to increase stacking performance may be used but shall be external to the liner.
- 6.5.5.5.11 Where IBCs are intended for stacking, the bearing surface shall be such as to distribute the load in a safe manner.

6.5.5.6 *Specific requirements for wooden IBCs*

6.5.5.6.1 These requirements apply to wooden IBCs for the carriage of solids which are filled or discharged by gravity. Wooden IBCs are of the following types:

- 11C Natural wood with inner liner
- 11D Plywood with inner liner
- 11F Reconstituted wood with inner liner.

6.5.5.6.2 Wooden IBCs shall not incorporate top lifting devices.

6.5.5.6.3 The strength of the materials used and the method of construction of the body shall be appropriate to the capacity and intended use of the IBC.

6.5.5.6.4 Natural wood shall be well seasoned, commercially dry and free from defects that would materially lessen the strength of any part of the IBC. Each part of the IBC shall consist of one piece or be equivalent thereto. Parts are considered equivalent to one piece when a suitable method of glued assembly is used (as for instance Lindermann joint, tongue and groove joint, ship lap or rabbet joint); or butt joint with at least two corrugated metal fasteners at each joint, or when other methods at least equally effective are used.

6.5.5.6.5 Bodies of plywood shall be at least 3-ply. They shall be made of well seasoned rotary cut, sliced or sawn veneer, commercially dry and free from defects that would materially lessen the strength of the body. All adjacent plies shall be glued with water-resistant adhesive. Other suitable materials may be used with plywood for the construction of the body.

6.5.5.6.6 Bodies of reconstituted wood shall be made of water-resistant reconstituted wood such as hardboard, particle board or other suitable type.

6.5.5.6.7 IBCs shall be firmly nailed or secured to corner posts or ends or be assembled by equally suitable devices.

6.5.5.6.8 The liner shall be made of a suitable material. The strength of the material used and the construction of the liner shall be appropriate to the capacity of the IBC and the intended use. Joins and closures shall be siftproof and capable of withstanding pressures and impacts liable to occur under normal conditions of handling and carriage.

6.5.5.6.9 Any integral pallet base forming part of an IBC or any detachable pallet shall be suitable for mechanical handling with the IBC filled to its maximum permissible gross mass.

6.5.5.6.10 The pallet or integral base shall be designed so as to avoid any protrusion of the base of the IBC that might be liable to damage in handling.

6.5.5.6.11 The body shall be secured to any detachable pallet to ensure stability in handling and carriage. Where a detachable pallet is used, its top surface shall be free from sharp protrusions that might damage the IBC.

6.5.5.6.12 Strengthening devices such as timber supports to increase stacking performance may be used but shall be external to the liner.

6.5.5.6.13 Where IBCs are intended for stacking, the bearing surface shall be such as to distribute the load in a safe manner.

6.5.6 **Test requirements for IBCs****6.5.6.1** *Performance and frequency of tests*

6.5.6.1.1 Each IBC design type shall successfully pass the tests prescribed in this Chapter before being used and being approved by the competent authority allowing the allocation of the mark. An IBC design type is defined by the design, size, material and thickness, manner of construction and means of filling and discharging but may include various surface treatments. It also includes IBCs which differ from the design type only in their lesser external dimensions.

6.5.6.1.2 Tests shall be carried out on IBCs prepared for carriage. IBCs shall be filled as indicated in the relevant sections. The substances to be carried in the IBCs may be replaced by other substances except where this would invalidate the results of the tests. For solids, when another substance is used it shall have the

same physical characteristics (mass, grain size, etc.) as the substance to be carried. 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.

6.5.6.2 *Design type tests*

6.5.6.2.1 One IBC of each design type, size, wall thickness and manner of construction shall be submitted to the tests listed in the order shown in 6.5.6.3.7 and as set out in 6.5.6.4 to 6.5.6.13. These design type tests shall be carried out as required by the competent authority.

6.5.6.2.2 To prove sufficient chemical compatibility with the contained goods or standard liquids in accordance with 6.5.6.3.3 or 6.5.6.3.5 for rigid plastics IBCs of type 31H2 and for composite IBCs of types 31HH1 and 31HH2, a second IBC can be used when the IBCs are designed to be stacked. In such case both IBCs shall be subjected to a preliminary storage.

6.5.6.2.3 The competent authority may permit the selective testing of IBCs which differ only in minor respects from a tested type, e.g. with small reductions in external dimensions.

6.5.6.2.4 If detachable pallets are used in the tests, the test report issued in accordance with 6.5.6.14 shall include a technical description of the pallets used.

6.5.6.3 *Preparation of IBCs for testing*

6.5.6.3.1 Paper and fibreboard IBCs and composite IBCs with fibreboard outer casings shall be conditioned for at least 24 hours in an atmosphere having a controlled temperature and relative humidity (r.h.). There are three options, one of which shall be chosen. The preferred atmosphere is $23 \pm 2^\circ\text{C}$ and $50\% \pm 2\%$ r.h. The two other options are $20 \pm 2^\circ\text{C}$ and $65\% \pm 2\%$ r.h.; or $27 \pm 2^\circ\text{C}$ and $65\% \pm 2\%$ r.h.

NOTE: Average values shall fall within these limits. Short-term fluctuations and measurement limitations may cause individual measurements to vary by up to $\pm 5\%$ relative humidity without significant impairment of test reproducibility.

6.5.6.3.2 Additional steps shall be taken to ascertain that the plastics material used in the manufacture of rigid plastics IBCs (types 31H1 and 31H2) and composite IBCs (types 31HZ1 and 31HZ2) complies respectively with the requirements in 6.5.5.3.2 to 6.5.5.3.4 and 6.5.5.4.6 to 6.5.5.4.8.

6.5.6.3.3 To prove there is sufficient chemical compatibility with the contained goods, the sample IBC shall be subjected to a preliminary storage for six months, during which the samples shall remain filled with the substances they are intended to contain or with substances which are known to have at least as severe a stress-cracking, weakening or molecular degradation influence on the plastics materials in question, and after which the samples shall be submitted to the applicable tests listed in the table in 6.5.6.3.7.

6.5.6.3.4 Where the satisfactory behaviour of the plastics material has been established by other means, the above compatibility test may be dispensed with. Such procedures shall be at least equivalent to the above compatibility test and recognized by the competent authority.

6.5.6.3.5 For polyethylene rigid plastics IBCs (types 31H1 and 31H2) in accordance with 6.5.5.3 and composite IBCs with polyethylene inner receptacle (types 31HZ1 and 31HZ2) in accordance with 6.5.5.4, chemical compatibility with filling liquids assimilated in accordance with 4.1.1.21 may be verified as follows with standard liquids (see 6.1.6).

The standard liquids are representative for the processes of deterioration on polyethylene, as there are softening through swelling, cracking under stress, molecular degradation and combinations thereof.

The sufficient chemical compatibility of the IBCs may be verified by storage of the required test samples for three weeks at 40°C with the appropriate standard liquid(s); where this standard liquid is water, storage in accordance with this procedure is not required. Storage is not required either for test samples which are used for the stacking test in case of the standard liquids wetting solution and acetic acid. After this storage, the test samples shall undergo the tests prescribed in 6.5.6.4 to 6.5.6.9.

The compatibility test for tert-Butyl hydroperoxide with more than 40 % peroxide content and peroxyacetic acids of Class 5.2 shall not be carried out using standard liquids. For these substances, sufficient chemical compatibility of the test samples shall be verified during a storage period of six months at ambient temperature with the substances they are intended to carry.

Results of the procedure in accordance with this paragraph from polyethylene IBCs can be approved for an equal design type, the internal surface of which is fluorinated.

6.5.6.3.6 For IBC design types, made of polyethylene, as specified in 6.5.6.3.5, which have passed the test in 6.5.6.3.5, the chemical compatibility with filling substances may also be verified by laboratory tests proving that the effect of such filling substances on the test specimens is less than that of the appropriate standard liquid(s) taking into account the relevant processes of deterioration. The same conditions as those set out in 4.1.1.21.2 shall apply with respect to relative density and vapour pressure.

6.5.6.3.7 *Design type tests required and sequential order*

Type of IBC	Vibration ^f	Bottom lift	Top lift ^a	Stacking ^b	Leak-proofness	Hydraulic pressure	Drop	Tear	Topple	Righting ^c
Metal:										
11A, 11B, 11N	-	1st ^a	2nd	3rd	-	-	4th ^e	-	-	-
21A, 21B, 21N	-	1st ^a	2nd	3rd	4th	5th	6th ^e	-	-	-
31A, 31B, 31N	1st	2nd ^a	3rd	4th	5th	6th	7th ^e	-	-	-
Flexible ^d	-	-	x ^c	x	-	-	x	x	x	x
Rigid plastics:										
11H1, 11H2	-	1st ^a	2nd	3rd	-	-	4th	-	-	-
21H1, 21H2	-	1st ^a	2nd	3rd	4th	5th	6th	-	-	-
31H1, 31H2	1st	2nd ^a	3rd	4th ^g	5th	6th	7th	-	-	-
Composite:										
11HZ1, 11HZ2	-	1st ^a	2nd	3rd	-	-	4th ^e	-	-	-
21HZ1, 21HZ2	-	1st ^a	2nd	3rd	4th	5th	6th ^e	-	-	-
31HZ1, 31HZ2	1st	2nd ^a	3rd	4th ^g	5th	6th	7th ^e	-	-	-
Fibreboard	-	1st	-	2nd	-	-	3rd	-	-	-
Wooden	-	1st	-	2nd	-	-	3rd	-	-	-

^a When IBCs are designed for this method of handling.

^b When IBCs are designed to be stacked.

^c When IBCs are designed to be lifted from the top or the side.

^d Required test indicated by x; an IBC which has passed one test may be used for other tests, in any order.

^e Another IBC of the same design may be used for the drop test.

^f Another IBC of the same design may be used for the vibration test.

^g The second IBC in accordance with 6.5.6.2.2 can be used out of the sequential order direct after the preliminary storage.

6.5.6.4 *Bottom lift test*

6.5.6.4.1 *Applicability*

For all fibreboard and wooden IBCs, and for all types of IBC which are fitted with means of lifting from the base, as a design type test.

6.5.6.4.2 *Preparation of the IBC for test*

The IBC shall be filled. A load shall be added and evenly distributed. The mass of the filled IBC and the load shall be 1.25 times the maximum permissible gross mass.

6.5.6.4.3 *Method of testing*

The IBC shall be raised and lowered twice by a lift truck with the forks centrally positioned and spaced at three quarters of the dimension of the side of entry (unless the points of entry are fixed). The forks shall penetrate to three quarters of the direction of entry. The test shall be repeated from each possible direction of entry.

6.5.6.4.4 *Criteria for passing the test*

No permanent deformation which renders the IBC, including the base pallet, if any, unsafe for carriage and no loss of contents.

6.5.6.5 *Top lift test***6.5.6.5.1** *Applicability*

For all types of IBC which are designed to be lifted from the top and for flexible IBCs designed to be lifted from the top or the side, as a design type test.

6.5.6.5.2 *Preparation of the IBC for test*

Metal, rigid plastics and composite IBCs shall be filled. A load shall be added and evenly distributed. The mass of the filled IBC and the load shall be twice the maximum permissible gross mass. Flexible IBCs shall be filled with a representative material and then shall be loaded to six times their maximum permissible gross mass, the load being evenly distributed.

6.5.6.5.3 *Methods of testing*

Metal and flexible IBCs shall be lifted in the manner for which they are designed until clear of the floor and maintained in that position for a period of five minutes.

Rigid plastics and composite IBCs shall be lifted:

- (a) By each pair of diagonally opposite lifting devices, so that the hoisting forces are applied vertically, for a period of five minutes; and
- (b) By each pair of diagonally opposite lifting devices, so that the hoisting forces are applied toward the centre at 45° to the vertical, for a period of five minutes.

6.5.6.5.4 Other methods of top lift testing and preparation at least equally effective may be used for flexible IBCs.

6.5.6.5.5 *Criteria for passing the test*

- (a) Metal, rigid plastics and composite IBCs: the IBC remains safe for normal conditions of carriage, there is no observable permanent deformation of the IBC, including the base pallet, if any, and no loss of contents;
- (b) Flexible IBCs: no damage to the IBC or its lifting devices which renders the IBC unsafe for carriage or handling and no loss of contents.

6.5.6.6 *Stacking test***6.5.6.6.1** *Applicability*

For all types of IBC which are designed to be stacked on each other, as a design type test.

6.5.6.6.2 *Preparation of the IBC for test*

The IBC shall be filled to its maximum permissible gross mass. If the specific gravity of the product being used for testing makes this impracticable, the IBC shall additionally be loaded so that it is tested at its maximum permissible gross mass the load being evenly distributed.

6.5.6.6.3 *Method of testing*

- (a) The IBC shall be placed on its base on level hard ground and subjected to a uniformly distributed superimposed test load (see 6.5.6.6.4). For rigid plastics IBCs of type 31H2 and composite IBCs of types 31HH1 and 31HH2, a stacking test shall be carried out with the original filling substance or a standard liquid (see 6.1.6) in accordance with 6.5.6.3.3 or 6.5.6.3.5 using the second IBC in accordance with 6.5.6.2.2 after the preliminary storage. IBCs shall be subjected to the test load for a period of at least:
 - (i) 5 minutes, for metal IBCs;
 - (ii) 28 days at 40 °C, for rigid plastics IBCs of types 11H2, 21H2 and 31H2 and for composite IBCs with outer casings of plastics material which bear the stacking load (i.e., types 11HH1, 11HH2, 21HH1, 21HH2, 31HH1 and 31HH2);
 - (iii) 24 hours, for all other types of IBCs;

(b) The load shall be applied by one of the following methods:

- (i) One or more IBCs of the same type filled to the maximum permissible gross mass stacked on the test IBC;
- (ii) Appropriate weights loaded on to either a flat plate or a reproduction of the base of the IBC, which is stacked on the test IBC.

6.5.6.6.4 *Calculation of superimposed test load*

The load to be placed on the IBC shall be 1.8 times the combined maximum permissible gross mass of the number of similar IBCs that may be stacked on top of the IBC during carriage.

6.5.6.6.5 *Criteria for passing the test*

- (a) All types of IBCs other than flexible IBCs: no permanent deformation which renders the IBC including the base pallet, if any, unsafe for carriage and no loss of contents;
- (b) Flexible IBCs: no deterioration of the body which renders the IBC unsafe for carriage and no loss of contents.

6.5.6.7 *Leakproofness test*

6.5.6.7.1 *Applicability*

For those types of IBC used for liquids or for solids filled or discharged under pressure, as a design type test and periodic test.

6.5.6.7.2 *Preparation of the IBC for test*

The test shall be carried out before the fitting of any thermal insulation equipment. Vented closures shall either be replaced by similar non-vented closures or the vent shall be sealed.

6.5.6.7.3 *Method of testing and pressure to be applied*

The test shall be carried out for a period of at least 10 minutes using air at a gauge pressure of not less than 20 kPa (0.2 bar). The air tightness of the IBC shall be determined by a suitable method such as by air-pressure differential test or by immersing the IBC in water or, for metal IBCs, by coating the seams and joints with a soap solution. In the case of immersing a correction factor shall be applied for the hydrostatic pressure.

6.5.6.7.4 *Criterion for passing the test*

No leakage of air.

6.5.6.8 *Internal pressure (hydraulic) test*

6.5.6.8.1 *Applicability*

For those types of IBCs used for liquids or for solids filled or discharged under pressure, as a design type test.

6.5.6.8.2 *Preparation of the IBC for test*

The test shall be carried out before the fitting of any thermal insulation equipment. Pressure-relief devices shall be removed and their apertures plugged, or shall be rendered inoperative.

6.5.6.8.3 *Method of testing*

The test shall be carried out for a period of at least 10 minutes applying a hydraulic pressure not less than that indicated in 6.5.6.8.4. The IBCs shall not be mechanically restrained during the test.

6.5.6.8.4 *Pressures to be applied***6.5.6.8.4.1** Metal IBCs:

- (a) For IBCs of types 21A, 21B and 21N, for packing group I solids, a 250 kPa (2.5 bar) gauge pressure;
- (b) For IBCs of types 21A, 21B, 21N, 31A, 31B and 31N, for packing groups II or III substances, a 200 kPa (2 bar) gauge pressure;
- (c) In addition, for IBCs of types 31A, 31B and 31N, a 65kPa (0.65 bar) gauge pressure. This test shall be performed before the 200 kPa (2 bar) test.

6.5.6.8.4.2 Rigid plastics and composite IBCs:

- (a) For IBCs of types 21H1, 21H2, 21HZ1 and 21HZ2: 75 kPa (0.75 bar) (gauge);
- (b) For IBCs of types 31H1, 31H2, 31HZ1 and 31HZ2: whichever is the greater of two values, the first as determined by one of the following methods:
 - (i) The total gauge pressure measured in the IBC (i.e. the vapour pressure of the filling substance and the partial pressure of the air or other inert gases, minus 100 kPa) at 55 °C multiplied by a safety factor of 1.5; this total gauge pressure shall be determined on the basis of a maximum degree of filling in accordance with 4.1.1.4 and a filling temperature of 15 °C;
 - (ii) 1.75 times the vapour pressure at 50 °C of the substance to be carried minus 100 kPa, but with a minimum test pressure of 100 kPa;
 - (iii) 1.5 times the vapour pressure at 55 °C of the substance to be carried minus 100 kPa, but with a minimum test pressure of 100 kPa;and the second as determined by the following method:
 - (iv) Twice the static pressure of the substance to be carried, with a minimum of twice the static pressure of water;

6.5.6.8.5 *Criteria for passing the test(s):*

- (a) For IBCs of types 21A, 21B, 21N, 31A, 31B and 31N, when subjected to the test pressure specified in 6.5.6.8.4.1 (a) or (b): no leakage;
- (b) For IBCs of types 31A, 31B and 31N, when subjected to the test pressure specified in 6.5.6.8.4.1 (c): no permanent deformation which renders the IBC unsafe for carriage and no leakage;
- (c) For rigid plastics and composite IBCs: no permanent deformation which would render the IBC unsafe for carriage and no leakage.

6.5.6.9 *Drop test***6.5.6.9.1** *Applicability*

For all types of IBCs, as a design type test.

6.5.6.9.2 *Preparation of the IBC for test*

- (a) Metal IBCs: the IBC shall be filled to not less than 95 % of its maximum capacity for solids or 98 % of its maximum capacity for liquids. Pressure-relief devices shall be removed and their apertures plugged, or shall be rendered inoperative;

- (b) Flexible IBCs: the IBC shall be filled to the maximum permissible gross mass, the contents being evenly distributed;
- (c) Rigid plastics and composite IBCs: the IBC shall be filled to not less than 95 % of its maximum capacity for solids or 98 % of its maximum capacity for liquids. Arrangements provided for pressure relief may be removed and plugged or rendered inoperative. Testing of IBCs shall be carried out when the temperature of the test sample and its contents has been reduced to minus 18 °C or lower. Where test samples of composite IBCs are prepared in this way the conditioning specified in 6.5.6.3.1 may be waived. Test liquids shall be kept in the liquid state, if necessary by the addition of anti-freeze. This conditioning may be disregarded if the materials in question are of sufficient ductility and tensile strength at low temperatures;
- (d) Fibreboard and wooden IBCs: The IBC shall be filled to not less than 95 % of its maximum capacity.

6.5.6.9.3

Method of testing

The IBC shall be dropped on its base onto a non-resilient, horizontal, flat, massive and rigid surface in conformity with the requirements of 6.1.5.3.4, in such a manner as to ensure that the point of impact is that part of the base of the IBC considered to be the most vulnerable. IBCs of 0.45 m³ or less capacity shall also be dropped:

- (a) Metal IBCs: on the most vulnerable part other than the part of the base tested in the first drop;
- (b) Flexible IBCs: on the most vulnerable side;
- (c) Rigid plastics, composite, fibreboard and wooden IBCs: flat on a side, flat on the top and on a corner.

The same IBC or a different IBC of the same design may be used for each drop.

6.5.6.9.4

Drop height

For solids and liquids, if the test is performed with the solid or liquid to be carried or with another substance having essentially the same physical characteristics:

Packing group I	Packing group II	Packing group III
1.8 m	1.2 m	0.8 m

For liquids if the test is performed with water:

- (a) Where the substances to be carried have a relative density not exceeding 1.2:

Packing group II	Packing group III
1.2 m	0.8 m

- (b) Where the substances to be carried have a relative density exceeding 1.2, the drop heights shall be calculated on the basis of the relative density (d) of the substance to be carried rounded up to the first decimal as follows:

Packing group II	Packing group III
$d \times 1.0$ m	$d \times 0.67$ m

6.5.6.9.5

Criteria for passing the test(s):

- (a) Metal IBCs: no loss of contents;
- (b) Flexible IBCs: no loss of contents. A slight discharge, e.g. from closures or stitch holes, upon impact shall not be considered to be a failure of the IBC provided that no further leakage occurs after the IBC has been raised clear of the ground;
- (c) Rigid plastics, composite, fibreboard and wooden IBCs: no loss of contents. A slight discharge from a closure upon impact shall not be considered to be a failure of the IBC provided that no further leakage occurs;

- (d) All IBCs: no damage which renders the IBC unsafe to be carried for salvage or for disposal, and no loss of contents. In addition, the IBC shall be capable of being lifted by an appropriate means until clear of the floor for five minutes.

NOTE: The criteria in (d) apply to design types for IBCs manufactured as from 1 January 2011.

6.5.6.10 *Tear test*

6.5.6.10.1 *Applicability*

For all types of flexible IBCs, as a design type test.

6.5.6.10.2 *Preparation of the IBC for test*

The IBC shall be filled to not less than 95 % of its capacity and to its maximum permissible gross mass, the contents being evenly distributed.

6.5.6.10.3 *Method of testing*

Once the IBC is placed on the ground, a 100 mm knife score, completely penetrating the wall of a wide face, is made at a 45° angle to the principal axis of the IBC, halfway between the bottom surface and the top level of the contents. The IBC shall then be subjected to a uniformly distributed superimposed load equivalent to twice the maximum permissible gross mass. The load shall be applied for at least five minutes. An IBC which is designed to be lifted from the top or the side shall then, after removal of the superimposed load, be lifted clear of the floor and maintained in that position for a period of five minutes.

6.5.6.10.4 *Criteria for passing the test*

The cut shall not propagate more than 25 % of its original length.

6.5.6.11 *Topple test*

6.5.6.11.1 *Applicability*

For all types of flexible IBC, as a design type test.

6.5.6.11.2 *Preparation of the IBC for test*

The IBC shall be filled to not less than 95 % of its capacity and to its maximum permissible gross mass, the contents being evenly distributed.

6.5.6.11.3 *Method of testing*

The IBC shall be caused to topple on to any part of its top on to a rigid, non-resilient, smooth, flat and horizontal surface.

6.5.6.11.4 *Topple height*

Packing group I	Packing group II	Packing group III
1.8 m	1.2 m	0.8 m

6.5.6.11.5 *Criteria for passing the test*

No loss of contents. A slight discharge, e.g. from closures or stitch holes, upon impact shall not be considered to be a failure of the IBC provided that no further leakage occurs.

6.5.6.12 ***Righting test***6.5.6.12.1 *Applicability*

For all flexible IBCs designed to be lifted from the top or side, as a design type test.

6.5.6.12.2 *Preparation of the IBC for test*

The IBC shall be filled to not less than 95 % of its capacity and to its maximum permissible gross mass, the contents being evenly distributed.

6.5.6.12.3 *Method of testing*

The IBC, lying on its side, shall be lifted at a speed of at least 0.1 m/s to upright position, clear of the floor, by one lifting device or by two lifting devices when four are provided.

6.5.6.12.4 *Criteria for passing the test*

No damage to the IBC or its lifting devices which renders the IBC unsafe for carriage or handling.

6.5.6.13 ***Vibration test***6.5.6.13.1 *Applicability*

For all IBCs used for liquids, as a design type test.

NOTE: This test applies to design types for IBCs manufactured after 31 December 2010 (see also 1.6.1.14).

6.5.6.13.2 *Preparation of the IBC for test*

A sample IBC shall be selected at random and shall be fitted and closed as for carriage. The IBC shall be filled with water to not less than 98 % of its maximum capacity.

6.5.6.13.3 *Test method and duration*

6.5.6.13.3.1 The IBC shall be placed in the centre of the test machine platform with a vertical sinusoidal, double amplitude (peak-to peak displacement) of 25 mm \pm 5 %. If necessary, restraining devices shall be attached to the platform to prevent the specimen from moving horizontally off the platform without restricting vertical movement.

6.5.6.13.3.2 The test shall be conducted for one hour at a frequency that causes part of the base of the IBC to be momentarily raised from the vibrating platform for part of each cycle to such a degree that a metal shim can be completely inserted intermittently at, at least, one point between the base of the IBC and the test platform. The frequency may need to be adjusted after the initial set point to prevent the packaging from going into resonance. Nevertheless, the test frequency shall continue to allow placement of the metal shim under the IBC as described in this paragraph. The continuing ability to insert the metal shim is essential to passing the test. The metal shim used for this test shall be at least 1.6 mm thick, 50 mm wide, and be of sufficient length to be inserted between the IBC and the test platform a minimum of 100 mm to perform the test.

6.5.6.13.4 *Criteria for passing the test*

No leakage or rupture shall be observed. In addition, no breakage or failure of structural components, such as broken welds or failed fastenings, shall be observed.

6.5.6.14 *Test report*

6.5.6.14.1 A test report containing at least the following particulars shall be drawn up and shall be made available to the users of the IBC:

1. Name and address of the test facility;
2. Name and address of applicant (where appropriate);
3. A unique test report identification;
4. Date of the test report;
5. Manufacturer of the IBC;
6. Description of the IBC design type (e.g. dimensions, materials, closures, thickness, etc.) including method of manufacture (e.g. blow moulding) and which may include drawing(s) and/or photograph(s);
7. Maximum capacity;
8. Characteristics of test contents, e.g. viscosity and relative density for liquids and particle size for solids. For rigid plastics and composite IBCs subject to the hydraulic pressure test in 6.5.6.8, the temperature of the water used;
9. Test descriptions and results;
10. The test report shall be signed with the name and status of the signatory.

6.5.6.14.2 The test report shall contain statements that the IBC prepared as for carriage was tested in accordance with the appropriate requirements of this Chapter and that the use of other packaging methods or components may render it invalid. A copy of the test report shall be available to the competent authority.

CHAPTER 6.6

REQUIREMENTS FOR THE CONSTRUCTION AND TESTING OF LARGE PACKAGINGS

6.6.1 General

6.6.1.1 The requirements of this Chapter do not apply to:

- (a) Packagings for Class 2, except large packagings for articles, including aerosols;
- (b) Packagings for Class 6.2, except large packagings for clinical waste of UN No. 3291;
- (c) Class 7 packages containing radioactive material.

6.6.1.2 Large packagings shall be manufactured, tested and remanufactured under a quality assurance programme which satisfies the competent authority in order to ensure that each manufactured or remanufactured large packaging meets the requirements of this Chapter.

NOTE: ISO 16106:2020 "Transport packages for dangerous goods – Dangerous goods packagings, intermediate bulk containers (IBCs) and large packagings – Guidelines for the application of ISO 9001" provides acceptable guidance on procedures which may be followed.

6.6.1.3 The specific requirements for large packagings in 6.6.4 are based on large packagings currently used. In order to take into account progress in science and technology, there is no objection to the use of large packagings having specifications different from those in 6.6.4 provided they are equally effective, acceptable to the competent authority and able to successfully fulfil the requirements described in 6.6.5. Methods of testing other than those described in ADR are acceptable provided they are equivalent and are recognized by the competent authority.

6.6.1.4 Manufacturers and subsequent distributors of packagings shall provide information regarding procedures to be followed and a description of the types and dimensions of closures (including required gaskets) and any other components needed to ensure that packages as presented for carriage are capable of passing the applicable performance tests of this Chapter.

6.6.2 Code for designating types of large packagings


6.6.2.1 The code used for large packagings consist of:

- (a) Two Arabic numerals:
 - 50 for rigid large packagings; or
 - 51 for flexible large packagings; and
- (b) A capital letter in Latin character indicating the nature of the material, e.g. wood, steel etc. The capital letters used shall be those shown in 6.1.2.6.

6.6.2.2 The letters "T" or "W" may follow the Large Packaging code. The letter "T" signifies a large salvage packaging conforming to the requirements of 6.6.5.1.9. The letter "W" signifies that the large packaging, although of the same type indicated by the code, is manufactured to a specification different from those in 6.6.4 and is considered equivalent in accordance with the requirements in 6.6.1.3.

6.6.3 Marking**6.6.3.1 Primary marking**

Each large packaging manufactured and intended for use in accordance with the provisions of ADR shall bear marks which are durable, legible and placed in a location so as to be readily visible. Letters, numerals and symbols shall be at least 12 mm high and shall show:

- (a) The United Nations packaging symbol .

This symbol shall not be used for any purpose other than certifying that a packaging, a flexible bulk container, a portable tank or a MEGC complies with the relevant requirements in Chapter 6.1, 6.2, 6.3, 6.5, 6.6, 6.7 or 6.11. For metal large packagings on which the marks are stamped or embossed, the capital letters "UN" may be applied instead of the symbol;

- (b) The number "50" designating a large rigid packaging or "51" for flexible large packagings, followed by the material type in accordance with 6.5.1.4.1 (b);
- (c) A capital letter designating the packing group(s) for which the design type has been approved:
- X for packing groups I, II and III
Y for packing groups II and III
Z for packing group III only;
- (d) The month and year (last two digits) of manufacture;
- (e) The State authorizing the allocation of the mark; indicated by the distinguishing sign used on vehicles in international road traffic¹;
- (f) The name or symbol of the manufacturer and other identification of the large packagings as specified by the competent authority;
- (g) The stacking test load in kg. For large packagings not designed for stacking the figure "0" shall be shown;
- (h) The maximum permissible gross mass in kilograms.

The primary mark required above shall be applied in the sequence of the sub-paragraphs.

Each mark applied in accordance with (a) to (h) shall be clearly separated, e.g. by a slash or space, so as to be easily identifiable.

¹ *Distinguishing sign of the State of registration used on motor vehicles and trailers in international road traffic, e.g. in accordance with the Geneva Convention on Road Traffic of 1949 or the Vienna Convention on Road Traffic of 1968.*

6.6.3.2

Examples of marking

50A/X/05 01/N/PQRS
2500/1000

For a large steel packaging suitable for stacking;
stacking load: 2 500 kg; maximum gross mass: 1 000 kg.



50H/Y/04 02/D/ABCD 987
0/800

For a large plastics packaging not suitable for stacking;
maximum gross mass: 800 kg.



51H/Z/06 01/S/1999
0/500

For a large flexible packaging not suitable for stacking;
maximum gross mass: 500 kg.



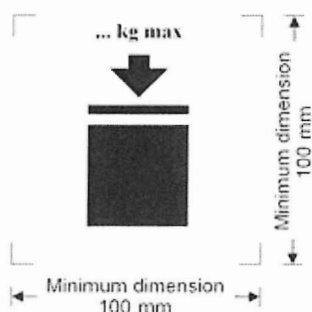
50AT/Y/05/01/B/PQRS
2500/1000

For a large steel salvage packaging suitable for stacking;
stacking load: 2 500 kg; maximum gross mass: 1 000 kg.

6.6.3.3

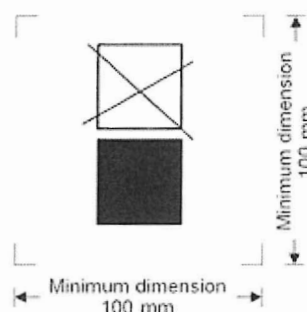
The maximum permitted stacking load applicable shall be displayed on a symbol as shown in Figure 6.6.3.3.1 or Figure 6.6.3.3.2. The symbol shall be durable and clearly visible.

Figure 6.6.3.3.1



Large packagings capable
of being stacked

Figure 6.6.3.3.2



Large packagings NOT
capable of being stacked

The minimum dimensions shall be 100 mm × 100 mm. The letters and numbers indicating the mass shall be at least 12 mm high. The area within the printer's marks indicated by the dimensional arrows shall be square. Where dimensions are not specified, all features shall be in approximate proportion to those shown. The mass marked above the symbol shall not exceed the load imposed during the design type test (see 6.6.5.3.3.4) divided by 1.8.

6.6.3.4

Where a large packaging conforms to one or more than one tested large packaging design type, including one or more than one tested packaging or IBC design type, the large packaging may bear more than one mark to indicate the relevant performance test requirements that have been met. Where more than one mark appears on a large packaging, the marks shall appear in close proximity to one another and each mark shall appear in its entirety.

6.6.4

Specific requirements for large packagings

6.6.4.1

Specific requirements for metal large packagings

50A steel
50B aluminium
50N metal (other than steel or aluminium)

6.6.4.1.1

The large packaging shall be made of suitable ductile metal in which the weldability has been fully demonstrated. Welds shall be skilfully made and afford complete safety. Low-temperature performance shall be taken into account when appropriate.

6.6.4.1.2

Care shall be taken to avoid damage by galvanic action due to the juxtaposition of dissimilar metals.

6.6.4.2 *Specific requirements for flexible material large packagings*

51H flexible plastics
51M flexible paper

- 6.6.4.2.1 The large packaging shall be manufactured from suitable materials. The strength of the material and the construction of the flexible large packagings shall be appropriate to its capacity and its intended use.
- 6.6.4.2.2 All materials used in the construction of flexible large packagings of types 51M shall, after complete immersion in water for not less than 24 hours, retain at least 85 % of the tensile strength as measured originally on the material conditioned to equilibrium at 67 % relative humidity or less.
- 6.6.4.2.3 Seams shall be formed by stitching, heat sealing, glueing or any equivalent method. All stitched seam-ends shall be secured.
- 6.6.4.2.4 Flexible large packagings shall provide adequate resistance to ageing and to degradation caused by ultraviolet radiation or the climatic conditions, or by the substance contained, thereby rendering them appropriate to their intended use.
- 6.6.4.2.5 For plastics flexible large packagings where protection against ultraviolet radiation is required, it shall be provided by the addition of carbon black or other suitable pigments or inhibitors. These additives shall be compatible with the contents and remain effective throughout the life of the large packaging. Where use is made of carbon black, pigments or inhibitors other than those used in the manufacture of the tested design type, re-testing may be waived if changes in the carbon black content, the pigment content or the inhibitor content do not adversely affect the physical properties of the material of construction.
- 6.6.4.2.6 Additives may be incorporated into the material of the large packaging to improve the resistance to ageing or to serve other purposes, provided that these do not adversely affect the physical or chemical properties of the material.
- 6.6.4.2.7 When filled, the ratio of height to width shall be not more than 2:1.

6.6.4.3 *Specific requirements for plastics large packagings*

50H rigid plastics

- 6.6.4.3.1 The large packaging shall be manufactured from suitable plastics material of known specifications and be of adequate strength in relation to its capacity and its intended use. The material shall be adequately resistant to ageing and to degradation caused by the substance contained or, where relevant, by ultraviolet radiation. Low temperature performance shall be taken into account when appropriate. Any permeation of the substance contained shall not constitute a danger under normal conditions of carriage.
- 6.6.4.3.2 Where protection against ultraviolet radiation is required, it shall be provided by the addition of carbon black or other suitable pigments or inhibitors. These additives shall be compatible with the contents and remain effective throughout the life of the outer packaging. Where use is made of carbon black, pigments or inhibitors other than those used in the manufacture of the tested design type, re-testing may be waived if changes in the carbon black content, the pigment content or the inhibitor content do not adversely affect the physical properties of the material of construction.
- 6.6.4.3.3 Additives may be incorporated in the material of the large packaging to improve the resistance to ageing or to serve other purposes, provided that these do not adversely affect the physical or chemical properties of the material.

6.6.4.4 *Specific requirements for fibreboard large packagings*

50G rigid fibreboard

- 6.6.4.4.1 Strong and good quality solid or double-faced corrugated fibreboard (single or multiwall) shall be used, appropriate to the capacity of the large packagings and to their intended use. The water resistance of the outer surface shall be such that the increase in mass, as determined in a test carried out over a period of 30 minutes by the Cobb method of determining water absorption, is not greater than 155 g/m² - see ISO 535:2014. It shall have proper bending qualities. Fibreboard shall be cut, creased without scoring, and slotted so as to permit assembly without cracking, surface breaks or undue bending. The fluting or corrugated fibreboard shall be firmly glued to the facings.

- 6.6.4.4.2 The walls, including top and bottom, shall have a minimum puncture resistance of 15 J measured according to ISO 3036:1975.
- 6.6.4.4.3 Manufacturing joins in the outer packaging of large packagings shall be made with an appropriate overlap and shall be taped, glued, stitched with metal staples or fastened by other means at least equally effective. Where joins are effected by gluing or taping, a water-resistant adhesive shall be used. Metal staples shall pass completely through all pieces to be fastened and be formed or protected so that any inner liner cannot be abraded or punctured by them.
- 6.6.4.4.4 Any integral pallet base forming part of a large packaging or any detachable pallet shall be suitable for mechanical handling with the large packaging filled to its maximum permissible gross mass.
- 6.6.4.4.5 The pallet or integral base shall be designed so as to avoid any protrusion of the base of the large packaging that might be liable to damage in handling.
- 6.6.4.4.6 The body shall be secured to any detachable pallet to ensure stability in handling and carriage. Where a detachable pallet is used, its top surface shall be free from sharp protrusions that might damage the large packaging.
- 6.6.4.4.7 Strengthening devices such as timber supports to increase stacking performance may be used but shall be external to the liner.
- 6.6.4.4.8 Where large packagings are intended for stacking, the bearing surface shall be such as to distribute the load in a safe manner.
- 6.6.4.5 *Specific requirements for wooden large packagings*
- 50C natural wood
50D plywood
50F reconstituted wood
- 6.6.4.5.1 The strength of the materials used and the method of construction shall be appropriate to the capacity and intended use of the large packagings.
- 6.6.4.5.2 Natural wood shall be well seasoned, commercially dry and free from defects that would materially lessen the strength of any part of the large packagings. Each part of the large packagings shall consist of one piece or be equivalent thereto. Parts are considered equivalent to one piece when a suitable method of glued assembly is used as for instance Lindermann joint, tongue and groove joint, ship lap or rabbet joint; or butt joint with at least two corrugated metal fasteners at each joint, or when other methods at least equally effective are used.
- 6.6.4.5.3 Large packagings of plywood shall be at least 3-ply. They shall be made of well seasoned rotary cut, sliced or sawn veneer, commercially dry and free from defects that would materially lessen the strength of the large packaging. All adjacent plies shall be glued with water-resistant adhesive. Other suitable materials may be used with plywood for the construction of the large packaging.
- 6.6.4.5.4 Large packagings of reconstituted wood shall be made of water-resistant reconstituted wood such as hardboard, particle board or other suitable type.
- 6.6.4.5.5 Large packagings shall be firmly nailed or secured to corner posts or ends or be assembled by equally suitable devices.
- 6.6.4.5.6 Any integral pallet base forming part of a large packaging or any detachable pallet shall be suitable for mechanical handling with the large packaging filled to its maximum permissible gross mass.
- 6.6.4.5.7 The pallet or integral base shall be designed so as to avoid any protrusion of the base of the large packaging that might be liable to damage in handling.
- 6.6.4.5.8 The body shall be secured to any detachable pallet to ensure stability in handling and carriage. Where a detachable pallet is used, its top surface shall be free from sharp protrusions that might damage the large packaging.
- 6.6.4.5.9 Strengthening devices such as timber supports to increase stacking performance may be used but shall be external to the liner.

- 6.6.4.5.10 Where large packagings are intended for stacking, the bearing surface shall be such as to distribute the load in a safe manner.

6.6.5 Test requirements for large packagings

6.6.5.1 Performance and frequency of test

- 6.6.5.1.1 The design type of each large packaging shall be tested as provided in 6.6.5.3 in accordance with procedures established by the competent authority allowing the allocation of the mark and shall be approved by this competent authority.

- 6.6.5.1.2 Each large packaging design type shall successfully pass the tests prescribed in this Chapter before being used. A large packaging design type is defined by the design, size, material and thickness, manner of construction and packing, but may include various surface treatments. It also includes large packagings which differ from the design type only in their lesser design height.

- 6.6.5.1.3 Tests shall be repeated on production samples at intervals established by the competent authority. For such tests on fibreboard large packagings, preparation at ambient conditions is considered equivalent to the provisions of 6.6.5.2.4.

- 6.6.5.1.4 Tests shall also be repeated after each modification which alters the design, material or manner of construction of large packagings.

- 6.6.5.1.5 The competent authority may permit the selective testing of large packagings that differ only in minor respects from a tested type, e.g. smaller sizes of inner packagings or inner packagings of lower net mass; and large packagings which are produced with small reductions in external dimension(s).

- 6.6.5.1.6 *(Reserved)*

NOTE: For the conditions for assembling different inner packagings in a large packaging and permissible variations in inner packagings, see 4.1.1.5.1.

- 6.6.5.1.7 The competent authority may at any time require proof, by tests in accordance with this section, that serially-produced large packagings meet the requirements of the design type tests.

- 6.6.5.1.8 Provided the validity of the test results is not affected and with the approval of the competent authority, several tests may be made on one sample.

6.6.5.1.9 Large salvage packagings

Large salvage packagings shall be tested and marked in accordance with the provisions applicable to packing group II large packagings intended for the carriage of solids or inner packagings, except as follows:

- (a) The test substance used in performing the tests shall be water, and the large salvage packagings shall be filled to not less than 98 % of their maximum capacity. 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. Alternatively, in performing the drop test, the drop height may be varied in accordance with 6.6.5.3.4.4.2 (b);
- (b) Large salvage packagings shall, in addition, have been successfully subjected to the leakproofness test at 30 kPa, with the results of this test reflected in the test report required by 6.6.5.4; and
- (c) Large salvage packagings shall be marked with the letter "T" as described in 6.6.2.2.

6.6.5.2 Preparation for testing

- 6.6.5.2.1 Tests shall be carried out on large packagings prepared as for carriage including the inner packagings or articles used. Inner packagings shall be filled to not less than 98 % of their maximum capacity for liquids or 95 % for solids. For large packagings where the inner packagings are designed to carry liquids and solids, separate testing is required for both liquid and solid contents. The substances in the inner packagings or the articles to be carried in the large packagings may be replaced by other material or articles except where this would invalidate the results of the tests. When other inner packagings or articles are used they shall have the same physical characteristics (mass, etc) as the inner packagings or

articles to be carried. 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.

6.6.5.2.2 In the drop tests for liquids, when another substance is used, it shall be of similar relative density and viscosity to those of the substance being carried. Water may also be used for the liquid drop test under the conditions in 6.6.5.3.4.4.

6.6.5.2.3 Large packagings made of plastics materials and large packagings containing inner packagings of plastic materials - other than bags intended to contain solids or articles - shall be drop tested when the temperature of the test sample and its contents has been reduced to -18 °C or lower. This conditioning may be disregarded if the materials in question are of sufficient ductility and tensile strength at low temperatures. Where test sample are prepared in this way, the conditioning in 6.6.5.2.4 may be waived. Test liquids shall be kept in the liquid state by the addition of anti-freeze if necessary.

6.6.5.2.4 Large packagings of fibreboard shall be conditioned for at least 24 hours in an atmosphere having a controlled temperature and relative humidity (r.h.). There are three options, one of which shall be chosen.

The preferred atmosphere is 23 °C ± 2 °C and 50 % ± 2 % r.h. The two other options are: 20 °C ± 2 °C and 65 % ± 2 % r.h.; or 27 °C ± 2 °C and 65 % ± 2 % r.h.

NOTE: Average values shall fall within these limits. Short term fluctuations and measurement limitations may cause individual measurements to vary by up to ± 5 % relative humidity without significant impairment of test reproducibility.

6.6.5.3 Test requirements

6.6.5.3.1 Bottom lift test

6.6.5.3.1.1 Applicability

For all types of large packagings which are fitted with means of lifting from the base, as a design type test.

6.6.5.3.1.2 Preparation of large packaging for test

The large packaging shall be loaded to 1.25 times its maximum permissible gross mass, the load being evenly distributed.

6.6.5.3.1.3 Method of testing

The large packaging shall be raised and lowered twice by a lift truck with the forks centrally positioned and spaced at three quarters of the dimension of the side of entry (unless the points of entry are fixed). The forks shall penetrate to three quarters of the direction of entry. The test shall be repeated from each possible direction of entry.

6.6.5.3.1.4 Criteria for passing the test

No permanent deformation which renders the large packaging unsafe for carriage and no loss of contents.

6.6.5.3.2 Top lift test

6.6.5.3.2.1 Applicability

For types of large packagings which are intended to be lifted from the top and fitted with means of lifting, as a design type test.

6.6.5.3.2.2 Preparation of large packaging for test

The large packaging shall be loaded to twice its maximum permissible gross mass. A flexible large packaging shall be loaded to six times its maximum permissible gross mass, the load being evenly distributed.

6.6.5.3.2.3 Method of testing

The large packaging shall be lifted in the manner for which it is designed until clear of the floor and maintained in that position for a period of five minutes.

6.6.5.3.2.4 *Criteria for passing the test*

- (a) All types of large packagings other than flexible large packagings: no permanent deformation which renders the large packaging, including the base pallet, if any, unsafe for carriage and no loss of contents;
- (b) Flexible large packagings: no damage to the large packaging or its lifting devices which renders the large packaging unsafe for carriage or handling and no loss of contents.

6.6.5.3.3 *Stacking test*

6.6.5.3.3.1 *Applicability*

For all types of large packagings which are designed to be stacked on each other, as a design type test.

6.6.5.3.3.2 *Preparation of large packaging for test*

The large packaging shall be filled to its maximum permissible gross mass.

6.6.5.3.3.3 *Method of testing*

The large packaging shall be placed on its base on level hard ground and subjected to a uniformly distributed superimposed test load (see 6.6.5.3.3.4) for a period of at least five minutes, large packagings of wood, fibreboard and plastics materials for a period of 24 h.

6.6.5.3.3.4 *Calculation of superimposed test load*

The load to be placed on the large packagings shall be 1.8 times the combined maximum permissible gross mass of the number of similar large packagings that may be stacked on top of the large packagings during carriage.

6.6.5.3.3.5 *Criteria for passing the test*

- (a) All types of large packagings other than flexible large packagings: no permanent deformation which renders the large packaging including the base pallet, if any, unsafe for carriage and no loss of contents;
- (b) Flexible large packagings: no deterioration of the body which renders the large packaging unsafe for carriage and no loss of contents.

6.6.5.3.4 *Drop test*

6.6.5.3.4.1 *Applicability*

For all types of large packagings as a design type test.

6.6.5.3.4.2 *Preparation of large packaging for testing*

The large packaging shall be filled in accordance with 6.6.5.2.1

6.6.5.3.4.3 *Method of testing*

The large packaging shall be dropped onto a non resilient, horizontal, flat, massive and rigid surface in conformity with the requirements of 6.1.5.3.4, in such a manner as to ensure that the point of impact is that part of the base of the large packaging considered to be the most vulnerable.

6.6.5.3.4.4 *Drop height*

NOTE: Large packagings for substances and articles of Class 1 shall be tested at the packing group II performance level.

- 6.6.5.3.4.4.1 For inner packagings containing solid or liquid substances or articles, if the test is performed with the solid, liquid or articles to be carried, or with another substance or article having essentially the same characteristics:

Packing group I	Packing group II	Packing group III
1.8 m	1.2 m	0.8 m

- 6.6.5.3.4.4.2 For inner packagings containing liquids if the test is performed with water:

- (a) Where the substances to be carried have a relative density not exceeding 1.2:

Packing group I	Packing group II	Packing group III
1.8 m	1.2 m	0.8 m

- (b) Where the substances to be carried have a relative density exceeding 1.2, the drop height shall be calculated on the basis of the relative density (d) of the substance to be carried, rounded up to the first decimal, as follows:

Packing group I	Packing group II	Packing group III
$d \times 1.5$ (m)	$d \times 1.0$ (m)	$d \times 0.67$ (m)

- 6.6.5.3.4.5 Criteria for passing the test

- 6.6.5.3.4.5.1 The large packaging shall not exhibit any damage liable to affect safety during carriage. There shall be no leakage of the filling substance from inner packaging(s) or article(s).

- 6.6.5.3.4.5.2 No rupture is permitted in large packagings for articles of Class 1 which would permit the spillage of loose explosive substances or articles from the large packaging.

- 6.6.5.3.4.5.3 Where a large packaging undergoes a drop test, the sample passes the test if the entire contents are retained even if the closure is no longer sift-proof.

6.6.5.4 *Certification and test report*

- 6.6.5.4.1 In respect of each design type of large packaging a certificate and mark (as in 6.6.3) shall be issued attesting that the design type including its equipment meets the test requirements.

- 6.6.5.4.2 A test report containing at least the following particulars shall be drawn up and shall be made available to the users of the large packaging:

1. Name and address of the test facility;
2. Name and address of applicant (where appropriate);
3. A unique test report identification;
4. Date of the test report;
5. Manufacturer of the large packaging;
6. Description of the large packaging design type (e.g. dimensions, materials, closures, thickness, etc) and/or photograph(s);
7. Maximum capacity/maximum permissible gross mass;
8. Characteristics of test contents, e.g. types and descriptions of inner packagings or articles used;
9. Test descriptions and results;
10. The test report shall be signed with the name and status of the signatory.

6.6.5.4.3

The test report shall contain statements that the large packaging prepared as for carriage was tested in accordance with the appropriate provisions of this Chapter and that the use of other packaging methods or components may render it invalid. A copy of the test report shall be available to the competent authority.

CHAPTER 6.7

REQUIREMENTS FOR THE DESIGN, CONSTRUCTION, INSPECTION AND TESTING OF PORTABLE TANKS AND UN MULTIPLE-ELEMENT GAS CONTAINERS (MEGCs)

NOTE 1: For fixed tanks (tank-vehicles), demountable tanks and tank-containers and tank swap bodies, with shells made of metallic materials, and battery-vehicles and multiple element gas containers (MEGCs) other than UN MEGCs, see Chapter 6.8; for vacuum operated waste tanks, see Chapter 6.10; for fixed tanks (tank-vehicles) and demountable tanks with shells made of fibre-reinforced plastics, see Chapter 6.13.

NOTE 2: The requirements of this Chapter also apply to portable tanks with shells made of fibre-reinforced plastics (FRP) to the extent indicated in Chapter 6.9.

6.7.1 Application and general requirements

6.7.1.1 The requirements of this Chapter apply to portable tanks intended for the carriage of dangerous goods, and to MEGCs intended for the carriage of non-refrigerated gases of Class 2, by all modes of carriage. In addition to the requirements of this Chapter, unless otherwise specified, the applicable requirements of the *International Convention for Safe Containers (CSC) 1972*, as amended, shall be fulfilled by any multimodal portable tank or MEGC which meets the definition of a "container" within the terms of that Convention. Additional requirements may apply to offshore portable tanks or MEGCs that are handled in open seas.

6.7.1.2 In recognition of scientific and technological advances, the technical requirements of this Chapter may be varied by alternative arrangements. These alternative arrangements shall offer a level of safety not less than that given by the requirements of this Chapter with respect to the compatibility with substances carried and the ability of the portable tank or MEGC to withstand impact, loading and fire conditions. For international carriage, alternative arrangement portable tanks or MEGCs shall be approved by the applicable competent authorities.

6.7.1.3 When a substance is not assigned a portable tank instruction (T1 to T23, T50 or T75) in Column (10) of Table A of in Chapter 3.2, interim approval for carriage may be issued by the competent authority of the country of origin. The approval shall be included in the documentation of the consignment and contain as a minimum the information normally provided in the portable tank instructions and the conditions under which the substance shall be carried.

6.7.2 Requirements for the design, construction, inspection and testing of portable tanks intended for the carriage of substances of Class 1 and Classes 3 to 9

6.7.2.1 Definitions

For the purposes of this section:

Alternative arrangement means an approval granted by the competent authority for a portable tank or MEGC that has been designed, constructed or tested to technical requirements or testing methods other than those specified in this Chapter:

Portable tank means a multimodal tank used for the carriage of substances of Class 1 and Classes 3 to 9. The portable tank includes a shell fitted with service equipment and structural equipment necessary for the carriage of dangerous substances. The portable tank shall be capable of being filled and discharged without the removal of its structural equipment. It shall possess stabilizing members external to the shell, and shall be capable of being lifted when full. It shall be designed primarily to be loaded onto a vehicle, wagon or sea-going or inland navigation vessel and shall be equipped with skids, mountings or accessories to facilitate mechanical handling. Tank-vehicles, tank-wagons, non-metallic tanks (except FRP portable tanks, see Chapter 6.9) and intermediate bulk containers (IBCs) are not considered to fall within the definition for portable tanks;

Shell means the part of the portable tank which retains the substance intended for carriage (tank proper), including openings and their closures, but does not include service equipment or external structural equipment;

Service equipment means measuring instruments and filling, discharge, venting, safety, heating, cooling and insulating devices;

Structural equipment means the reinforcing, fastening, protective and stabilizing members external to the shell;

Maximum allowable working pressure (MAWP) means a pressure that shall be not less than the highest of the following pressures measured at the top of the shell while in operating position:

- (a) The maximum effective gauge pressure allowed in the shell during filling or discharge; or
- (b) The maximum effective gauge pressure to which the shell is designed which shall be not less than the sum of:
 - (i) The absolute vapour pressure (in bar) of the substance at 65 °C, minus 1 bar; and
 - (ii) The partial pressure (in bar) of air or other gases in the ullage space being determined by a maximum ullage temperature of 65 °C and a liquid expansion due to an increase in mean bulk temperature of $t_r - t_f$ (t_f = filling temperature, usually 15 °C; t_r = maximum mean bulk temperature, 50 °C);

Design pressure means the pressure to be used in calculations required by a recognized pressure vessel code. The design pressure shall be not less than the highest of the following pressures:

- (a) The maximum effective gauge pressure allowed in the shell during filling or discharge; or
- (b) The sum of:
 - (i) The absolute vapour pressure (in bar) of the substance at 65 °C, minus 1 bar;
 - (ii) The partial pressure (in bar) of air or other gases in the ullage space being determined by a maximum ullage temperature of 65 °C and a liquid expansion due to an increase in mean bulk temperature of $t_r - t_f$ (t_f = filling temperature usually 15 °C; t_r = maximum mean bulk temperature, 50 °C); and
 - (iii) A head pressure determined on the basis of the static forces specified in 6.7.2.2.12, but not less than 0.35 bar; or
- (c) Two thirds of the minimum test pressure specified in the applicable portable tank instruction in 4.2.5.2.6;

Test pressure means the maximum gauge pressure at the top of the shell during the hydraulic pressure test equal to not less than 1.5 times the design pressure. The minimum test pressure for portable tanks intended for specific substances is specified in the applicable portable tank instruction in 4.2.5.2.6;

Leakproofness test means a test using gas subjecting the shell and its service equipment to an effective internal pressure of not less than 25 % of the MAWP;

Maximum permissible gross mass (MPGM) means the sum of the tare mass of the portable tank and the heaviest load authorized for carriage;

Reference steel means a steel with a tensile strength of 370 N/mm² and an elongation at fracture of 27 %;

Mild steel means a steel with a guaranteed minimum tensile strength of 360 N/mm² to 440 N/mm² and a guaranteed minimum elongation at fracture conforming to 6.7.2.3.3.3;

Design temperature range for the shell shall be -40 °C to 50 °C for substances carried under ambient conditions. For the other substances handled under elevated temperature conditions the design temperature shall be not less than the maximum temperature of the substance during filling, discharge or carriage. More severe design temperatures shall be considered for portable tanks subjected to severe climatic conditions;

Fine grain steel means steel which has a ferritic grain size of 6 or finer when determined in accordance with ASTM E 112-96 or as defined in EN 10028-3, Part 3;

Fusible element means a non-reclosable pressure relief device that is thermally actuated;

Offshore portable tank means a portable tank specially designed for repeated use for carriage to, from and between offshore facilities. An offshore portable tank is designed and constructed in accordance with the guidelines for the approval of containers handled in open seas specified by the International Maritime Organization in document MSC/Circ.860.

6.7.2.2 General design and construction requirements

6.7.2.2.1 Shells shall be designed and constructed in accordance with the requirements of a pressure vessel code recognized by the competent authority. Shells shall be made of metallic materials suitable for forming. The materials shall in principle conform to national or international material standards. For welded shells only a material whose weldability has been fully demonstrated shall be used. Welds shall be skilfully made and afford complete safety. When the manufacturing process or the materials make it necessary, the shells shall be suitably heat-treated to guarantee adequate toughness in the weld and in the heat affected zones. In choosing the material, the design temperature range shall be taken into account with respect to risk of brittle fracture, to stress corrosion cracking and to resistance to impact. When fine grain steel is used, the guaranteed value of the yield strength shall be not more than 460 N/mm² and the guaranteed value of the upper limit of the tensile strength shall be not more than 725 N/mm² according to the material specification. Aluminium may only be used as a construction material when indicated in a portable tank special provision assigned to a specific substance in Column (11) of Table A of Chapter 3.2 or when approved by the competent authority. When aluminium is authorized, it shall be insulated to prevent significant loss of physical properties when subjected to a heat load of 110 kW/m² for a period of not less than 30 minutes. The insulation shall remain effective at all temperatures less than 649 °C and shall be jacketed with a material with a melting point of not less than 700 °C. Portable tank materials shall be suitable for the external environment in which they may be carried.

6.7.2.2.2 Portable tank shells, fittings, and pipework shall be constructed from materials which are:

- (a) Substantially immune to attack by the substance(s) intended to be carried; or
- (b) Properly passivated or neutralized by chemical reaction; or
- (c) Lined with corrosion-resistant material directly bonded to the shell or attached by equivalent means.

6.7.2.2.3 Gaskets shall be made of materials not subject to attack by the substance(s) intended to be carried.

6.7.2.2.4 When shells are lined, the lining shall be substantially immune to attack by the substance(s) intended to be carried, homogeneous, non porous, free from perforations, sufficiently elastic and compatible with the thermal expansion characteristics of the shell. The lining of every shell, shell fittings and piping shall be continuous, and shall extend around the face of any flange. Where external fittings are welded to the tank, the lining shall be continuous through the fitting and around the face of external flanges.

6.7.2.2.5 Joints and seams in the lining shall be made by fusing the material together or by other equally effective means.

6.7.2.2.6 Contact between dissimilar metals which could result in damage by galvanic action shall be avoided.

6.7.2.2.7 The materials of the portable tank, including any devices, gaskets, linings and accessories, shall not adversely affect the substance(s) intended to be carried in the portable tank.

6.7.2.2.8 Portable tanks shall be designed and constructed with supports to provide a secure base during carriage and with suitable lifting and tie-down attachments.

6.7.2.2.9 Portable tanks shall be designed to withstand, without loss of contents, at least the internal pressure due to the contents, and the static, dynamic and thermal loads during normal conditions of handling and carriage. The design shall demonstrate that the effects of fatigue, caused by repeated application of these loads through the expected life of the portable tank, have been taken into account.

6.7.2.2.9.1 For portable tanks that are intended for use offshore, the dynamic stresses imposed by handling in open seas shall be taken into account.

6.7.2.2.10 A shell which is to be equipped with a vacuum-relief device shall be designed to withstand, without permanent deformation, an external pressure of not less than 0.21 bar above the internal pressure. The vacuum-relief device shall be set to relieve at a vacuum setting not greater than minus (-) 0.21 bar unless

the shell is designed for a higher external over pressure, in which case the vacuum-relief pressure of the device to be fitted shall be not greater than the tank design vacuum pressure. A shell used for the carriage of solid substances (powdery or granular) of packing groups II or III only, which do not liquefy during carriage, may be designed for a lower external pressure, subject to the approval of the competent authority. In this case, the vacuum valve shall be set to relieve at this lower pressure. A shell that is not to be fitted with a vacuum-relief device shall be designed to withstand, without permanent deformation an external pressure of not less than 0.4 bar above the internal pressure.

6.7.2.2.11 Vacuum-relief devices used on portable tanks intended for the carriage of substances meeting the flash-point criteria of Class 3, including elevated temperature substances carried at or above their flash-point, shall prevent the immediate passage of flame into the shell, or the portable tank shall have a shell capable of withstanding, without leakage an internal explosion resulting from the passage of flame into the shell.

6.7.2.2.12 Portable tanks and their fastenings shall, under the maximum permissible load, be capable of absorbing the following separately applied static forces:

- (a) In the direction of travel: twice the MPGM multiplied by the acceleration due to gravity (g)¹;
- (b) Horizontally at right angles to the direction of travel: the MPGM (when the direction of travel is not clearly determined, the forces shall be equal to twice the MPGM) multiplied by the acceleration due to gravity (g)¹;
- (c) Vertically upwards: the MPGM multiplied by the acceleration due to gravity (g)¹; and
- (d) Vertically downwards: twice the MPGM (total loading including the effect of gravity) multiplied by the acceleration due to gravity (g)¹.

6.7.2.2.13 Under each of the forces in 6.7.2.2.12, the safety factor to be observed shall be as follows:

- (a) For metals having a clearly defined yield point, a safety factor of 1.5 in relation to the guaranteed yield strength; or
- (b) For metals with no clearly defined yield point, a safety factor of 1.5 in relation to the guaranteed 0.2 % proof strength and, for austenitic steels, the 1 % proof strength.

6.7.2.2.14 The values of yield strength or proof strength shall be the values according to national or international material standards. When austenitic steels are used, the specified minimum values of yield strength or proof strength according to the material standards may be increased by up to 15 % when these greater values are attested in the material inspection certificate. When no material standard exists for the metal in question, the value of yield strength or proof strength used shall be approved by the competent authority.

6.7.2.2.15 Portable tanks shall be capable of being electrically earthed when intended for the carriage of substances meeting the flash-point criteria of Class 3 including elevated temperature substances carried at or above their flash-point. Measures shall be taken to prevent dangerous electrostatic discharge.

6.7.2.2.16 When required for certain substances by the applicable portable tank instruction indicated in Column (10) of Table A of Chapter 3.2 and described in 4.2.5.2.6 or by a portable tank special provision indicated in Column (11) of Table A of Chapter 3.2 and described in 4.2.5.3, portable tanks shall be provided with additional protection, which may take the form of additional shell thickness or a higher test pressure, the additional shell thickness or higher test pressure being determined in the light of the inherent risks associated with the carriage of the substances concerned.

6.7.2.2.17 Thermal insulation directly in contact with the shell intended for substances carried at elevated temperature shall have an ignition temperature at least 50 °C higher than the maximum design temperature of the tank.

6.7.2.3 *Design criteria*

6.7.2.3.1 Shells shall be of a design capable of being stress-analysed mathematically or experimentally by resistance strain gauges, or by other methods approved by the competent authority.

¹ For calculation purposes $g = 9.81 \text{ m/s}^2$.

- 6.7.2.3.2 Shells shall be designed and constructed to withstand a hydraulic test pressure not less than 1.5 times the design pressure. Specific requirements are laid down for certain substances in the applicable portable tank instruction indicated in Column (10) of Table A of Chapter 3.2 and described in 4.2.5.2.6 or by a portable tank special provision indicated in Column (11) of Table A of Chapter 3.2 and described in 4.2.5.3. Attention is drawn to the minimum shell thickness requirements specified in 6.7.2.4.1 to 6.7.2.4.10.
- 6.7.2.3.3 For metals exhibiting a clearly defined yield point or characterized by a guaranteed proof strength (0.2 % proof strength, generally, or 1 % proof strength for austenitic steels) the primary membrane stress σ (sigma) in the shell shall not exceed 0.75 Re or 0.50 Rm, whichever is lower, at the test pressure, where:
- Re = yield strength in N/mm², or 0.2 % proof strength or, for austenitic steels, 1 % proof strength;
- Rm = minimum tensile strength in N/mm².
- 6.7.2.3.3.1 The values of Re and Rm to be used shall be the specified minimum values according to national or international material standards. When austenitic steels are used, the specified minimum values for Re and Rm according to the material standards may be increased by up to 15 % when greater values are attested in the material inspection certificate. When no material standard exists for the metal in question, the values of Re and Rm used shall be approved by the competent authority or its authorized body.
- 6.7.2.3.3.2 Steels which have a Re/Rm ratio of more than 0.85 are not allowed for the construction of welded shells. The values of Re and Rm to be used in determining this ratio shall be the values specified in the material inspection certificate.
- 6.7.2.3.3.3 Steels used in the construction of shells shall have an elongation at fracture, in %, of not less than 10 000/Rm with an absolute minimum of 16 % for fine grain steels and 20 % for other steels. Aluminium and aluminium alloys used in the construction of shells shall have an elongation at fracture, in %, of not less than 10 000/6Rm with an absolute minimum of 12 %.
- 6.7.2.3.3.4 For the purpose of determining actual values for materials, it shall be noted that for sheet metal, the axis of the tensile test specimen shall be at right angles (transversely) to the direction of rolling. The permanent elongation at fracture shall be measured on test specimens of rectangular cross sections in accordance with ISO 6892:1998 using a 50 mm gauge length.
- 6.7.2.4 Minimum shell thickness**
- 6.7.2.4.1 The minimum shell thickness shall be the greater thickness based on:
- (a) The minimum thickness determined in accordance with the requirements of 6.7.2.4.2 to 6.7.2.4.10;
- (b) The minimum thickness determined in accordance with the recognized pressure vessel code including the requirements in 6.7.2.3; and
- (c) The minimum thickness specified in the applicable portable tank instruction indicated in Column (10) of Table A of Chapter 3.2 and described in 4.2.5.2.6 or by a portable tank special provision indicated in Column (11) of Table A of Chapter 3.2 and described in 4.2.5.3.
- 6.7.2.4.2 The cylindrical portions, ends (heads) and manhole covers of shells not more than 1.80 m in diameter shall be not less than 5 mm thick in the reference steel or of equivalent thickness in the metal to be used. Shells more than 1.80 m in diameter shall be not less than 6 mm thick in the reference steel or of equivalent thickness in the metal to be used, except that for powdered or granular solid substances of packing group II or III the minimum thickness requirement may be reduced to not less than 5 mm thick in the reference steel or of equivalent thickness in the metal to be used.
- 6.7.2.4.3 When additional protection against shell damage is provided, portable tanks with test pressures less than 2.65 bar may have the minimum shell thickness reduced, in proportion to the protection provided, as approved by the competent authority. However, shells not more than 1.80 m in diameter shall be not less than 3 mm thick in the reference steel or of equivalent thickness in the metal to be used. Shells more than 1.80 m in diameter shall be not less than 4 mm thick in the reference steel or of equivalent thickness in the metal to be used.

6.7.2.4.4 The cylindrical portions, ends (heads) and manhole covers of all shells shall be not less than 3 mm thick regardless of the material of construction.

6.7.2.4.5 The additional protection referred to in 6.7.2.4.3 may be provided by overall external structural protection, such as suitable "sandwich" construction with the outer sheathing (jacket) secured to the shell, double wall construction or by enclosing the shell in a complete framework with longitudinal and transverse structural members.

6.7.2.4.6 The equivalent thickness of a metal other than the thickness prescribed for the reference steel in 6.7.2.4.2 shall be determined using the following formula:

$$e_1 = \frac{21.4e_0}{\sqrt[3]{Rm_1 \times A_1}}$$

where:

e_1 = required equivalent thickness (in mm) of the metal to be used;

e_0 = minimum thickness (in mm) of the reference steel specified in the applicable portable tank instruction indicated in Column (10) of Table A of Chapter 3.2 and described in 4.2.5.2.6 or by a portable tank special provision indicated in Column (11) of Table A of Chapter 3.2 and described in 4.2.5.3;

Rm_1 = guaranteed minimum tensile strength (in N/mm²) of the metal to be used (see 6.7.2.3.3);

A_1 = guaranteed minimum elongation at fracture (in %) of the metal to be used according to national or international standards.

6.7.2.4.7 When in the applicable portable tank instruction in 4.2.5.2.6, a minimum thickness of 8 mm or 10 mm is specified, it shall be noted that these thicknesses are based on the properties of the reference steel and a shell diameter of 1.80 m. When a metal other than mild steel (see 6.7.2.1) is used or the shell has a diameter of more than 1.80 m, the thickness shall be determined using the following formula:

$$e_1 = \frac{21.4e_0 d_1}{1,8 \sqrt[3]{Rm_1 \times A_1}}$$

where:

e_1 = required equivalent thickness (in mm) of the metal to be used;

e_0 = minimum thickness (in mm) of the reference steel specified in the applicable portable tank instruction indicated in Column (10) of Table A of Chapter 3.2 and described in 4.2.5.2.6 or by a portable tank special provision indicated in Column (11) of Table A of Chapter 3.2 and described in 4.2.5.3;

d_1 = diameter of the shell (in m), but not less than 1.80 m;

Rm_1 = guaranteed minimum tensile strength (in N/mm²) of the metal to be used (see 6.7.2.3.3);

A_1 = guaranteed minimum elongation at fracture (in %) of the metal to be used according to national or international standards.

6.7.2.4.8 In no case shall the wall thickness be less than that prescribed in 6.7.2.4.2, 6.7.2.4.3 and 6.7.2.4.4. All parts of the shell shall have a minimum thickness as determined by 6.7.2.4.2 to 6.7.2.4.4. This thickness shall be exclusive of any corrosion allowance.

6.7.2.4.9 When mild steel is used (see 6.7.2.1), calculation using the formula in 6.7.2.4.6 is not required.

6.7.2.4.10 There shall be no sudden change of plate thickness at the attachment of the ends (heads) to the cylindrical portion of the shell.

6.7.2.5 Service equipment

- 6.7.2.5.1 Service equipment shall be so arranged as to be protected against the risk of being wrenched off or damaged during handling and carriage. When the connection between the frame and the shell allows relative movement between the sub-assemblies, the equipment shall be so fastened as to permit such movement without risk of damage to working parts. The external discharge fittings (pipe sockets, shut-off devices), the internal stop-valve and its seating shall be protected against the danger of being wrenched off by external forces (for example using shear sections). The filling and discharge devices (including flanges or threaded plugs) and any protective caps shall be capable of being secured against unintended opening.
- 6.7.2.5.2 All openings in the shell, intended for filling or discharging the portable tank shall be fitted with a manually operated stop-valve located as close to the shell as reasonably practicable. Other openings, except for openings leading to venting or pressure-relief devices, shall be equipped with either a stop-valve or another suitable means of closure located as close to the shell as reasonably practicable.
- 6.7.2.5.3 All portable tanks shall be fitted with a manhole or other inspection openings of a suitable size to allow for internal inspection and adequate access for maintenance and repair of the interior. Compartmented portable tanks shall have a manhole or other inspection openings for each compartment.
- 6.7.2.5.4 As far as reasonably practicable, external fittings shall be grouped together. For insulated portable tanks, top fittings shall be surrounded by a spill collection reservoir with suitable drains.
- 6.7.2.5.5 Each connection to a portable tank shall be clearly marked to indicate its function.
- 6.7.2.5.6 Each stop-valve or other means of closure shall be designed and constructed to a rated pressure not less than the MAWP of the shell taking into account the temperatures expected during carriage. All stop-valves with screwed spindles shall close by a clockwise motion of the handwheel. For other stop-valves the position (open and closed) and direction of closure shall be clearly indicated. All stop-valves shall be designed to prevent unintentional opening.
- 6.7.2.5.7 No moving parts, such as covers, components of closures, etc., shall be made of unprotected corrodible steel when they are liable to come into frictional or percussive contact with aluminium portable tanks intended for the carriage of substances meeting the flash-point criteria of Class 3 including elevated temperature substances carried at or above their flash-point.
- 6.7.2.5.8 Piping shall be designed, constructed and installed so as to avoid the risk of damage due to thermal expansion and contraction, mechanical shock and vibration. All piping shall be of a suitable metallic material. Welded pipe joints shall be used wherever possible.
- 6.7.2.5.9 Joints in copper tubing shall be brazed or have an equally strong metal union. The melting point of brazing materials shall be no lower than 525 °C. The joints shall not decrease the strength of the tubing as may happen when cutting threads.
- 6.7.2.5.10 The burst pressure of all piping and pipe fittings shall be not less than the highest of four times the MAWP of the shell or four times the pressure to which it may be subjected in service by the action of a pump or other device (except pressure-relief devices).
- 6.7.2.5.11 Ductile metals shall be used in the construction of valves and accessories.
- 6.7.2.5.12 The heating system shall be designed or controlled so that a substance cannot reach a temperature at which the pressure in the tank exceeds its MAWP or causes other hazards (e.g. dangerous thermal decomposition).
- 6.7.2.5.13 The heating system shall be designed or controlled so that power for internal heating elements shall not be available unless the heating elements are completely submerged. The temperature at the surface of the heating elements for internal heating equipment, or the temperature at the shell for external heating equipment shall, in no case, exceed 80 % of the autoignition temperature (in °C) of the substance carried.
- 6.7.2.5.14 If an electrical heating system is installed inside the tank, it shall be equipped with an earth leakage circuit breaker with a releasing current of less than 100 mA.
- 6.7.2.5.15 Electrical switch cabinets mounted to tanks shall not have a direct connection to the tank interior and shall provide protection of at least the equivalent of type IP56 according to IEC 144 or IEC 529.

6.7.2.6 Bottom openings

6.7.2.6.1 Certain substances shall not be carried in portable tanks with bottom openings. When the applicable portable tank instruction identified in Column (10) of Table A of Chapter 3.2 and described in 4.2.5.2.6 indicates that bottom openings are prohibited there shall be no openings below the liquid level of the shell when it is filled to its maximum permissible filling limit. When an existing opening is closed it shall be accomplished by internally and externally welding one plate to the shell.

6.7.2.6.2 Bottom discharge outlets for portable tanks carrying certain solid, crystallizable or highly viscous substances shall be equipped with not less than two serially fitted and mutually independent shut-off devices. The design of the equipment shall be to the satisfaction of the competent authority or its authorized body and shall include:

- (a) An external stop-valve, fitted as close to the shell as reasonably practicable, and so designed as to prevent any unintended opening through impact or other inadvertent act; and
- (b) A liquid tight closure at the end of the discharge pipe, which may be a bolted blank flange or a screw cap.

6.7.2.6.3 Every bottom discharge outlet, except as provided in 6.7.2.6.2, shall be equipped with three serially fitted and mutually independent shut-off devices. The design of the equipment shall be to the satisfaction of the competent authority or its authorized body and include:

- (a) A self-closing internal stop-valve, that is a stop-valve within the shell or within a welded flange or its companion flange, such that:
 - (i) The control devices for the operation of the valve are designed so as to prevent any unintended opening through impact or other inadvertent act;
 - (ii) The valve may be operable from above or below;
 - (iii) If possible, the setting of the valve (open or closed) shall be capable of being verified from the ground;
 - (iv) Except for portable tanks having a capacity of not more than 1 000 litres, it shall be possible to close the valve from an accessible position of the portable tank that is remote from the valve itself; and
 - (v) The valve shall continue to be effective in the event of damage to the external device for controlling the operation of the valve;
- (b) An external stop-valve fitted as close to the shell as reasonably practicable; and
- (c) A liquid tight closure at the end of the discharge pipe, which may be a bolted blank flange or a screw cap.

6.7.2.6.4 For a lined shell, the internal stop-valve required by 6.7.2.6.3 (a) may be replaced by an additional external stop-valve. The manufacturer shall satisfy the requirements of the competent authority or its authorized body.

6.7.2.7 Safety-relief devices

6.7.2.7.1 All portable tanks shall be fitted with at least one pressure-relief device. All relief devices shall be designed, constructed and marked to the satisfaction of the competent authority or its authorized body.

6.7.2.8 *Pressure-relief devices*

- 6.7.2.8.1 Every portable tank with a capacity not less than 1 900 litres and every independent compartment of a portable tank with a similar capacity, shall be provided with one or more pressure-relief devices of the spring-loaded type and may in addition have a frangible disc or fusible element in parallel with the spring-loaded devices except when prohibited by reference to 6.7.2.8.3 in the applicable portable tank instruction in 4.2.5.2.6. The pressure-relief devices shall have sufficient capacity to prevent rupture of the shell due to over pressurization or vacuum resulting from filling, discharging, or from heating of the contents.
- 6.7.2.8.2 Pressure-relief devices shall be designed to prevent the entry of foreign matter, the leakage of liquid and the development of any dangerous excess pressure.
- 6.7.2.8.3 When required for certain substances by the applicable portable tank instruction indicated in Column (10) of Table A of Chapter 3.2 and described in 4.2.5.2.6, portable tanks shall have a pressure-relief device approved by the competent authority. Unless a portable tank in dedicated service is fitted with an approved relief device constructed of materials compatible with the substance carried, the relief device shall comprise a frangible disc preceding a spring-loaded pressure-relief device. When a frangible disc is inserted in series with the required pressure-relief device, the space between the frangible disc and the pressure-relief device shall be provided with a pressure gauge or suitable tell-tale indicator for the detection of disc rupture, pinholing, or leakage which could cause a malfunction of the pressure-relief system. The frangible disc shall rupture at a nominal pressure 10 % above the start to discharge pressure of the relief device.
- 6.7.2.8.4 Every portable tank with a capacity less than 1 900 litres shall be fitted with a pressure-relief device which may be a frangible disc when this disc complies with the requirements of 6.7.2.11.1. When no spring-loaded pressure-relief device is used, the frangible disc shall be set to rupture at a nominal pressure equal to the test pressure. In addition, fusible elements conforming to 6.7.2.10.1 may also be used.
- 6.7.2.8.5 When the shell is fitted for pressure discharge, the inlet line shall be provided with a suitable pressure-relief device set to operate at a pressure not higher than the MAWP of the shell, and a stop-valve shall be fitted as close to the shell as reasonably practicable.

6.7.2.9 *Setting of pressure-relief devices*

- 6.7.2.9.1 It shall be noted that the pressure-relief devices shall operate only in conditions of excessive rise in temperature, since the shell shall not be subject to undue fluctuations of pressure during normal conditions of carriage (see 6.7.2.12.2).
- 6.7.2.9.2 The required pressure-relief device shall be set to start-to-discharge at a nominal pressure of five-sixths of the test pressure for shells having a test pressure of not more than 4.5 bar and 110 % of two-thirds of the test pressure for shells having a test pressure of more than 4.5 bar. After discharge the device shall close at a pressure not more than 10 % below the pressure at which the discharge starts. The device shall remain closed at all lower pressures. This requirement does not prevent the use of vacuum-relief or combination pressure-relief and vacuum-relief devices.

6.7.2.10 *Fusible elements*

- 6.7.2.10.1 Fusible elements shall operate at a temperature between 100 °C and 149 °C on condition that the pressure in the shell at the fusing temperature will be not more than the test pressure. They shall be placed at the top of the shell with their inlets in the vapour space and when used for transport safety purposes, they shall not be shielded from external heat. Fusible elements shall not be used on portable tanks with a test pressure which exceeds 2.65 bar unless specified by special provision TP36 in Column (11) of Table A of Chapter 3.2. Fusible elements used on portable tanks intended for the carriage of elevated temperature substances shall be designed to operate at a temperature higher than the maximum temperature that will be experienced during carriage and shall be to the satisfaction of the competent authority or its authorized body.

6.7.2.11 *Frangible discs*

- 6.7.2.11.1 Except as specified in 6.7.2.8.3, frangible discs shall be set to rupture at a nominal pressure equal to the test pressure throughout the design temperature range. Particular attention shall be given to the requirements of 6.7.2.5.1 and 6.7.2.8.3 if frangible discs are used.

6.7.2.11.2 Frangible discs shall be appropriate for the vacuum pressures which may be produced in the portable tank.

6.7.2.12 Capacity of pressure-relief devices

6.7.2.12.1 The spring-loaded pressure-relief device required by 6.7.2.8.1 shall have a minimum cross sectional flow area equivalent to an orifice of 31.75 mm diameter. Vacuum-relief devices, when used, shall have a cross sectional flow area not less than 284 mm².

6.7.2.12.2 The combined delivery capacity of the pressure relief system (taking into account the reduction of the flow when the portable tank is fitted with frangible-discs preceding spring-loaded pressure-relief devices or when the spring-loaded pressure-relief devices are provided with a device to prevent the passage of the flame), in condition of complete fire engulfment of the portable tank shall be sufficient to limit the pressure in the shell to 20 % above the start-to-discharge pressure of the pressure limiting device. Emergency pressure-relief devices may be used to achieve the full relief capacity prescribed. These devices may be fusible, spring loaded or frangible disc components, or a combination of spring-loaded and frangible disc devices. The total required capacity of the relief devices may be determined using the formula in 6.7.2.12.2.1 or the table in 6.7.2.12.2.3.

6.7.2.12.2.1 To determine the total required capacity of the relief devices, which shall be regarded as being the sum of the individual capacities of all the contributing devices, the following formula shall be used:

$$Q = 12.4 \frac{FA^{0.82}}{LC} \sqrt{\frac{ZT}{M}}$$

where:

Q = minimum required rate of discharge in cubic metres of air per second (m³/s) at standard conditions: 1 bar and 0 °C (273 K);

F = is a coefficient with the following value:

for uninsulated shells: F = 1;

for insulated shells: F = U(649 - t)/13.6 but in no case is less than 0.25

where:

U = heat transfer coefficient of the insulation, in kW·m⁻²·K⁻¹, at 38 °C;

t = actual temperature of the substance during filling (in °C); when this temperature is unknown, let t = 15 °C;

The value of F given above for insulated shells may be taken provided that the insulation is in accordance with 6.7.2.12.2.4;

A = total external surface area of shell in m²;

Z = the gas compressibility factor in the accumulating condition (when this factor is unknown, let Z = 1.0);

T = absolute temperature in Kelvin (°C + 273) above the pressure-relief devices in the accumulating condition;

L = the latent heat of vaporization of the liquid, in kJ/kg, in the accumulating condition;

M = molecular mass of the discharged gas;

C = a constant which is derived from one of the following formulae as a function of the ratio k of specific heats:

$$k = \frac{c_p}{c_v}$$

where:

c_p is the specific heat at constant pressure; and

c_v is the specific heat at constant volume.

When $k > 1$:

$$C = \sqrt{k \left(\frac{2}{k+1} \right)^{\frac{k+1}{k-1}}}$$

When $k = 1$ or k is unknown:

$$C = \frac{1}{\sqrt{e}} = 0.607$$

where e is the mathematical constant 2.7183

C may also be taken from the following table:

k	C	k	C	k	C
1.00	0.607	1.26	0.660	1.52	0.704
1.02	0.611	1.28	0.664	1.54	0.707
1.04	0.615	1.30	0.667	1.56	0.710
1.06	0.620	1.32	0.671	1.58	0.713
1.08	0.624	1.34	0.674	1.60	0.716
1.10	0.628	1.36	0.678	1.62	0.719
1.12	0.633	1.38	0.681	1.64	0.722
1.14	0.637	1.40	0.685	1.66	0.725
1.16	0.641	1.42	0.688	1.68	0.728
1.18	0.645	1.44	0.691	1.70	0.731
1.20	0.649	1.46	0.695	2.00	0.770
1.22	0.652	1.48	0.698	2.20	0.793
1.24	0.656	1.50	0.701		

6.7.2.12.2.2

As an alternative to the formula above, shells designed for the carriage of liquids may have their relief devices sized in accordance with the table in 6.7.2.12.2.3. This table assumes an insulation value of $F = 1$ and shall be adjusted accordingly when the shell is insulated. Other values used in determining this table are:

M	=	86.7	T	=	394 K
L	=	334.94 kJ/kg	C	=	0.607
Z	=	1			

6.7.2.12.2.3

Minimum required rate of discharge, Q , in cubic metres per air per second at 1 bar and 0 °C (273 K)

A Exposed area (square metres)	Q (cubic metres of air per second)	A Exposed area (square metres)	Q (cubic metres of air per second)
2	0.230	37.5	2.539
3	0.320	40	2.677
4	0.405	42.5	2.814
5	0.487	45	2.949
6	0.565	47.5	3.082
7	0.641	50	3.215
8	0.715	52.5	3.346
9	0.788	55	3.476

A Exposed area (square metres)	Q (cubic metres of air per second)	A Exposed area (square metres)	Q (cubic metres of air per second)
10	0.859	57.5	3.605
12	0.998	60	3.733
14	1.132	62.5	3.860
16	1.263	65	3.987
18	1.391	67.5	4.112
20	1.517	70	4.236
22.5	1.670	75	4.483
25	1.821	80	4.726
27.5	1.969	85	4.967
30	2.115	90	5.206
32.5	2.258	95	5.442
35	2.400	100	5.676

6.7.2.12.2.4 Insulation systems, used for the purpose of reducing venting capacity, shall be approved by the competent authority or its authorized body. In all cases, insulation systems approved for this purpose shall:

- (a) Remain effective at all temperatures up to 649 °C; and
- (b) Be jacketed with a material having a melting point of 700 °C or greater.

6.7.2.13 *Marking of pressure-relief devices*

6.7.2.13.1 Every pressure-relief device shall be clearly and permanently marked with the following particulars:

- (a) The pressure (in bar or kPa) or temperature (in °C) at which it is set to discharge;
- (b) The allowable tolerance at the discharge pressure for spring-loaded devices;
- (c) The reference temperature corresponding to the rated pressure for frangible discs;
- (d) The allowable temperature tolerance for fusible elements; and
- (e) The rated flow capacity of the spring-loaded pressure relief devices, frangible discs or fusible elements in standard cubic metres of air per second (m³/s);
- (f) The cross sectional flow areas of the spring loaded pressure-relief devices, frangible discs and fusible elements in mm².

When practicable, the following information shall also be shown:

- (g) The manufacturer's name and relevant catalogue number of the device.

6.7.2.13.2 The rated flow capacity marked on the spring-loaded pressure-relief devices shall be determined according to ISO 4126-1:2004 and ISO 4126-7:2004.

6.7.2.14 *Connections to pressure-relief devices*

6.7.2.14.1 Connections to pressure-relief devices shall be of sufficient size to enable the required discharge to pass unrestricted to the safety device. No stop-valve shall be installed between the shell and the pressure-relief devices except where duplicate devices are provided for maintenance or other reasons and the stop-valves serving the devices actually in use are locked open or the stop-valves are interlocked so that at least one of the duplicate devices is always in use. There shall be no obstruction in an opening leading to a vent or pressure-relief device which might restrict or cut-off the flow from the shell to that device. Vents or pipes from the pressure-relief device outlets, when used, shall deliver the relieved vapour or liquid to the atmosphere in conditions of minimum back-pressure on the relieving devices.

6.7.2.15 *Siting of pressure-relief devices*

6.7.2.15.1 Each pressure-relief device inlet shall be situated on top of the shell in a position as near the longitudinal and transverse centre of the shell as reasonably practicable. All pressure-relief device inlets shall under maximum filling conditions be situated in the vapour space of the shell and the devices shall be so arranged as to ensure the escaping vapour is discharged unrestrictedly. For flammable substances, the escaping vapour shall be directed away from the shell in such a manner that it cannot impinge upon the shell. Protective devices which deflect the flow of vapour are permissible provided the required relief-device capacity is not reduced.

6.7.2.15.2 Arrangements shall be made to prevent access to the pressure-relief devices by unauthorized persons and to protect the devices from damage caused by the portable tank overturning.

6.7.2.16 *Gauging devices*

6.7.2.16.1 Glass level-gauges and gauges made of other fragile material, which are in direct communication with the contents of the tank shall not be used.

6.7.2.17 *Portable tank supports, frameworks, lifting and tie-down attachments*

6.7.2.17.1 Portable tanks shall be designed and constructed with a support structure to provide a secure base during carriage. The forces specified in 6.7.2.2.12 and the safety factor specified in 6.7.2.2.13 shall be considered in this aspect of the design. Skids, frameworks, cradles or other similar structures are acceptable.

6.7.2.17.2 The combined stresses caused by portable tank mountings (e.g. cradles, framework, etc.) and portable tank lifting and tie-down attachments shall not cause excessive stress in any portion of the shell. Permanent lifting and tie-down attachments shall be fitted to all portable tanks. Preferably they shall be fitted to the portable tank supports but may be secured to reinforcing plates located on the shell at the points of support.

6.7.2.17.3 In the design of supports and frameworks the effects of environmental corrosion shall be taken into account.

6.7.2.17.4 Forklift pockets shall be capable of being closed off. The means of closing forklift pockets shall be a permanent part of the framework or permanently attached to the framework. Single compartment portable tanks with a length less than 3.65 m need not have closed off forklift pockets provided that:

- (a) The shell including all the fittings are well protected from being hit by the forklift blades; and
- (b) The distance between the centres of the forklift pockets is at least half of the maximum length of the portable tank.

6.7.2.17.5 When portable tanks are not protected during carriage, according to 4.2.1.2, the shells and service equipment shall be protected against damage to the shell and service equipment resulting from lateral or longitudinal impact or overturning. External fittings shall be protected so as to preclude the release of the shell contents upon impact or overturning of the portable tank on its fittings. Examples of protection include:

- (a) Protection against lateral impact which may consist of longitudinal bars protecting the shell on both sides at the level of the median line;
- (b) Protection of the portable tank against overturning which may consist of reinforcement rings or bars fixed across the frame;
- (c) Protection against rear impact which may consist of a bumper or frame;
- (d) Protection of the shell against damage from impact or overturning by use of an ISO frame in accordance with ISO 1496-3:1995.

6.7.2.18 *Design approval*

6.7.2.18.1 The competent authority or its authorized body shall issue a design approval certificate for any new design of a portable tank. This certificate shall attest that a portable tank has been surveyed by that authority, is suitable for its intended purpose and meets the requirements of this Chapter and where

appropriate, the provisions for substances provided in Chapter 4.2 and in Table A of Chapter 3.2. When a series of portable tanks are manufactured without change in the design, the certificate shall be valid for the entire series. The certificate shall refer to the prototype test report, the substances or group of substances allowed to be carried, the materials of construction of the shell and lining (when applicable) and an approval number. The approval number shall consist of the distinguishing sign or mark of the State in whose territory the approval was granted, indicated by the distinguishing sign used on vehicles in international road traffic², and a registration number. Any alternative arrangements according to 6.7.1.2 shall be indicated on the certificate. A design approval may serve for the approval of smaller portable tanks made of materials of the same kind and thickness, by the same fabrication techniques and with identical supports, equivalent closures and other appurtenances.

6.7.2.18.2 The prototype test report for the design approval shall include at least the following:

- (a) The results of the applicable framework test specified in ISO 1496-3:1995;
- (b) The results of the initial inspection and test according to 6.7.2.19.3; and
- (c) The results of the impact test in 6.7.2.19.1, when applicable.

6.7.2.19 Inspection and testing

6.7.2.19.1 Portable tanks meeting the definition of container in the *International Convention for Safe Containers (CSC)*, 1972, as amended, shall not be used unless they are successfully qualified by subjecting a representative prototype of each design to the Dynamic, Longitudinal Impact Test prescribed in the *Manual of Tests and Criteria*, Part IV, Section 41.

6.7.2.19.2 The shell and items of equipment of each portable tank shall be inspected and tested before being put into service for the first time (initial inspection and test) and thereafter at not more than five-year intervals (5 year periodic inspection and test) with an intermediate periodic inspection and test (2.5 year periodic inspection and test) midway between the 5 year periodic inspections and tests. The 2.5 year inspection and test may be performed within 3 months of the specified date. An exceptional inspection and test shall be performed regardless of the date of the last periodic inspection and test when necessary according to 6.7.2.19.7.

6.7.2.19.3 The initial inspection and test of a portable tank shall include a check of the design characteristics, an internal and external examination of the portable tank and its fittings with due regard to the substances to be carried, and a pressure test. Before the portable tank is placed into service, a leakproofness test and a check of the satisfactory operation of all service equipment shall also be performed. When the shell and its fittings have been pressure-tested separately, they shall be subjected together after assembly to a leakproofness test.

6.7.2.19.4 The 5-year periodic inspection and test shall include an internal and external examination and, as a general rule, a hydraulic pressure test. For tanks only used for the carriage of solid substances, other than toxic or corrosive substances that do not liquefy during carriage, the hydraulic pressure test may be replaced by a suitable pressure test at 1.5 times the MAWP, subject to competent authority approval. Sheathing, thermal insulation and the like shall be removed only to the extent required for reliable appraisal of the condition of the portable tank. When the shell and equipment have been pressure-tested separately, they shall be subjected together after assembly to a leakproofness test.

6.7.2.19.5 The intermediate 2.5 year periodic inspection and test shall at least include an internal and external examination of the portable tank and its fittings with due regard to the substances intended to be carried, a leakproofness test and a check of the satisfactory operation of all service equipment. Sheathing, thermal insulation and the like shall be removed only to the extent required for reliable appraisal of the condition of the portable tank. For portable tanks intended for the carriage of a single substance, the 2.5 year internal examination may be waived or substituted by other test methods or inspection procedures specified by the competent authority or its authorized body.

² Distinguishing sign of the State of registration used on motor vehicles and trailers in international road traffic, e.g. in accordance with the Geneva Convention on Road Traffic of 1949 or the Vienna Convention on Road Traffic of 1968.


- 6.7.2.19.6 *Inspection and test of portable tanks and filling after the date of expiry of the last periodic inspection and test*
- 6.7.2.19.6.1 A portable tank may not be filled and offered for carriage after the date of expiry of the last 5 year or 2.5 year periodic inspection and test as required by 6.7.2.19.2. However, a portable tank filled prior to the date of expiry of the last periodic inspection and test may be carried for a period not to exceed three months beyond the date of expiry of the last periodic test or inspection. In addition, a portable tank may be carried after the date of expiry of the last periodic test and inspection:
- (a) After emptying but before cleaning, for purposes of performing the next required test or inspection prior to refilling; and
 - (b) Unless otherwise approved by the competent authority, for a period not to exceed six months beyond the date of expiry of the last periodic test or inspection, in order to allow the return of dangerous goods for proper disposal or recycling. Reference to this exemption shall be mentioned in the transport document.
- 6.7.2.19.6.2 Except as provided for in 6.7.2.19.6.1, portable tanks which have missed the timeframe for their scheduled 5 year or 2.5-year periodic inspection and test may only be filled and offered for carriage if a new 5-year periodic inspection and test is performed according to 6.7.2.19.4.
- 6.7.2.19.7 The exceptional inspection and test is necessary when the portable tank shows evidence of damaged or corroded areas, or leakage, or other conditions that indicate a deficiency that could affect the integrity of the portable tank. The extent of the exceptional inspection and test shall depend on the amount of damage or deterioration of the portable tank. It shall include at least the 2.5 year inspection and test according to 6.7.2.19.5.
- 6.7.2.19.8 The internal and external examinations shall ensure that:
- (a) The shell is inspected for pitting, corrosion, or abrasions, dents, distortions, defects in welds or any other conditions, including leakage, that might render the portable tank unsafe for carriage. The wall thickness shall be verified by appropriate measurement if this inspection indicates a reduction of wall thickness;
 - (b) The piping, valves, heating/cooling system, and gaskets are inspected for corroded areas, defects, or any other conditions, including leakage, that might render the portable tank unsafe for filling, discharge or carriage;
 - (c) Devices for tightening manhole covers are operative and there is no leakage at manhole covers or gaskets;
 - (d) Missing or loose bolts or nuts on any flanged connection or blank flange are replaced or tightened;
 - (e) All emergency devices and valves are free from corrosion, distortion and any damage or defect that could prevent their normal operation. Remote closure devices and self-closing stop-valves shall be operated to demonstrate proper operation;
 - (f) Linings, if any, are inspected in accordance with criteria outlined by the lining manufacturer;
 - (g) Required marks on the portable tank are legible and in accordance with the applicable requirements; and
 - (h) The framework, supports and arrangements for lifting the portable tank are in a satisfactory condition.
- 6.7.2.19.9 The inspections and tests in 6.7.2.19.1, 6.7.2.19.3, 6.7.2.19.4, 6.7.2.19.5 and 6.7.2.19.7 shall be performed or witnessed by an expert approved by the competent authority or its authorized body. When the pressure test is a part of the inspection and test, the test pressure shall be the one indicated on the data plate of the portable tank. While under pressure, the portable tank shall be inspected for any leaks in the shell, piping or equipment.
- 6.7.2.19.10 In all cases when cutting, burning or welding operations on the shell have been effected, that work shall be to the approval of the competent authority or its authorized body taking into account the pressure

vessel code used for the construction of the shell. A pressure test to the original test pressure shall be performed after the work is completed.

- 6.7.2.19.11 When evidence of any unsafe condition is discovered, the portable tank shall not be returned to service until it has been corrected and the test is repeated and passed. .

6.7.2.20 Marking

- 6.7.2.20.1 Every portable tank shall be fitted with a corrosion-resistant metal plate permanently attached to the portable tank in a conspicuous place readily accessible for inspection. When for reasons of portable tank arrangements the plate cannot be permanently attached to the shell, the shell shall be marked with at least the information required by the pressure vessel code. As a minimum, at least the following information shall be marked on the plate by stamping or by any other similar method:

- (a) Owner information
 - (i) Owner's registration number;
- (b) Manufacturing information
 - (i) Country of manufacture;
 - (ii) Year of manufacture;
 - (iii) Manufacturer's name or mark;
 - (iv) Manufacturer's serial number;
- (c) Approval information
 - (i) The United Nations packaging symbol .

This symbol shall not be used for any purpose other than certifying that a packaging, a flexible bulk container, a portable tank or a MEGC complies with the relevant requirements in Chapter 6.1, 6.2, 6.3, 6.5, 6.6, 6.7 or 6.11;

- (ii) Approval country;
 - (iii) Authorized body for the design approval;
 - (iv) Design approval number;
 - (v) Letters 'AA', if the design was approved under alternative arrangements (see 6.7.1.2);
 - (vi) Pressure vessel code to which the shell is designed;
- (d) Pressures
 - (i) MAWP (in bar gauge or kPa gauge)³;
 - (ii) Test pressure (in bar gauge or kPa gauge)³;
 - (iii) Initial pressure test date (month and year);
 - (iv) Identification mark of the initial pressure test witness;
 - (v) External design pressure⁴ (in bar gauge or kPa gauge)³;
 - (vi) MAWP for heating/cooling system (in bar gauge or kPa gauge)³ (when applicable);


³ The unit used shall be indicated.

⁴ See 6.7.2.2.10.

- (e) Temperatures
 - (i) Design temperature range (in °C)³;
- (f) Materials
 - (i) Shell material(s) and material standard reference(s);
 - (ii) Equivalent thickness in reference steel (in mm)³;
 - (iii) Lining material (when applicable);
- (g) Capacity
 - (i) Tank water capacity at 20 °C (in litres)³;
This indication is to be followed by the symbol "S" when the shell is divided by surge plates into sections of not more than 7 500 litres capacity;
 - (ii) Water capacity of each compartment at 20 °C (in litres)³ (when applicable, for multi-compartment tanks).
This indication is to be followed by the symbol "S" when the compartment is divided by surge plates into sections of not more than 7 500 litres capacity;
- (h) Periodic inspections and tests
 - (i) Type of the most recent periodic test (2.5-year, 5-year or exceptional);
 - (ii) Date of the most recent periodic test (month and year);
 - (iii) Test pressure (in bar gauge or kPa gauge)³ of the most recent periodic test (if applicable);
 - (iv) Identification mark of the authorized body who performed or witnessed the most recent test.

³ The unit used shall be indicated.

Figure 6.7.2.20.1: Example of a plate for marking

Owner's registration number					
MANUFACTURING INFORMATION					
Country of manufacture					
Year of manufacture					
Manufacturer					
Manufacturer's serial number					
APPROVAL INFORMATION					
	Approval country				
	Authorized body for design approval				
	Design approval number		'AA' (if applicable)		
Shell design code (pressure vessel code)					
PRESSURES					
MAWP		bar or kPa			
Test pressure		bar or kPa			
Initial pressure test date:	(mm/yyyy)	Witness stamp:			
External design pressure		bar or kPa			
MAWP for heating/cooling system (when applicable)		bar or kPa			
TEMPERATURES					
Design temperature range		°C to °C			
MATERIALS					
Shell material(s) and material standard reference(s)					
Equivalent thickness in reference steel		mm			
Lining material (when applicable)					
CAPACITY					
Tank water capacity at 20 °C		litres	'S' (if applicable)		
Water capacity of compartment at 20 °C (when applicable, for multi-compartment tanks)		litres	'S' (if applicable)		
PERIODIC INSPECTIONS / TESTS					
Test type	Test date	Witness stamp and test pressure ^a	Test type	Test date	Witness stamp and test pressure ^a
	(mm/yyyy)	bar or kPa		(mm/yyyy)	bar or kPa

^a Test pressure if applicable.

6.7.2.20.2 The following particulars shall be durably marked either on the portable tank itself or on a metal plate firmly secured to the portable tank:

Name of the operator

Maximum permissible gross mass (MPGM) _____ kg

Unladen (tare) mass _____ kg

Portable tank instruction in accordance with 4.2.5.2.6

NOTE: For the identification of the substances being carried, see also Part 5.

6.7.2.20.3 If a portable tank is designed and approved for handling in open seas, the words "OFFSHORE PORTABLE TANK" shall be marked on the identification plate.