

may be made of water-resistant reconstituted wood such as hardboard or particle board. Materials other than natural wood may be used for construction of structural equipment of the outer packaging.

(ii) Outer packagings of plywood must 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 must be glued with water-resistant adhesive. Materials other than plywood may be used for construction of structural equipment of the outer packaging. Outer packagings must be firmly nailed or secured to corner posts or ends or be assembled by equally suitable devices.

(iii) Outer packagings of reconstituted wood must be constructed of water-resistant reconstituted wood such as hardboard or particle board. Materials other than reconstituted wood may be used for the construction of structural equipment of reconstituted wood outer packaging.

(iv) Fiberboard outer packagings must be constructed of strong, solid, or double-faced corrugated fiberboard (single or multiwall).

(A) Water resistance of the outer surface must 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 grams per square meter (0.0316 pounds per square foot—see ISO International Standard 535-1976 (E)). Fiberboard must have proper bending qualities. Fiberboard must be cut, creased without cutting through any thickness of fiberboard, and slotted so as to permit assembly without cracking, surface breaks, or undue bending. The fluting of corrugated fiberboard must be firmly glued to the facings.

(B) The ends of fiberboard outer packagings may have a wooden frame or be constructed entirely of wood. Wooden battens may be used for reinforcements.

(C) Manufacturers' joints in the bodies of outer packagings must be taped, lapped and glued, or lapped and stitched with metal staples.

(D) Lapped joints must have an appropriate overlap.

(E) Where closing is effected by gluing or taping, a water-resistant adhesive must be used.

(F) All closures must be sift-proof.

(v) Outer packagings of plastic materials must be constructed in accordance with the relevant provisions of paragraph (c)(3) of this section.

(5) Any integral pallet base forming part of an IBC, or any detachable pallet, must be suitable for the mechanical handling of an IBC filled to its maximum permissible gross mass.

(i) The pallet or integral base must be designed to avoid protrusions that may cause damage to the IBC in handling.

(ii) The outer packaging must be secured to any detachable pallet to ensure stability in handling and transportation. Where a detachable pallet is used, its top surface must be free from sharp protrusions that might damage the IBC.

(iii) Strengthening devices, such as timber supports to increase stacking performance, may be used but must be external to the inner receptacle.

(iv) The load-bearing surfaces of IBCs intended for stacking must be designed to distribute loads in a stable manner. An IBC intended for stacking must be designed so that loads are not supported by the inner receptacle.

(6) Intermediate IBCs of type 31HZ2 must be limited to a capacity of not more than 1,250 L.

[Amdt. 178-103, 59 FR 38068, July 26, 1994, as amended by Amdt. 178-119, 62 FR 24743, May 6, 1997; 66 FR 45387, Aug. 28, 2001; 67 FR 61016, Sept. 27, 2002]

§ 178.708 Standards for fiberboard IBCs.

(a) The provisions of this section apply to fiberboard IBCs intended to contain solids that are loaded or discharged by gravity. Fiberboard IBCs are designated: 11G.

(b) Definitions for fiberboard IBC types:

(1) *Fiberboard IBCs* consist of a fiberboard body with or without separate top and bottom caps, appropriate service and structural equipment, and if necessary an inner liner (but no inner packaging).

(2) *Liner* means a separate tube or bag, including the closures of its openings, inserted in the body but not forming an integral part of it.

(c) Construction requirements for fiberboard IBCs are as follows:

(1) Top lifting devices are prohibited in fiberboard IBCs.

(2) Fiberboard IBCs must be constructed of strong, solid or double-faced corrugated fiberboard (single or multiwall) that is appropriate to the capacity of the outer packaging and its intended use. Water resistance of the outer surface must 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 grams per square meter (0.0316 pounds per square foot see ISO 535–1976(E)). Fiberboard must have proper bending qualities. Fiberboard must be cut, creased without cutting through any thickness of fiberboard, and slotted so as to permit assembly without cracking, surface breaks, or undue bending. The fluting of corrugated fiberboard must be firmly glued to the facings.

(i) The walls, including top and bottom, must have a minimum puncture resistance of 15 Joules (11 foot-pounds of energy) measured according to ISO 3036, incorporated by reference in §171.7 of this subchapter.

(ii) Manufacturers' joints in the bodies of IBCs must be made with an appropriate overlap and be taped, glued, stitched with metal staples or fastened by other means at least equally effective. Where joints are made by gluing or taping, a water-resistant adhesive must be used. Metal staples must 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.

(3) The strength of the material used and the construction of the liner must be appropriate to the capacity of the IBC and the intended use. Joints and closures must be sift-proof and capable of withstanding pressures and impacts liable to occur under normal conditions of handling and transport.

(4) Any integral pallet base forming part of an IBC, or any detachable pallet, must be suitable for the mechan-

ical handling of an IBC filled to its maximum permissible gross mass.

(i) The pallet or integral base must be designed to avoid protrusions that may cause damage to the IBC in handling.

(ii) The outer packaging must be secured to any detachable pallet to ensure stability in handling and transport. Where a detachable pallet is used, its top surface must be free from sharp protrusions that might damage the IBC.

(iii) Strengthening devices, such as timber supports to increase stacking performance, may be used but must be external to the inner liner.

(iv) The load-bearing surfaces of IBCs intended for stacking must be designed to distribute loads in a stable manner.

[Amdt. 178–103, 59 FR 38068, July 26, 1994, as amended at 66 FR 45386, Aug. 28, 2001]

§ 178.709 Standards for wooden IBCs.

(a) The provisions in this section apply to wooden IBCs intended to contain solids that are loaded or discharged by gravity. Wooden IBC types are designated:

- (1) 11C Natural wood with inner liner.
- (2) 11D Plywood with inner liner.
- (3) 11F Reconstituted wood with inner liner.

(b) Definitions for wooden IBCs:

(1) *Wooden IBCs* consist of a rigid or collapsible wooden body together with an inner liner (but no inner packaging) and appropriate service and structural equipment.

(2) *Liner* means a separate tube or bag, including the closures of its openings, inserted in the body but not forming an integral part of it.

(c) Construction requirements for wooden IBCs are as follows:

(1) Top lifting devices are prohibited in wooden IBCs.

(2) The strength of the materials used and the method of construction must be appropriate to the capacity and intended use of the IBC.

(i) Natural wood used in the construction of an IBC must be well-seasoned, commercially dry, and free from defects that would materially lessen the strength of any part of the IBC. Each IBC part must consist of uncut wood or a piece equivalent in strength and integrity. IBC parts are equivalent