



Technocraft Industries (India) Ltd.

Titeseal Closure Product Data Sheet

Metal Lacquer EHD0002 (285-C-102) Buff Epoxy Phenolic Drum Closure With Various Gaskets

General Information

- Manufactured in compliance with ISO-15750-3
- Threads comply with ISO-228
- Raw Material : Flange (HR Mild Steel), Plug (CR Mild Steel)
- Resin Type : Epoxy Phenolic
- Finish : Golden Brown above chromate zinc
- We can use equivalent lacquer or even same as used by drum manufacturer on request. Our standard lacquer is of Valspar-USA. Code no(EHD0002 (285-C102). For more details on lacquer [click here](#) or contact Valspar-USA.
- To obtain data on insertion process into drum head, our existing customers may [click here](#) to obtain insertion process bulletin and insertion gauge drawing specific to this flange insertion gauges are given free to our customers.

Closure is available with any of following standard Technocraft gaskets. Special formulations available on request. (To know about chemical compatibility for special products [click here](#) or send email or contact postally.)

- **Black Nitrile Gasket :** Black Nitrile Rubber (NBR) is resistant to petroleum Oils, Aromatic Hydrocarbons, Mineral Oils, Vegetable Oils and many Acids. Black Nitrile has excellent sealing properties.
- **White EPDM Gasket :** EPDM is a multi-purpose sealing material with good and excellent chemical properties. EPDM is FDA compliant. As plug gasket, it is not recommended for application involving petroleum derivatives.
- **Square PE Gasket (For Plug) :** Square PE gasket due to nature of the Polythelene (PE) have limited heat resistance and are subject to "Cold Flow" and as such to loss of compression / closing torque.
- **Round PE Gasket (For Plug) :** Square PE gasket due to nature of the Polythelene (PE) have limited heat resistance and are subject to "Cold Flow" and as such to loss of compression / closing torque.
- **Square Poly Irradiated gasket (For Plug) :** Improved heat resistance due to nature of Polythelene (PE) the washers are subject to "Cold Flow" and as such to loss of compression / closing torque.
- **Round Poly Irradiated gasket (For Plug) :** Improved heat resistance due to nature of Polythelene (PE) the washers are subject to "Cold Flow" and as such to loss of compression / closing torque.

Item Code

50mm RTT Flange with
Black Buna – 2LRFB1
EPDM – 2LRFE1
Dual – 2LRFD1

20mm RTT Flange with
Black Buna – 3LRFB1
EPDM – 3LRFE1
Dual – 3LRFD1

50mm Conventional Flange with
Black Buna – 2LTFB1
EPDM – 2LTFE1
Dual – 2LTFD1

20mm Conventional Flange with
Black Buna – 3LTFB1
EPDM – 3LTFE1
Dual – 3LTFD1

50mm GRT Flange with
Black Buna – 2LGFB1
EPDM – 2LGFE1
Large Black Buna – 2LGFB1
Large EPDM – 2LGFEL1

20mm GRT Flange with
Black Buna – 3LGFB1
EPDM – 3LGFE1
Large Black Buna – 3LGFB1
Large EPDM – 3LGFEL1

50mm Plug with
Black Buna – 2LTPB1
EPDM – 2LTPE1
Round PE – 2LTPRP1
Square PE – 2LTPSP1
Round Poly Irradiated – 2LTPRI1
Square Poly Irradiated – 2LTPPI1

20mm Plug with
Black Buna – 3LTPB1
EPDM – 3LTPE1
Round PE – 3LTPRP1
Square PE – 3LTPSP1
Round Poly Irradiated – 3LTPRI1
Square Poly Irradiated – 3LTPPI1

Torque and Temperature Information

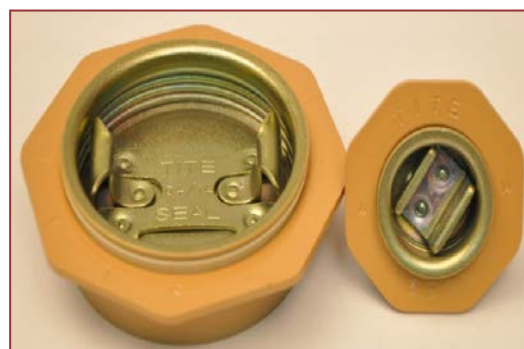
Gasket	Temp. (Max)	Oven Time (Max)	50mm (2") #	20mm (3/4") #
Black Nitrile (Black Buna) for Flange & Bung	220 ⁰ C	15 mins.	15 – 25 ft.lbs 20 – 34 Nm	8 – 15 ft.lbs 11 – 20 Nm
White Buna for Flange & Bung	180 ⁰ C	20 mins.	15 – 25 ft.lbs 20 – 34 Nm	8 – 15 ft.lbs 11 – 20 Nm
White EPDM for Flange & Bung	205 ⁰ C	20 mins.	15 – 25 ft.lbs 20 – 34 Nm	8 – 15 ft.lbs 11 – 20 Nm
Black EPDM for Flange & Bung	180 ⁰ C	20 mins.	15 – 25 ft.lbs 20 – 34 Nm	8 – 15 ft.lbs 11 – 20 Nm
Polyethylene Round Cross Section Square Cross Section for Bung	N.A	N.A	15 – 25 ft.lbs 20 – 34 Nm	8 – 15 ft.lbs 11 – 20 Nm
Irradiated Polyethylene Square Cross Section for Bung	250 ⁰ C	20 mins.	18 – 25 ft.lbs 24 – 34 Nm	8 – 15 ft.lbs 11 – 20 Nm
Viton for Flange & Bung	230 ⁰ C	15 mins.	15 – 25 ft.lbs 20 – 34 Nm	8 – 15 ft.lbs 11 – 20 Nm
Teflon for Flange & Bung	107 ⁰ C	15 mins.	18 – 25 ft.lbs 24 – 34 Nm	10 – 15 ft.lbs 14 – 20 Nm

Minimum values are meant for Drum Maker and Maximum for Drum Filler

Standard Packing

Item	Box Quantity	Box Size	Pallet Quantity	Pallet Size
50mm Flange	250	16"(L)x 16"(W) x 7.5"(H)	9000	52" x 42"
20mm Flange	500	18.25" x 9.25" x 6.5"	25000	52" x 42"
50mm Plug	250	12.5" x 12.5" x 6"	15000	52" x 42"
20mm Plug	1000	11.5" x 11.5" x 5.5"	60000	52" x 42"

- Boxes are marked with item code.
- Pallets are stretch wrapped.
- Optional Special packaging as per customer's requirement.



- More information can be availed by [clicking here](#) or by contacting our head quarters as per details on our web page.
- The raw material used confirms to the standard for Restriction Of hazardous Materials.
- Ensure that liquid filled is compatible to zinc.