

Technocraft Industries (India) Ltd.

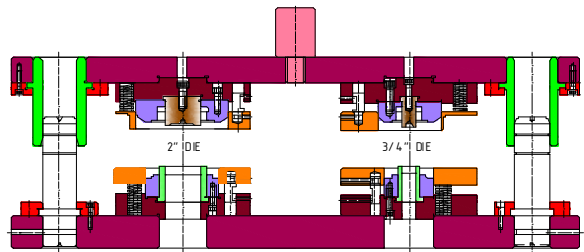
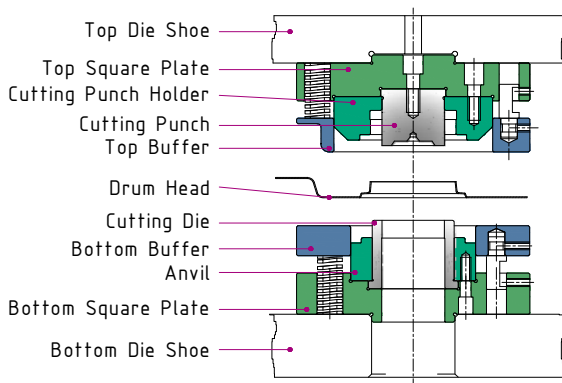
Titeseal Closure Manual

Standard Technocraft Tandem Double Shot Flange Insertion

Standard Technocraft Insertion Dies for both first and second operation are running at various customers all over the world, large proportion of population being in U.S.A. Automated and batch systems both offered as per customer's requirements. Full engineering backup with just a phone call / email available.

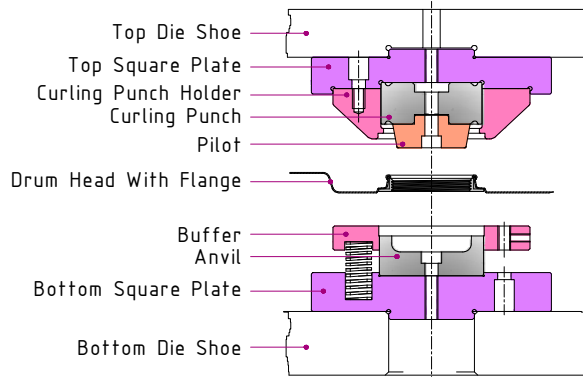
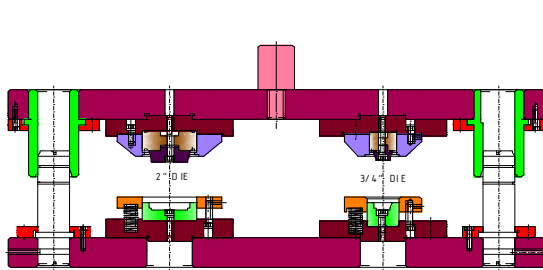
1st Operation

First operation die forms pocket in head for flange insertion.



2nd Operation

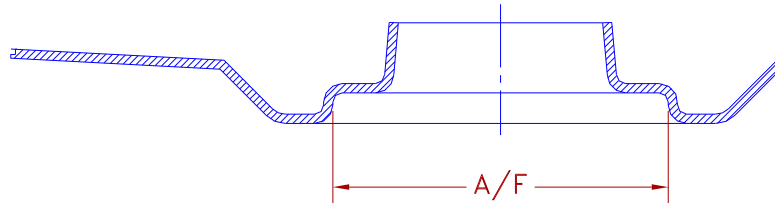
Second operation die inserts flange into pocket formed in first operation to give a leakproof assembly.



1st Operation of Drum Top forming with the help of Technocraft Insertion Dies and Tools.

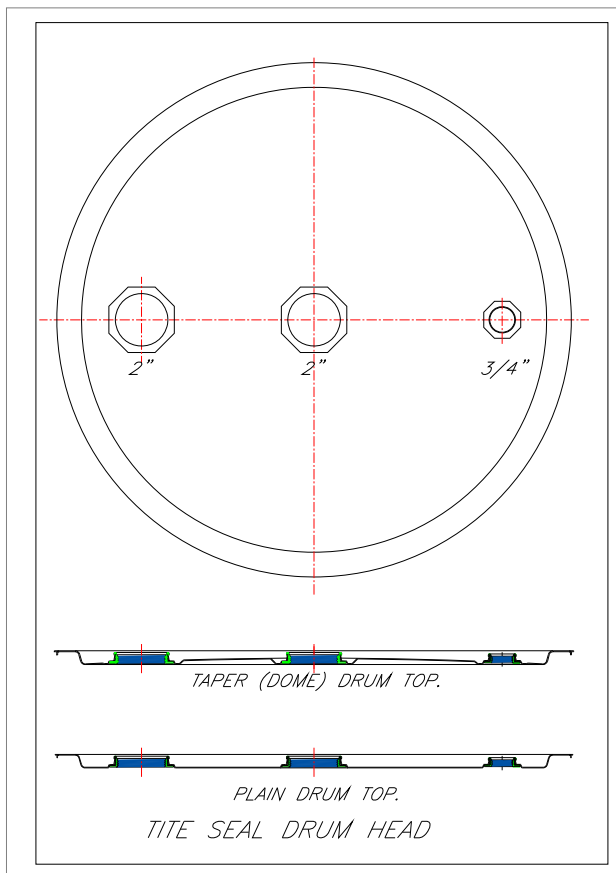
The specified diameter and height to be maintained at the time of curling flange on drum top with the help of Technocraft Insertion Dies and Tools.

Drum top of thickness are 0.80mm, 1.00mm & 1.20mm

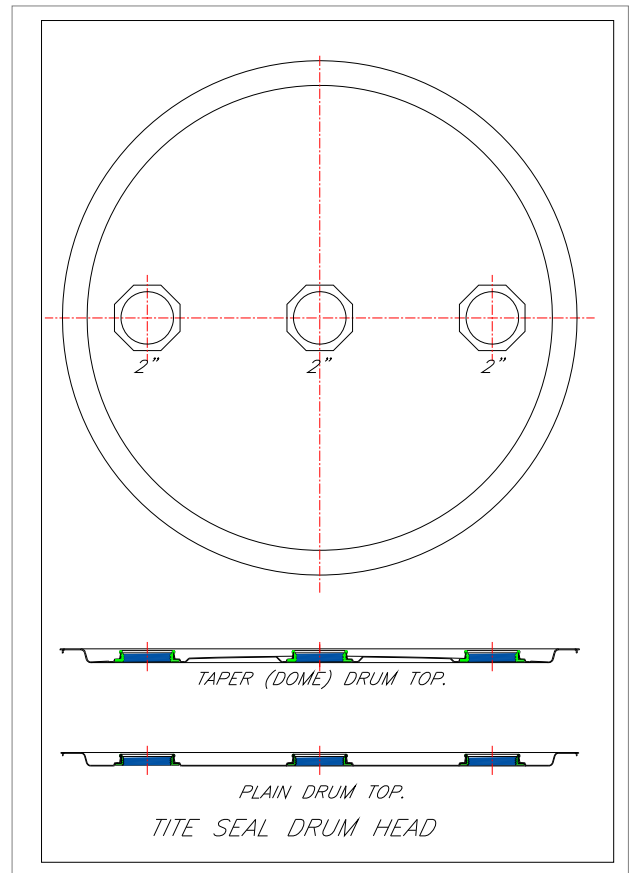


FLANGE SEATING FACE

We also offer special dies as below as per customer's request.



2" - 2" - 3/4"

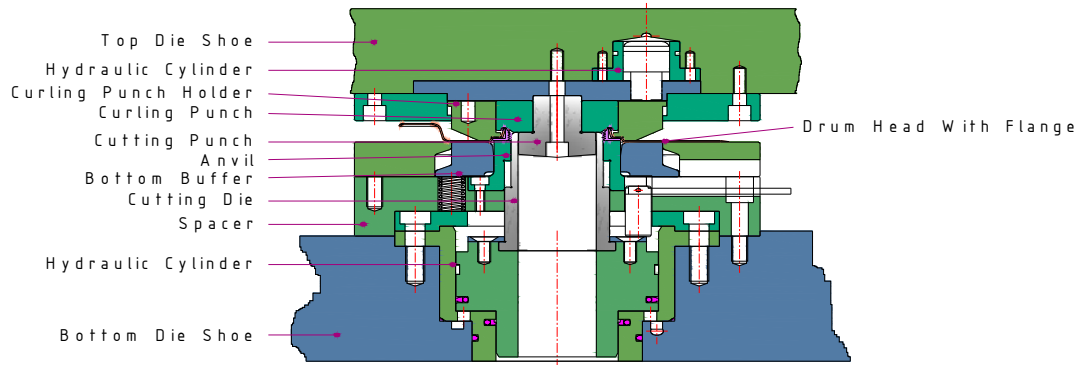


2" - 2" - 2"

Contact or [click here](#) to obtain recommended pocket dimensions out of first operation on drum head for closure insertion. Information is given only to customers of Technocraft closures.

Single Operation Tandem Flange Insertion

Technocraft offers you another revolution in drum manufacture by directly inserting flanges in drum top in single stroke. This needs only one press of minimum 100 tone load capacity and specifically designed die-set with hydraulic accessories. Press can be made to run continuous stroke to save clutch wear and conserve compressed air.



Full Automation of our High End Insertion Tooling

In many steel drum manufacturing plants around the world, our automatic flange insertion lines are in use. There is auto head feed, auto flange feed, press automation. Lines are fully supported by Technocraft with large inventory of parts and highly skilled technicians and quality engineers to train customer work force and give technical service. Lines are state of the art and together with legendary Technocraft quality out perform competition in quality, reliability resulting in zero rejects. Auto setups could be single shot or two step as per customer preference and press availability. Technocraft inhouse engineering team has skill and support to handle complex special customer requirements such as special pocket shapes to be formed at insertion area or to automate second operation on preformed first operation heads coming out of stagger blanking head lines.

Our single shot insertion systems are a generation ahead of competition particularly with respect to automated component feed into the die. Component is not taken over the die and dropped to a free fall into cavity, instead cutting die is locked down during upward travel of press ram, component is fed straight into position, then cutting die is unlocked to spring back up through component bore. This feature is known to save rejects and painstaking setting efforts as feed is much more positive, there is no chance of hang up during a drop. This feature performs admirably in continuous stroke.

Engineering support.

Technocraft has a strong pool of engineering talent waiting to support customer for any problem faced even if tooling belong to customer. Technocraft can guide to solve issues with such tooling if need be.



We recommend use of Technocraft Insertion gauge to check quality of insertion. A variety of gauges and special tool parts available for customer's special applications and for ease of use of insertion dies most optionally. Die support is provided only to Technocraft drum closure customers.

Technocraft customers may [click here](#) or contact as per address on our web page for a free download of our product bulletin that gives critical dimensions that need to be maintained for good quality insertion.

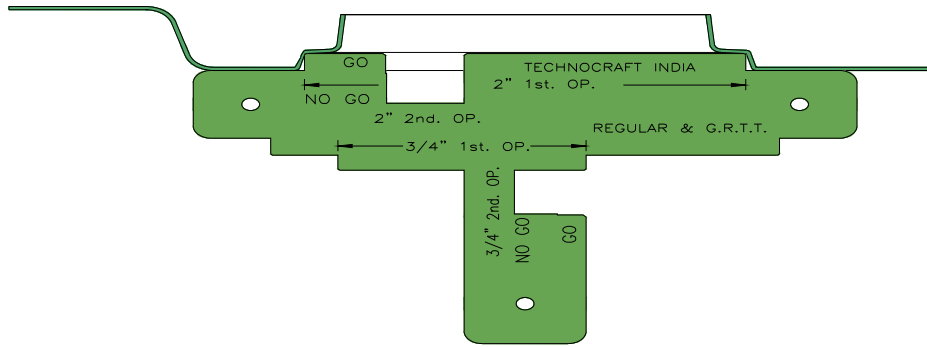
Complete die manual and die drawings are provided to customers of Technocraft using our insertion dies. Technocraft die service is just a phone call or mail / SMS message away. Our skilled technicians provide service to our automated and semi-automated die installations most parts of the world. A combination of Technocraft closures, Technocraft Insertion Dies and Technocraft service would result in near zero defect rate.

- To learn more details or for specific applications, [click here](#) or send email or contact postally to our head quarters in Mumbai, India

Technocraft Flange Insertion Process Control

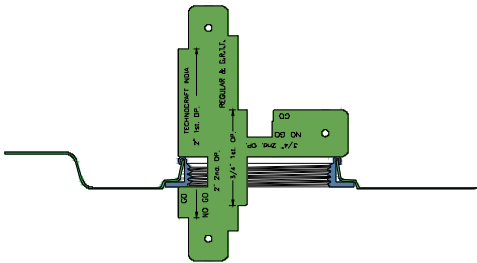
Technocraft supply gauges, specification and documentation to assist customers in roducing consistent quality of the flange insertion.

Technocraft Insertion—Checking the 1st Operation

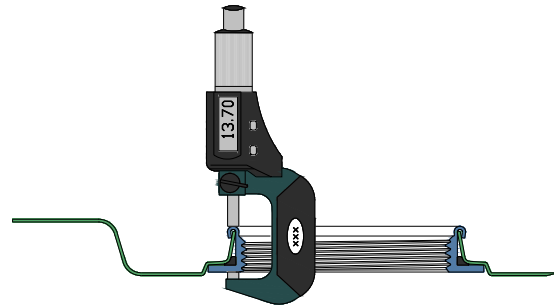


Above gauge checks depth of octagon form. Lower depth shows up gap at drum head beyond octagon form.

Technocraft Insertion—Checking the 2nd Operation



Same gauge check curling height. There is “Go” and “No GO” in line for ease of user.



It is recommended to measure the height with a micrometer. The picture shows how this is done, using a micrometer for 2” flange. Measure the height of the inserted flange at 4 spots

- For various settings, please contact Technocraft for appropriate heights.
- To learn more details or for specific applications, [click here](#) or send email or contact postally to our head quarters in Mumbai, India