



Technocraft Industries (India) Ltd.

Titeseal Closure Product Data Sheet

Metal Lacquer L-1 Clear 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 : 100 % Phenolic*
- *Finish : Clear Phenolic above chromated zinc*
- *We can use equivalent lacquer or even same as used by drum manufacturer on request. Our standard lacquer is KNS-USA. Code no L-1 Clear Phenolic. For more details on lacquer [click here](#) or contact KNS-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 – 2LRFB4
EPDM – 2LRFE4
Dual – 2LRFD4

20mm RTT Flange with
Black Buna – 3LRFB4
EPDM – 3LRFE4
Dual – 3LRFD4

50mm Conventional Flange with
Black Buna – 2LTFB4
EPDM – 2LTFE4
Dual – 2LTFD4

20mm Conventional Flange with
Black Buna – 3LTFB4
EPDM – 3LTFE4
Dual – 3LTFD4

50mm GRT Flange with
Black Buna – 2LGFB4
EPDM – 2LGFE4
Large Black Buna – 2LGFB4
Large EPDM – 2LGFEL4

20mm GRT Flange with
Black Buna – 3LGFB4
EPDM – 3LGFE4
Large Black Buna – 3LGFB4
Large EPDM – 3LGFEL4

50mm Plug with
Black Buna – 2LTPB4
EPDM – 2LTPE4
Round PE – 2LTPRP4
Square PE – 2LTPSP4
Round Poly Irradiated – 2LTPRI4
Square Poly Irradiated – 2LTPPI4

20mm Plug with
Black Buna – 3LTPB4
EPDM – 3LTPE4
Round PE – 3LTPRP4
Square PE – 3LTPSP4
Round Poly Irradiated – 3LTPRI4
Square Poly Irradiated – 3LTPPI4

Torque and Temperature Information

Gasket	Temp. (Max)	Oven Time (Max)	50mm (2") #	20mm (3/4") #
Black Nitrile (Black Buna) for Flange & Bung	220° C	15 mins.	15 – 25 ft.lbs 20 – 34 Nm	8 – 15 ft.lbs 11 – 20 Nm
White Buna for Flange & Bung	180° C	20 mins.	15 – 25 ft.lbs 20 – 34 Nm	8 – 15 ft.lbs 11 – 20 Nm
White EPDM for Flange & Bung	205° C	20 mins.	15 – 25 ft.lbs 20 – 34 Nm	8 – 15 ft.lbs 11 – 20 Nm
Black EPDM for Flange & Bung	180° 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° C	20 mins.	18 – 25 ft.lbs 24 – 34 Nm	8 – 15 ft.lbs 11 – 20 Nm
Viton for Flange & Bung	230° C	15 mins.	15 – 25 ft.lbs 20 – 34 Nm	8 – 15 ft.lbs 11 – 20 Nm
Teflon for Flange & Bung	107° 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.