



# Technocraft Industries (India) Ltd.

## Titeseal Closure Product Data Sheet

### Metal Lacquer L-15 Dark Brown 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 : Phenolic / Epoxy*
- *Finish : Dark Brown above chromate 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-15 Dark Brown. 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 – 2LRFB2  
EPDM – 2LRFE2  
Dual – 2LRFD2

20mm RTT Flange with  
Black Buna – 3LRFB2  
EPDM – 3LRFE2  
Dual – 3LRFD2

50mm Conventional Flange with  
Black Buna – 2LTFB2  
EPDM – 2LTFE2  
Dual – 2LTFD2

20mm Conventional Flange with  
Black Buna – 3LTFB2  
EPDM – 3LTFE2  
Dual – 3LTFD2

50mm GRT Flange with  
Black Buna – 2LGFB2  
EPDM – 2LGFE2  
Large Black Buna – 2LGFBL2  
Large EPDM – 2LGFEL2

20mm GRT Flange with  
Black Buna – 3LGFB2  
EPDM – 3LGFE2  
Large Black Buna – 3LGFBL2  
Large EPDM – 3LGFEL2

50mm Plug with  
Black Buna – 2LTPB2  
EPDM – 2LTPE2  
Round PE – 2LTPRP2  
Square PE – 2LTPSP2  
Round Poly Irradiated – 2LTPRI2  
Square Poly Irradiated – 2LTPPI2

20mm Plug with  
Black Buna – 3LTPB2  
EPDM – 3LTPE2  
Round PE – 3LTPRP2  
Square PE – 3LTPSP2  
Round Poly Irradiated – 3LTPRI2  
Square Poly Irradiated – 3LTPPI2

## 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.