



Technocraft Industries (India) Ltd.

Titeseal Closure Product Data Sheet

Metal Lacquer PPG 2088-320 Golden 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 : Epoxy Phenolic
- Finish : Golden Brown above chromated zinc
- We can use equivalent lacquer or even same as used by drum manufacturer on request. Our standard lacquer is PPG-France. Code no PPG 2088-320. For more details on lacquer [click here](#) or contact PPG-France.
- 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 – 2LRFB6
EPDM – 2LRFE6
Dual – 2LRFD6

20mm RTT Flange with
Black Buna – 3LRFB6
EPDM – 3LRFE6
Dual – 3LRFD6

50mm Conventional Flange with
Black Buna – 2LTFB6
EPDM – 2LTFE6
Dual – 2LTFD6

20mm Conventional Flange with
Black Buna – 3LTFB6
EPDM – 3LTFE6
Dual – 3LTFD6

50mm GRT Flange with
Black Buna – 2LGFB6
EPDM – 2LGFE6
Large Black Buna – 2LGFBL6
Large EPDM – 2LGFEL6

20mm GRT Flange with
Black Buna – 3LGFB6
EPDM – 3LGFE6
Large Black Buna – 3LGFBL6
Large EPDM – 3LGFEL6

50mm Plug with
Black Buna – 2LTPB6
EPDM – 2LTPE6
Round PE – 2LTPRP6
Square PE – 2LTSP6
Round Poly Irradiated – 2LTPRI6
Square Poly Irradiated – 2LTPI6

20mm Plug with
Black Buna – 3LTPB6
EPDM – 3LTPE6
Round PE – 3LTPRP6
Square PE – 3LTSP6
Round Poly Irradiated – 3LTPRI6
Square Poly Irradiated – 3LTPI6

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.