



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.*
- *Round PE Gasket (For Plug) : Square PE gasket due to nature of the Polythelene (PE) have limited heat resistance.*
- *Square Poly Irradiated gasket (For Plug) : Improved heat resistance and improved chemical resistance due to cross-linking by electron beam radiation.*
- *Round Poly Irradiated gasket (For Plug) : Improved heat resistance and improved chemical resistance due to cross-linking by electron beam radiation.*

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.