

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
 <u>click here</u> 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 <u>click here</u> 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 – 2LTPI2

20mm Plug with

Black Buna - 3LTPB2
EPDM - 3LTPE2
Round PE - 3LTPRP2
Square PE - 3LTPSP2
Round Poly Irradiated - 3LTPRI2
Square Poly Irradiated - 3LTPI2

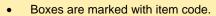
Torque and Temperature Information

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	Box Size	Pallet	Pallet
item	BOX	Box Size	Pallet	Pallet
	Quantity		Quantity	Size
50mm	250	16"(L)x 16"(W) x 7.5"(H)	9000	52" x 42"
Flange				
20mm	500	18.25" x 9.25" x 6.5"	25000	52" x 42"
Flange				
50mm	250	12.5" x 12.5" x 6"	15000	52" x 42"
Plug				
20mm	1000	11.5" x 11.5" x 5.5"	60000	52" x 42"
Plug				



- Pallets are stretch wrapped.
- Optional Special packaging as per customer's requirement.



- More information can be availed by <u>clicking here</u> 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.