

TECHNOCRAFT TORQUE MATRIX

General

The recommended torques are only valid for the Technocraft Closure System. The conversion ftlbs – Kgm – Nm has been rounded off, the following conversion factors were used.

1 Kgm = 10 Nm

1 ftlbs = 0.13825 Kgm

After tightening of plugs, torques will reduce over period. Particularly plastic components are subject to stress relaxation resulting in a reduction of torque. In general no re-tightening of plugs will be required when the recommended torques have been applied.

For Quality Assurance purposes it is recommended to check regularly process parameters (e.g. Air Pressures), which determine the required torque. Furthermore it should be noted that torques which are measured clockwise are different when measured anti-clockwise.

Rubber includes Nitrile, EPDM, Viton, etc and P.E. stands for PolyEthylene. Please contact Technocraft when the torques does not give a satisfactory result.

RECOMMENDED CLOSING TORQUES FOR DRUM MAKERS

Plug Type	Washer Type	¾" Closure			2" Closure		
		ftlbs	Kgm	Nm	Ftlbs	Kgm	Nm
Steel Plugs	Rubber	7 - 14	1.0 – 2.0	10 – 20	8 – 14	1.1 – 2.0	11 – 20
	P.E.	7 - 14	1.0 – 2.0	10 – 20	11 – 18	1.5 – 2.5	15 – 25
Plastic Plugs	Rubber	8 – 12	1.1 – 1.7	11 – 17	10 – 20	1.4 – 2.8	14 – 28
	P.E.	8 – 12	1.1 – 1.7	11 – 17	10 – 20	1.4 – 2.8	14 – 28

RECOMMENDED CLOSING TORQUES FOR DRUM FILLERS

Plug Type	Washer Type	¾" Closure			2" Closure		
		ftlbs	Kgm	Nm	Ftlbs	Kgm	Nm
Steel Plugs	Rubber	7 - 14	1.0 – 2.0	10 – 20	14 – 23	2.0 – 3.2	20 – 32
	P.E.	7 - 14	1.0 – 2.0	10 – 20	14 – 23	2.0 – 3.2	20 – 32
Plastic Plugs	Rubber	8 – 12	1.1 – 1.7	11 – 17	10 – 20	1.4 – 2.8	14 – 28
	P.E.	8 – 12	1.1 – 1.7	11 – 17	10 – 20	1.4 – 2.8	14 – 28