



# Tri-Sure Drum Fitting Closing Instruction

CSC Form QA-FM-L256

Rev. 4

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### Manual Hand Tool:

1. Place the fitting on the top of the container in the threaded opening.
2. Start turning the fitting to the right, till the threads have started to engage.
3. Finish installing the fitting with the manufacturers suggested wrench.
4. Make sure that the fitting is torqued to the proper specification. (See chart below.)

### Pneumatic Hand Tool:

1. Place the fitting on the top of the container in the threaded opening.
2. Start turning the fitting to the right, till the threads have started to engage.
3. Finish installing the fitting by using the pneumatic tool.
4. Make sure that the fitting is torqued to the proper specification. (See chart below.)

## 2" Plugs

<u>Gasket Material</u>	<u>Plastic Plug</u>	<u>Steel Plug</u>	<u>Oven Temp</u>
Buna	20 ft-lbs	30 ft-lbs	450 F
White Buna	20 ft-lbs	30 ft-lbs	450 F
Irradiated L. D. Polyethylene	15 ft-lbs	30 ft-lbs	375 F
L. D. Polyethylene	15 ft-lbs	Not Available	Not Available
Dapon	20 ft-lbs	30 ft-lbs	450F
E.P.T	20 ft-lbs	30 ft-lbs	450 F
White EPT	20 ft-lbs	30 ft-lbs	450 F
White EPT	20 ft-lbs	Not Available	Not Available

## 3/4" Plugs

Buna	9 ft lbs	15 ft lbs	450 F
White Buna	9 ft lbs	15 ft lbs	450 F
L. D. Polyethylene	5 ft lbs	20 ft lbs	120 F
Irradiated L. D. Polyethylene	5 ft lbs	20 ft lbs	375 F
Dapon	9 ft lbs	15 ft lbs	450 F
E.P.T	9 ft lbs	15 ft lbs	450 F
White E.P.T	9 ft lbs	15 ft lbs	450 F

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