

Updates & Revisions to Closing Instruction Manual as of 10/13/22

- Tri-Sure Drum Fitting Closing Instructions QA-FM-L256

2" Plugs

Gasket Material	Plastic Plug	Steel Plug	Oven Temp
Black Buna	20 ft-lbs	30 ft-lbs	450° F
White Buna	20 ft-lbs	30 ft-lbs	450° F
Irradiated LD Polyethylene	30 ft-lbs	30 ft-lbs	375° F
LD Polyethylene	30 ft-lbs	30 ft-lbs	120° F
Dapon	20 ft-lbs	30 ft-lbs	450° F
EPT / EPDM	20 ft-lbs	30 ft-lbs	450° F
White EPT / EPDM	20 ft-lbs	30 ft-lbs	450° F

3/4" Plugs

Gasket Material	Plastic Plug	Steel Plug	Oven Temp
Black Buna	7 ft-lbs (84 in-lbs)	15 ft-lbs	450° F
White Buna	7 ft-lbs (84 in-lbs)	15 ft-lbs	450° F
Irradiated LD Polyethylene	7 ft-lbs (84 in-lbs)	15 ft-lbs	375° F
LD Polyethylene	7 ft-lbs (84 in-lbs)	15 ft-lbs	120° F
Dapon	7 ft-lbs (84 in-lbs)	15 ft-lbs	450° F
EPT / EPDM	7 ft-lbs (84 in-lbs)	15 ft-lbs	450° F
White EPT / EPDM	7 ft-lbs (84 in-lbs)	15 ft-lbs	450° F

***Changed torque specification on the 2" Plastic Plug that uses the Polyethylene and Polyethylene Irradiated gasket from 20 ft-lbs. to 30 ft-lbs. to ensure that Plugs pass the Hydrostatic Pressure requirements.

***Changed the torque specification for all 3/4" Plastic Plugs from 9 ft-lbs to 7 ft-lbs (84 in-lbs.) to eliminate damaging the fitting from trying to use to high of a torque specification.