

Orlando Drum Tight Head Drum Closure Instructions

Note: Inspect all bungs before installing in a drum to ensure gasket is in place intact and not damaged.

Instructions on closing a 1A1, 55 and 30 gal. tight head steel or 1H1 plastic drum.

Drum Type	Plug	Gasket	Tightening Torque	
			¾ Inch Bung	2 Inch Bung
Steel	Tri-Sure steel & Polyethylene Polypropylene & Nylon	Rubber-Blk Buna, White-Buna, Burl, White Neoprene, Viton, Silicone & EPDM	8-15 ft./lbs.	15-22 ft./lbs.
		Polyethylene, Irradiated, Polyethylene % Teflon	11-18 ft./lbs.	15-22 ft./lbs.
Steel	Tri-sure Polyethylene	Self Gasketing	5 ft./lbs.	12 ft./lbs.
Steel	Rieke Steel (for 1 ½" steel plugs use 2" torques)	Rubber, Quartermaster, Hycar, White Buna, White Asbestos, White Dapon, EPT Black	15 ft./lbs.	30 ft./lbs.
		Poly Seal (plastic) Irradiated & Non-Irradiated	20 ft./lbs.	40 ft./lbs.
Plastic	Rieke Polyethylene, Polypropylene, Nylon	Rubber, Wht. Buna, EDPM Blk, EDPM Wht, Dapon, Irradiated & Non-Irradiated (Self Sealing)	9 ft./lbs.	20 ft./lbs.