

# AMERICAN FLANGE & MANUFACTURING CO. INC.

## TRI-SURE CLOSURES

### GASKET TEMPERATURES AND RECOMMENDED TORQUES

GASKET	MAXIMUM TEMPERATURE	MAXIMUM OVEN TIME	TORQUE* 3/4"	TORQUE* 2"
BLACK BUNA	450 F	15 MIN	10-12 FT. LBS.	15-20 FT. LBS.
WHITE BUNA	250 F	15 MIN	10-12 FT. LBS.	15-20 FT. LBS.
BUTYL	400 F	15 MIN	10-12 FT. LBS.	15-20 FT. LBS.
WHITE NEO	250 F	15 MIN	10-12 FT. LBS.	15-20 FT. LBS.
POLYETHYLENE	200 F	15 MIN	15-20 FT. LBS.	25-30 FT. LBS.
IRRADIATED POLY	350 F	15 MIN	15-20 FT. LBS.	25-30 FT. LBS.
VITON	450 F	15 MIN	10-12 FT. LBS.	15-20 FT. LBS.
HYPALON	200 F	15 MIN	10-12 FT. LBS.	15-20 FT. LBS.
TEFLON	225 F	15 MIN	15-20 FT. LBS.	25-30 FT. LBS.
SILICONE	500 F	15 MIN	10-12 FT. LBS.	15-20 FT. LBS.
E.P.D.M.	400 F	15 MIN	10-12 FT. LBS.	15-20 FT. LBS.

\* RECOMMENDED TORQUES WHEN USED IN TRI-SURE STEEL FLANGES.

## RIEKE CORPORATION

### TORQUE INSTRUCTIONS

2" PLUGS W/BLACK BUNA GASKET - 30 FT. POUNDS
3/4" PLUGS W/BLACK BUNA GASKET - 15 FT. POUNDS