



TECHNICAL SPECIFICATION
OPEN-TOP INTERMEDIATE STEEL DRUM

Nom. Dia.	Volume	Body		Ends		Weight	UN Approval (Optional)
		Thickness	Tolerance	Thickness	Tolerance		
Ø280	6 Lt.	0.60mm	±0.05mm	0.60mm	±0.05mm	1.8 Kg.	1A2/Y1.4/140 1A2/X45/S
Ø280	12 Lt.	0.60mm	±0.05mm	0.60mm	±0.05mm	2.2 Kg.	1A2/Y1.4/140 1A2/X45/S
Ø280	20 Lt.	0.60mm	±0.05mm	0.60mm	±0.05mm	2.9 Kg.	1A2/Y1.4/140 1A2/X45/S
Ø280	22 Lt.	0.60mm	±0.05mm	0.60mm	±0.05mm	3.0 Kg.	1A2/Y1.4/140 1A2/X45/S
Ø280	25 Lt.	0.60mm	±0.05mm	0.60mm	±0.05mm	3.2 Kg.	1A2/Y1.4/140 1A2/X45/S
Ø280	30 Lt.	0.60mm	±0.05mm	0.60mm	±0.05mm	3.6 Kg.	1A2/Y1.4/140 1A2/X45/S
Ø360	30 Lt.	0.60mm	±0.05mm	0.60mm	±0.05mm	3.6 Kg.	1A2/Y1.4/100 1A2/X90/S
Ø360	40 Lt.	0.60mm	±0.05mm	0.60mm	±0.05mm	4.1 Kg.	1A2/Y1.4/100 1A2/X90/S
Ø360	47 Lt.	0.60mm	±0.05mm	0.60mm	±0.05mm	4.5 Kg.	1A2/Y1.4/100 1A2/X90/S
Ø360	50 Lt.	0.60mm	±0.05mm	0.60mm	±0.05mm	4.6 Kg.	1A2/Y1.4/100 1A2/X90/S
Ø360	60 Lt.	0.60mm	±0.05mm	0.60mm	±0.05mm	5.2 Kg.	1A2/Y1.4/100 1A2/X90/S
Ø400	60 Lt.	0.60mm	±0.05mm	0.60mm	±0.05mm	5.4 Kg.	--

DIMENSIONS : See the technical drawing.

Material and Production Specifications:

Body is electrically seam welded. Two beads are formed on the body of drums with 60 Lt. volume, other drums are non-beaded. Body and bottom-end are seamed by 5-layered seaming technique (double seam) and seaming compound is applied to the seaming line prior to seaming operation. Top end is fixed to the drum by a closing ring with an elastic washer in between.

Steel : Cold Rolled Steel (EN 10130 and EN 10131)

Ring : Manufactured of Hot Dipped Galvanized Steel, sealable closing ring with lever.

External Paint : Exterior of the drum is finished with oven-drying enamel as per customer preference.

Dry film thickness for body : 18 microns min.

Dry film thickness for ends : 25 microns min.

Gloss for paint : 60 Gloss min. (with 60° Glossmeter)

Interior Coating (Optional) : Interior of the drum is lined with with foodgrade epoxy phenolic lacquer.

Dry film thickness : 7 microns min.

Marking : Production date and manufacturer name are coded on the lower side of the body with ink-jet system. Any other coding can be made with silk-screening system on the body or top-end of the drum.



İZVAR AMBALAJ SANAYİ VE TİCARET A.Ş.
Merkez : Acarlar İş Merkezi F-Blok K3 No 10 Kavacık 34805, Beykoz İstanbul
Tel: ++ 90 216 6802080 Faks: ++ 90 216 6802090
Fabrika : Tavşantepe Sk. No 74 Pelitli 41490, Gebze Kocaeli
Tel: ++ 90 262 7510220 Faks: ++ 90 262 7510221





Tests

: All in process and final product tests are undertaken according to ISO 9001:2000 Quality Management System and test results are informed to the customer by Quality Reports. All the drums are 100% leak tested.



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