



**TECHNICAL SPECIFICATION**  
**CONICAL INTERMEDIATE STEEL DRUM**

Nom. Dia.	Volume	Body		Ends		Weight	UN Approval (Optional)
		Thickness	Tolerance	Thickness	Tolerance		
Ø360	20 Lt.	0.60mm	±0.05mm	0.60mm	±0.05mm	2.8 Kg.	1A2/Y1.4/100 1A2/X35/S
Ø360	25 Lt.	0.60mm	±0.05mm	0.60mm	±0.05mm	3.1 Kg.	1A2/Y1.4/100 1A2/X43/S
Ø360	30 Lt.	0.60mm	±0.05mm	0.60mm	±0.05mm	3.4 Kg.	1A2/Y1.4/100 1A2/X51/S
Ø360	40 Lt.	0.60mm	±0.05mm	0.60mm	±0.05mm	3.8 Kg.	1A2/Y1.4/100 1A2/X67/S
Ø360	60 Lt.	0.60mm	±0.05mm	0.60mm	±0.05mm	5.1 Kg.	1A2/Y1.4/100 1A2/X100/S
Ø360	67 Lt.	0.60mm	±0.05mm	0.60mm	±0.05mm	5.5 Kg.	--
Ø400	67 Lt.	0.60mm	±0.05mm	0.60mm	±0.05mm	5.5 Kg.	--

**DIMENSIONS** : See the technical drawing.

**Material and Production Specifications:**

Body is electrically seam welded. One bead is formed on the body of drums. 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)

**Closures** : 2" and ¾" closures and cap-seals. (TS EN ISO 15750-3)

**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.

**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.

**İZVAR AMBALAJ SANAYİ VE TİCARET A.Ş.**

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