



**TECHNICAL SPECIFICATION
CONICAL STEEL DRUM**

Volume	Body		Ends		Weight	UN Approval
	Thickness	Tolerance	Thickness	Tolerance		
194 Lt.	0.60 mm.	± 0.05 mm.	0.60 mm.	± 0.05 mm.	10.2 Kg.	--
194 Lt.	0.70 mm.	± 0.06 mm.	0.60 mm.	± 0.05 mm.	11.4 Kg.	--
194 Lt.	0.80 mm.	± 0.06 mm.	0.70 mm.	± 0.06 mm.	13.0 Kg.	--
194 Lt.	0.80 mm.	± 0.06 mm.	0.80 mm.	± 0.06 mm.	14.9 Kg.	1A2/X300/S
194 Lt.	0.90 mm.	± 0.07 mm.	1.00 mm.	± 0.07 mm.	16.6 Kg.	1A2/Y1.2/100 1A2/X320/S
217 Lt.	0.60 mm.	± 0.05 mm.	0.60 mm.	± 0.05 mm.	10.8 Kg.	--
217 Lt.	0.70 mm.	± 0.06 mm.	0.60 mm.	± 0.05 mm.	12.0 Kg.	--
217 Lt.	0.80 mm.	± 0.06 mm.	0.80 mm.	± 0.06 mm.	15.8 Kg.	1A2/X300/S
217 Lt.	0.90 mm.	± 0.07 mm.	1.00 mm.	± 0.07 mm.	17.6 Kg.	1A2/Y1.2/100 1A2/X320/S
230 Lt.	0.70 mm.	± 0.06 mm.	0.60 mm.	± 0.05 mm.	12.4 Kg.	--

DIMENSIONS : See the technical drawing.

Material and Production Specifications:

Body is electrically seam welded and conically shaped by expansion. One bead is formed on the upper part of the body. Body and bottom-end are seamed by 5-layered seaming technique (double seam). 30 vacuum holes of ø3mm can be opened on the bottom-end on request. Top end is fixed to the drum by a closing ring.

- Body** : Cold Rolled Steel (EN 10130 and EN 10131)
- Ends** : Cold Rolled Steel (EN 10130 and EN 10131) or Hot Dip Galvanized Steel (EN 10142 and EN 10143)
- 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.
- 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.



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