



## TECHNICAL SPECIFICATION OPEN-TOP STEEL DRUM

**STANDARDS** : TS EN ISO 15750-1

**DIMENSIONS** : See the technical drawing.

Volume	Body		Ends		Weight	UN Approval (Optional)
	Thickness	Tolerance	Thickness	Tolerance		
216.5 Lt.	0.70 mm.	± 0.06 mm.	0.80 mm.	± 0.07 mm.	13.9 Kg.	--
216.5 Lt.	0.70 mm.	± 0.06 mm.	0.90 mm.	± 0.08 mm.	14.4 Kg.	--
216.5 Lt.	0.70 mm.	± 0.06 mm.	1.00 mm.	± 0.08 mm.	15.0 Kg.	--
216.5 Lt.	0.80 mm.	± 0.06 mm.	0.80 mm.	± 0.07 mm.	15.2 Kg.	1A2/Y1.2/120 1A2/X300/S
216.5 Lt.	0.80 mm.	± 0.06 mm.	0.90 mm.	± 0.08 mm.	15.7 Kg.	1A2/X300/S
216.5 Lt.	0.80 mm.	± 0.06 mm.	1.00 mm.	± 0.08 mm.	16.2 Kg.	1A2/Y1.2/120 1A2/X300/S
216.5 Lt.	0.90 mm.	± 0.07 mm.	0.90 mm.	± 0.08 mm.	17.0 Kg.	1A2/Y1.4/120
216.5 Lt.	0.90 mm.	± 0.07 mm.	1.00 mm.	± 0.08 mm.	17.5 Kg.	1A2/Y1.5/120
216.5 Lt.	1.00 mm.	± 0.07 mm.	1.00 mm.	± 0.08 mm.	18.8 Kg.	1A2/Y1.5/120
216.5 Lt.	1.00 mm.	± 0.07 mm.	1.20 mm.	± 0.08 mm.	19.9 Kg.	--
216.5 Lt.	1.20 mm.	± 0.08 mm.	1.20 mm.	± 0.08 mm.	22.5 Kg.	--
216.5 Lt.	1.30 mm.	± 0.08 mm.	1.30 mm.	± 0.08 mm.	24.3 Kg.	--

### Material and Production Specifications:

Body is electrically seam welded. Two beads are formed on the body. Body and bottom-end are seamed by 7-layered seaming technique (triple 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.

Corrugations are formed between the beads and the ends for extra resistance at the corrugated types.

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

**Ring** : Manufactured of Hot Dipped Galvanized Steel, sealable closing ring with lever. (Closing ring with nut and bolts may be as optional)

**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 9001:2015 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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