



TECHNICAL SPECIFICATION
OPEN-TOP INTERMEDIATE STEEL DRUM

Nom. Dia.	Volume	Body		Ends		Weight	UN Approval
		Thickness	Tolerance	Thickness	Tolerance		
Ø280	18 Lt.	0.60mm	±0.05mm	0.60mm	±0.05mm	2.7 Kg.	--
Ø280	20 Lt.	0.60mm	±0.05mm	0.60mm	±0.05mm	2.9 Kg.	--
Ø280	22 Lt.	0.60mm	±0.05mm	0.60mm	±0.05mm	3.0 Kg.	--
Ø280	25 Lt.	0.60mm	±0.05mm	0.60mm	±0.05mm	3.2 Kg.	--
Ø280	30 Lt.	0.60mm	±0.05mm	0.60mm	±0.05mm	3.6 Kg.	1A2/X50/S
Ø360	30 Lt.	0.60mm	±0.05mm	0.70mm	±0.05mm	3.8 Kg.	1A2/X50/S
Ø360	40 Lt.	0.60mm	±0.05mm	0.70mm	±0.05mm	4.4 Kg.	--
Ø360	50 Lt.	0.60mm	±0.05mm	0.70mm	±0.05mm	4.7 Kg.	--
Ø360	60 Lt.	0.60mm	±0.05mm	0.70mm	±0.05mm	5.5 Kg.	1A2/X100/S
Ø360	62 Lt.	0.60mm	±0.05mm	0.70mm	±0.05mm	5.6 Kg.	--
Ø360	64 Lt.	0.60mm	±0.05mm	0.70mm	±0.05mm	5.7 Kg.	--
Ø400	60 Lt.	0.60mm	±0.05mm	0.60mm	±0.05mm	5.5 Kg.	1A2/X100/S

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)

Closures : 2" and ¾" closures and cap-seals. (EN 12928)

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.

Merkez : Acarlar İş Merkezi F-Blok K3 No10 Kavacık 34805 Beykoz İstanbul

Tel: ++ 90 216 6802080 Faks: ++ 90 216 6802090

Fabrika : Pelitli, 41490, Gebze Kocaeli

Tel: ++ 90 262 7510220 Faks: ++ 90 262 7510221

www.izvar.com





**TECHNICAL SPECIFICATION
CONICAL INTERMEDIATE STEEL DRUM**

Nom. Dia.	Volume	Body		Ends		Weight	UN Approval
		Thickness	Tolerance	Thickness	Tolerance		
Ø360	20 Lt.	0.60mm	±0.05mm	0.60mm	±0.05mm	2.8 Kg.	1A2/X40/S
Ø360	30 Lt.	0.60mm	±0.05mm	0.60mm	±0.05mm	3.4 Kg.	1A2/X50/S
Ø360	40 Lt.	0.60mm	±0.05mm	0.60mm	±0.05mm	3.8 Kg.	1A2/X60/S
Ø360	60 Lt.	0.60mm	±0.05mm	0.60mm	±0.05mm	5.1 Kg.	1A2/X90/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. (EN 12928)

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.

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