



TECHNICAL SPECIFICATION OPEN-TOP STEEL DRUM

STANDARDS : TS 10789 EN 209

DIMENSIONS : See the technical drawing.

Volume	Body		Ends		Weight	UN Approval
	Thickness	Tolerance	Thickness	Tolerance		
213 Lt.	0.70 mm.	± 0.06 mm.	0.80 mm.	0.07 mm.	13.9 Kg.	1A2/X/300/S
213 Lt.	0.70 mm.	± 0.06 mm.	0.90 mm.	0.08 mm.	14.4 Kg.	--
213 Lt.	0.70 mm.	± 0.06 mm.	1.00 mm.	0.08 mm.	15.0 Kg.	--
213 Lt.	0.80 mm.	± 0.06 mm.	0.80 mm.	0.07 mm.	15.2 Kg.	--
213 Lt.	0.80 mm.	± 0.06 mm.	0.90 mm.	0.08 mm.	15.7 Kg.	--
213 Lt.	0.80 mm.	± 0.06 mm.	1.00 mm.	0.08 mm.	16.2 Kg.	1A2/X/250/S
213 Lt.	0.90 mm.	± 0.07 mm.	0.90 mm.	0.08 mm.	17.0 Kg.	1A2/X/300/S
213 Lt.	0.90 mm.	± 0.07 mm.	1.00 mm.	0.08 mm.	17.5 Kg.	1A2/X/300/S
213 Lt.	1.00 mm.	± 0.07 mm.	1.00 mm.	0.08 mm.	18.8 Kg.	1A2/X/250/S
213 Lt.	1.00 mm.	± 0.07 mm.	1.20 mm.	0.08 mm.	19.9 Kg.	--
213 Lt.	1.20 mm.	± 0.08 mm.	1.20 mm.	0.08 mm.	22.5 Kg.	--
213 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 Cold Rolled Steel, sealable, electro-galvanized 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 9001:2000 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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