



TECHNICAL SPECIFICATION
TIGHT-HEAD INTERMEDIATE STEEL DRUM

Nom. Dia.	Volume	Body		Ends		Weight	UN Approval
		Thickness	Toletance	Thickness	Toletance		
Ø170	4 Lt.	0.50mm	±0.05mm	0.50mm	±0.05mm	0.95 Kg	1A1/X1.0/250
Ø280	15 Lt.	0.60mm	±0.05mm	0.60mm	±0.05mm	2.5 Kg.	--
Ø280	20 Lt.	0.60mm	±0.05mm	0.60mm	±0.05mm	2.7 Kg.	--
Ø280	25 Lt.	0.60mm	±0.05mm	0.60mm	±0.05mm	3.0 Kg.	--
Ø280	30 Lt.	0.60mm	±0.05mm	0.60mm	±0.05mm	3.4 Kg.	1A1/X1.5/250
Ø360	30 Lt.	0.60mm	±0.05mm	0.70mm	±0.05mm	3.7 Kg.	1A1/X1.5/250
Ø360	40 Lt.	0.60mm	±0.05mm	0.70mm	±0.05mm	4.3 Kg.	--
Ø360	60 Lt.	0.60mm	±0.05mm	0.70mm	±0.05mm	5.3 Kg.	1A1/X1.5/250
Ø400	60 Lt.	0.60mm	±0.05mm	0.70mm	±0.05mm	5.5 Kg.	1A1/X1.5/250

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 ends are seamed by 5-layered seaming technique (double seam) and seaming compound is applied to the seaming line prior to seaming operation.

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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