



TECHNICAL SPECIFICATION
CONICAL STEEL DRUM (WITH PLASTIC TOP-END)

Volume	Body		Bottom-End		Weight
	Thickness	Tolerance	Thickness	Tolerance	
194 Lt.	0.60 mm.	± 0.05 mm.	0.60 mm.	± 0.05 mm.	9.0 Kg.
194 Lt.	0.70 mm.	± 0.06 mm.	0.60 mm.	± 0.05 mm.	10.2 Kg.
194 Lt.	0.80 mm.	± 0.06 mm.	0.70 mm.	± 0.06 mm.	11.6 Kg.
217 Lt.	0.60 mm.	± 0.05 mm.	0.60 mm.	± 0.05 mm.	9.5 Kg.
217 Lt.	0.70 mm.	± 0.06 mm.	0.60 mm.	± 0.05 mm.	10.7 Kg.
217 Lt.	0.80 mm.	± 0.06 mm.	0.80 mm.	± 0.06 mm.	13.3 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 $\varnothing 3$ mm can be opened on the bottom-end on request.

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

Bottom-End : Cold Rolled Steel (EN 10130 and EN 10131) or Hot Dip Galvanized Steel (EN 10142 and EN 10143)

Top-End : Polypropylene, colored with white masterbatch and UV protective agent added.

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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