



TECHNICAL SPECIFICATION TIGHT-HEAD STEEL DRUM

STANDARDS : TS 11168 EN 210

DIMENSIONS : See the technical drawing.

Volume	Body		Ends		Weight	UN Approval
	Thickness	Tolerance	Thickness	Tolerance		
216.5 Lt.	0.70 mm.	± 0.06 mm.	0.80 mm.	0.07 mm.	13.4 Kg.	1A1/X1.5/250
216.5 Lt.	0.70 mm.	± 0.06 mm.	0.90 mm.	0.08 mm.	13.9 Kg.	1A1/X1.5/250
216.5 Lt.	0.70 mm.	± 0.06 mm.	1.00 mm.	0.08 mm.	14.4 Kg.	--
216.5 Lt.	0.80 mm.	± 0.06 mm.	0.80 mm.	0.07 mm.	14.7 Kg.	1A1/X1.5/250
216.5 Lt.	0.80 mm.	± 0.06 mm.	0.90 mm.	0.08 mm.	15.2 Kg.	1A1/X1.5/250
216.5 Lt.	0.80 mm.	± 0.06 mm.	1.00 mm.	0.08 mm.	15.7 Kg.	1A1/X1.5/250
216.5 Lt.	0.90 mm.	± 0.07 mm.	0.90 mm.	0.08 mm.	16.5 Kg.	1A1/X1.5/250
216.5 Lt.	0.90 mm.	± 0.07 mm.	1.00 mm.	0.08 mm.	17.0 Kg.	1A1/X1.5/250
216.5 Lt.	1.00 mm.	± 0.07 mm.	1.00 mm.	0.08 mm.	18.3 Kg.	1A1/X1.5/250
216.5 Lt.	1.00 mm.	± 0.07 mm.	1.20 mm.	0.08 mm.	19.4 Kg.	1A1/X1.5/250
216.5 Lt.	1.20 mm.	± 0.08 mm.	1.20 mm.	0.08 mm.	21.9 Kg.	1A1/X1.5/250
216.5 Lt.	1.30 mm.	± 0.08 mm.	1.30 mm.	0.08 mm.	23.8 Kg.	1A1/X1.5/250

Material and Production Specifications:

Body is electrically seam welded. Two beads are formed on the body. Body and ends are seamed by 7-layered seaming technique (triple seam) and seaming compound is applied to the seaming line prior to seaming operation.

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)

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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