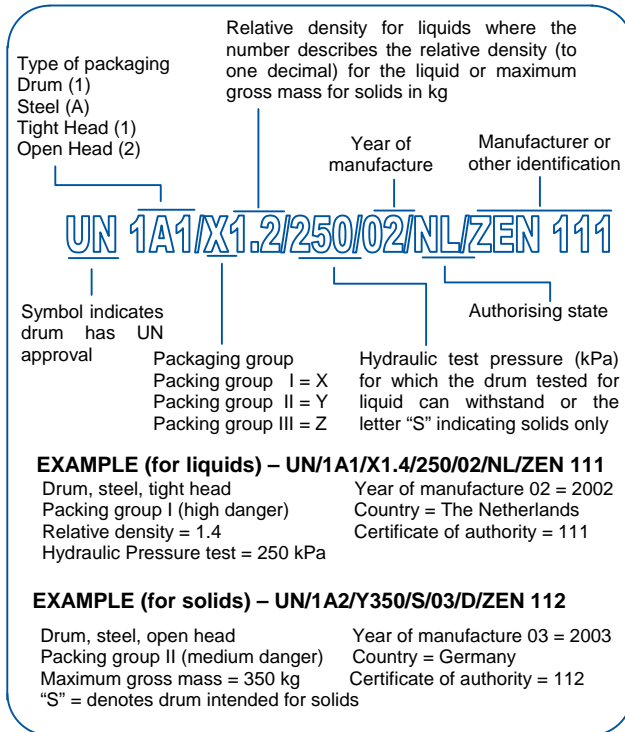


## UN Marking of large TH steel drums

For the transport of dangerous goods				
Gauge Combinations (mm)			UN Mark	UN Mark
Top	Body	Bottom	Recommendation	Special
1.5	1.5	1.5	X 1.2/250	X 2.0/400
1.5	1.2	1.5	X 1.2/250	X 2.0/400
1.2	1.2	1.2	X 1.2/250	X 1.8/300
1.2	1.1	1.2	X 1.2/250	X 1.8/300
1.2	1.0	1.2	X 1.2/250	X 1.8/300
1.0	1.0	1.0	X 1.2/250	N/A
1.0	0.9	1.0	X 1.2/250	N/A
1.0	0.8	1.0	X 1.2/250	N/A
0.8	0.8	0.8	Y 1.4/150	N/A
0.8	0.7	0.8	Y 1.4/150	N/A

These UN marking are now also an ICDM recommendation

UN marking ref: UN "Orange Book" Part 6.1



# SEFA

*Large steel drums are dimensionally defined by ISO & EN standards*

*SEFA in close cooperation with ICDM – harmonise and standardise the additional aspects of drum making*

*All approved recommendations can be found on the SEFA website*



[www.sefa.be](http://www.sefa.be)

*ICDM recommendations can be found on the ICDM website*



[www.icdm.org](http://www.icdm.org)

# SEFA

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# SEFA

## SEFA TECHNICAL RECOMMENDATIONS FOR STEEL DRUMS

International standard for  
 steel drums are:  
 ISO 15750  
 EN209 & EN210

SEFA  
 Tel: +33 (0)490 965 853 (France)

European Association of Steel Drum Manufacturers  
 Syndicat Européen De L'Industrie Des Fûts En Acier  
 Verband Der Europäischen Stahlfassindustrie

## Cold rolled steel specification for drums

The reference international standard for steel specification are: **ISO 3574 & ISO 16162**

### Additional specification

Aspect of steel for drums have been developed by SEFA in co-operation with its suppliers members from the European Steel Industry and can be found on the SEFA website



[www.sefa.be](http://www.sefa.be)

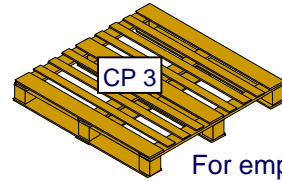
## Palletising

SEFA has adopted the VCI (German Chemical Industry) standards for the palletisation of empty/filled steel drums.

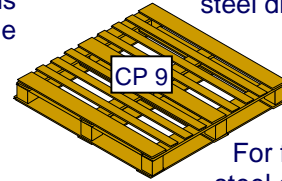
Detail of configurations can be found on the SEFA website



[www.vci.de](http://www.vci.de)



For empty steel drums



For filled steel drums

## External RAL paint colours

ICDM including SEFA, SSCI, AOSD have developed a worldwide fully compliant standard for external drum paints


### Why was the RAL standard chosen?


The RAL (European Colour Standard) is the most widely accepted international colour system and is suitable for printing of drums (the alternative Pantone® system is only suitable for printing on paper)

### SEFA Colour Booklet

A fully up to date colour booklet is available from any drum-making member of SEFA



 <p><b>ICDM/SEFA</b> Preferred RAL Colours</p>	1002	5015	7037
	3011	5017	7038
	3013	6005	9003
	5010	6010	9005
	5013	7035	

 <p><b>SEFA</b> Additional RAL Colours</p>	3009	6029	9010
	3020	7001	9006
	5002	8004	
	5012	9002	

*DISCLAIMER: Please note that the colours shown on this page offer only an approximation of their actual real-life counterparts.*



[www.icdm.org](http://www.icdm.org)



[www.ral.de](http://www.ral.de)

## Internal cleanliness of steel drums

This is a very important issue for drum users in certain critical industries.

These two methods are recommended by SEFA and ICDM:

- Laboratory test
- Factory production test

### Laboratory test

ICDM (SEFA, SSCI, AOSD) has adopted the NAS 1638 (National Aerospace Standard) cleanliness test method as their measure for the cleanliness of steel drums. According to this standard a fluid cleanliness is measured by weighing and particulate counting. Plain drums typically comply with NAS class 5, weight class 100 of this standard. Internally coated drums comply typically with NAS class 3, weight class 100.

This method is complicated and time consuming, a simpler Factory Production Test is available and suitable for most of the drum applications

### Factory production test

This method involves using a vacuum cleaner with a well-defined filter fitted in order to compare visually against a white filter reference and evaluate dirt in the drum.

Contamination weight is given by the filter weight increase after the test

Details of test methods can be found on the SEFA and ICDM websites



[www.sefa.be](http://www.sefa.be)



[www.icdm.org](http://www.icdm.org)

