



**INTERNATIONAL CONFEDERATION
OF DRUM MANUFACTURERS**

Secretariat: S E F A

Members

A O S D

Asia Oceanic Drum Association
Tekko Kalkan Bldg., 2-10
3-Chome, Kayabacho
Nihonbashi, Chuo-ku
Tokyo, 103, Japan
Tel: ++81 3 36 69 51 41
Fax: ++81 3 36 69 29 69
EMAIL: drum.pail@jsda.gr.jp
www.jsda.gr.jp

S E F A

Syndicat Europeen de l'industrie des
Fûts en Acier
c/o Agoria
Diamant Building, Bld. A. Reyers 80
1030 BRUXELLES
Tel: ++32 (0) 484 437 660
EMAIL: sefa.be@telenet.be
www.sefa.be
www.icdm.org

S S C I

Steel Shipping Container Institute
1101 14th Street, NW Suite 1001
Washington, DC20005 U.S.A.
Tel: +1 202 408 1900
Fax: +1 202 408 1972
EMAIL: ssci@SteelContainers.com
www.steelcontainers.com

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ICDM RECOMMENDATION

LABORATORY METHOD FOR MEASURING THE INTERNAL CLEANLINESS OF STEEL DRUMS

**This document supersedes the SEFA Recommendation
(reference: SEFA R05:012002)**

The object of this recommendation is to define monitoring techniques together with the minimum values guaranteed by our profession.

1. Drums concerned

Metallic drums with a capacity equal or above 200 liters having seamed top and bottom.

Open top drums as well as small and medium drums are not included in this recommendation and may be added later on.

2. Reference international specification

- NAS 1638 (National Aerospace Standards)

3. Monitoring techniques

- 3.1) Use of a drum taken during the production (batch/run) after plug screwing or when delivered at customer's facilities with only one plug handling. (The plug will be removed for the test and screwed in, in a clean environment).
- 3.2) Use of 5 litres of solvent (Isopropanol or toluene).
- 3.3) Pre-filtering of the solvent through a filter of 0.8 -1µm before putting it in the drum and use of a container perfectly clean so as to contain the filtered solvent. Cleanliness of the solvent is then measured and can be deducted from final result On voluntary basis one may state this blanc result in the measurement record.
- 3.4) Solvent is poured into this drum without adding pollution.
- 3.5) Washing of all parts (top, bottom, body) by rotation and sloping.
 - (1) Bottom washing: swilling out the bottom by rotating the drum placed lengthwise manually with its bottom downward.
 - (2) Body washing: swilling out the body by rolling the drum placed sideways or by rotating using a rotating machine.
 - (3) Top washing: swilling out the bottom by rotating the drum placed lengthwise manually with its bottom downward.
 - (4) Body washing: swilling out the body by rolling the drum placed sideways or by rotating using a rotating machine.
- 3.6) Recovery of the solvent by use of a pumping process perfectly clean and suitable to extract properly more than 95% of the solvent and the particles.
- 3.7) Numbering of particles found in 100 ml solvent after a single washing. Depending of the equipment it may be necessary to repeat the measurement so as to make sure the result is representative.
To get the contamination in the drum, the counting result should be multiplied by 50.
- 3.8) Filtration of the 5 litres of solvent via a membrane filter with 1 µm absolute pore size.
- 3.9) Weighing of the dry residues.
 - Fix film filter with up to 0.1mg weighing capacity and to filtrate test solution.
 - After filtrating test solution, swill out the inner wall of the funnel using a washing bottle with a small quantity of cleaning solution.
 - Suction by using a vacuum pump until the liquid on the filter is completely suctioned. (In this case, if suction power is too strong, liquid enters into vacuum pump. So vacuum is to be adjusted properly.)
 - Stop the vacuum pump, to take out the filter with tweezers and place it in a clean plate or in aluminum foiled tray.

- Dry the filter which gathers inclusion together with the plate or aluminum foiled tray in a suitable means.
- Weigh up to 0.1mg accuracy the filter using a precision balance.

4. Guaranteed limits

4.1) Drums concerned

98 % of the drums delivered among the family defined in paragraph 1.

4.2) Uncoated drums

- Particles – NAS class 5

i.e. :	Particles sizes in μm	Contamination of 200 l of liquid in a drum Particles per 100 ml
	5 à 15 μ	8 000
	15 à 25 μ	1 425
	25 à 50 μ	253
	50 à 100 μ	45
	> 100 μ	8

- Weight – NAS class 100
i.e. 0,02 mg for 100 ml of containing, which means a maximum of 40 mg for a 200 litres drum.

4.3) Internal Coated drums

- Particles – NAS class 3

i.e. :	Particles sizes en μm	Contamination of 200 l of liquid in a drum Particles per 100 ml
	5 à 15 μ	2 000
	15 à 25 μ	356
	25 à 50 μ	63
	50 à 100 μ	11
	> 100 μ	2

- Weight – NAS class 100
i.e. 0,02 mg for 100 ml of containing, which means a maximum of 40 mg for a 200 litres drum.

Remark : A drum is not free of particles after one washing in practice the situation might be less favourable.

5. Application date

SUPPLIER		DRUM INTERNAL CLEANLINESS	
CUSTOMER :		Controlled by :	
		Date :	
Product code :		Production date :	
Tracability :		Factory :	
		Production line :	
RESULTS OF MEASUREMENT			
<u>PARTICLES</u>			
Size	Number of particles in the drum (A) (Calculated result III 7)	Contamination of 200 l of liquid in a drum Particles per 100 ml (A/2000)	NAS Class
5 – 15 μ			
15 – 25 μ			
25 – 50 μ			
50 – 100 μ			
> 100 μ			

	Global NAS class :	
	Weight of particles : mg (result III 9) Weight per 100 ml (: 2000) : mg Class NAS : 100	
Test result according to ICDM Recommendation		