

भारतीय मानक
डामर ड्रम — विशिष्ट
(तीसरा पुनरीक्षण)

Indian Standard
BITUMEN DRUMS — SPECIFICATION
(*Third Revision*)

UDC 621·798·144 (669·141·24) : 665·775

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BUREAU OF INDIAN STANDARDS
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FOREWORD

This Indian Standard (Third Revision) was adopted by the Bureau of Indian Standards, after the draft finalized by the Metal Containers Sectional Committee, had been approved by the Metallurgical Engineering Division Council.

This standard was first published in 1977 and then revised in 1989. In the present revision of this standard, the following major change has been incorporated:

Dimensions of drums and closures have been modified in line with the present manufacturing practices in the country.

For the purpose of deciding whether a particular requirement of this standard is complied with, the final value, observed or calculated, expressing the result of a test or analysis, shall be rounded off in accordance with IS 2 : 1960 ' Rules for rounding off numerical values (*revised*) '. The number of significant places retained in the rounded off value should be the same as that of the specified value in this standard.

Indian Standard

BITUMEN DRUMS — SPECIFICATION

(Third Revision)

1 SCOPE

This standard covers the requirements of steel drums, with fixed ends of nominal capacities 160 litres and 200 litres, used for packing of bitumen having penetration value 225 and below.

2 REFERENCES

The following Indian Standards are necessary adjuncts to this standard:

IS No.	Title
513 : 1994	Cold rolled low carbon steel sheets and strips (<i>fourth revision</i>)
1079 : 1994	Hot rolled carbon steel sheets strip (<i>fifth revision</i>)
1394 : 1984	Glossary of terms relating to metal containers (<i>third revision</i>)
1993 : 1993	Cold reduced tinplates and blackplates (<i>first revision</i>)
2471 : 1963	Methods of test for metal containers
3259 : 1966	Methods of sampling of metal containers

3 TERMINOLOGY

For the purpose of this standard, the definitions given in IS 1394 : 1984 shall apply.

4 DIMENSIONS

4.1 Drums

The drums shall be manufactured in two sizes conforming to the dimensions shown in Fig. 1.

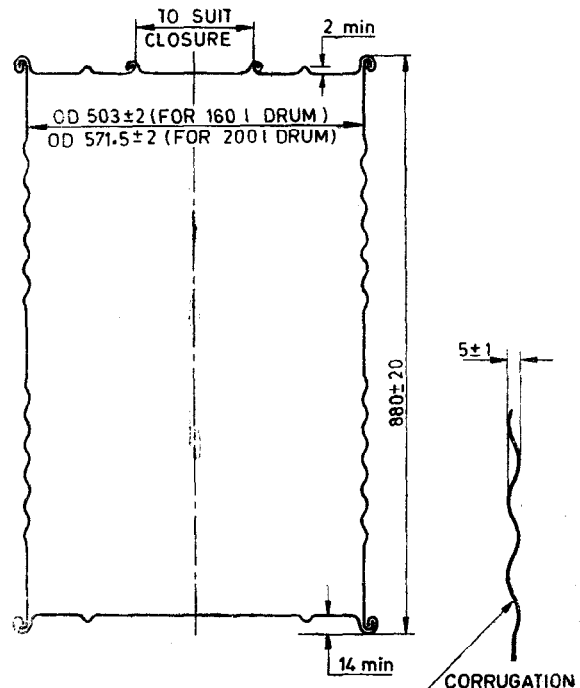
4.2 Closure

The closure shall have dimensions as shown in Fig. 2.

5 MATERIAL

5.1 Body and Ends

The body and ends of the drums shall be made from steel sheets of nominal thickness 0.63 mm conforming to IS 513 : 1994 or IS 1079 : 1994.



All dimensions in millimetres.

FIG. 1 DIMENSIONS FOR BITUMEN DRUM

5.2 Closures

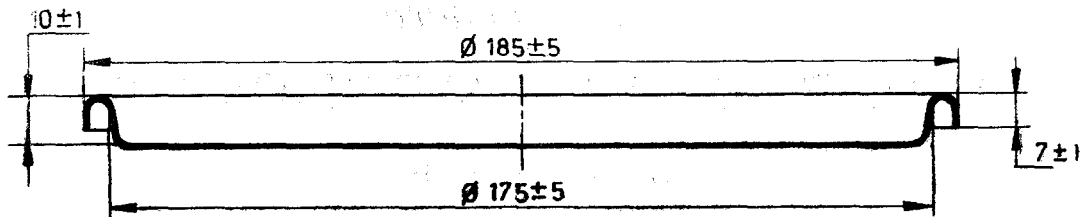
The closures shall be made from steel sheets of nominal thickness 0.30 mm conforming to IS 513 : 1994 or tinplate conforming to IS 1993 : 1993 for crimping.

6 CONSTRUCTION

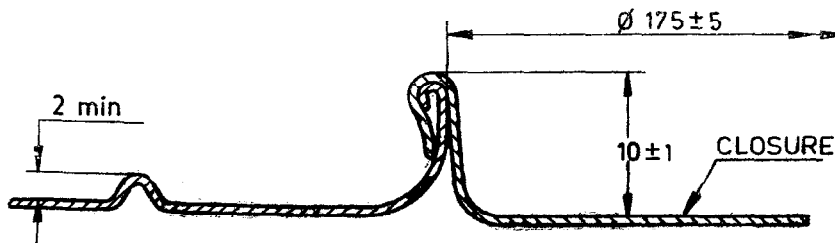
6.1 The sheets after blanking, or trimming, or both shall be free from cracks, dents, pittings, rush and other defects.

6.2 The body side seam shall be continuously resistance welded. The top and bottom end seams shall be double seamed with five fold chimes or spiral seams. A suitable sealing compound may be used.

6.3 The body shall be strengthened by 12 corrugations which shall be symmetrical to the centre line as shown in Fig. 1. The depth of corrugation shall be measured from the top of their crest to the root of their trough.



CLOSURE



ASSEMBLY

All dimensions in millimetres.

FIG. 2 CLOSURE AT CENTRE

6.4 The bottom and top ends may have strengthening corrugations.

6.5 Closure

The drums shall be provided with an aperture at the centre to suit the closure. Closure shall be crimped on to the central aperture of the drums by the purchaser. The assembly details for closure are shown in Fig. 2. The closure diameter shall be so as to fit on the drum aperture in snug fitting position. Closure may be supplied with the drum, as specified by the purchaser.

7 FINISH

7.1 The drums shall be new, thoroughly clean and free from rust, loose scales, moisture and other foreign matter.

7.2 The outside surface of the drums may be painted or left unpainted as agreed to between the purchaser and the supplier.

8 AIR PRESSURE TEST

8.1 Each drum shall be subjected to the air pressure test according to the provisions of IS 2471 : 1963. The drum shall not show any sign of leakage when subjected to an internal air pressure of 20 kPa (0.2 kgf/cm²) for a minimum period of 5 seconds.

8.2 If there is a minor leakage found during leakage test it may be manually welded and the drum shall be retested for leakage test. If the leakage is found again, the drum shall be rejected.

9 SAMPLING

Representative samples of the drums for tests regarding dimension, capacity, construction, finish shall be drawn according to the provisions of IS 3259 : 1966.

10 MARKING

10.1 The drums shall be marked indelibly with the following particulars:

- Indicating the source of the manufacturer,
- Year of manufacture, and
- Any other marking as agreed to between the purchaser and the supplier.

10.1.1 The marking may be done by embossing on the drum ends or closure or by lithography on the closures or by painting on the drum or by any other agreed method.

11 STANDARD MARK

The drums may also be marked with the Standard Mark.

Standard Mark

The use of the Standard Mark is governed by the provisions of the *Bureau of Indian Standards Act, 1986* and the Rules and Regulations made thereunder. The Standard Mark on products covered by an Indian Standard conveys the assurance that they have been produced to comply with the requirements of that standard under a well defined system of inspection, testing and quality control which is devised and supervised by BIS and operated by the producer. Standard marked products are also continuously checked by BIS for conformity to that standard as a further safeguard. Details of conditions under which a licence for the use of the Standard Mark may be granted to manufacturers or producers may be obtained from the Bureau of Indian Standards.

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Amendments Issued Since Publication

Amend No.	Date of Issue	Text Affected

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AMENDMENT NO. 1 APRIL 1994
TO
IS 3575 : 1993 BITUMEN DRUMS — SPECIFICATION
(Third Revision)

(*Page 1, clause 2*) — Substitute: 'IS 513 : 1986 Cold rolled low carbon steel sheets and strips (*third revision*)' for 'IS 513 : 1994 Cold rolled low carbon steel sheets and strips (*fourth revision*)' and 'IS 1079 : 1988 Hot rolled carbon steel sheet and strip (*fourth revision*)' for 'IS 1079 : 1994 Hot rolled carbon steel sheets and strip (*fifth revision*)'.

(*Page 1, clauses 5.1 and 5.2*) — Substitute 'IS 513 : 1986' for 'IS 513 : 1994' and 'IS 1079 : 1988' for 'IS 1079 : 1994'.

(MTD 32)

Reprography Unit, BIS, New Delhi, India

AMENDMENT NO. 2 SEPTEMBER 1995
TO
IS 3575 : 1993 BITUMEN DRUMS — SPECIFICATION
(Third Revision)

(Page 2, clause 6.5, last sentence) — Delete.

(Amendment No. 1, April 1994) — Withdrawn.

(MTD 32)

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