

Drumstock® prepainted steel

Designed for: Drumstock

Revision 10, Mar 2013. This literature supersedes all previous issues.

GENERAL DESCRIPTION

Drumstock® prepainted steel, designed by BlueScope Steel Limited specifically for the manufacture of drumstock suitable for storing chemically active materials. The product exhibits good formability and combines a chemically resistant drum liner with a weather resistant drum outer coating.

TYPICAL USES

Drums for transportation and storage of products such as fruit pulps, dairy products, and detergents. For material selection advice, please contact your nearest BlueScope Steel Sales office.

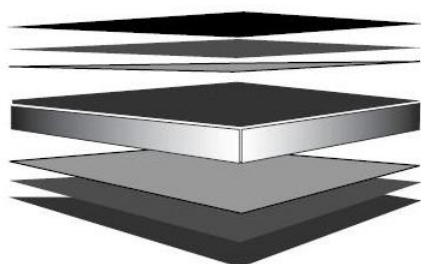
AUSTRALIAN STANDARDS

Substrate - AS/NZS 1595

PREFERRED SUBSTRATES

CA45S-E {Refer Note 5}

Please refer to current price list or BlueScope Steel Limited State Sales Office for availability of colours and dimensions.



← Top coat for drum liner (Mobiliner 40 Red, Nom 15µm) {Refer Notes 1 & 2}
 ← Conversion Coating

← Steel Substrate

← Conversion coating

← Universal Corrosion Inhibitive Primer (For coloured reverse coats only)

← Reverse Coat for drum outer (Pearl White + Primer = Nom 18µm; or Primer Only, Nom 7µm) {Refer Notes 1, 3, 4, & 8}

PRODUCT ATTRIBUTES

Property	Test & Evaluation Method(s)	Results
Flexibility (Coloured reverse coat)		
T-bend	ASTM D4145-83	Maximum 8T (no cracking drum outer and inner linings). Refer Note 5.
Resistance to abrasion (Coloured reverse coat)		
Taber Abraser - 1000g CS-10 wheels	AS/NZS 1580.403.2; NCCA Tech. Bull. 4.3.2 (test & eval)	≤20mg per 100 cycles
Scratch	AS 2331.4.7 (test & eval)	Typically 2000g
Resistance to solvents (Coloured reverse coat)		
Exposure	ASTM D1308 (3.1.1) & ASTM D2244 (Colour); AS/NZS 1580.481.1.9 (Blisters)	No discolouration or blistering. Refer Notes 6 & 7.
Resistance to acids (Coloured reverse coat)		
Exposure	ASTM D1308 (3.1.1) & ASTM D2244 (Colour); AS/NZS 1580.481.1.9 (Blisters)	No discolouration or blistering. Refer Note 7.
Resistance to alkalis (Coloured reverse coat)		
Exposure	ASTM D1308 (3.1.1) & ASTM D2244 (Colour); AS/NZS 1580.481.1.9 (Blisters)	No discolouration or blistering. Refer Note 7

Drumstock® prepainted steel

Continued

Designed for: Drumstock

Revision 10, Mar 2013. This literature supersedes all previous issues.

ATTRIBUTES TESTED DURING MANUFACTURE

Property	Test & Evaluation Method(s)	Results
Adhesion		
Reverse Impact	AS/NZS 2728 (App. E); NCCA Tech. Bull. 4.2.6 (test & eval)	≥10 joules (drum outer and inner lining)
T-bend	AS/NZS 2728 (App. F); NCCA Tech. Bull. 4.2.8 (test & eval)	Maximum 6T (drum outer and inner lining). Refer Note 5
Hardness		
Pencil	AS/NZS 1580.405.1; NCCA Tech. Bull. 4.2.5 (test & eval)	HB or harder (drum outer)
Specular gloss		
60° meter	AS/NZS 1580.602.2; ASTM D523 (test & eval)	≥70 units
Degree of cure		
MEK Double Rubs	NCCA Tech. Bull. 4.2.11	30 Double Rubs minimum (topcoated exterior coating and inner lining)

IMPORTANT NOTES

- 1 Due to the wide range of products packaged, under various but specific conditions, responsibility for pack tests rests with the end user (i.e., the packager). In situations where it is required to overpaint and restore Drumstock® prepainted steel (eg the welded seam side stripe on 200 litre drum bodies), the curing schedule should not exceed 7 minutes at 240 °C. Times and temperatures in excess of these will cause thermal degradation of the coatings.
- 2 The mobiliner 40 red paint system used on the top surface of Drumstock® prepainted steel is approvable under section 175.300 of the US FDA Code of Federal Regulations for use in contact with food. It is the responsibility of the manufacturer to ensure that national and local food standards legislation are taken into account in determining the suitability of BlueScope Steel's Drumstock® prepainted steel for food contact use.
- 3 Reverse Coat - the coating applied to the exposed surface of the prepainted coil which is expected to meet the Performance Requirements.
- 4 The product is supplied with a nominal 80 unit (60°) gloss Reverse Coat.
- 5 The minimum internal bend diameters for forming processes to achieve no paint cracking (visible using x10 magnification) and to avoid paint adhesion issues are specified by the T-Bend flexibility and T-Bend adhesion results respectively - where 1T equals the total coated thickness (tct) in mm of the material. These results are based on testing at 20-25 deg C.
- 6 For most products, the metallurgical ageing process which is inherent in the paint stoving cycle will result in some loss of ductility compared with unpainted product. However, minimum strength levels designated by relevant standards will still be applicable.
- 7 Improper storage or use of non-approved roll-forming lubricants may cause brand transfer and paint blushing, and may adversely affect colour and long term durability. Product in coil or sheet pack form must be kept dry. If the coil or sheet pack becomes wet, it must be separated and dried (refer AS/NZS 2728 Appendix L, and also technical bulletin TB7). Contact your nearest BlueScope Steel Sales office to obtain advice on appropriate rollforming lubricants.
- 8 Where a pretreated only reverse side is ordered, BlueScope Steel Ltd will not accept claims for corrosion arising from recommended storage conditions. This is because the paint line pretreatment system is designed for coil coating where immediate overpainting is mandatory, and is not designed as a passivation system.
- 9 Drumstock® prepainted steel has good resistance to accidental spillage of substances such as paint thinners, cleaning products, mineral acids and alkalis. All spillages however, should be removed as soon as possible in accordance with the advice given in the appropriate safety data sheet

DRUMSTOCK® is a registered trade mark of BlueScope Steel Limited.
BlueScope is a trade mark of BlueScope Steel Limited.

Please ensure you have the current datasheet for this product as displayed at www.bluescopesteel.com

BlueScope Steel Limited

BlueScope Steel Limited ABN 16 000 011 058

BlueScope Steel (AIS) Pty Ltd ABN 19 000 019 625

SYDNEY (02) 9319 9000 MELBOURNE (03) 9586 2222 BRISBANE (07) 3845 9300 ADELAIDE (08) 8243 7333 PERTH (08) 9365 6666

Copyright © 2013 BlueScope Steel Limited

2 of 2

