

**PDS/Drum Part #:**  
**055C400UL1**

**Change  
Controlled  
Process Stamp:**

**Picture(s) of Drum**



**Specific Manufacturing Line:**

**Raw Materials**

**Resin** L99 HMWPE Resin

**Color# (wt%)** L84 (1.0%)

**Specific Resin(s)**

**Color Description**  
Blue

**Embossments**

**Regulatory**

**Custom**

1.  1H1/Y1.9/100/\*\*  
USA/M-4602

2.2mm

2.  1H1/Y1.4/100/\*\*  
USA/M-4602  
WITH VENTED CLOSURE

\*\* Last two digits of  
current year

**Specific Comments**

**Bung Opening 1 = NPS**



L16-WL : 2" NPT Plug & EPDM Gasket

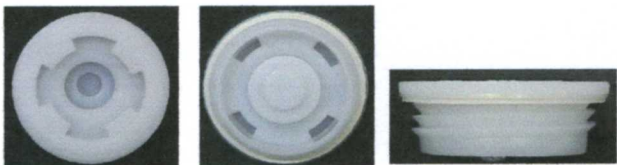
**Capseal 1**

**Weepholes Required?** YES

**Bag Part #:**

**Label Part # (Placement):**

**Bung Opening 2 = Buttress**



L10-WL : 2" Buttress Plug & EPDM Gasket

**Capseal 2**

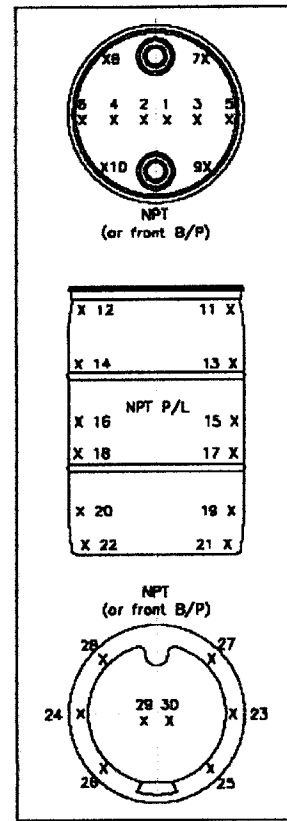
**Stencil # (Placement):**

**Pallet Part #:**

**Pallet Arrangement:** 9+9

**055C400UL1**

<u>Description</u>	<u>UOM</u>	<u>Spec. Min</u>	<u>Spec. Max</u>
<u>Drum Weight</u>	Lbs	20.60	21.60
<u>Drum Height</u>	Inches	34.50	35.00
<u>Drum mid-panel Diameter</u>	Inches	23.00	23.50
<u>Drum Thicknesses</u>			
<u>Points # 1-2</u>	Inches	0.150	0.240
<u>Points # 3-10</u>	Inches	0.150	0.220
<u>Points # 11-22</u>	Inches	0.145	0.185
<u>Points # 23-30</u>	Inches	0.150	0.220
<u>Circum. Dist. Range</u>	Inches	0.000	0.030
<u>Bung Major Dia. (Butrs)</u>	Inches	2.560	2.620
<u>Bung Minor Dia. (NPS)</u>	Inches	2.205	2.265
<u>Bung Ovality (Buttress)</u>	Inches	0.000	0.100
<u>Bung Ovality (NPS)</u>	Inches	0.000	0.100
<u>Dynamic Compression</u>	Lbs	5500	N/A



**All drums 'must' adhere to the following criteria to be determined acceptable:**

- Embossments: Recycle/Month-Year Wheel
- MAUSER ECO-CYCLE is located towards the top of the drum on the sidewall
- The bung housing must be properly formed, smooth, even, and free of burrs
- No excess flash on the bung or top parting line
- No nick marks, uneven surface, or dips in the gasket sealing surface
- Buttress opening to have 1 ½ fully formed threads (540 degrees of thread surface)
- NPS opening to have 3 fully formed threads.
- Defects created from knives, drum handling, or mold will be considered unacceptable
- Water marks from condensation on the mold is acceptable
- Drum sidewalls to be free of carbon and other contamination
- No collapsed sidewalls, sunken tops/bottoms, or rocker bottoms
- Aftercooler rotation sequence (first – last), with correct NPS/Buttress probes
- All drums must pass pressure differential leak detector
- 2 Weep holes. NO drill marks on top of drums.
- Plugs & gaskets must be 100% clean and free of any contamination
- No twisted, discolored, or missing gaskets
- Stack drums 18 to a pallet
- Torque plugs to 20 ft/lbs