



National Standards Authority of Ireland

IRISH STANDARD

**I.S. EN 12711:2000**

ICS 55.140

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**STEEL DRUMS - NON-REMOVABLE HEAD  
(TIGHT HEAD) DRUMS WITH A MINIMUM  
TOTAL CAPACITY OF 230 L**

*This Irish Standard was  
published under the  
authority of the National  
Standards Authority of  
Ireland  
and comes into effect on:  
April 28, 2000*

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EUROPEAN STANDARD  
NORME EUROPÉENNE  
EUROPÄISCHE NORM

**EN 12711**

January 2000

ICS 55.140

English version

**Steel drums - Non-removable head (tight head) drums with a  
minimum total capacity of 230 l**

Fûts en acier - Fûts à ouverture partielle d'une capacité  
totale de 230 l minimum

Stahlfässer - Spundfässer mit einem Gesamtvolumen von  
mindestens 230 l

This European Standard was approved by CEN on 6 November 1999.

CEN members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for giving this European Standard the status of a national standard without any alteration. Up-to-date lists and bibliographical references concerning such national standards may be obtained on application to the Central Secretariat or to any CEN member.

This European Standard exists in three official versions (English, French, German). A version in any other language made by translation under the responsibility of a CEN member into its own language and notified to the Central Secretariat has the same status as the official versions.

CEN members are the national standards bodies of Austria, Belgium, Czech Republic, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and United Kingdom.



EUROPEAN COMMITTEE FOR STANDARDIZATION  
COMITÉ EUROPÉEN DE NORMALISATION  
EUROPÄISCHES KOMITEE FÜR NORMUNG

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## Foreword

This European Standard has been prepared by Technical Committee CEN/TC 261 "Packaging", the secretariat of which is held by AFNOR.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by July 2000, and conflicting national standards shall be withdrawn at the latest by July 2000.

According to the CEN/CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Czech Republic, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and the United Kingdom.

This standard has been drawn up in order to specify a drum type of larger capacity, frequently used in Europe. This standard is one of a series of standards on steel drums of 15 l to 230 l and closures.

Efficient packaging is of great importance for the distribution and the protection of goods. Insufficient or inappropriate packaging can lead to damage or wastage of the contents of the package.

## 1. Scope

This European Standard specifies the characteristics and dimensions of non-removable head (tight head) drums, manufactured from steel sheet, having a minimum total capacity of 230 l.

## 2. Normative references

This European Standard incorporates by dated or undated reference, provisions from other publications. These normative references are cited at the appropriate places in the text and the publications are listed hereafter. For dated references, subsequent amendments to or revisions of any of these publications apply to this European standard only when incorporated in it by amendment or revision. For undated references the latest edition of the publication referred to applies.

EN 10111	Continuously hot-rolled low carbon steel sheet and strip for cold forming - Technical delivery conditions.
EN 10130+A1	Cold rolled low carbon steel flat products for cold forming - Technical delivery conditions.
EN 10131	Cold rolled uncoated low carbon and high yield strength steel flat products for cold forming - Tolerances on dimensions and shape.
prEN 12928:1997	Inserted flange type closure systems for steel drums with a total capacity of 20 l to 230 l.
EN ISO 90-2:1999	Light gauge metal containers - Definitions and determination of dimensions and capacities — Part 2: General use containers (ISO 90-2:1997).
ISO 228-1	Pipe threads where pressure-tight joints are not made on the threads - Part 1 : Dimensions, tolerances and designation.
ISO 668	Series 1 freight containers - Classification, dimensions and ratings.

## 3. Terms and definitions

For the purposes of this standard, the following terms and definitions apply.

### 3.1

#### **non-removable head (tight head) drum (TH)**

cylindrical packaging made of steel, the ends of which are permanently fixed to the body, with openings for filling, emptying and venting in the head

### 3.2

#### **nominal capacity (NC)**

capacity in litres which, by convention, is used to represent a class of drums of similar brimful capacities

### 3.3

#### **brimful capacity (BC)**

volume of water in litres held by the drum when filled through the filling orifice to the point of overflowing

NOTE Annex A specifies the method for measuring brimful capacity.

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