Coated Steel - Prepainted
Data Sheet

September 2021 - This literature supersedes all previous issues

DRUMSTOCK® prepainted steel

General description

DRUMSTOCK® prepainted steel (PKG), designed by BlueScope, specifically for the manufacture of drumstock suitable for storing chemically active materials. The product offers 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 visit steel.com.au or contact Steel Direct.

Australian and International standards

Substrate – AS/NZS 1595:1998 (R2016)
ISO 9001:2015 Quality System certified

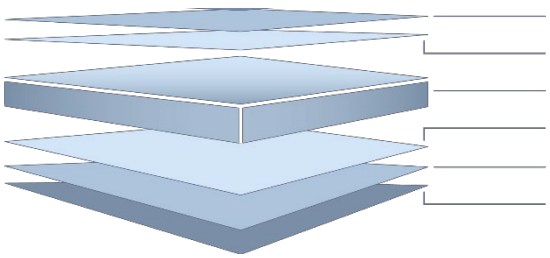
Preferred substrates

CA45S-E {Refer Note 5}.

For substrate properties please refer to the DRUMSTOCK® steel datasheet.

CORSTRIP® film is NOT available for this product.

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



Top coat for drum liner (Mobiliner 40 Red, Nominal 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 = nominal 18µm total; or Primer Only, Nominal 7µm) {Refer Notes 1,3, 4, & 8}

Attributes tested during manufacture

Property	Test & Evaluation Method(s)	Results
Adhesion		
Reverse impact	AS/NZS 2728:2013 (App. E)	≥10 joules (drum outer and inner lining)
T-bend	AS/NZS 2728:2013 (App. F)	Maximum 6T (drum outer and inner lining). Refer Note 5.
Hardness		
Pencil	AS/NZS 1580.405.1:1996 (R2013)	HB or harder (drum outer)
Specular gloss		
60° meter	AS/NZS 1580.602.2:1995 (R2013); ASTM D523-14 (2018)	≥ 70 units
Degree of Cure		
MEK Double Rubs	BlueScope Standard	30 Double Rubs minimum (topcoated exterior coating and inner lining)

Product attributes

Property	Test & Evaluation Method(s)	Results
Flexibility (coloured reverse coat)		
T-bend	ASTM D4145-10 (2018)	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 1580.403.2-2006	≤ 20mg per 100 cycles
Scratch	AS 2331.4.7-2006 (R2017)	Typically 2000g
Resistance to solvents, acids, alkalis (coloured reverse coat)		
Exposure	ASTM D1308-20 (3.1.1) & ASTM D2244-21 (Colour); AS/NZS 1580.481.1.9:1998 (R2013) (Blisters)	No discolouration or blistering. Refer Notes 6 & 7.

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 (PKG) (e.g. the welded seam side stripe on 200l 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. This product is found to be compliant with US FDA 21 CFR 175.300, extracted with n-heptane, 2 h / 150˚F (66˚C). Compliance has also been shown to Food Contact Material regulations from other jurisdictions including EU, Swiss, Chinese, Japanese, and Great Britain. It remains the responsibility of the packaging manufacturer to determine and demonstrate suitability of this product for particular food and package types. Please contact BlueScope for further information.

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°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 2728:2013 Appendix L, and also Technical Bulletin TB7). Contact Steel Direct to obtain advice on appropriate rollforming lubricants.

8. Where a pretreated only reverse side is ordered, BlueScope 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 (PKG) 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.

steel.com.au
To learn more about this product

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