



The drum reconditioning process.

The **Washing Plant** is an indexing walking beam conveyor positioned above three tanks. The first two tanks contain hot caustic soda and sodium metasilicate. The third tank contains hot wash water. The first ten stations allow the contents of the drum to drain out into holding tanks. The next six stage stations are used to clean the drum both internally and externally. The last four stations remove the residual washing solution both internally and externally by the application of the hot wash water.

The washed drum are then transferred to a **Chimbing Machine**. This machine is used to straighten the edges (Chimb) that stand proud at each end of the drum.

The drum is then transferred to a **De-Denter Machine**. This machine pumps air at a pressure of 55psi into the drum to remove any dents.

The drum is then transferred to a **Drum Drier**. This involves using steam and air to dry the drum both internally and externally.

The drum is then transferred to an area within the factory for a **Manual Inspection**. Drums undergo an internal and external inspection to ensure that they are “fit for purpose” and to determine their suitability for any particular customer requirement. Drums are then segregated into ‘grades’ and stored awaiting a suitable order.

When a suitable order is received, drums and **Prepared for Painting**. Drums are removed from storage and closures are fitted. The drums are then **Shot Blasted** to remove existing paint from the exterior and provide a ‘key’ for the customer’s chosen paint

The drum is then transferred to a **Leak Test Machine**. This machine uses pressurized air to determine if a leak is present. The machine is calibrated by means of a drum fitted with a bung incorporating a calibrated pinhole.

Having completed all the above processes, the drum is transferred to a **Paint Spraying Machine** where it is coated with ‘high solids’ paint in the customer’s chosen colour. The sprayed drum is then dried in an Oven.

The **Oven Drying** uses either steam or electric heat exchanger for this process. The paint spraying operation is covered by a pollution, prevention and control permit (**PPC Permit**). Emissions from this process are continuously monitored.

The drum will then travel along the conveyor. The drum will be **Labelled** for identification purposes and then loaded onto a vehicle to be delivered to the customer.