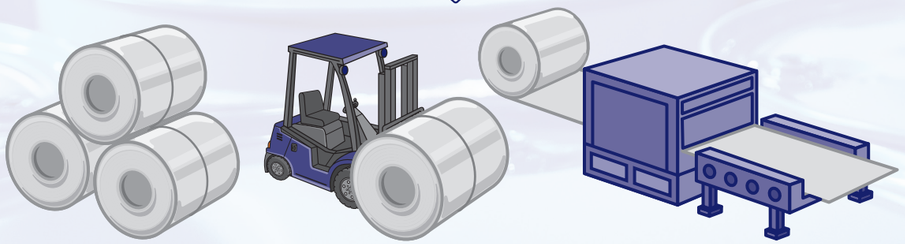
STEEL DRUM MANUFACTURING PROCESS

NCC NORTH COAST CONTAINER

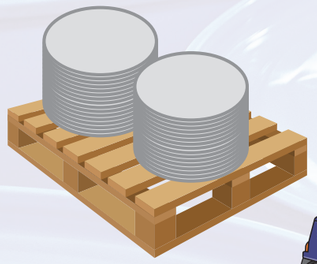
Receiving & Decoiling Stage

1. Receiving steel coils & cutting them to length

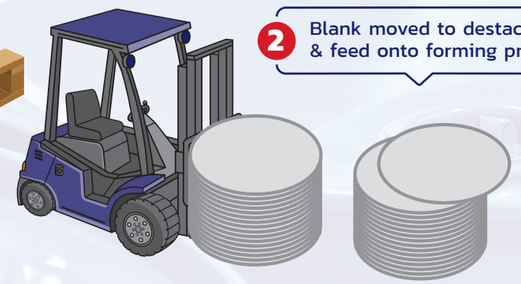


Pressing Blanks (Top & Bottom) Stage

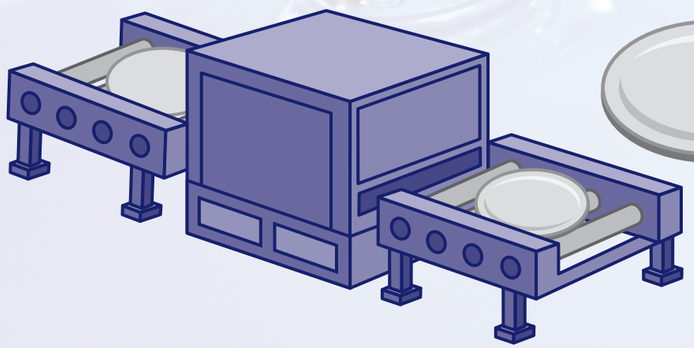
1. Blanks pressed, stacked & stored for tops & bottoms

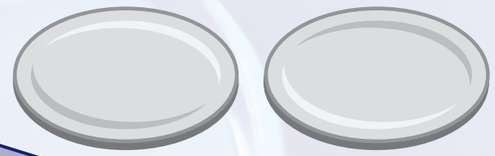


2. Blank moved to destacker & feed onto forming press

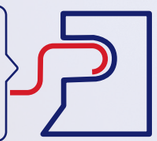


3. Blanks are die formed into tops & bottoms & characters pressed on bottom to UN codification

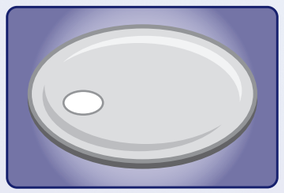




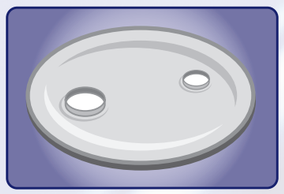
4. Profiled roller produces curl on rotating end required for body seaming



5. Holes punched for flange fitting on top

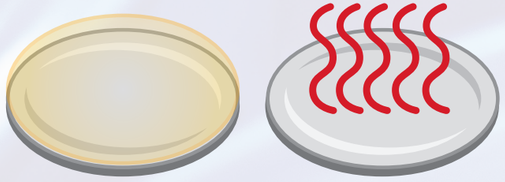


6. Flange is curled into punched pocket



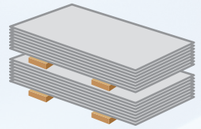
OPTIONAL

7. Internal lining applied & cured in oven at 450°

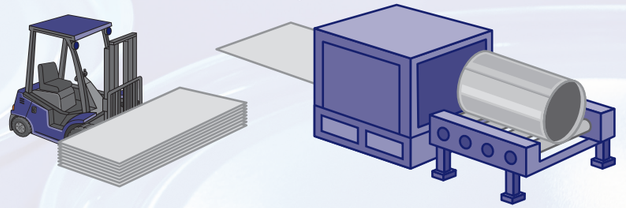


Welding & Forming Drum Stage

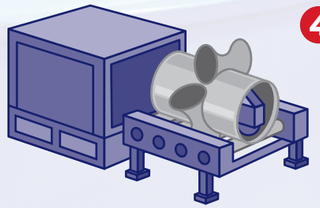
1. Sheet bundle is placed in storage



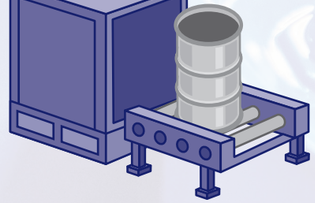
2. Bundle is transported to form overlapping cylinder shell for welding

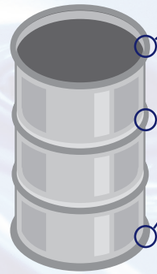


3. Cylinder is joined by resistant & fast welding



4. Rolling hoops & flanges are formed

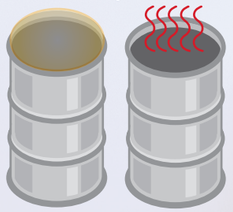




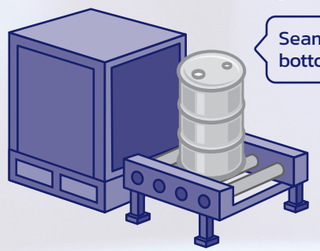
4. Flanging unit forms flanges on top
   Roll form press makes body beads
   Flanging unit forms flanges on bottom

OPTIONAL

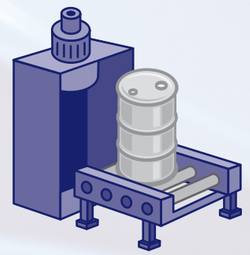
5. Internal lining applied & cured in oven at 450°



6. Seaming head & bottom on drum

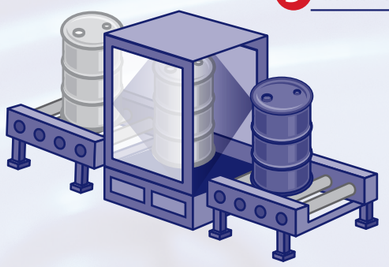


7. Drum is mechanically tested for a secure & accurate seal



8. Drum is Painted

9. Install head & closure ring on open head drum



10. Completed steel drums, lined, painted & ready to load on trucks or pallets for ship