

**STANDARDS FOR THE  
DESIGN / MANUFACTURE /  
PERFORMANCE / PURCHASING  
OF  
9 GALLON STAINLESS STEEL CASK  
BEER CONTAINERS**

## **Executive Summary:**

The following three documents refer to reusable draught stainless steel beer containers (**casks**) and are an industry recommendation to address best practice in the design, manufacture, purchase and performance of said containers, to ensure due diligence.

The information held within these documents is drawn from previous industry standards.

These documents may be used separately or in combination, as required

Thanks is given to the UK brewers who have given permission for their standards and specifications to be used and who have engaged throughout the process.

## ***Participating Associations:***

British Beer & Pub Association  
Tel: +44 (0)20 7627 9191  
Email: [slivens@beerandpub.com](mailto:slivens@beerandpub.com)  
Website [www.beerandpub.com](http://www.beerandpub.com)

Brewing, Food & Beverage Industry Suppliers' Association  
Tel: +44 (0)1902 422303  
Email: [info@bfbi.org.uk](mailto:info@bfbi.org.uk)  
Website [www.bfbi.org.uk](http://www.bfbi.org.uk)

Society of Independent Brewers  
Tel: +44 (0)845 337 9158  
Email: [secretariat@siba.co.uk](mailto:secretariat@siba.co.uk)  
Website: [www.siba.co.uk](http://www.siba.co.uk)

# **GENERIC DESIGN STANDARD**

## **9 GALLON STAINLESS STEEL CASK BEER CONTAINERS**



## 1. Technical Drawings

- 1.1 The Manufacturer must adhere to a specified technical drawing for that size and type of container. This shall either be issued by [Brewer] or produced by the manufacturer in response to dimensional and other constraints stipulated by [Brewer] (see Appendix 1) and signed by [Brewer's] nominated representative. Manufacturers' drawings must show dimensions and all tolerances, material gauges (identifying whether initial or as finished), weld positions and types (eg, MIG/GMAW, TIG/GTAW) and any filler rods used.
- 1.2 Each drawing must carry a unique reference (eg. drawing number/ sheet number/ issue number) and any change to the information thereon must have the prior, written agreement of [Nominated representative of Brewer] and must result in a new reference (eg: by updating the issue number). The new issue must identify the change and the date from which it is applicable.
- 1.3 Subsequent tenders may be met by reference to such authorised drawings.
- 1.4 Unless fully dimensioned on the master drawings (as per 1.1 above) separate drawings of keystones, shive rings and chimbs (or skirts) must be provided.
- 1.5 All drawings remain the property of the manufacturer, or issuer (Brewer), and are confidential unless otherwise agreed.

## 2 Materials

### 2.1 *Stainless Steel containers:*

- 2.1.1 The deep drawn body shells shall be AISI 304 stainless steel of initial minimum thickness  $1.5 \pm 0.1$  mm and a tensile strength of 550-700 N/mm<sup>2</sup>.
- 2.1.2 Chimbs (skirts) shall be manufactured from AISI 304 stainless steel of initial minimum thickness  $1.7 \pm 0.1$  mm and a tensile strength greater than 850 N/mm<sup>2</sup>, and/or  $2.00 \pm 0.1$  mm and a tensile strength greater than 600 N/mm<sup>2</sup>
- 2.1.3 Keystone and Shive rings and shive plate shall be manufactured from stainless steel 304L.

## 3 Capacity and weight

- 3.1 The capacity of all stainless steel containers is to be equivalent to 41.34 - 41.48 ltrs of water (or 9 gallons, 17.5 fluid ounces  $\pm$  2 fluid ounces ) at 4°C.
- 3.2 The weight of each finished stainless steel container, clean and dry is to be within a tolerance of 0.5kg of the manufacturer's specified weight

## 4 Identification

At the discretion of the customer, each stainless steel container shall be stamped or engraved as below on the outer face of the top chimb.

#### 4.1 *Ownership*

"THIS CONTAINER REMAINS THE PROPERTY OF [Brewer]. UNAUTHORISED THIRD PARTY USE OR DISPOSAL IS PROHIBITED"

#### 4.2 *Manufacturers' Stamp*

#### 4.3 *Serial numbers*

Serial numbers, as listed on [Brewer's] Purchase Order, shall be permanently stamped into/marked on the top chimb or where requested by the customer.

#### 4.4 *Discretionary Additional Information*

- BEVERAGE USE ONLY
- European beverage use symbol (fork and glass)
- Re-cycleable container symbol (four arrows)

#### 4.6 *Colour identification*

To assist container identification, an industry colour-banding scheme is operated in the UK. Colour combinations already allocated are listed on the BBPA/SIBA Container Master Database (see <http://cask.beerandpub.com>). The specification for each of [Brewer's] containers is given in Appendix 1 within the Container Master Database.

Those brands not defined by colour banding should be identified by name bands, situated on the body of the container and/or embossed on the chimb.

### **5 Hand holes**

If required, two hand holes of a minimum size of 104 x 22 mm should be incorporated in the upper chimb, diametrically opposite one another.

### **6 Drain holes**

6.1 Refer to manufacturing standard section 8.2

### **7 Function**

The Manufacturer must ensure that the cask is fully drainable via the shive orifice.

### **8. Dispense**

The keystone position on the cask should be in a position to ensure efficient dispense of the container.

**[Brewer's] Critical dimensions comparison template  
(see diagrams within Manufacturing Standard)**

The following dimensions should be carefully considered when selecting the end design of cask. Any existing containers within the fleet should be considered.

	<b>Dimension</b>	<b>Cask A</b>	<b>Cask B</b>	<b>Cask C</b>	<b>Cask D</b>
	Manufacturer				
	Overall height				
	Top rolling-ring to floor				
	Bottom rolling-ring to floor				
	Rolling-ring centres				
	Length of body between rolling-rings				
	Diameter over rolling-rings				
	Diameter between rolling-rings				
	Shive Orifice				
	Keystone Orifice				
	Capacity				
	Weight				

**GENERIC  
MANUFACTURING/PERFORMANCE  
STANDARD**

**9 GALLON STAINLESS STEEL CASK  
BEER CONTAINERS**



# 9 GALLON STAINLESS STEEL DOUBLE APERTURE CASK SPECIFICATION

## A. TECHNICAL REQUIREMENTS

### 1. Design, Dimensions, Constructions, Specifications

Containers to be manufactured to meet dimensional criteria and other relevant parameters as detailed on enclosed table.

### 2. Material

Body to be deep drawn shells of AISI 304 stainless steel of initial minimum thickness  $1.50 \pm 0.1$  mm and 550-700 N/mm<sup>2</sup> tensile strength.

The deep drawing process should not reduce the body thickness to ensure that performance tests are not compromised .

Chimbs (skirts) to be manufactured from AISI 304 stainless steel of initial minimum thickness  $1.70 \pm 0.1$  mm and 850 N/mm<sup>2</sup> tensile strength and/or  $2.00 \pm 0.1$  mm and a tensile strength greater than 600 N/mm<sup>2</sup>

Keystone and Shive Ring to be manufactured from AISI 304 stainless steel alloy. Keystone when welded to the top dome of the cask to incorporate a finger guard (when deemed necessary) between the keystone and top chimb.

Keystone perpendicularity to be guaranteed (maximum deviation  $\pm 1^\circ$ ).

### 3. Drawings

Designs and drawings will be made available to each respective company prior to manufacture. One copy to be signed and returned to the Manufacturer, the other retained by the customer for their records. All drawings remain the sole property of the Manufacturer.

### 4. Profile - Rolling Rings

Rolling ring profile is critical with regard to distribution requirements and to conform to safe materials handling working practices.

## 5. Capacity/Weight

The capacity of all stainless steel containers is to be equivalent to 9 Gallon, 17.5 fluid ounces  $\pm 0.2$  fluid ounces of water at 4°C.

The average value of capacity over any production run must be nominal or above nominal.

Every container shall be weighed at the end of the manufacturing process. The average weight over any production run must be as close to the nominal as possible ( $\pm 0.5$ ) kg of the Manufacturer's specified weight.

## 6. Identification

Each container will be identified as per the Design Specification (see Design Specification items 4.1 – 4.6), to include the following:

(i) Ownership

"THIS CONTAINER REMAINS THE PROPERTY OF 'Owning Brewer'.  
"UNAUTHORISED THIRD PARTY USE OR DISPOSAL IS PROHIBITED"

(ii) Container Number

To ensure traceability, a container number, unique to the brand owner, must be applied .

Numbering sequence to be consecutive with all following orders for that year of manufacture.

Records to be kept for a minimum of 7 years.

N.B. Containers rejected subsequent to identification, that cannot be re-worked, should be destroyed according to the latest version of BBPA document TC 423

If replacement numbers are substituted, a record to be made also.

(iii) Manufacturer

Manufacturer's stamp and certification block to include:

Name  
Capacity  
Material and Quality  
Tare weight  
Production Date

(iv) Discretionary Additional Information

The following to be impressed on the outer face of the chimb.

- a. BEVERAGE USE ONLY.
- b. European beverage use symbols.
- c. Re-cycpleable container symbol (four arrows)

(v) Colour identification

Each container shall have, where detailed by the customer, painted rings around the main body of the cask denoting the individual customer. Those brands not defined by colour banding should be identified by name bands, situated on the body of the container and/or embossed on the chimb.

A simple adhesion test shall be carried out 24 hours after application and curing and each time the batch of paint is changed

**7. Hand Holes**

If required, minimum size 104 x 22 mm should be incorporated in the upper chimb, diametrically opposite one another. All edges must be deburred to give a smooth finish.

**8. Construction Quality**

8.1 Welds

Circumferential chimbs (skirts) welds to be of the correct penetration, guaranteeing full weld strength. All welds will be smooth, free from cracks, projections, crevice pinholes, scale, spatter and staining.

No manual reweld is permitted around the shive orifice and keystone holes and there must be no weld spatter on their inner surfaces.

Any required manual reweld work must not exceed 20% of the circumferential weld length around both chimbs.

Manual reweld work must not exceed 10% of the total circumferential weld length around the shive plate area.

8.2 Alignment of Component Parts (butt welds only).

8.2.1 Where two components are of different gauges at the point of contact, the thinner material should be positioned within the surfaces of the thicker.

8.2.2 The maximum permissible step between surfaces exposed to beer at any point along the weld run shall be 0.4 mm or 25% of the gauge of the components at the point of contact (the thinner in the case of materials of two different gauges), whichever is the lesser.

8.2.3 Where neither surface is exposed to beer (eg: in the case of the shive bush outer weld) the limit in 8.2.2 shall be applied to the outer surfaces.

8.3 Penetration

8.3.1 Butt Welds

8.3.1.1 The weld shall penetrate for at least the full depth of the original area of contact of the two component parts at all points along the weld run.

- 8.3.1.2 Overpenetration on the side in contact with beer shall be no more than the value defined for misalignment in 8.2.2 above as measured from the original innermost point of contact of the two components (but see 8.3.1.4 below).
- 8.3.1.3 The height of the weld bead above the higher surface nearest to the weld torch must not exceed a value equal to that defined for misalignment in 8.2.2 above (but see 8.3.1.4 below).
- 8.3.1.4 Where a weld run is laid down with the torch acting from the side which will be in contact with beer, section 8.3.1.3 shall apply and not 8.3.1.2.
- 8.3.1.5 Where a weld is formed by two passes, one from each side of the joint, it must be demonstrable by sectioning of samples that the weld beads meet or overlap so as to comply with 8.3.1.1 above.

### 8.3.2 Fillet Welds

- 8.3.2.1 The weld run must fuse the full thickness of the attached component, and must penetrate demonstrably adequately into the parent material, over the entire length of the weld run.
- 8.3.2.2 Where the fillet weld will be in contact with beer (eg. a patch, or inner shive, plate) the weld bead shall not protrude above the surface of the attached plate by more than 0.4 mm or 25% of the gauge of the attached plate, whichever is the lesser.
- 8.3.2.3 After any pickling there shall be no weld bead standing proud of the opposite surface of the main plate from that onto which the fillet weld was made.

### 8.4 Drain Holes

Internal drain holes between top chimb and body shall be 2 in number; diametrically opposed. Also there shall be similar drain holes between the bottom chimb and body.

Minimum of 2 drain holes in the chimb bead.

The orientation of the smaller drain holes to the larger shall be at 90 degrees.

### 8.5 Internal and External Finish

The stainless steel surface shall be pickled to eliminate any form of contamination or rusting. After thorough cleaning and/or pressure testing all external surfaces shall be bright, smooth and degreased with the interior without imperfection, which could create cleaning difficulties. The finished containers must be fit for filling procedures and not liable to impart any flavour taint or contaminants.

N.B. Measurement of rinse water pH must be undertaken continuously to ensure neutrality (pH 6-7) to avoid and eliminate any residual acidic build up.

## 8.6 Rusting

No evidence of rust on containers will be permitted.

## 8.7 Aperture Alignment

The shive and Keystone apertures must be diametrically apposed where the Shive centre is positioned at 180 degrees to the Keystone centre. A manufacturing tolerance of +/- 2 degrees is permitted.

## 9. **Pressure Requirement**

Each cask shall be subjected to a final pneumatic test of a minimum of 15 psi (1 bar) for a minimum of 60 seconds.

A record of these tests shall be provided after delivery(when requested), in the form of a certificate of conformity.

## 10. **Sub-Contracting**

A third party may not undertake manufacture or reproduction of any part of the items or drawings specified, without prior permission of the Purchaser.

## 11. **Final Inspection**

All casks shall be subject to a final visual inspection by a trained and competent member of the Manufacturer's company.

## 12. **Supplier Quality Assurances and Performance Testing**

The customer may inspect production of manufacturing processes and premises before manufacture is commenced according to an established, accredited audit procedure and also to inspect production of containers during the process.

The Manufacturer shall carry out performance testing at start of production and during manufacturing schedule at the minimum rate detailed in the Testing Procedure section.

## 13. **Guarantees (Warranty)**

All containers shall conform to agreed Codes of Practice and Standards for beer containers.

The Manufacturer will provide a written guarantee/warranty against faulty materials and manufacturing processes for a period not less than seven years.

## 14. **Ownership**

No goods identified according to this specification may be supplied to a third party, without prior permission.

**15. Delivery Requirements**

These should be detailed with the official order, as required by the customer.

**16. Incoming Goods Inspection/Complaints**

The Manufacturer requires any complaint after delivery in the form of written mail or email detailing container(s) serial number and fault.

**17. Changes**

No change to any of the above details may be incorporated without joint approval of the Manufacturer and the customer.

**A. SPECIFICATION SHEET TEMPLATE  
9 GALLON CASK – STAINLESS STEEL DOUBLE APERTURE**

ITEM	DESCRIPTION	SPECIFICATION
T3	Initial Gauge - Top Chimb (Skirt)	
T1/T2	Initial Gauge - Body Shell	
T4	Initial Gauge - Bottom Chimb (Skirt)	
W1	Chimb (Skirt) Diameter maximum / minimum	
W3	Outside Diameter over Rolling Rings	
W4	Outside Diameter between Rolling Rings	
-	Inside Diameter between Rolling Rings	
H1	Overall Height	
H13	Top Chimb (Skirt) Bead Diameter	
H11	Top Chime (Skirt) to Body (Shell)	
H12	Bottom Chimb (Skirt) to Body (Shell)	
H13	Bottom Chimb (Skirt) Bead Diameter	
H5	Bottom Chimb (Skirt) to Bottom Rolling Ring (Centre)	
H2	Bottom Chimb (Skirt) to Top Rolling Ring (Centre)	
H4	Length of Flat Cylinder between Rolling Rings	
H3	Rolling Ring	
H10	Handle Depth	
W2	Handle Width	
	Construction Capacity Litres @ 4°C	
	Weight	
	Cruciforms	
	Colour paint bands - -	
	Shive centre in relation to Keystone centre (180° +/- 2°)	
	Transponder position (spot welded minimum 4 points)	

## B. TESTING PROGRAMME

Testing requirements are itemised on 12 separate sheets as follows:-

1. Dimensional checks - raw materials
2. Dimensional checks
3. Dimensional checks
4. Mechanical test – 45 degree drop test (Set-Up)
5. Mechanical test – 45 degree drop test (Handle Hole)
6. Mechanical test – 45 degree drop test (Keystone)
7. Mechanical test – 45 degree drop test (Bottom chimb butt weld)
8. Mechanical test – Horizontal drop test
9. Inspection test including alignment of 2 shells check
10. Paint adhesion test
11. Transponder Integrity test (when fitted)

The suggested minimum testing programme is as follows:

Test frequency:

- (1): Twice daily minimum for each batch of steel
- (2): Twice daily during production
- (3): Twice daily minimum
- (4): 2 at start of production, then 1 per day
- (5): 2 at start of production, then 1 per day
- (6): 2 at start of production, then 1 per day
- (7): 2 at start of production, then 1 per day
- (8): 100 % inspection on centre weld jigs
- (9): 5 at start of production (and change of paint batch) and 1 every day thereafter
- (10): Twice daily when transponders are fitted

All containers shall be:

1. Hydraulic pressure tested at 15 p.s.i. for 60 seconds.
2. Checked for the alignment of the 2 shells tolerance, max 1mm

Where any failures to specification occur the Manufacturer has an established procedure for re-testing, stopping the production line where necessary and making the necessary adjustments.

## Performance Criteria – as per performance specifications

It is recognised that two distinctly different design types of Stainless Steel 9 Gallon Casks are available from the manufacturers who have contributed to the development of this generic specification.

The key relevant difference with regards to mechanical tests is the chimb design with one option being a flat sided chimb and the alternative being a curved chimb.

Due to the difference in performance of each chimb within the mechanical tests it is necessary to include deformation standards that are applicable to each design type.

### DROP TESTS

3 drops from a height of 1.20 metres (4 feet) onto a 25 mm (1") thick steel plate, (casks filled with liquid).

#### (i) Drop Test - Top Chimb (Skirt)/Hand Hole

At an angle of 45° onto the hand hole

Deformation standard:	At impact	Flat Chimb < 14 mm	Curved Chimb < 20 mm
	Perpendicular to impact	< 2 mm	< 2 mm

NO PERMANENT SHELL DEFORMATION IS ACCEPTABLE.

NO EVIDENCE OF SPLITTING.

#### (ii) Drop Test - Top Chimb/Keystone Housing

Deformation standard:	At impact	Flat Chimb < 14 mm	Curved Chimb < 16 mm
	Perpendicular to impact	< 2 mm	< 2 mm

Clearance Chimb to Keystone Housing – access to Keystone must not be compromised.

#### (iii) Drop Test - Bottom Chimb/Butt Weld

Deformation standard:	At impact	Flat Chimb < 14 mm	Curved Chimb < 18 mm
	Perpendicular to impact	< 2 mm	< 2 mm

3 drops from a height of 1.20 metres (4 feet) onto a 25 mm (1") thick steel plate, (casks filled with liquid).

#### (iv) Drop Test - Horizontal

Deformation standard:	At impact	Flat Chimb < 15 mm	Curved Chimb < 18 mm
	Perpendicular to impact	< 2 mm	< 2 mm

## Results of Testing

All the results of testing carried out will be forwarded to the customer's nominated agent.

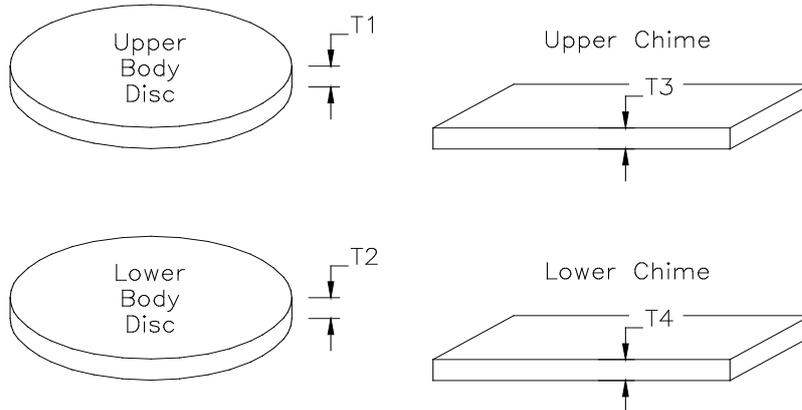
Particular critical parameters are:

- H1 overall height
- W1 chimb diameter
- W4 outside diameter body
- K1 keystone internal diameter
- S1 shive internal diameter
- weight and capacity

## TEMPLATE

### 1. DIMENSIONAL CHECKS FOR RAW MATERIAL

Manufacturer	
Steel supplier	

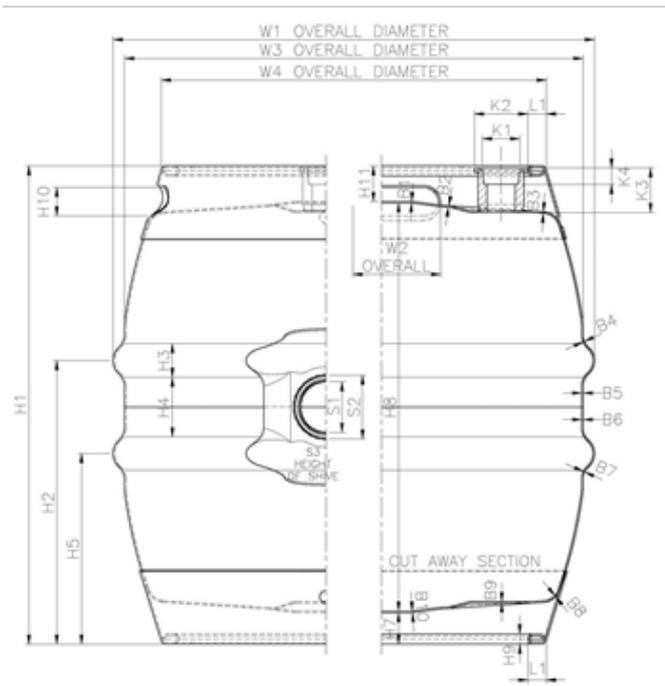


STEEL BATCH DETAILS	TENSILE SPEC.	TENSILE VALUE	DIM.	IDENTIFICATION NUMBER (Traceability)	THICKNESS SPEC.	THICKNESS VALUE
	550 - 700 N/mm <sup>2</sup>		T1		1.50 ± 0.1 mm	
	550 - 700 N/mm <sup>2</sup>		T2		1.50 ± 0.1 mm	
	>850 N/mm <sup>2</sup>		T3		1.7 ± 0.1 mm	
or	>600 N/mm <sup>2</sup>		T3		2.0 ± 0.1 mm	
	>850 N/mm <sup>2</sup>		T4		1.7 ± 0.1 mm	
or	>600 N/mm <sup>2</sup>		T4		2.0 ± 0.1 mm	

## TEMPLATE

### 2. STAINLESS STEEL DIMENSIONAL CHECKS

Manufacturer				
Manufacturing date				
Identification No.	T1	T2	T3	T4
Cask number				



DIM.	SPEC.	Value
H1		
H2		
H3 Top		
H3 Bottom		
H4		
H5		
H9 Top		
H9 Bottom		
L1 Lip		
H10		
H11		
H12		
H13 Top		
H13 Bottom		
K1 Keystone I/D		
K2 Keystone O/D		
K3 Keystone		
K4 Keystone		
S1 Shive I/D		
S2 Shive O/D		
S3 Shive length		

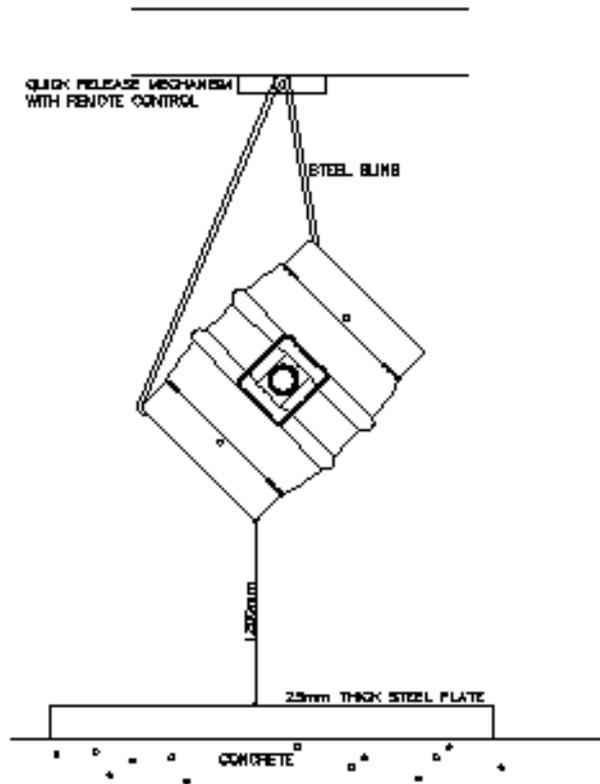
## TEMPLATE

### 3. STAINLESS STEEL DIMENSIONAL CHECKS

Manufacturer				
Manufacturing date				
Identification No.	T1	T2	T3	T4
Cask number				

	DIM.	SPEC.	Value
	W1 (max)		
	W1 (min)		
	W2		
	W3 Top		
	W3 Bottom		
	W4		
	WEIGHT		
	CAPACITY		
	B1		
B2			
B3			
B4			
B5			
B6			
B7			
B8			
B9			
B10			

#### 4. MECHANICAL TEST - 45° DROP TEST (Set-up)



## TEMPLATE

### 5. MECHANICAL TEST - 45° DROP TEST - TOP HAND HOLE TEMPLATE

Casks shall be filled completely with cold water and shive and keystone apertures sealed.

Casks shall be dropped from 1.2 metres (4 feet) using slings set at correct angle (45°) with a quick release mechanism 3 times onto a 1 inch (25mm) steel plate on concrete. It is essential that the point of impact is exactly the same each time. Any leakage shall be noted. After each drop the displacement from the normal inside and outside diameter of the chimb at the point of impact and also inside and outside diameter perpendicular to it shall be measured.

**Test Procedure:**

3 drops to same position:

1. Top chimb /hand hole

Manufacturer				
Manufacturing date				
Identification No.	T1	T2	T3	T4
Cask number				

	Point of Impact "A" Inside Diameter	Difference	Perpendicular to Impact "B" Inside Diameter	Difference
Before Test		-		-
Drop 1				
Drop 2				
Drop 3				
Specification	-	< 14 / 20 mm	-	< 2 mm

**Remarks:**

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 .....

## TEMPLATE

### 6. MECHANICAL TEST - 45° DROP TEST – ON TO KEYSTONE

Casks shall be filled completely with cold water and shive and keystone apertures sealed.

Casks shall be dropped from 1.2 metres (4 feet) using slings set at correct angle (45°) with a quick release mechanism 3 times onto a 1 inch (25mm) steel plate on concrete. It is essential that the point of impact is exactly the same each time. Any leakage shall be noted. After each drop the displacement from the normal inside and outside diameter of the chimb at the point of impact and also inside and outside diameter perpendicular to it shall be measured.

**Test Procedure:**

3 drops to same position:

2. Top chimb /90° from hand hole landing on keystone

Manufacturer				
Manufacturing date				
Identification No.	T1	T2	T3	T4
Cask number				

	Point of Impact "A" Inside Diameter	Difference	Perpendicular to Impact "B" Inside Diameter	Difference
Before Test		-		-
Drop 1				
Drop 2				
Drop 3				
Specification	-	< 14 / 16 mm	-	< 2 mm

**Remarks:**

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 .....

## TEMPLATE

### 7. MECHANICAL TEST - 45° DROP TEST - BOTTOM BUTT WELD

Casks shall be filled completely with cold water and shive and keystone apertures sealed.

Casks shall be dropped from 1.2 metres (4 feet) using slings set at correct angle (45°) with a quick release mechanism 3 times onto a 1 inch (25mm) steel plate on concrete. It is essential that the point of impact is exactly the same each time. Any leakage shall be noted. After each drop the displacement from the normal inside and outside diameter of the chimb at the point of impact and also inside and outside diameter perpendicular to it shall be measured.

**Test Procedure:**

3 drops to same position:

3. Bottom chimb /Butt weld

Manufacturer				
Manufacturing date				
Identification No.	T1	T2	T3	T4
Cask number				

	Point of Impact "A" Inside Diameter	Difference	Perpendicular to Impact "B" Inside Diameter	Difference
Before Test		-		-
Drop 1				
Drop 2				
Drop 3				
Specification	-	< 14 / 18 mm	-	< 2 mm

**Remarks:**

.....  
 .....

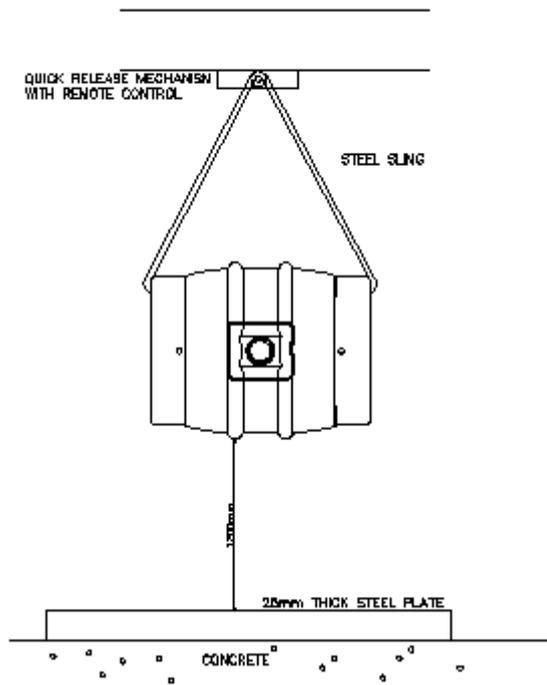
## TEMPLATE

### 8. MECHANICAL TEST - HORIZONTAL DROP TEST – SHIVE PLATE

Conditions as for 45° drop test, except casks shall be dropped from a horizontal shive position. Measurements shall be outside diameter of the rolling rings.

Two tests – (A) one dropping directly onto shive the other (B) dropping at 90deg to shive

Manufacturer				
Manufacturing date				
Identification No.	T1	T2	T3	T4
Cask number				



	Point of Impact "A1"	Variation	Point of Impact "A2"	Variation	Perpendicular to Impact "B1"	Variation	Perpendicular to Impact "B2"	Variation
Before Test								
Drop 1								
Drop 2								
Specification		< 15 / 18 mm		< 15 / 18 mm		< 2mm		< 2mm

**Remarks:**

.....

.....

**TEMPLATE**

**9. INSPECTION TEST  
(ACCORDING TO MANUFACTURER'S ESTABLISHED REGIME)**

**Test Procedure:**

Examine the external appearance of the container including the welds.  
Cut the container in half longitudinally and examine the condition of the internal welds and surfaces. Also check for the alignment of the two halves

Manufacturer	
Manufacturing date	

INSPECTION TEST						
Identification No.				Cask Number	Details	
T1	T2	T3	T4			
Specification misalignment				Max 1mm		

**Remarks:** .....

.....

.....

## 10. PAINT ADHESION TEST

**Test Procedure:**

After 24 hours application and curing the Manufacturer will test paint/ink via a scratch/adhesion test, according to the ultimate usage conditions, as outlined by the Manufacturer.

Any paint removed during gentle scratching or by adhesion to the tape (masking) is a failure and all casks produced at this time must be inspected.

This test shall be repeated as per testing schedule and whenever a fresh batch of paint is used.

The testing of paint/ink by the Manufacturer is undertaken as a matter of course as part of due diligence.

Manufacturer	
Manufacturing date	

INSPECTION TEST					
Identification No.				Cask Number	Details
T1	T2	T3	T4		

**Remarks:**

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.....

.....

**TEMPLATE  
SPECIFICATION AMENDMENT RECORD**

PAGE	SECTION	DATE	NAME	AMENDMENT

**TEMPLATE  
DRAWING AMENDMENT RECORD**

<b>Cask drawing</b>			
INDEX	DATE	NAME	AMENDMENT

<b>Bottom chimb drawing</b>			
INDEX	DATE	NAME	AMENDMENT

<b>Top chimb drawing</b>			
INDEX	DATE	NAME	AMENDMENT

# **GENERIC PURCHASING STANDARD**

## **9 GALLON STAINLESS STEEL CASK BEER CONTAINERS**



## **1 General**

- 1.1 Supply must comply with the requirements of [Brewer's] attached Design Specification, including identified and authorised technical drawings, and with the industry (BBPA, BFBi and SIBA)
- 1.2 No changes in materials or design specifications shall be made without written approval of the authorised representative of [Brewer].

## **2 Legislation**

- 2.1 All Manufacturers must adopt Good Manufacturing Practice according to EC Regulation 2023/2006. Particular attention is drawn to Articles 1, 3 and 5.
- 2.2 All product-contact materials must comply with the Framework Directive (EC 1935/2004; The *'Materials and Articles intended to come into contact with Food'* Regulation). Particular attention is drawn to Articles 3, 15, 16 and 17.
- 2.3 All product-contact surfaces must comply with Article 2 of the Food Hygiene Regulations (EC 852/2004). Particular attention is drawn to Article 2 and Chapters II and V

## **3 Ownership identification and colour banding**

- 3.1 [Brewer's] ownership identification (name) shall be applied to each container in the format detailed in [Brewer's] Design Standard.
- 3.2 A unique and permanent colour band(s) shall be applied to each container in the format detailed in [Brewer's] Design Standard. Written confirmation of [Brewer's] entitlement to specify this colour-banding will be submitted to the container manufacturer.

Those brands not defined by colour banding should be identified by name bands, situated on the body of the container and/or embossed on the chimb.

## **4 Container Numbering**

- 4.1 In the format detailed in the [Brewer's] Design Standard, a unique and permanent serial number shall be applied to each container.
- 4.2 The serial numbers to be used for each production run will be specified on [Brewer's] Purchase Order/Instructions.
- 4.3 Lists of serial numbers used shall be sent to [Brewer] immediately upon completion of the production run. These lists will identify the technical drawings to which the containers were made.
- 4.4 The cask manufacturer shall keep copies of these data for a minimum of 7 years.

## **5 Quality Assurance and Quality Control**

- 5.1 [Brewer] encourages every Manufacturer to operate a "right first time" policy and to seek industry accepted accreditation.
- 5.2 [Brewer] (or his appointed, qualified nominee) reserves the right to inspect production of the manufacturing process and premises before manufacture is commenced according to the established accredited audit procedure, and also to inspect and, if necessary, halt production of containers during the process.
- 5.3 [Brewer] (or his appointed, qualified nominee) reserves the right to inspect the Manufacturer's Technical Production Files detailing all materials and manufacturing processes. [Brewer] undertakes to respect the confidentiality of this information.

## **6 Guarantees/Warranty**

- 6.1 There shall be provided a written guarantee/warranty by the container manufacturer against faulty materials and manufacturing processes for a period not less than seven years.
- 6.2 A list of manufacturers who have lodged their records with the BFBi may be accessed via +44 (0)1902 422303.

## **APPENDIX**

### **Participating Manufacturers/Suppliers:**

#### **Kammac**

UK  
Tel: +44 (0)1283 743734  
Email: jay.patel@kammac.com  
Website: www.kammac.com

#### **Kegspertise Ltd**

UK  
Tel: +44 (0)1274 851464  
Email: andy.dorr@kegspertise.com  
Website: www.kegspertise.com

#### **Maisonneuve-Keg SA**

France  
Tel: +33 (0)233 51 9027  
Email: amarie@groupe-maisonneuve.com  
Website: www.groupe-maisonneuve.com

#### **Morrow Brothers Ltd**

UK  
Tel : +44 (0) +44 (0)1772 311882  
Email : liam@morrow-brothers.co.uk  
Website : www.morrow-brothers.co.uk

#### **Portinox SA**

Spain  
Tel: (UK Office) +44 (0)1924 885010  
Email: tparker@portinoxuk.co.uk  
Website: www.portinox.es

#### **Sovereign Beverage Company Ltd**

UK  
Tel: +44 (0)1254 277899  
Email: mail@devlin.plus.com  
Website: www.sovereignbeverage.com