



WORLD LEADER IN DRUM DISPOSAL ENGINEERING



We are the global leader in designing, manufacturing, and installing high-efficiency drum crushers, drum washers and drum washer crusher systems

We are the world leader in the design and engineering of the most advanced drum recycling and industrial drum cleaning systems. We provide the largest selection of commercial and industrial drum crushers, drum washers and drum washer crusher systems to meet any special project requirement.

Our systems and environmental solutions are meticulously designed to deliver the highest performance and continuous heavy-duty services.

www.drumbeaters.com

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1. Commercial Drum Crusher



DC5000 & DC6000 Models

The Commercial Drum Crusher Models DC5000 & DC6000 are designed to crush a 55-gallon drum down to 2.5" in height depending on the gauge of the drum, significantly reducing storage space requirements and transport fees.

These models come complete with motor starter, hydraulic door safety switch, and an oil sight gauge with temperature indicator.

Standard Features

- Crushing force 60,000 pounds at 3000 psi
- Crush 55 gallon steel drum down to 2.5"
- Cycle time from 28 to 45 sec.
- 60 gallon hydraulic tank
- Drip pan for liquid containment
- Directional control valve
- Drum ring locator - keeps the drum aligned
- Emergency stop push button and motor starter
- Portability with forklift truck or mounted on a trailer
- Safety features to comply with OSHA
- Heavy duty steel construction

Optional Features

- Galvanized finish
- Epoxy paint
- Auto cycle directional control valve
- Hydraulic push button control
- Explosion proof
- Other optional features available

Available Models

- DC5000 - 5 HP Electric Motor
- DC5000 - 10 HP Electric Motor
- DC5000 - 10 HP Diesel Motor
- DC5000 - 11 HP Gasoline Motor
- DC6000 - 11 HP Gasoline Motor (Portable)

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2. Industrial Drum Crusher



DC7000 & DC8000 Models

The Industrial Drum Crusher Models DC7000 & DC8000 are super heavy duty drum crusher compactor systems and are used to crush a large volume of drums continuously.

These models can be used to compact waste inside of the drum or to crush an empty 55 gallon drum down to less than 2.5" in height depending on the gauge of the drum. Heavy duty construction with all structural components made of steel.

Standard Features

- Crushing force 85,000 pounds at 3000 psi or 70,000 pounds at 2500 psi
- Crush 55 gallon steel drum down to less than 2.5"
- Cycle time from 30 sec.
- 60 gallon hydraulic tank
- Drip pan for liquid containment
- Directional control valve
- Drum ring locator - keeps the drum aligned
- Emergency stop push button and motor starter
- Portability with forklift truck or mounted on a trailer
- Safety features to comply with OSHA
- Heavy duty steel construction

Optional Features

- Galvanized finish
- Epoxy paint
- Auto cycle directional control valve
- Hydraulic push button control
- Explosion proof
- Drum ejection system
- Drum conveyor
- Dutch door
- Other optional features available

Available Models

- DC7000 - 10 HP Electric Motor
- DC7000 - 10 HP Diesel Motor
- DC8000 - 20 HP Diesel Motor (Portable)

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3. Trash Can Washer TCW-100



Model TCW-100

The Trash Can Washer Model TCW-100 is constructed from high-quality stainless steel and is designed for longevity, efficiency, and simplicity. This system requires only a simple 120V wall outlet and a water source. It can use any sanitizer or soap solution, offering a high level of versatility.

Combined with our high-pressure rotary wash nozzle, the TCW-100 is guaranteed to thoroughly clean 360° of your container's interior area.

Main Features

- Electrical requirement 120V (other options available)
- Controls: foot pedal
- Construction: 304 stainless steel

Advantages

- **Health Risks:** Regular cleaning eliminates harmful bacteria and viruses that can thrive in dirty containers, reducing the risk of illnesses and infections.
- **Prevents Pest Infestations:** Clean bins are less attractive to pests such as rodents, insects, and other vermin, which are drawn to food residues and odors in uncleaned containers.
- **Minimizes Odors:** Removing decaying organic matter and other waste materials helps prevent foul odors, creating a more pleasant environment for everyone.
- **Improves Aesthetics:** Clean bins contribute to a tidier appearance of homes, workplaces, and public areas, reflecting positively on the surrounding environment.
- **Enhances Safety:** By removing hazardous substances and reducing spills from overflow, clean containers minimize slip and fall risks and other safety hazards.
- **Protects the Environment:** Properly cleaning and maintaining trash containers can prevent harmful chemicals and waste materials from contaminating soil and waterways.

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4. Garbage Can Washer GCW-100



Model GCW-100

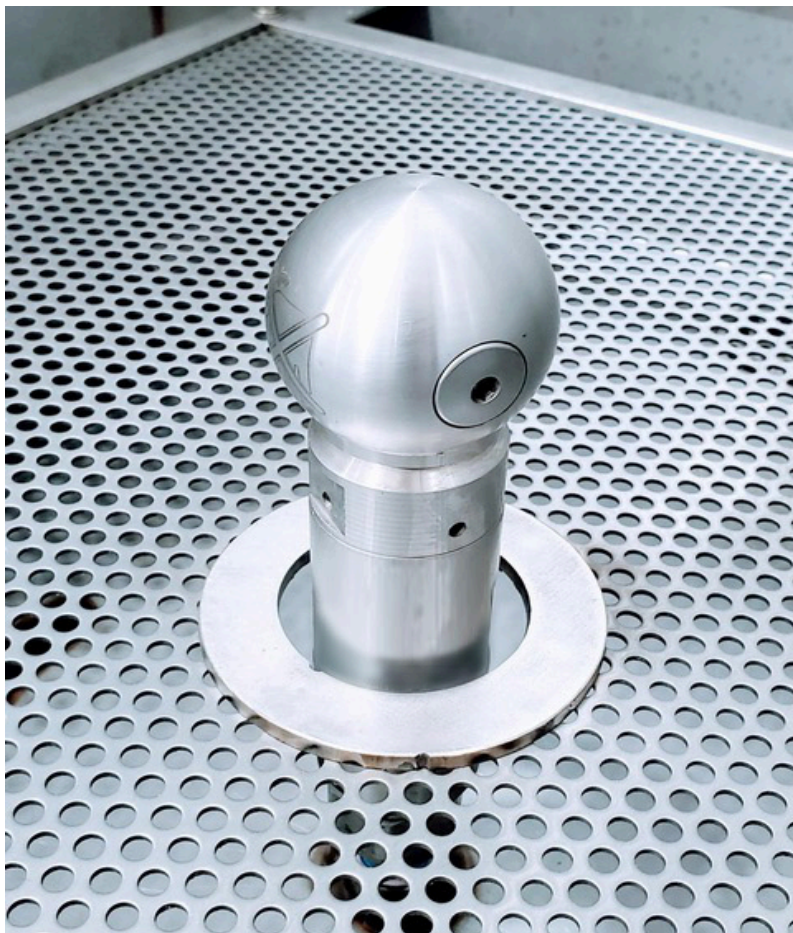
The GCW-100 garbage can washing system is a unique system that is designed to wash the interior of garbage cans sized up to 95 gallons. This system is capable of using your choice of soap, sanitizer, and/or deodorizer to achieve a high level of cleanliness. The system uses a custom engineered wash nozzle to cover 360° of the interior surface of any garbage can. Customer must supply any temperature of water between 40°F and 160°F to the pump.

Main Features

- **Electrical Controls:** Main Power Disconnect on the Front Cover. One (1) electronic safety switch (electronic photo eye). System only washes if a garbage can is placed on the wash stand. Push Button On/Off & Emergency E -Stop Controls. HMI/PLC with adjustable cycle times.
- **Wash Nozzle:** Custom Engineered Fluid Driven Rotary Spray Wash Nozzle
- **Pressure Pump & Motor:** One high pressure 5 HP pump @ 1500 psi @ 5 GPM
- **System Water Requirements:** Minimum 10 GPM 1" NPT Connection, Minimum 15 PSI, Water Temperature 40°F–160°F
- **Electrical Requirements:** 480 volt, 3 phase, 7 amp draw
- **Inlet:** 1" NPT
- **Drain:** Gravity drain with 2" NPT port
- **Wash Gun:** Yes
- **Dimensions:**
 - Height: 62.00" (157.48 cm)
 - Width (includes electrical box): 58.0" (147.32 cm)
 - Depth: 60.0" (152.40 cm)
- **Weight:** 1,030 lbs. (467.20 kg)

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5. Drum Washer JLP-1



Model JLP-100

The JLP-100 is a high pressure low volume drum washer. It is designed to wash and rinse the interior of drums and garbage cans sized up to 110 gallons using water, detergent, solvent, or hot water. This system uses a high speed rotary nozzle for washing 100% the interior of drums and containers. The construction is heavy duty.

The wash station has a control box containing a start and stop button and an emergency stop button. The washing station is protected by a safety system to prevent the operator from activating a station when a garbage can is removed prior to the wash cycle being finished.

The JLP-100 is good for open top drums or trash cans. In combination with the utility of our high- pressure rotary wash nozzle, the JLP-100 is guaranteed to fully wash 360° of your container's surface area.

Main Features

- High pressure low volume drum washer
- Washes open top drums or trash can
- Eliminates viruses and bacteria if using sanitizer or soap solution
- Eliminates rodent and Insect Infestation
- Reduces risk of cross contamination
- Protects against health hazards
- Removes odors and improves hygiene

Specifications

- Electrical requirements: 480V 3 Phase (other options available upon request)
- Controls: control panel containing a start and stop button and an emergency stop button
- Construction: 304 Stainless Steel frame and collection reservoir
- Wash gun for external container washing

Optional Features

- Automated feed line for sanitizer, soap, rinse aid, etc.

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6. Drum Washer DW55-ITR



DRUM WASHER - MODEL DW55-ITR



DRUM WASHER - MODEL DW55-ITR

Model DW55-ITR

The Drum Washer System Model DW55-ITR is designed to wash and rinse the interior of drums and pails sized up to 85 gallons using water, detergent, solvent, or hot water.

The DW55-ITR System is a unique self-contained drum washer that can wash 5 gallon pails and both closed and open top drums up to 85 gallons.

This system is capable of washing a wide range of residues from containers. Containers that have oil, solvent, fuel, inks and mastics can be washed in 40 seconds.

The DW55-ITR System can also be configured to include additional wash station(s). Each wash station has a station control box containing a start and stop button and an emergency stop button.

Each washing system can include an external recirculation tank with 250, 500 or 1000 gallon capacity depending on the number of wash stations.

Main Features

- Electrical requirement 480V (other options available)
- Internal recirculation tank 120 gallons capacity
- Controls: foot pedal
- Construction: 304 stainless steel

Optional Features

- External recirculation tank to increase washing capacity (250, 500 or 1000 gallons)
- Electric heaters for the internal and external recirculation tanks
- Explosion proof system
- Oil recovery skimmer system
- High impact nozzle
- Wash gun for external container washing
- Other optional features available

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7. Drum Washer DW55-IO



Model DW55-IO

The Drum Washer Model DW55-IO is designed to wash and rinse the interior and exterior of pails and drums sized up to 55 gallons using water, detergent, solvent, or hot water if the electric immersion heater option is selected.

The construction is heavy duty and includes an internal recirculation tank system with 220 gallon reservoir. This system uses high speed rotary nozzles. Washing the drums with a high speed rotary nozzle will deliver wash fluid to 100% of the interior and exterior of the drums or containers.

Standard Features

- Washes up to 55 gallon drums (steel and plastic)
- Washes interior & exterior of close top and open top drums
- Can use water, detergent or solvent
- Stainless steel construction
- Internal recirculation tank system 220 gallon capacity
- Fully adjustable wash timer. (1 sec. to 66 hours)
- Push button On/Off controls
- Stainless steel pressure building stack pump
- Portability with forklift truck
- Electrical control box Nema 4 Washdown
- Safety features to comply with OSHA

Optional Features

- Explosion proof system: when you have a hazardous area
- High impact wash nozzle
- Galvanized finish: protective coating of zinc to provide corrosion resistance
- MMF (Multi Media Filtration) system
- Complete caustic and acid plumbing package
- External recirculation tank to increase washing capacity (250, 500 or 1000 gallon capacity)
- Additional wash station (makes system two wash stations)
- Two (2) 10,000 watt electric immersion heaters for the recirculation tank to provide hot water
- Special cover to control fumes and/or retain heat if water is heated
- Oil recovery skimmer system for the 1000 gallons tank recirculation system
- Other optional features available

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8. Drum Washer Tunnel



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Drum Washer Tunnel Model DWT

The Drum Washer Tunnel Systems DWT Series is an automated conveyor/tunnel system designed for efficient drum cleaning, capable of washing and rinsing up to 100 drums per hour (DWT-100 Model) and 200 drums per hour (DWT-200 Model). Its adjustable conveyor speeds range from 1 to 24 feet per minute, allowing customization for various soil conditions.

The system features a custom-designed rotary wash/rinse arm for cleaning the drum's exterior and rotary pop-up nozzles for the interior, suitable for both open and closed-top drums. A single wash station includes a 1-inch stainless steel manifold with sixteen (16) 304 stainless steel fan jet nozzles, which rotate to clean the sides and top of the drum. For interior cleaning, a 400 RPM rotary pop-up spray nozzle ensures comprehensive coverage.

The DWT Series is designed for continuous operation and ships pre-plumbed and pre-wired, simplifying installation. Its modular design ensures seamless integration for a fully operational washing system. Capable of handling both light and heavy waste conditions, the DWT Series provides consistent, high-quality cleaning for industrial drum washing and cleaning processes.

Standard Features

- Washes up to 55 gallon drums (steel and plastic)
- Washes interior & exterior of open top drums
- Can use water, detergent or solvent
- General Construction Upper housing of the drum washing and rinsing chambers is constructed of 12 gauge 304 SS
- Fully adjustable conveyor speed (between 1 ft to 12 ft per minute)
- Push button On/Off controls
- Stainless steel pressure building stack pump
- Return pump
- Electrical control box Nema 4 washdown
- Safety features to comply with OSHA

Optional Features

- Explosion proof system: when you have a hazardous area
- Galvanized finish: protective coating of zinc to provide corrosion resistance
- MMF (Multi Media Filtration) system
- Complete caustic and acid plumbing package
- External recirculation tank to increase washing capacity (1000 gallon capacity)
- Two (2) 10,000 watt electric immersion heaters for the recirculation tank to provide hot water
- Oil recovery skimmer system for the 1000 gallons tank recirculation system
- Other optional features available

9. Drum Washer Crushers



TRC-7000



DWC-7000

Models TRC-7000 & DWC-7000

Our Drum Washer Crushers are dual-purpose systems engineered to wash and crush steel drums automatically within the same chamber.

The Drum Washer Crusher Model TRC-7000 is a dual purpose machine. It can be used to wash drums or/and to crush the drum in the same chamber.

The Drum Washer Crusher Model DWC-7000 is a single purpose machine. Used to wash and to crush the drum in the same chamber with a higher rate.

Standard Features

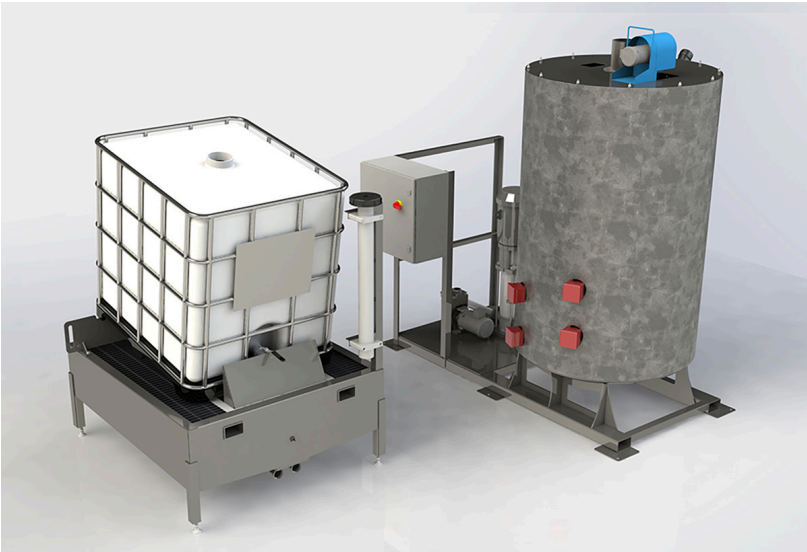
- Washes up to 55 gallon steel/plastic drums (85 gallon optional feature)
- Piercing point on the crushing plate
- Washes close top and open top drums (interior)
- Can use water, detergent or solvent
- Internal tank recirculation system 120 gallon capacity
- Stainless steel construction
- Fully adjustable wash timer. (1 sec. to 66 hours)
- Touch screen controls
- Stainless steel pressure building stack pump
- Portability with fork lift truck
- Electrical control box Nema 4 Washdown
- 220/ 440 volt, 3 phase 60/ 50 hertz
- Safety features to comply with OSHA

Optional Features

- Explosion proof system: when you have a hazardous area
- Chamber enlarged for washing/crushing 85 gallon drum
- Dual wash wand & nitrogen wand (DWC-7000)
- Automatic drum ejection system: for ejecting the crushed drum out of the chamber
- Automatic drum conveyor system: for moving the crushed drums to a dumpster
- Vent fan: heavy-duty
- Hepa filter: This type of air filter can remove at least 99.97% of airborne particles
- External recirculation tank to increase washing capacity (250, 500 or 1000 gallons)
- Galvanized finish: protective coating of zinc to provide corrosion resistance
- Portable options available
- Other optional features available

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10. IBC Tote Washer



Models TW-100

The IBC Tote Washer models TW-100 are specifically designed for washing and rinsing the interiors of totes and containers. The system is fully equipped with PLC controls and includes a 500-gallon Tank Recirculation System. All equipment functions are PLC controlled, ensuring that the cleaning standards for an IBC (Tote) are consistently repeatable, guaranteeing the same quality standards are met each time. Furthermore, all machine functions—and make-up water, if the auto-fill option is selected—are automated.

Drumbeaters TW-100 significantly increase productivity through automation and the use of high impact nozzle technology.

Standard Features

- Washes totes and 55 gallon drums (steel and plastic)
- Can use water, detergent or solvent
- High impact wash rotating nozzle
- Tote wash cap & nozzle assembly with 12ft. pressure hose
- Steel galvanized and stainless steel construction
- Tank recirculation system with 500 gallon capacity (1000 gallon optional)
- Tank construction: carbon steel or stainless steel
- Fully adjustable wash timer (1 sec. to 66 hours)
- Push button On/Off controls
- Stainless steel pressure building stack pump
- Electrical control box Nema 12
- 480 volt, 3 phase 60 hertz (other voltages & hertz available)
- Safety features to comply with OSHA

Optional Features

- Explosion proof system: when you have a hazardous area
- Immersion heaters for heating the cleaning solution (inside of the Tank Recirculation System)
- Oil recovery skimmer system (inside of the tank recirculation system)
- Custom configuration



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11. Recirculation Tanks



RT-250



RT-500



RT-1000

Models RT

These systems are constructed with 304 stainless steel and have a capacity of 250, 500 and 1000 gallons.

Our recirculation tank systems are equipped with a self priming centrifugal return pump.

Available Models

- RT-250: Recirculation Tank 250 Gallon Capacity
- RT-500: Recirculation Tank 500 Gallon Capacity
- RT-1000: Recirculation Tank 1000 Gallon Capacity

Optional Features

- Immersion heaters for heating the cleaning solution (inside of the Tank Recirculation System)
- Oil recovery skimmer system (inside of the tank recirculation system)
- Custom configuration

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12. Filtration System

MULTI-MEDIA FILTRATION & RECIRCULATION SYSTEM Model RTF-500



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Multimedia Filtration System RTF-500

The RTF-500 Multi-Media Filtration & Recirculation Tank System can be used with all of our washing systems and can also be used with our special water based cleaning solvents and degreasers. The RTF-500 is a versatile system that is designed to not only recirculate the wash fluid but to also clean the wash fluid using a combination of flocculation and a multi-media filtration bed.

The RTF-500 gives the user the ability to clean a wide range of residues from containers such as but limited to:

- Paints (water based & oil)
- Adhesives & mastics
- Most types of resins
- Almost any material with high solid content

Standard Features

- PLC control system
- Nema 4 Electrical enclosure
- Vertical multistage pressure pump
- Centrifugal return pump
- 304 stainless steel construction
- Bag filter & debris strainer
- Emergency stop button
- Forklift pockets for portability

Optional Features

- Nema 4X Electrical enclosure
- Nema 7 Electrical enclosure
- Hazardous classifications (EXP) components
- Increased pump output
- Heated flock tank & recirculation tank
- Steel cover panels (standard with all heat options)
- Electric oil skimmer
- Custom configuration

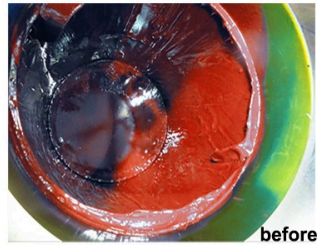
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13. Drum Cleaning Solvent

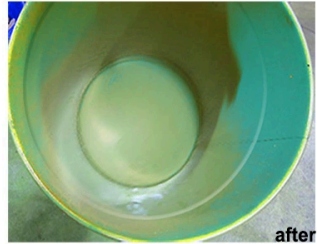
DRUM CLEANING SOLVENT CP1131949



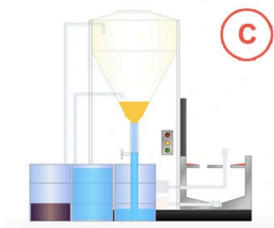
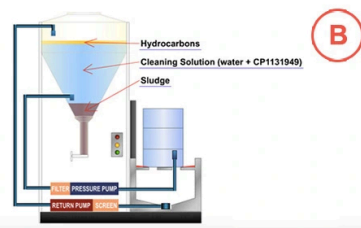
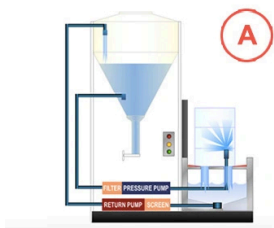
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before



after



- A.** You can mix 1 part of CP1131949 with upto 9 parts of water. This product cleans very aggressively when heated to 180F (82.22C) using a high speed rotary nozzle. Washing the drums with a high speed rotary nozzle will deliver wash fluid to 100% of the interior of the drums or containers.
- B.** You can decant your wash solution and dispose the residues from the bottom of the tank and remove all hydrocarbons and oils from the top.
- C.** You can storage and use the cleaning solvent over and over, you might lose about 5% of the solvent each time.

CP1131949 is Non Flammable - Biodegradable cleaning solution. This agent replaces the use of flammable solvents.

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Drumbeaters #CP1131949

Drumbeaters #CP1131949 is a special non flammable solvent that works with our Drum Washer Systems. You can mix one part of CP1131949 with nine parts of water. This product cleans very aggressively when heated to 180F (82.22C). Drumbeaters #CP1131949 is super efficient in removing oil, dirt and grease from the interior and exterior of drum's surfaces.

Using CP1131949 in our drum washing systems you can decant the wash solution and dispose the residues from the bottom of the tank and remove all hydrocarbons and oils from the top and use the cleaning solvent over and over, you might lose about 5% of the solvent each time and because you mix with water VOCs are not a problem when you are cleaning.

Features

- Low toxicity
- Natural based terpene
- Rapid biodegradation
- Non-ozone depleting
- Non-carcinogenic
- None to very faint pine odor
- Flash point over 93C/200F

Applications

- Oil
- Resins
- Glues
- Tar
- Grease
- Polymers
- Paints
- Coatings
- Silicones
- Asphalt
- Polyisocyanurate
- Polyurethane

14. Drum Plastic Recycle



Models IDS-55 & CDS-55

Our Plastic Drum Recycling Saw systems cut 55 US gallon plastic drums into pieces allowing your company to utilize smaller granulators to recycle the downsized large parts.

The Drum Saw Systems are powered with electrically operated motors operated by a programmed PLC manufactured by Omron

- The Industrial Drum Saw cuts 55 gallon plastic drums safely into 6 pieces.
- The Commercial Drum Saw cuts 55 gallon plastic drums safely into 4 pieces.
- Electrical requirements: 220 or 440 Volt. 50 or 60 hz. 3 Phase.



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15. Cryo-Cleaner® System



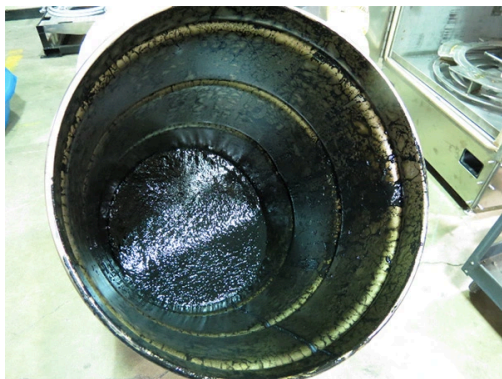
Innovative patented system which cleans residues from containers without the use of soaps, solvents or water

Clean metal or plastic containers without using soaps, solvents or water with our unique patented cryogenic cleaning system! Using the science of cryogenics, you can clean previously hard to handle products such as mastics, paints & resins (to name just a few) in an environmentally safe and economic fashion. Benefits include reduced plant operating costs, environmental compliance, a worker-friendly safe cleaning area, the ability to recycle residues for reuse and elimination of RCRA liability. Frozen plastic containers may also be smashed into small pieces for more economical disposal or recycling. By applying the science of cryogenics, we are able to provide companies an economical and efficient method to clean pails and drums.

This procedure results in not having to use solvents or other fluids to clean left over residues from containers and thereby reduces the volume of waste generated during the cleaning process.

Benefits of the Cryo-Cleaner® System

- **No Residue Contamination:** Removes residues without water, solvents, or soaps—allowing for clean, recyclable waste with no hazardous contamination.
- **Minimized Environmental Impact:** Uses inert, non-polluting liquid nitrogen, producing no harmful emissions or wastewater—safe for air, soil, and water systems.
- **No Added Waste Stream:** Since no cleaning agents are used, the waste volume remains minimal and uncontaminated—simplifying disposal or recycling.
- **Improved Worker Safety:** Suppresses harmful fumes (V.O.C.s), reduces contact with chemicals, and requires only standard protective gear.
- **Non-Combustible & Non-Corrosive:** Uses nitrogen, which is inert and safe compared to traditional chemical cleaners.
- **Recyclable & Reusable Containers:** Cleaned containers can be crushed for recycling or reused with minimal additional treatment.



Before



After



Frozen black dispersion material removed from drum

16. Our Company



Building Lasting Relationships and Achieving Success Across Industries

Collaborating with organizations of various sizes and spanning diverse industries worldwide, we have dedicated ourselves to our clients since our inception. Our commitment has led to notable successes and the establishment of enduring relationships.

Beyond manufacturing, Drumbeaters also provides recycling services to a broad spectrum of industries worldwide.

Privacy Policy

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All specifications and images shown in this marketing brochure are for informational and illustrative purposes. The actual design and specifications of the equipment may vary due to continuous product enhancements.

We are a global company.
We provide worldwide distribution.

We are the World Leader in Environmental Drum Disposal Engineering

Drumbeaters of America Inc. specializes in the engineering and manufacturing of systems for industrial companies aimed at reducing, transforming, and ideally eliminating waste products generated in manufacturing processes.

For over a quarter century, Drumbeaters of America has been designing and manufacturing systems that can wash, rinse, and crush drums, pack drums, remove residues from containers without increasing the waste stream, provide closed loop dispensing systems for viscous and air sensitive products, remove oil from soils, drill cuttings, and surfaces, and many more application solutions.

Our History

Established in 1991, Drumbeaters initially manufactured drum crushers to decrease the volume of steel drums for disposal or recycling not only for Crown but also for other companies through their sister company, Crown Fluid Applied Systems, and other local businesses. This endeavor led to the origin of the name “Drumbeaters” and marked the start of their journey.

The founders of Drumbeaters have leveraged their extensive experience to view waste handling and recycling as an opportunity to creatively address customers' waste challenges in unconventional ways. Drumbeaters aim to minimize waste volume and, wherever possible, completely eradicate waste through recycling or zero waste systems.

Our Location

Our company is staffed by mechanical and electrical engineers and operates a prototype fabrication and machine shop. All products and systems are finally assembled at Drumbeaters' facility in Elburn, Illinois, USA.

Equipment Financing

Drumbeaters of America, in partnership with Dimension Funding, offers financing that covers 100% of the costs for Drumbeaters' equipment, including shipping, installation, and maintenance. For more information visit: <https://www.drumbeaters.com/leasing>

Contact Us

Your satisfaction and the proper disposal of your drums are our top priorities. We look forward to connecting with you soon.

Drumbeaters of America Inc.

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<https://www.drumbeaters.com>

17. Our Clients

Drumbeaters' customers include Fortune 500 manufacturers, U.S. military installations, various governmental agencies, and waste remediation contractors. Its equipment has been dispatched globally, and the company has established sales and contacts with numerous European and global companies, maintaining a sales representation in Europe.

Over the last 26 years, Drumbeaters has cultivated a robust network of contacts among industrial hazardous waste generators and processors, as well as in the environmental enforcement field, gaining insights and developing solutions, building machinery, and offering environmental services.



- Elmendorf Air Force - USA
- Akzo Chemical Company - USA
- Akzo Nobel Company - USA
- Polygon - USA
- Aldrich Chemical - USA
- Solvay Polymers - USA
- American Cyanamid (BASF) - USA
- Chevron - Nigeria
- Chevron - Angola
- Power Company - Puerto Rico
- MagneTek - USA
- Delphi Automotive Systems - USA
- 3M Company - USA
- Des Moines Sanitary District - USA
- Base Ag-Chem Equip. Company - USA
- Eli Lilly - USA
- Ford Motors - USA
- General Motors - USA
- ISP Fine Chemicals - USA
- Knapheide Manufacturing - USA
- City of Philadelphia - USA
- Roche Pharmaceutical - USA
- Kraft Foods - USA
- United Nations - Mauritania
- United Nations - Mali
- AEC - Ecuador
- Encana - Ecuador
- Agip North Caspian Operating Co. - Kazakhstan

- Marine Corps Base Camp Lejeune - USA
- Merck - USA
- Alcan Toyo - USA
- Lockheed Advanced Development - USA
- Flinn - USA
- Doane Pet Care - USA
- Illiamiam - USA
- Lennox Industries - USA
- Rhodia California - USA
- Loctite FAS SpA - USA
- Dallas-Fort Worth Airport - USA
- Marine Corp Air Ground Combat - USA
- Merck Pharmaceutical - USA
- Naval Base - CBC - California - USA
- Protectoseal Company - USA
- Schering Plough - Singapore
- Sin Tung - Tahiti
- Allied Signal - USA
- St. Croix Alumina - USA
- Department of Defense Depo. - USA
- U.S. Electrical Motors - USA
- Wacker Chemie - Germany
- Wellman Inc. of Mississippi - USA
- Whirlpool Corporation - USA
- AeroJet Fine Chemical - USA
- Acme Refining - USA
- Chroma Source - USA
- Coastal - Aruba
- Croda - USA
- GM Corp. - USA
- Teledyne Brown - USA
- Vitaquest - USA
- Smurfit Stone - USA
- Kencoil - USA
- Ohio Edison - USA
- Iowa University - USA