BEVERAGE CAN DIVISION

PRODUCT SPECIFICATION

Version 71

Prepared by:	Rafał Gargol	Date: 2023.10.18	Signature 
Approved by:	Marcin Fijałkowski	Date: 2023.10.18	Signature 

WHAT IS NEW? CHANGES FROM V.70

Chapter	Change	Date	Status	Prepared by
1.1.33	Card for 500 NG2 have been removed from Specification	6/5/2023	Done	Michał Siedlik
1.2.45	Added a packaging option for Spanish Pallet 269ml/9,1oz with patttern for 330FIT	6/5/2023	Done	Michał Siedlik
1.2.4	Added a 355ml FIT Can on Swedish Pallet	6/5/2023	Done	Michał Siedlik
6.1	Chapter rename	24/08/2023	Done	Bianca Patrut
6.1.1 A)	Adding the PFAS NI description	24/08/2023	Done	Bianca Patrut
6.1.1 B)	Adding the PFAS NI description (Coatings combinations)	24/08/2023	Done	Bianca Patrut
6.1.1	Adding the labels examples in the new system	24/08/2023	Done	Bianca Patrut
6.1.1	Adding the LASER printed sleeve example	24/08/2023	Done	Bianca Patrut
6.2.1	Update of the coding for retort cans	24/08/2023	Done	Bianca Patrut
1.4.4	Codings update for Itumbiara and Maracanau, Colombia, Finland and Netehrlands	24/07/2023	Done	Bianca Patrut
1.4.2	Codings added for Muncie and Finland	24/07/2023	Done	Bianca Patrut
1.2.42	250 ml slim / 8,5 OZ SLIM - Spanish pallet / 2ND LAYOUT arrangement (598 cans per layer)"	8/3/2023	Done	Michał Siedlik
1.2.52	300 ml STD - Spanish pallet / 2ND LAYOUT arrangement (390 cans per layer)	8/3/2023	Done	Michał Siedlik
1.5.3	Adding PRINT Proof at the customers request	24/08/2023	Done	Bianca Patrut
3.1.4	Removed information about NGC Can and changing the seam thicknes only for 0,170	8/28/2023	Done	MJędrychowski
3.1.5	Removed information about NGC Can and changing the seam thicknes only for 0,170	8/28/2023	Done	MJędrychowski
3.2.2	Removed information about NGC CAN	8/28/2023	Done	MJędrychowski
3.2.6	Removed information about NGC CAN	8/28/2023	Done	MJędrychowski
3.2.1	Removed information about NGC CAN	8/28/2023	Done	MJędrychowski
2.2.11	Changed of final palet drawing , adding information about cardboard cap	8/28/2023	Done	MJędrychowski
2.2.22	Changed of final palet drawing, adding information about cardboard cap	8/28/2023	Done	MJędrychowski
2.2.24	Changed of final palet drawing , adding information about cardboard cap	8/28/2023	Done	MJędrychowski
6.1.1	Changed drawing of sleeves and adding information about new type of marking sleeves	8/28/2023	Done	MJędrychowski
2.2.3	Adding information about the new type of marking the sleeves (sleeves without text cdl etc.) Site only for marked sleeves	9/11/2023	Done	MJędrychowski
2.2.4	Changing the table with information of marking of the sleeves locations	9/11/2023	Done	MJędrychowski
3.1.1	Adding the information about free space, seam gap, tightness raiting, BHB and Countersink depth. Changing the drawing with value F	9/11/2023	Done	MJędrychowski
3.1.2	Adding the information about free space, seam gap, tightness raiting, BHB and Countersink depth. Changing the drawing with value F	9/11/2023	Done	MJędrychowski
3.1.3	Adding the information about free space, seam gap, tightness raiting, BHB and Countersink depth. Changing the drawing with value F	9/11/2023	Done	MJędrychowski
3.1.4	Adding the information about free space, seam gap, tightness raiting, BHB and Countersink depth. Changing the drawing with value F	9/11/2023	Done	MJędrychowski
3.1.5	Adding the information about free space, seam gap, tightness raiting, BHB and Countersink depth. Changing the drawing with value F	9/11/2023	Done	MJędrychowski
3.1.6	Adding the information about free space, seam gap, tightness raiting, BHB and Countersink depth. Changing the drawing with value F	9/11/2023	Done	MJędrychowski
1.2.64	269 ml FIT - Addition of new arrangement - 493 cans per layer	9/15/2023	Done	Michał Siedlik
1.2.96	Added an American Pallet for 269ml/9,1oz FIT with 2 layouts 493 and 528 cans per layer	4/14/2023	Done	Michał Siedlik
2.1.3	Deleting information about RPT END	15/11/2023	Done	MJędrychowski
2.1.7	Deleting information about RPT END	15/11/2023	Done	MJędrychowski
2.1.22	Deleting information about RPT TAB	15/11/2023	Done	MJędrychowski

INTRODUCTION

The CANPACK production of beverage cans is realized in nineteen production plants.
The factories are located in;

- Poland (Brzesko and Bydgoszcz),
- Ukraine (Vyshgorod),
- Romania (Bucharest),
- United Arab Emirates (Dubai),
- United Kingdom (Scunthorpe),
- India (Aurangabad and Nuh),
- Russia (Volokolamsk and Novocherkassk),
- Morocco (Casablanca),
- Finland (Hämeenlinna),
- Netherlands (Helmond),
- Brazil (Maracanau and Itumbiara),
- Colombia (Tocancipá),
- Czech Republic (Stříbro),
- United States of America (Olyphant),
- United States of America (Muncie).

Our company offers beverage cans having capacities of:
150ml, 185ml, 200ml, 222ml, 240ml, 250ml, 269ml, 300ml, 330ml, 350ml, 355ml, 440ml, 449ml, 473ml, 500ml, 550ml, 568ml, 710ml.

For the above mentioned beverage cans, we offer easy-open ends B64 and CDL in the following sizes:
- 200 SOE STD/LOE,
- 202 SOE STD/LOE,
- 206 SOE LOE.

The CANPACK production of easy-open ends is realized at five production lines, located in:

- Poland (Brzesko and Bydgoszcz),
- United Arab Emirates (Dubai),
- Brazil (Maracanau).
- United States of America (Olyphant)

Additionally, our company provides service for seaming machines and service visits at filling lines at beverage factories direct locations.

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CANPACK uses an IMS Policy that guarantees that the Company produces safe and high quality products that are achieved, based on an implemented and integrated management systems, in compliance with international standards. CANPACK is an innovative company using advanced production technologies for its development. The Company also makes new investments in the development field. In 1999 the CANPACK Group, as the first company in Poland, initiated a recycling program for beverage cans made of aluminium (ACRS – Aluminium Can Recycling System). This program allowed companies to segregate waste materials and to introduce segregated collection of other used packagings made of aluminium.
CANPACK had received the Innovation Certificate in 2005 and had finished as the 140th company in the list of 500 most innovate companies in Poland, list prepared by the Polish Science Academy. Our products are made of materials of the best possible quality, meeting the EU and FDA requirements and having all necessary certificates.
In its processes, CANPACK produces goods in accordance to the WORLD CLASS MANUFACTURING methods. By continous staff trainings, the company strives to achieve ambitious and high quality manufacturing processes, together with the highest achievable productivity. Thanks to a constant work in the matter of quality and production improvements, CANPACK has gained the trust of many respected companies all over the world in just few years.

Please, find below the addresses where you can get support or additional information.

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Transfer, disclosure or any other use of such informations without a consent of the Company, as well as acquiring it from an unauthorized third party, represents an act of unfair competition.

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TABLE OF CONTENTS

TABLE OF CONTENTS

TABLE OF CONTENTS

TABLE OF CONTENTS

TABLE OF CONTENTS

CAN - BASIC INFORMATION

CAN - BASIC INFORMATION

1.1.1 SPECIFICATION OF THE ALUMINIUM BEVERAGE CANS

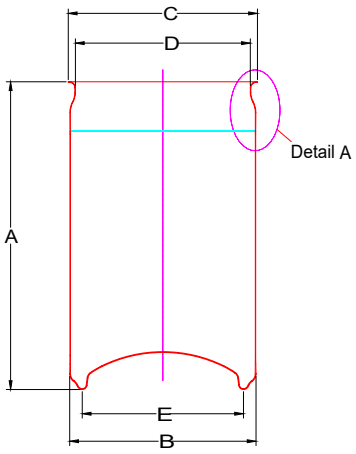
CAN type		Chapter	Capacity (ml)		Designated location	Dedicated END Type	Height	
Market Name	Body Type		[ml]	[us fl oz]			[mm]	[in]
Slim	202	1.1.2	150	5,1		200	88,40	3,480
		1.1.3	185	6,3		200	103,38	4,070
		1.1.4	200	6,8		200	111,20	4,378
		1.1.5	240	8,1		200	130,00	5,118
		1.1.6	250	8,5		200	134,00	5,276
FIT	204	1.1.7	200	6,8		200	95,20	3,748
		1.1.8	200	6,8		202	95,20	3,748
		1.1.9	222	7,5	NA	202	103,84	4,088
		1.1.10	269	9,1	SA	200	122,22	4,812
		1.1.11	269	9,1	SA	202	122,22	4,812
		1.1.12	300	10,1		200	133,89	5,271
		1.1.13	300	10,1		202	133,89	5,271
		1.1.14	330	11,2		200	145,40	5,724
		1.1.15	330	11,2		202	145,40	5,724
		1.1.16	355	12,0		200	156,90	6,177
		1.1.17	355	12,0		202	156,90	6,177
		1.1.18	355	12,0	NA	202	155,63	6,127
		1.1.19	355	12,0	ME	200	156,60	6,165
		1.1.20	355	12,0	ME	202	156,60	6,165
LongFIT	209	1.1.21	449	15,2		202	168,00	6,614
STD	211	1.1.22	300	10,1		202	106,27	4,184
		1.1.23	330	11,2		202	115,20	4,535
		1.1.24	330	11,2	SA	202	115,20	4,535
		1.1.25	350	11,8	SA	202	122,22	4,812
		1.1.26	355	12,0		202	122,22	4,812
		1.1.27	355	12,0	NA	202	122,22	4,812
		1.1.28	355	12,0	SA	202	122,22	4,812
		1.1.29	440	14,9		202	149,90	5,902
		1.1.30	473	16,0	NA	202	157,23	6,190
		1.1.31	473	16,0	SA	202	157,23	6,190
		1.1.32	500	16,9		202	168,00	6,614
		1.1.33	550	18,6		202	182,65	7,191
		1.1.34	550	18,6	SA	202	182,50	7,185
		1.1.35	568	19,2		202	188,09	7,405
STD EMBOSS	211	1.1.36	330	11,2	PL	202	115,20	4,535
		1.1.37	500	16,9	PL	202	168,00	6,614
	300	1.1.38	710	24,0	NA	206	193,29	7,610

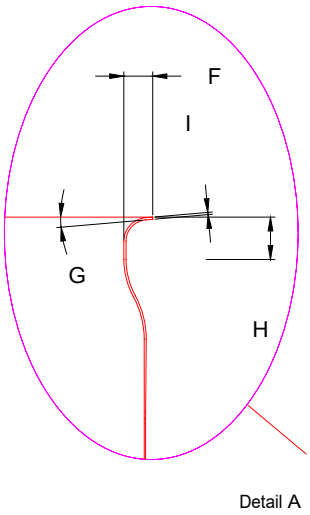
Locations:
NA - North America, SA - South America, ME - Middle East, RU - Russia, IN - India, PL - Poland

Product:	Date:	Type:	Chapter:
ALUMINIUM BEVERAGE CAN PORTFOLIO	01.01.2022	Aluminium cans	1.1.1
	Revision: 4	Approved by:	

CAN - BASIC INFORMATION

1.1.2 ALUMINIUM BEVERAGE CAN 150 ML / 5,1 OZ SLIM / EOE 200



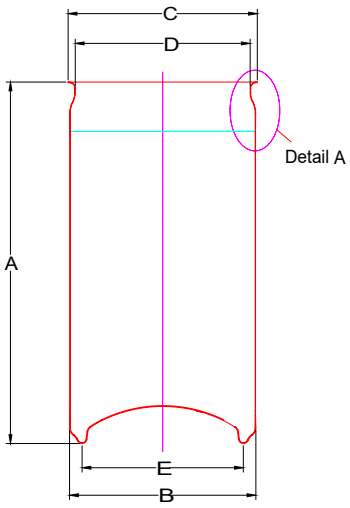


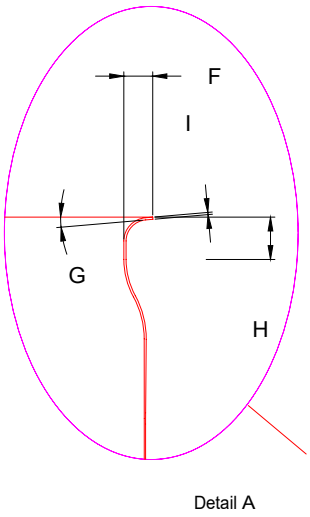
CAN Parameters/Properties						
Units system	**Metric**			**Imperial**		
Capacity	**[ml]**	**150**	**-**	**[us fl oz]**	**5,1**	**-**
A - Can height	**[mm]**	**88,40**	**+/- 0,30**	**[In]**	**3,480**	**+/- 0,012**
B - Outside diameter	**[mm]**	**53,40**	**max**	**[In]**	**2,102**	**max**
C - Flange diameter	**[mm]**	**55,00**	**max**	**[In]**	**2,165**	**max**
D - Inside neck diameter	**[mm]**	**50,00**	**+/- 0,30**	**[In]**	**1,969**	**+/- 0,012**
E - Base diameter	**[mm]**	**46,10**	**max**	**[In]**	**1,815**	**max**
F - Flange width	**[mm]**	**2,08**	**+/- 0,25**	**[In]**	**0,082**	**+/- 0,010**
G - Flange angle	**[°]**	**0 - 12**	**-**	**[°]**	**0 - 12**	**-**
H - Neck seaming clearance	**[mm]**	**3,05**	**min**	**[In]**	**0,120**	**min**
I - Flange thickness	**[mm]**	**0,160**	**+/- 0,015**	**[In]**	**0,0063**	**+/- 0,0006**
Inside pressure	**[kPa]**	**620**	**min**	**[psi]**	**90**	**min**
Axial load	**[N]**	**675**	**min**	**[lbf]**	**152**	**min**
Matching END Type	**Type**	**200 END**				
Material	**Type**	**Aluminium Alloy**				
Inside lacquer	**Type**	**Water base**				

Product:	Date:	Type:	Chapter:
ALUMINIUM BEVERAGE CAN	01.01.2022	202/200/200 SLIM Body/Dome/Neck	1.1.2
	Revision: 6	Approved by:	

CAN - BASIC INFORMATION

1.1.3 ALUMINIUM BEVERAGE CAN 185 ML / 6,3 OZ SLIM / EOE 200



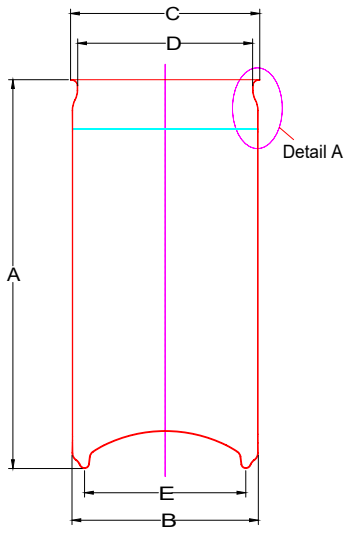


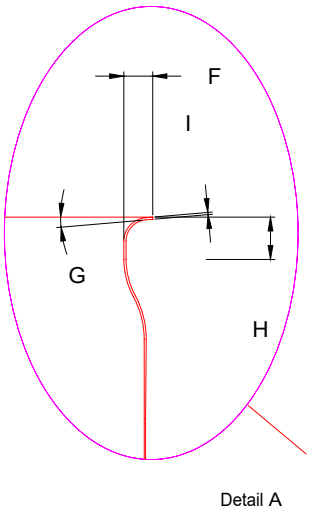
CAN Parameters/Properties						
Units system	**Metric**			**Imperial**		
Capacity	**[ml]**	**185**	**-**	**[us fl oz]**	**6,3**	**-**
A - Can height	**[mm]**	**103,38**	**+/- 0,30**	**[In]**	**4,070**	**+/- 0,012**
B - Outside diameter	**[mm]**	**53,40**	**max**	**[In]**	**2,102**	**max**
C - Flange diameter	**[mm]**	**55,00**	**max**	**[In]**	**2,165**	**max**
D - Inside neck diameter	**[mm]**	**50,00**	**+/- 0,30**	**[In]**	**1,969**	**+/- 0,012**
E - Base diameter	**[mm]**	**46,10**	**max**	**[In]**	**1,815**	**max**
F - Flange width	**[mm]**	**2,08**	**+/- 0,25**	**[In]**	**0,082**	**+/- 0,010**
G - Flange angle	**[°]**	**0 - 12**	**-**	**[°]**	**0 - 12**	**-**
H - Neck seaming clearance	**[mm]**	**3,05**	**min**	**[In]**	**0,120**	**min**
I - Flange thickness	**[mm]**	**0,160**	**+/- 0,015**	**[In]**	**0,0063**	**+/- 0,0006**
Inside pressure	**[kPa]**	**620**	**min**	**[psi]**	**90**	**min**
Axial load	**[N]**	**675**	**min**	**[lbf]**	**152**	**min**
Matching END Type	**Type**	**200 END**				
Material	**Type**	**Aluminium Alloy**				
Inside lacquer	**Type**	**Water base**				

Product:	Date:	Type:	Chapter:
ALUMINIUM BEVERAGE CAN	01.01.2022	202/200/200 SLIM Body/Dome/Neck	1.1.3
	Revision: 6	Approved by:	

CAN - BASIC INFORMATION

1.1.4 ALUMINIUM BEVERAGE CAN 200 ML / 6,8 OZ SLIM / EOE 200



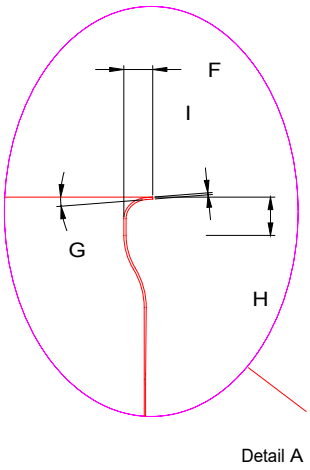


CAN Parameters/Properties						
Units system	**Metric**			**Imperial**		
Capacity	**[ml]**	**200**	**-**	**[us fl oz]**	**6,8**	**-**
A - Can height	**[mm]**	**111,20**	**+/- 0,30**	**[In]**	**4,378**	**+/- 0,012**
B - Outside diameter	**[mm]**	**53,40**	**max**	**[In]**	**2,102**	**max**
C - Flange diameter	**[mm]**	**55,00**	**max**	**[In]**	**2,165**	**max**
D - Inside neck diameter	**[mm]**	**50,00**	**+/- 0,30**	**[In]**	**1,969**	**+/- 0,012**
E - Base diameter	**[mm]**	**46,10**	**max**	**[In]**	**1,815**	**max**
F - Flange width	**[mm]**	**2,08**	**+/- 0,25**	**[In]**	**0,082**	**+/- 0,010**
G - Flange angle	**[°]**	**0 - 12**	**-**	**[°]**	**0 - 12**	**-**
H - Neck seaming clearance	**[mm]**	**3,05**	**min**	**[In]**	**0,120**	**min**
I - Flange thickness	**[mm]**	**0,160**	**+/- 0,015**	**[In]**	**0,0063**	**+/- 0,0006**
Inside pressure	**[kPa]**	**620**	**min**	**[psi]**	**90**	**min**
Axial load	**[N]**	**675**	**min**	**[lbf]**	**152**	**min**
Matching END Type	**Type**	**200 END**				
Material	**Type**	**Aluminium Alloy**				
Inside lacquer	**Type**	**Water base**				

Product:	Date:	Type:	Chapter:
ALUMINIUM BEVERAGE CAN	01.01.2022	202/200/200 SLIM Body/Dome/Neck	1.1.4
	Revision: 6	Approved by:	

CAN - BASIC INFORMATION

1.1.5 ALUMINIUM BEVERAGE CAN 240 ML / 8,1 OZ SLIM / EOE 200

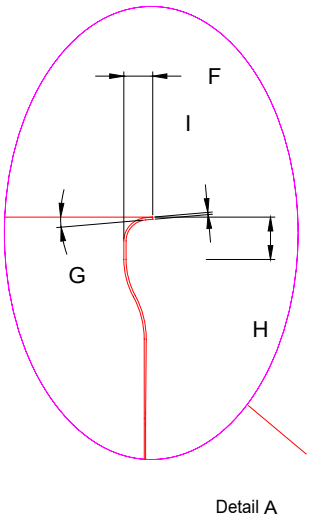


CAN Parameters/Properties						
Units system	**Metric**			**Imperial**		
Capacity	**[ml]**	**240**	**-**	**[us fl oz]**	**8,1**	**-**
A - Can height	**[mm]**	**130,00**	**+/- 0,30**	**[In]**	**5,118**	**+/- 0,012**
B - Outside diameter	**[mm]**	**53,40**	**max**	**[In]**	**2,102**	**max**
C - Flange diameter	**[mm]**	**55,00**	**max**	**[In]**	**2,165**	**max**
D - Inside neck diameter	**[mm]**	**50,00**	**+/- 0,30**	**[In]**	**1,969**	**+/- 0,012**
E - Base diameter	**[mm]**	**46,10**	**max**	**[In]**	**1,815**	**max**
F - Flange width	**[mm]**	**2,08**	**+/- 0,25**	**[In]**	**0,082**	**+/- 0,010**
G - Flange angle	**[°]**	**0 - 12**	**-**	**[°]**	**0 - 12**	**-**
H - Neck seaming clearance	**[mm]**	**3,05**	**min**	**[In]**	**0,120**	**min**
I - Flange thickness	**[mm]**	**0,160**	**+/- 0,015**	**[In]**	**0,0063**	**+/- 0,0006**
Inside pressure	**[kPa]**	**620**	**min**	**[psi]**	**90**	**min**
Axial load	**[N]**	**675**	**min**	**[lbf]**	**152**	**min**
Matching END Type	**Type**	**200 END**				
Material	**Type**	**Aluminium Alloy**				
Inside lacquer	**Type**	**Water base**				

Product:	Date:	Type:	Chapter:
ALUMINIUM BEVERAGE CAN	01.01.2022	202/200/200 SLIM Body/Dome/Neck	1.1.5
	Revision: 6	Approved by:	

CAN - BASIC INFORMATION

1.1.6 ALUMINIUM BEVERAGE CAN 250 ML / 8,5 OZ SLIM / EOE 200

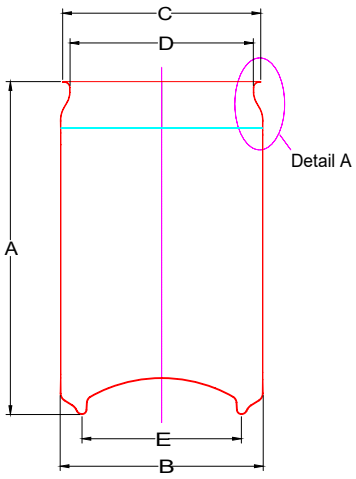


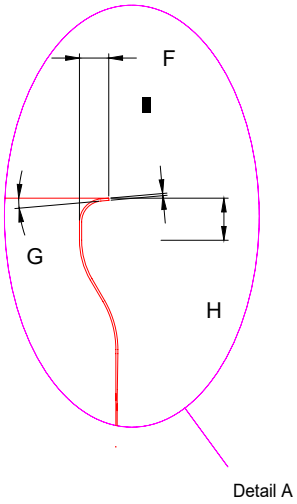
CAN Parameters/Properties						
Units system	**Metric**			**Imperial**		
Capacity	**[ml]**	**250**	**-**	**[us fl oz]**	**8,5**	**-**
A - Can height	**[mm]**	**134,00**	**+/- 0,30**	**[In]**	**5,276**	**+/- 0,012**
B - Outside diameter	**[mm]**	**53,40**	**max**	**[In]**	**2,102**	**max**
C - Flange diameter	**[mm]**	**55,00**	**max**	**[In]**	**2,165**	**max**
D - Inside neck diameter	**[mm]**	**50,00**	**+/- 0,30**	**[In]**	**1,969**	**+/- 0,012**
E - Base diameter	**[mm]**	**46,10**	**max**	**[In]**	**1,815**	**max**
F - Flange width	**[mm]**	**2,08**	**+/- 0,25**	**[In]**	**0,082**	**+/- 0,010**
G - Flange angle	**[°]**	**0 - 12**	**-**	**[°]**	**0 - 12**	**-**
H - Neck seaming clearance	**[mm]**	**3,05**	**min**	**[In]**	**0,120**	**min**
I - Flange thickness	**[mm]**	**0,160**	**+/- 0,015**	**[In]**	**0,0063**	**+/- 0,0006**
Inside pressure	**[kPa]**	**620**	**min**	**[psi]**	**90**	**min**
Axial load	**[N]**	**675**	**min**	**[lbf]**	**152**	**min**
Matching END Type	**Type**	**200 END**				
Material	**Type**	**Aluminium Alloy**				
Inside lacquer	**Type**	**Water base**				

Product:	Date:	Type:	Chapter:
ALUMINIUM BEVERAGE CAN	01.01.2022	202/200/200 SLIM Body/Dome/Neck	1.1.6
	Revision: 6	Approved by:	

CAN - BASIC INFORMATION

1.1.7 ALUMINIUM BEVERAGE CAN 200 ML / 6,8 OZ FIT / EOE 200



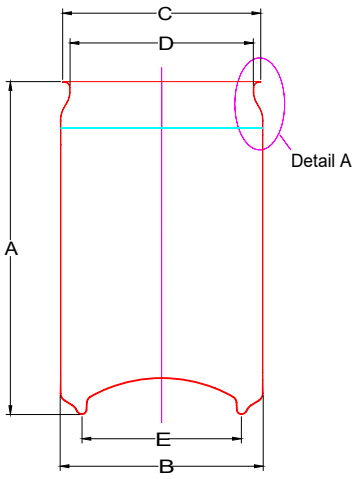


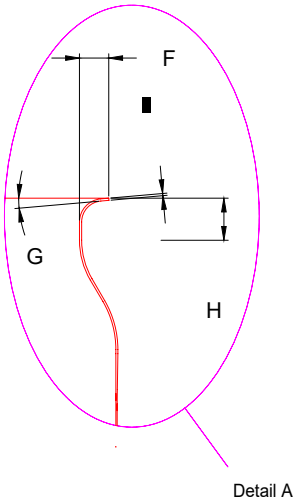
CAN Parameters/Properties						
Units system	**Metric**			**Imperial**		
Capacity	**[ml]**	**200**	**-**	**[us fl oz]**	**6,8**	**-**
A - Can height	**[mm]**	**95,20**	**+/- 0,30**	**[In]**	**3,748**	**+/- 0,012**
B - Outside diameter	**[mm]**	**58,10**	**max**	**[In]**	**2,287**	**max**
C - Flange diameter	**[mm]**	**55,00**	**max**	**[In]**	**2,165**	**max**
D - Inside neck diameter	**[mm]**	**50,00**	**+/- 0,30**	**[In]**	**1,969**	**+/- 0,012**
E - Base diameter	**[mm]**	**45,57**	**max**	**[In]**	**1,794**	**max**
F - Flange width	**[mm]**	**2,08**	**+/- 0,25**	**[In]**	**0,082**	**+/- 0,010**
G - Flange angle	**[°]**	**0 - 12**	**-**	**[°]**	**0 - 12**	**-**
H - Neck seaming clearance	**[mm]**	**3,05**	**min**	**[In]**	**0,120**	**min**
I - Flange thickness	**[mm]**	**0,165**	**+/- 0,015**	**[In]**	**0,0065**	**+/- 0,0006**
Inside pressure	**[kPa]**	**620**	**min**	**[psi]**	**90**	**min**
Axial load	**[N]**	**675**	**min**	**[lbf]**	**152**	**min**
Matching END Type	**Type**	**200 END**				
Material	**Type**	**Aluminium Alloy**				
Inside lacquer	**Type**	**Water base**				

Product:	Date:	Type:	Chapter:
ALUMINIUM BEVERAGE CAN	01.01.2022	204/200/200 FIT Body/Dome/Neck	1.1.7
	Revision: 3	Approved by:	

CAN - BASIC INFORMATION

1.1.8 ALUMINIUM BEVERAGE CAN 200 ML / 6,8 OZ FIT / EOE 202

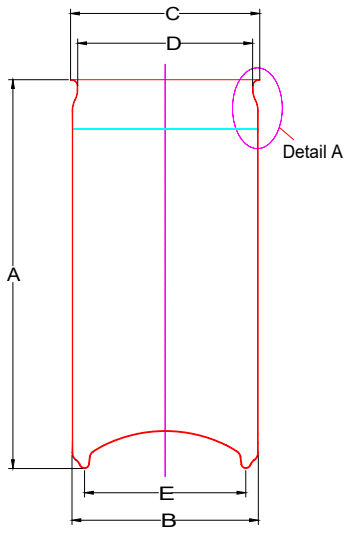


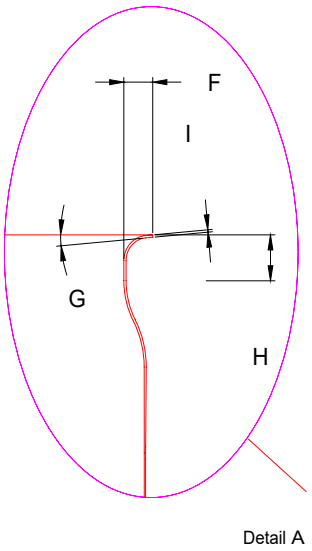


CAN Parameters/Properties						
Units system	**Metric**			**Imperial**		
Capacity	**[ml]**	**200**	**-**	**[us fl oz]**	**6,8**	**-**
A - Can height	**[mm]**	**95,2**	**+/- 0,30**	**[In]**	**3,748**	**+/- 0,012**
B - Outside diameter	**[mm]**	**58,1**	**max**	**[In]**	**2,287**	**max**
C - Flange diameter	**[mm]**	**57,50**	**max**	**[In]**	**2,264**	**max**
D - Inside neck diameter	**[mm]**	**52,40**	**+/- 0,30**	**[In]**	**2,063**	**+/- 0,012**
E - Base diameter	**[mm]**	**45,57**	**max**	**[In]**	**1,794**	**max**
F - Flange width	**[mm]**	**2,13**	**+/- 0,25**	**[In]**	**0,084**	**+/- 0,010**
G - Flange angle	**[°]**	**0 - 12**	**-**	**[°]**	**0 - 12**	**-**
H - Neck seaming clearance	**[mm]**	**3,05**	**min**	**[In]**	**0,120**	**min**
I - Flange thickness	**[mm]**	**0,165**	**+/- 0,015**	**[In]**	**0,0065**	**+/- 0,0006**
Inside pressure	**[kPa]**	**620**	**min**	**[psi]**	**90**	**min**
Axial load	**[N]**	**675**	**min**	**[lbf]**	**152**	**min**
Matching END Type	**Type**	**202 END**				
Material	**Type**	**Aluminium Alloy**				
Inside lacquer	**Type**	**Water base**				

Product:	Date:	Type:	Chapter:
ALUMINIUM BEVERAGE CAN	01.01.2022	204/200/202 FIT Body/Dome/Neck	1.1.8
	Revision: 3	Approved by:	

1.1.9 ALUMINIUM BEVERAGE CAN 222 ML / 7,5 OZ FIT / EOE 202



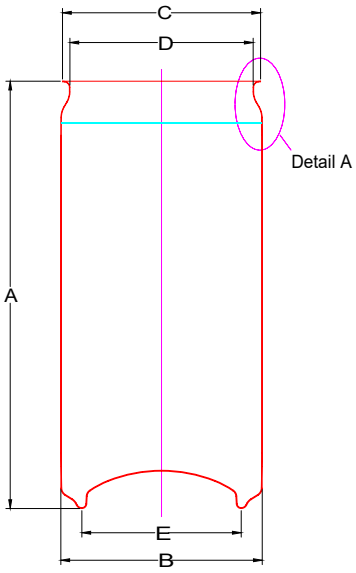


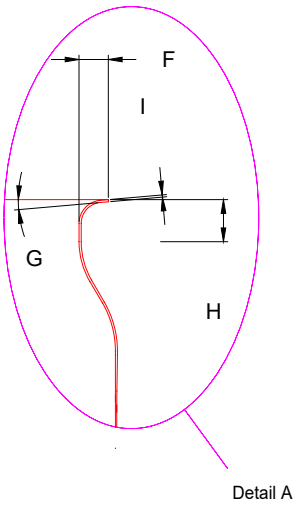
CAN Parameters/Properties						
Units system	**Metric**			**Imperial**		
Capacity	**[ml]**	**222**	**-**	**[us fl oz]**	**7,5**	**-**
A - Can height	**[mm]**	**103,84**	**+/- 0,30**	**[In]**	**4,088**	**+/- 0,012**
B - Outside diameter	**[mm]**	**57,60**	**max**	**[In]**	**2,268**	**max**
C - Flange diameter	**[mm]**	**57,50**	**max**	**[In]**	**2,264**	**max**
D - Inside neck diameter	**[mm]**	**52,40**	**+/- 0,30**	**[In]**	**2,063**	**+/- 0,012**
E - Base diameter	**[mm]**	**45,57**	**max**	**[In]**	**1,794**	**max**
F - Flange width	**[mm]**	**2,11**	**+/- 0,25**	**[In]**	**0,083**	**+/- 0,010**
G - Flange angle	**[°]**	**0 - 12**	**-**	**[°]**	**0 - 12**	**-**
H - Neck seaming clearance	**[mm]**	**3,05**	**min**	**[In]**	**0,120**	**min**
I - Flange thickness	**[mm]**	**0,165**	**+/- 0,015**	**[In]**	**0,0065**	**+/- 0,0006**
Inside pressure	**[kPa]**	**620**	**min**	**[psi]**	**90**	**min**
Axial load	**[N]**	**675**	**min**	**[lbf]**	**152**	**min**
Matching END Type	**Type**	**202 END**				
Material	**Type**	**Aluminium Alloy**				
Inside lacquer	**Type**	**Water base**				

Product:	Date:	Type:	Chapter:
ALUMINIUM BEVERAGE CAN	01.01.2022	204/200/202 FIT Body/Dome/Neck	1.1.9
	Revision: 1	Approved by:	

CAN - BASIC INFORMATION/South America

1.1.10 ALUMINIUM BEVERAGE CAN 269 ML / 9,1 OZ FIT / EOE 200



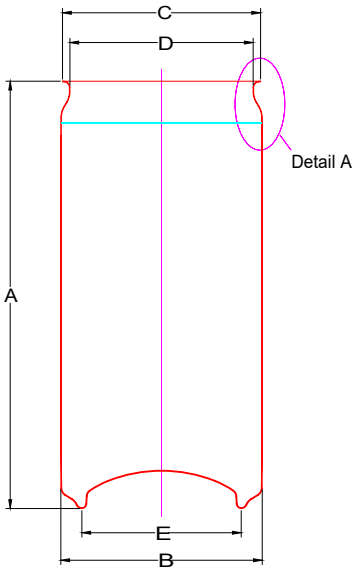


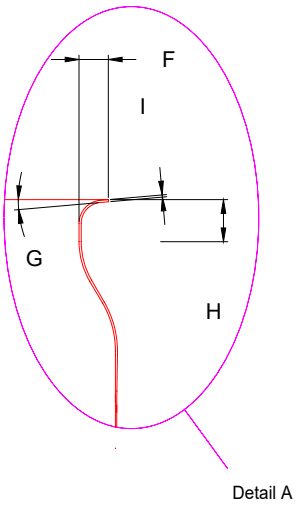
CAN Parameters/Properties						
Unit system	**Metric**			**Imperial**		
Capacity	**[ml]**	**269**	**-**	**[us fl oz]**	**9,1**	**-**
A - Can height	**[mm]**	**122,22**	**+/- 0,30**	**[In]**	**4,812**	**+/- 0,012**
B - Outside diameter	**[mm]**	**57,60**	**max**	**[In]**	**2,268**	**max**
C - Flange diameter	**[mm]**	**55,00**	**max**	**[In]**	**2,165**	**max**
D - Inside neck diameter	**[mm]**	**50,00**	**+/- 0,30**	**[In]**	**1,969**	**+/- 0,012**
E - Base diameter	**[mm]**	**45,57**	**max**	**[In]**	**1,794**	**max**
F - Flange width	**[mm]**	**2,08**	**+/- 0,25**	**[In]**	**0,082**	**+/- 0,010**
G - Flange angle	**[°]**	**0 - 12**	**-**	**[°]**	**0 - 12**	**-**
H - Neck seaming clearance	**[mm]**	**3,05**	**min**	**[In]**	**0,120**	**min**
I - Flange thickness	**[mm]**	**0,165**	**+/- 0,015**	**[In]**	**0,0065**	**+/- 0,0006**
Inside pressure	**[kPa]**	**620**	**min**	**[psi]**	**90**	**min**
Axial load	**[N]**	**675**	**min**	**[lbf]**	**152**	**min**
Matching END Type	**Type**	**200 END**				
Material	**Type**	**Aluminium Alloy**				
Inside lacquer	**Type**	**Water base**				

Product:	Date:	Type:	Chapter:
ALUMINIUM BEVERAGE CAN	01.01.2022	204/200/200 FIT Body/Dome/Neck	1.1.10
	Revision: 3	Approved by:	

CAN - BASIC INFORMATION/South America

1.1.11 ALUMINIUM BEVERAGE CAN 269 ML / 9,1 OZ FIT / EOE 202



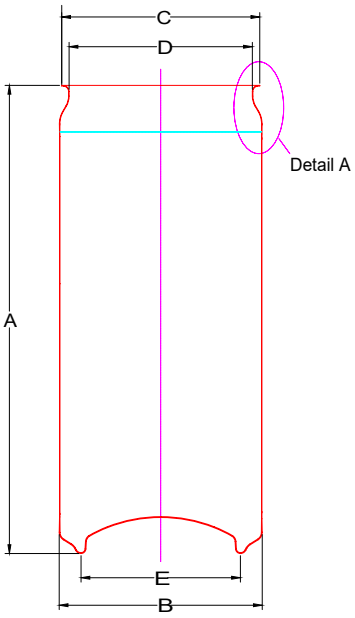


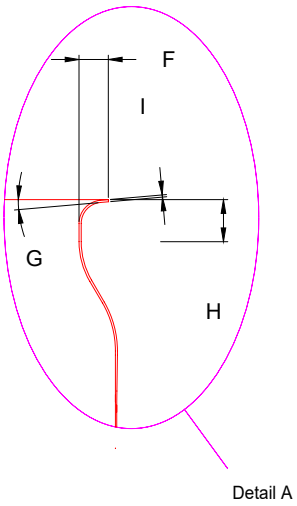
CAN Parameters/Properties						
Units system	**Metric**			**Imperial**		
Capacity	**[ml]**	**269**	**-**	**[us fl oz]**	**9,1**	**-**
A - Can height	**[mm]**	**122,22**	**+/- 0,30**	**[In]**	**4,812**	**+/- 0,012**
B - Outside diameter	**[mm]**	**57,60**	**max**	**[In]**	**2,268**	**max**
C - Flange diameter	**[mm]**	**57,50**	**max**	**[In]**	**2,264**	**max**
D - Inside neck diameter	**[mm]**	**52,40**	**+/- 0,30**	**[In]**	**2,063**	**+/- 0,012**
E - Base diameter	**[mm]**	**45,57**	**max**	**[In]**	**1,794**	**max**
F - Flange width	**[mm]**	**2,13**	**+/- 0,25**	**[In]**	**0,084**	**+/- 0,010**
G - Flange angle	**[°]**	**0 - 12**	**-**	**[°]**	**0 - 12**	**-**
H - Neck seaming clearance	**[mm]**	**3,05**	**min**	**[In]**	**0,120**	**min**
I - Flange thickness	**[mm]**	**0,165**	**+/- 0,015**	**[In]**	**0,0065**	**+/- 0,0006**
Inside pressure	**[kPa]**	**620**	**min**	**[psi]**	**90**	**min**
Axial load	**[N]**	**675**	**min**	**[lbf]**	**152**	**min**
Matching END Type	**Type**	**202 END**				
Material	**Type**	**Aluminium Alloy**				
Inside lacquer	**Type**	**Water base**				

Product:	Date:	Type:	Chapter:
ALUMINIUM BEVERAGE CAN	01.01.2022	204/200/202 FIT Body/Dome/Neck	1.1.11
	Revision: 3	Approved by:	

CAN - BASIC INFORMATION

1.1.12 ALUMINIUM BEVERAGE CAN 300 ML / 10,1 OZ FIT / EOE 200



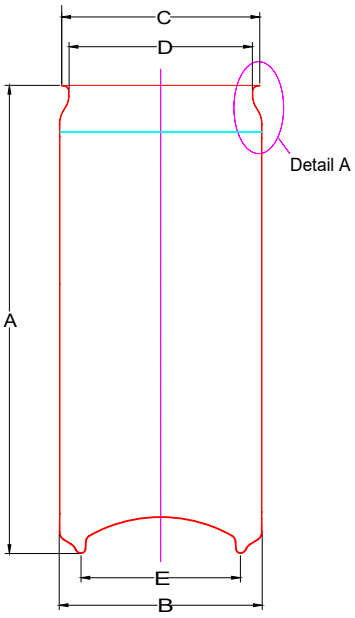


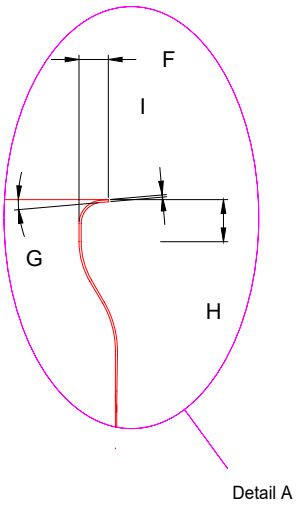
CAN Parameters/Properties						
Units system	**Metric**			**Imperial**		
Capacity	**[ml]**	**300**	**-**	**[us fl oz]**	**10,1**	**-**
A - Can height	**[mm]**	**133,89**	**+/- 0,30**	**[In]**	**5,271**	**+/- 0,012**
B - Outside diameter	**[mm]**	**58,10**	**max**	**[In]**	**2,287**	**max**
C - Flange diameter	**[mm]**	**55,00**	**max**	**[In]**	**2,165**	**max**
D - Inside neck diameter	**[mm]**	**50,00**	**+/- 0,30**	**[In]**	**1,969**	**+/- 0,012**
E - Base diameter	**[mm]**	**45,57**	**max**	**[In]**	**1,794**	**max**
F - Flange width	**[mm]**	**2,08**	**+/- 0,25**	**[In]**	**0,082**	**+/- 0,010**
G - Flange angle	**[°]**	**0 - 12**	**-**	**[°]**	**0 - 12**	**-**
H - Neck seaming clearance	**[mm]**	**3,05**	**min**	**[In]**	**0,120**	**min**
I - Flange thickness	**[mm]**	**0,165**	**+/- 0,015**	**[In]**	**0,0065**	**+/- 0,0006**
Inside pressure	**[kPa]**	**620**	**min**	**[psi]**	**90**	**min**
Axial load	**[N]**	**675**	**min**	**[lbf]**	**152**	**min**
Matching END Type	**Type**	**200 END**				
Material	**Type**	**Aluminium Alloy**				
Inside lacquer	**Type**	**Water base**				

Product:	Date:	Type:	Chapter:
ALUMINIUM BEVERAGE CAN	01.01.2022	204/200/200 FIT Body/Dome/Neck	1.1.12
	Revision: 6	Approved by:	

CAN - BASIC INFORMATION

1.1.13 ALUMINIUM BEVERAGE CAN 300 ML / 10,1 OZ FIT / EOE 202



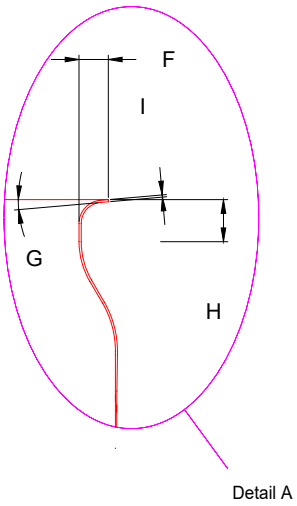


CAN Parameters/Properties						
Units system	**Metric**			**Imperial**		
Capacity	**[ml]**	**300**	**-**	**[us fl oz]**	**10,1**	**-**
A - Can height	**[mm]**	**133,89**	**+/- 0,30**	**[In]**	**5,271**	**+/- 0,012**
B - Outside diameter	**[mm]**	**58,10**	**max**	**[In]**	**2,287**	**max**
C - Flange diameter	**[mm]**	**57,50**	**max**	**[In]**	**2,264**	**max**
D - Inside neck diameter	**[mm]**	**52,40**	**+/- 0,30**	**[In]**	**2,063**	**+/- 0,012**
E - Base diameter	**[mm]**	**45,57**	**max**	**[In]**	**1,794**	**max**
F - Flange width	**[mm]**	**2,13**	**+/- 0,25**	**[In]**	**0,084**	**+/- 0,010**
G - Flange angle	**[°]**	**0 - 12**	**-**	**[°]**	**0 - 12**	**-**
H - Neck seaming clearance	**[mm]**	**3,05**	**min**	**[In]**	**0,120**	**min**
I - Flange thickness	**[mm]**	**0,165**	**+/- 0,015**	**[In]**	**0,0065**	**+/- 0,0006**
Inside pressure	**[kPa]**	**620**	**min**	**[psi]**	**90**	**min**
Axial load	**[N]**	**675**	**min**	**[lbf]**	**152**	**min**
Matching END Type	**Type**	**202 END**				
Material	**Type**	**Aluminium Alloy**				
Inside lacquer	**Type**	**Water base**				

Product:	Date:	Type:	Chapter:
ALUMINIUM BEVERAGE CAN	01.01.2022	204/200/202 FIT Body/Dome/Neck	1.1.13
	Revision: 6	Approved by:	

CAN - BASIC INFORMATION

1.1.14 ALUMINIUM BEVERAGE CAN 330 ML / 11,2 OZ FIT / EOE 200

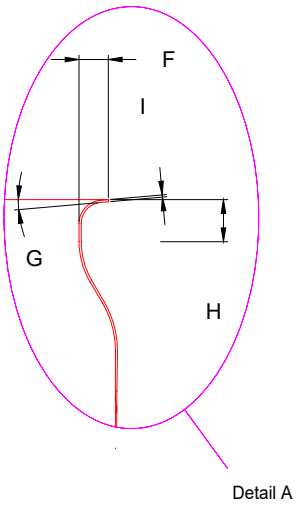


CAN Parameters/Properties						
Units system	**Metric**			**Imperial**		
Capacity	**[ml]**	**330**	**-**	**[us fl oz]**	**11,2**	**-**
A - Can height	**[mm]**	**145,40**	**+/- 0,30**	**[In]**	**5,724**	**+/- 0,012**
B - Outside diameter	**[mm]**	**58,10**	**max**	**[In]**	**2,287**	**max**
C - Flange diameter	**[mm]**	**55,00**	**max**	**[In]**	**2,165**	**max**
D - Inside neck diameter	**[mm]**	**50,00**	**+/- 0,30**	**[In]**	**1,969**	**+/- 0,012**
E - Base diameter	**[mm]**	**45,57**	**max**	**[In]**	**1,794**	**max**
F - Flange width	**[mm]**	**2,08**	**+/- 0,25**	**[In]**	**0,082**	**+/- 0,010**
G - Flange angle	**[°]**	**0 - 12**	**-**	**[°]**	**0 - 12**	**-**
H - Neck seaming clearance	**[mm]**	**3,05**	**min**	**[In]**	**0,120**	**min**
I - Flange thickness	**[mm]**	**0,165**	**+/- 0,015**	**[In]**	**0,0065**	**+/- 0,0006**
Inside pressure	**[kPa]**	**620**	**min**	**[psi]**	**90**	**min**
Axial load	**[N]**	**675**	**min**	**[lbf]**	**152**	**min**
Matching END Type	**Type**	**200 END**				
Material	**Type**	**Aluminium Alloy**				
Inside lacquer	**Type**	**Water base**				

Product:	Date:	Type:	Chapter:
ALUMINIUM BEVERAGE CAN	01.01.2022	204/200/200 FIT Body/Dome/Neck	1.1.14
	Revision: 6	Approved by:	

CAN - BASIC INFORMATION

1.1.15 ALUMINIUM BEVERAGE CAN 330 ML / 11,2 OZ FIT / EOE 202

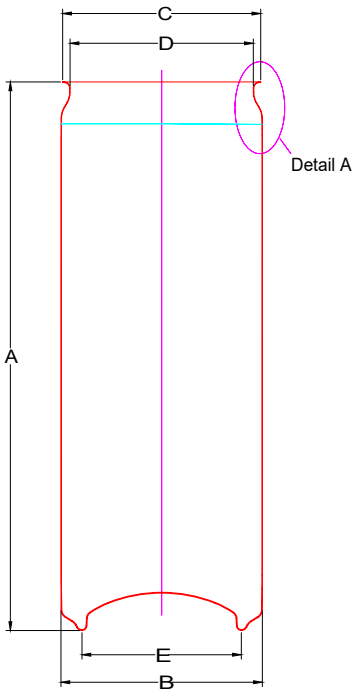


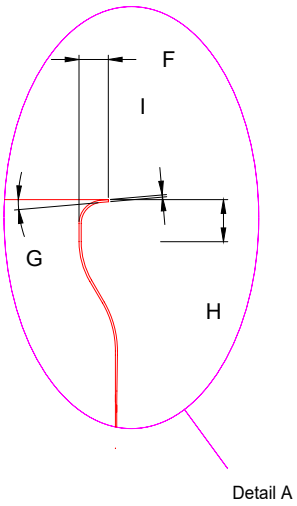
CAN Parameters/Properties						
Units system	Metric			Imperial		
Capacity	[ml]	330	-	[us fl oz]	11,2	-
A - Can height	[mm]	145,40	+/- 0,30	[In]	5,724	+/- 0,012
B - Outside diameter	[mm]	58,10	max	[In]	2,287	max
C - Flange diameter	[mm]	57,50	max	[In]	2,264	max
D - Inside neck diameter	[mm]	52,40	+/- 0,30	[In]	2,063	+/- 0,012
E - Base diameter	[mm]	45,57	max	[In]	1,794	max
F - Flange width	[mm]	2,13	+/- 0,25	[In]	0,084	+/- 0,010
G - Flange angle	[°]	0 - 12	-	[°]	0 - 12	-
H - Neck seaming clearance	[mm]	3,05	min	[In]	0,120	min
I - Flange thickness	[mm]	0,165	+/- 0,015	[In]	0,0065	+/- 0,0006
Inside pressure	[kPa]	620	min	[psi]	90	min
Axial load	[N]	675	min	[lbf]	152	min
Matching END Type	Type	202 END				
Material	Type	Aluminium Alloy				
Inside lacquer	Type	Water base				

Product:	Date:	Type:	Chapter:
ALUMINIUM BEVERAGE CAN	01.01.2022	204/200/202 FIT Body/Dome/Neck	1.1.15
	Revision: 6	Approved by:	

CAN - BASIC INFORMATION

1.1.16 ALUMINIUM BEVERAGE CAN 355 ML / 12,0 OZ FIT / EOE 200



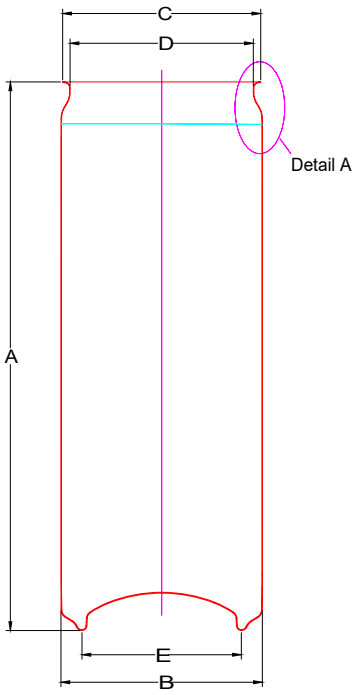


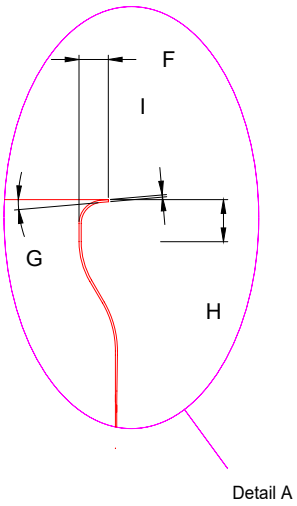
CAN Parameters/Properties						
Units system	**Metric**			**Imperial**		
Capacity	**[ml]**	**355**	**-**	**[us fl oz]**	**12,0**	**-**
A - Can height	**[mm]**	**156,9**	**+/- 0,30**	**[In]**	**6,177**	**+/- 0,012**
B - Outside diameter	**[mm]**	**58,10**	**max**	**[In]**	**2,287**	**max**
C - Flange diameter	**[mm]**	**55,00**	**max**	**[In]**	**2,165**	**max**
D - Inside neck diameter	**[mm]**	**50,00**	**+/- 0,30**	**[In]**	**1,969**	**+/- 0,012**
E - Base diameter	**[mm]**	**45,57**	**max**	**[In]**	**1,794**	**max**
F - Flange width	**[mm]**	**2,08**	**+/- 0,25**	**[In]**	**0,082**	**+/- 0,010**
G - Flange angle	**[°]**	**0 - 12**	**-**	**[°]**	**0 - 12**	**-**
H - Neck seaming clearance	**[mm]**	**3,05**	**min**	**[In]**	**0,120**	**min**
I - Flange thickness	**[mm]**	**0,165**	**+/- 0,015**	**[In]**	**0,0065**	**+/- 0,0006**
Inside pressure	**[kPa]**	**620**	**min**	**[psi]**	**90**	**min**
Axial load	**[N]**	**675**	**min**	**[lbf]**	**152**	**min**
Matching END Type	**Type**	**200 END**				
Material	**Type**	**Aluminium Alloy**				
Inside lacquer	**Type**	**Water base**				

Product:	Date:	Type:	Chapter:
ALUMINIUM BEVERAGE CAN	01.01.2022	204/200/200 FIT Body/Dome/Neck	1.1.16
	Revision: 4	Approved by:	

CAN - BASIC INFORMATION

1.1.17 ALUMINIUM BEVERAGE CAN 355 ML / 12,0 OZ FIT / EOE 202



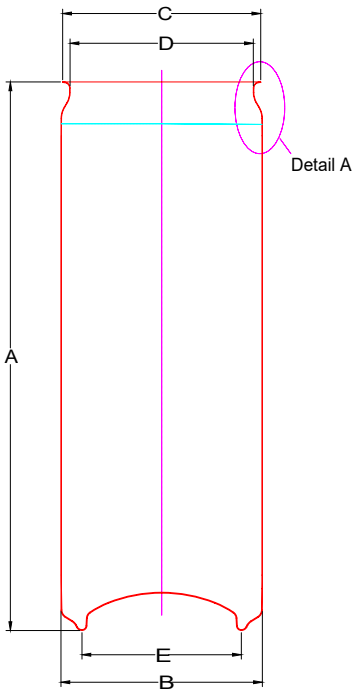


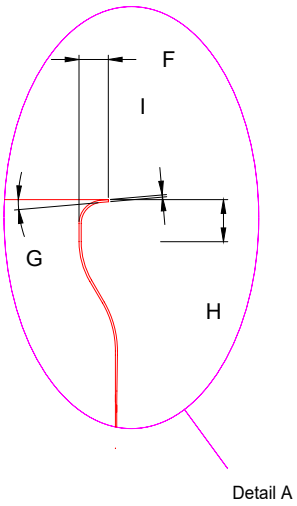
CAN Parameters/Properties						
Units system	Metric			Imperial		
Capacity	[ml]	355	-	[us fl oz]	12,0	-
A - Can height	[mm]	156,90	+/- 0,30	[In]	6,177	+/- 0,012
B - Outside diameter	[mm]	58,10	max	[In]	2,287	max
C - Flange diameter	[mm]	57,50	max	[In]	2,264	max
D - Inside neck diameter	[mm]	52,40	+/- 0,30	[In]	2,063	+/- 0,012
E - Base diameter	[mm]	45,57	max	[In]	1,79	max
F - Flange width	[mm]	2,13	+/- 0,25	[In]	0,084	+/- 0,010
G - Flange angle	[°]	0 - 12	-	[°]	0 - 12	-
H - Neck seaming clearance	[mm]	3,05	min	[In]	0,120	min
I - Flange thickness	[mm]	0,165	+/- 0,015	[In]	0,0065	+/- 0,0006
Inside pressure	[kPa]	620	min	[psi]	90	min
Axial load	[N]	675	min	[lbf]	152	min
Matching END Type	Type	202 END				
Material	Type	Aluminium Alloy				
Inside lacquer	Type	Water base				

Product:	Date:	Type:	Chapter:
ALUMINIUM BEVERAGE CAN	01.01.2022	204/200/202 FIT Body/Dome/Neck	1.1.17
	Revision: 4	Approved by:	

CAN - BASIC INFORMATION/North America

1.1.18 ALUMINIUM BEVERAGE CAN 355 ML / 12,0 OZ FIT / EOE 202



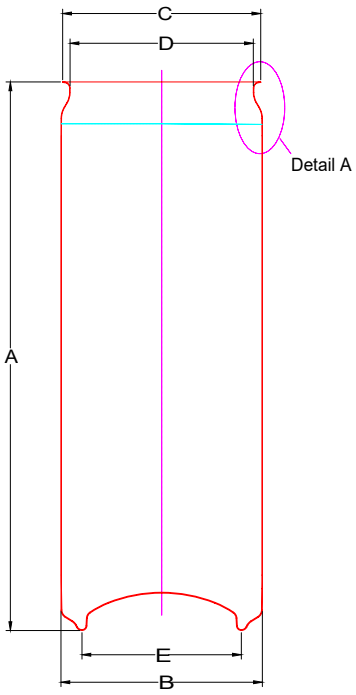


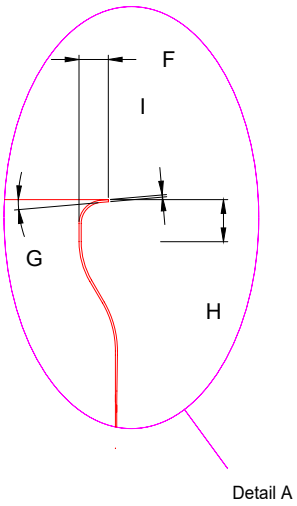
CAN Parameters/Properties						
Units system	**Metric**			**Imperial**		
Capacity	**[ml]**	**355**	**-**	**[us fl oz]**	**12,0**	**-**
A - Can height	**[mm]**	**155,63**	**+/- 0,30**	**[In]**	**6,127**	**+/- 0,012**
B - Outside diameter	**[mm]**	**57,60**	**max**	**[In]**	**2,268**	**max**
C - Flange diameter	**[mm]**	**57,50**	**max**	**[In]**	**2,264**	**max**
D - Inside neck diameter	**[mm]**	**52,40**	**+/- 0,30**	**[In]**	**2,063**	**+/- 0,012**
E - Base diameter	**[mm]**	**45,57**	**max**	**[In]**	**1,794**	**max**
F - Flange width	**[mm]**	**2,11**	**+/- 0,25**	**[In]**	**0,083**	**+/- 0,010**
G - Flange angle	**[°]**	**0 - 12**	**-**	**[°]**	**0 - 12**	**-**
H - Neck seaming clearance	**[mm]**	**3,05**	**min**	**[In]**	**0,120**	**min**
I - Flange thickness	**[mm]**	**0,165**	**+/- 0,015**	**[In]**	**0,0065**	**+/- 0,0006**
Inside pressure	**[kPa]**	**620**	**min**	**[psi]**	**90**	**min**
Axial load	**[N]**	**675**	**min**	**[lbf]**	**152**	**min**
Matching END Type	**Type**	**202 END**				
Material	**Type**	**Aluminium Alloy**				
Inside lacquer	**Type**	**Water base**				

Product:	Date:	Type:	Chapter:
ALUMINIUM BEVERAGE CAN	01.01.2022	204/200/202 FIT Body/Dome/Neck	1.1.18
	Revision: 4	Approved by:	

CAN - BASIC INFORMATION/Middle East

1.1.19 ALUMINIUM BEVERAGE CAN 355 ML / 12,0 OZ FIT / EOE 200



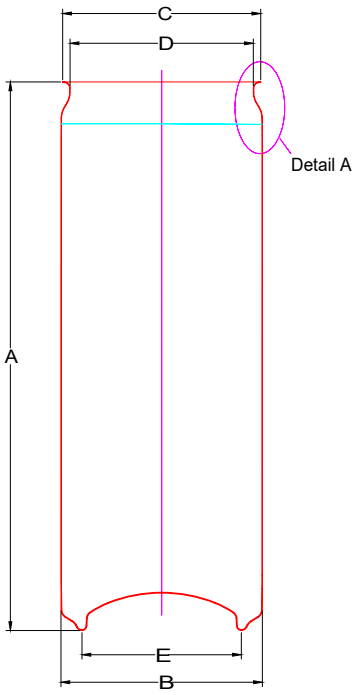


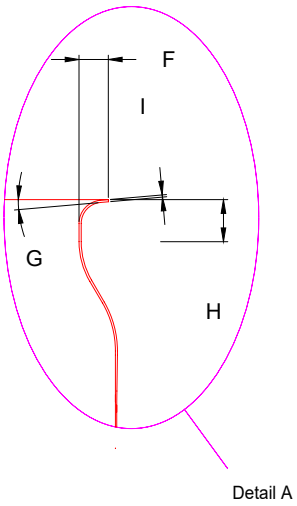
CAN Parameters/Properties						
Units system	Metric			Imperial		
Capacity	[ml]	355	-	[us fl oz]	12,0	-
A - Can height	[mm]	156,60	+/- 0,30	[In]	6,165	+/- 0,012
B - Outside diameter	[mm]	58,10	max	[In]	2,287	max
C - Flange diameter	[mm]	55,00	max	[In]	2,165	max
D - Inside neck diameter	[mm]	50,00	+/- 0,30	[In]	1,969	+/- 0,012
E - Base diameter	[mm]	45,57	max	[In]	1,794	max
F - Flange width	[mm]	2,08	+/- 0,25	[In]	0,082	+/- 0,010
G - Flange angle	[°]	0 - 12	-	[°]	0 - 12	-
H - Neck seaming clearance	[mm]	3,05	min	[In]	0,120	min
I - Flange thickness	[mm]	0,165	+/- 0,015	[In]	0,0065	+/- 0,0006
Inside pressure	[kPa]	620	min	[psi]	90	min
Axial load	[N]	675	min	[lbf]	152	min
Matching END Type	Type	200 END				
Material	Type	Aluminium Alloy				
Inside lacquer	Type	Water base				

Product:	Date:	Type:	Chapter:
ALUMINIUM BEVERAGE CAN	01.01.2022	204/200/200 FIT Body/Dome/Neck	1.1.19
	Revision: 4	Approved by:	

CAN - BASIC INFORMATION/Middle East

1.1.20 ALUMINIUM BEVERAGE CAN 355 ML / 12,0 OZ FIT / EOE 202



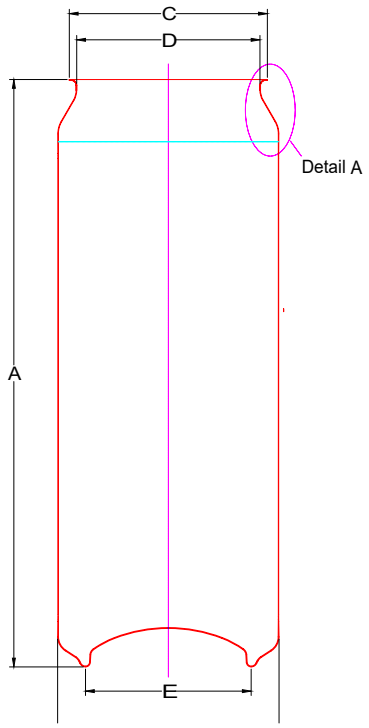


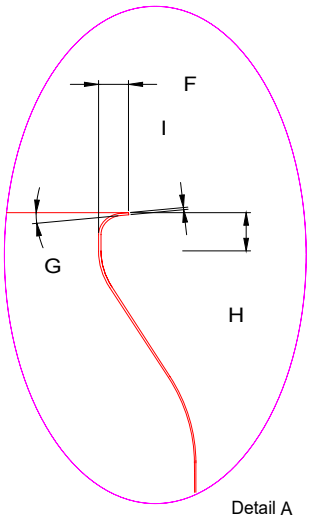
CAN Parameters/Properties						
Units system	**Metric**			**Imperial**		
Capacity	**[ml]**	**355**	**-**	**[us fl oz]**	**12,0**	**-**
A - Can height	**[mm]**	**156,60**	**+/- 0,30**	**[In]**	**6,165**	**+/- 0,012**
B - Outside diameter	**[mm]**	**58,10**	**max**	**[In]**	**2,287**	**max**
C - Flange diameter	**[mm]**	**57,50**	**max**	**[In]**	**2,264**	**max**
D - Inside neck diameter	**[mm]**	**52,40**	**+/- 0,30**	**[In]**	**2,063**	**+/- 0,012**
E - Base diameter	**[mm]**	**45,57**	**max**	**[In]**	**1,794**	**max**
F - Flange width	**[mm]**	**2,13**	**+/- 0,25**	**[In]**	**0,084**	**+/- 0,010**
G - Flange angle	**[°]**	**0 - 12**	**-**	**[°]**	**0 - 12**	**-**
H - Neck seaming clearance	**[mm]**	**3,05**	**min**	**[In]**	**0,120**	**min**
I - Flange thickness	**[mm]**	**0,165**	**+/- 0,015**	**[In]**	**0,0065**	**+/- 0,0006**
Inside pressure	**[kPa]**	**620**	**min**	**[psi]**	**90**	**min**
Axial load	**[N]**	**675**	**min**	**[lbf]**	**152**	**min**
Matching END Type	**Type**	**202 END**				
Material	**Type**	**Aluminium Alloy**				
Inside lacquer	**Type**	**Water base**				

Product:	Date:	Type:	Chapter:
ALUMINIUM BEVERAGE CAN	01.01.2022	204/200/202 FIT Body/Dome/Neck	1.1.20
	Revision: 4	Approved by:	

CAN - BASIC INFORMATION

1.1.21 ALUMINIUM BEVERAGE CAN 449 ML / 15,2 OZ LONGFIT / EOE 202



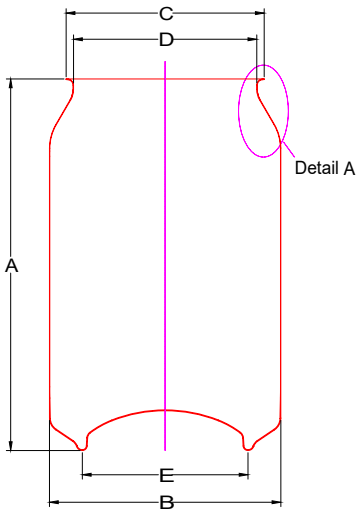


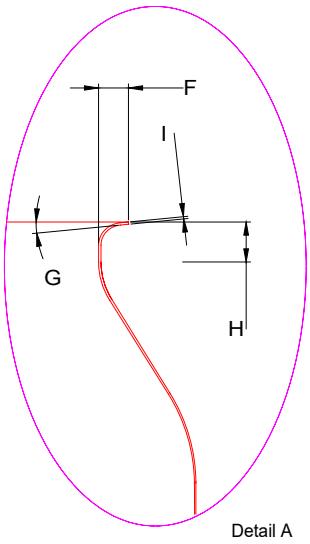
CAN Parameters/Properties						
Units system	Metric			Imperial		
Capacity	[ml]	449	-	[us fl oz]	15,2	-
A - Can height	[mm]	168,00	+/- 0,30	[In]	6,614	+/- 0,012
B - Outside diameter	[mm]	63,50	max	[In]	2,500	max
C - Flange diameter	[mm]	57,50	max	[In]	2,264	max
D - Inside neck diameter	[mm]	52,40	+/- 0,30	[In]	2,063	+/- 0,012
E - Base diameter	[mm]	47,37	max	[In]	1,865	max
F - Flange width	[mm]	2,13	+/- 0,25	[In]	0,084	+/- 0,010
G - Flange angle	[°]	0 - 12	-	[°]	0 - 12	-
H - Neck seaming clearance	[mm]	3,05	min	[In]	0,120	min
I - Flange thickness	[mm]	0,170	+/- 0,015	[In]	0,0067	+/- 0,0006
Inside pressure	[kPa]	620	min	[psi]	90	min
Axial load	[N]	675	min	[lbf]	152	min
Matching END Type	Type	202 END				
Material	Type	Aluminium Alloy				
Inside lacquer	Type	Water base				

Product:	Date:	Type:	Chapter:
ALUMINIUM BEVERAGE CAN	01.01.2022	209/202/202 LongFIT Body/Dome/Neck	1.1.21
	Revision: 5	Approved by:	

CAN - BASIC INFORMATION

1.1.22 ALUMINIUM BEVERAGE CAN 300 ML / 10,1 OZ STD / EOE 202



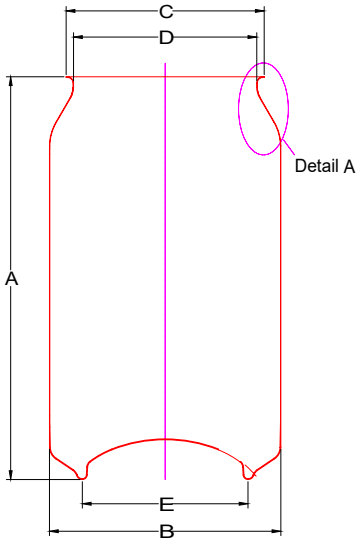


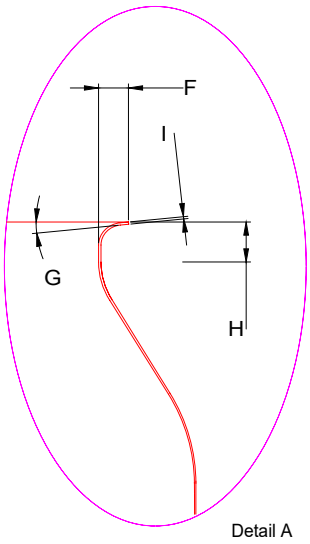
CAN Parameters/Properties						
Units system	**Metric**			**Imperial**		
Capacity	**[ml]**	**300**	**-**	**[us fl oz]**	**10,1**	**-**
A - Can height	**[mm]**	**106,27**	**+/- 0,30**	**[In]**	**4,184**	**+/- 0,012**
B - Outside diameter	**[mm]**	**66,30**	**max**	**[In]**	**2,610**	**max**
C - Flange diameter	**[mm]**	**57,50**	**max**	**[In]**	**2,264**	**max**
D - Inside neck diameter	**[mm]**	**52,40**	**+/- 0,30**	**[In]**	**2,063**	**+/- 0,012**
E - Base diameter	**[mm]**	**47,37**	**max**	**[In]**	**1,865**	**max**
F - Flange width	**[mm]**	**2,13**	**+/- 0,25**	**[In]**	**0,084**	**+/- 0,010**
G - Flange angle	**[°]**	**0 - 12**	**-**	**[°]**	**0 - 12**	**-**
H - Neck seaming clearance	**[mm]**	**3,05**	**min**	**[In]**	**0,120**	**min**
I - Flange thickness	**[mm]**	**0,170**	**+/- 0,015**	**[In]**	**0,0067**	**+/- 0,0006**
Inside pressure	**[kPa]**	**620**	**min**	**[psi]**	**90**	**min**
Axial load	**[N]**	**675**	**min**	**[lbf]**	**152**	**min**
Matching END Type	**Type**	**202 END**				
Material	**Type**	**Aluminium Alloy**				
Inside lacquer	**Type**	**Water base**				

Product:	Date:	Type:	Chapter:
ALUMINIUM BEVERAGE CAN	01.01.2022	211/202/202 STD Body/Dome/Neck	1.1.22
	Revision: 6	Approved by:	

CAN - BASIC INFORMATION

1.1.23 ALUMINIUM BEVERAGE CAN 330 ML / 11,2 OZ STD / EOE 202



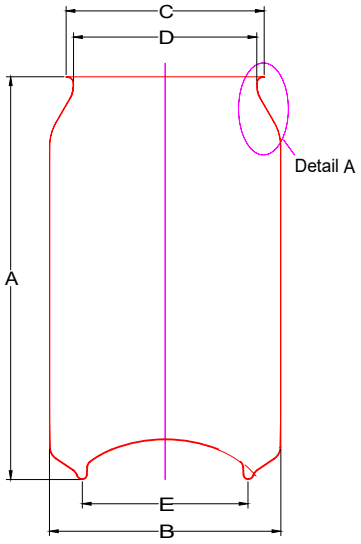


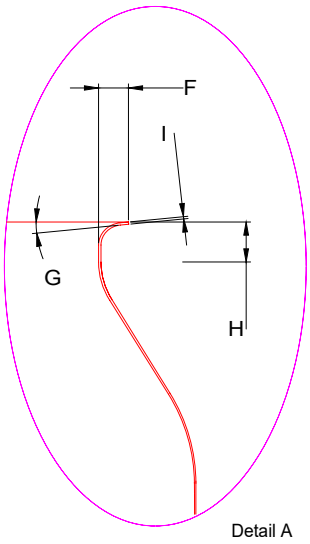
CAN Parameters/Properties						
Units system	Metric			Imperial		
Capacity	[ml]	330	-	[us fl oz]	11,2	-
A - Can height	[mm]	115,20	+/- 0,30	[In]	4,535	+/- 0,012
B - Outside diameter	[mm]	66,30	max	[In]	2,610	max
C - Flange diameter	[mm]	57,50	max	[In]	2,264	max
D - Inside neck diameter	[mm]	52,40	+/- 0,30	[In]	2,063	+/- 0,012
E - Base diameter	[mm]	47,37	max	[In]	1,865	max
F - Flange width	[mm]	2,13	+/- 0,25	[In]	0,084	+/- 0,010
G - Flange angle	[°]	0 - 12	-	[°]	0 - 12	-
H - Neck seaming clearance	[mm]	3,05	min	[In]	0,120	min
I - Flange thickness	[mm]	0,170	+/- 0,015	[In]	0,0067	+/- 0,0006
Inside pressure	[kPa]	620	min	[psi]	90	min
Axial load	[N]	675	min	[lbf]	152	min
Matching END Type	Type	202 END				
Material	Type	Aluminium Alloy				
Inside lacquer	Type	Water base				

Product:	Date:	Type:	Chapter:
ALUMINIUM BEVERAGE CAN	01.01.2022	211/202/202 STD Body/Dome/Neck	1.1.23
	Revision: 6	Approved by:	

CAN - BASIC INFORMATION/South America

1.1.24 ALUMINIUM BEVERAGE CAN 330 ML / 11,2 OZ STD / EOE 202



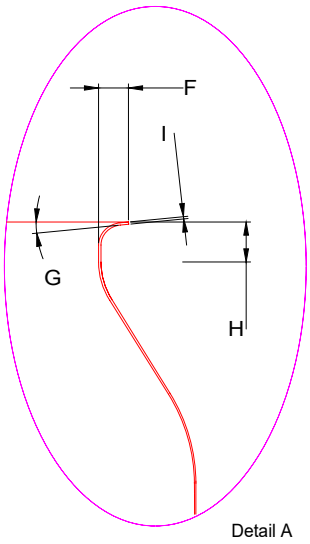


CAN Parameters/Properties						
Units system	**Metric**			**Imperial**		
Capacity	**[ml]**	**330**	**-**	**[us fl oz]**	**11,2**	**-**
A - Can height	**[mm]**	**115,20**	**+/- 0,30**	**[In]**	**4,535**	**+/- 0,012**
B - Outside diameter	**[mm]**	**66,15**	**max**	**[In]**	**2,604**	**max**
C - Flange diameter	**[mm]**	**57,50**	**max**	**[In]**	**2,264**	**max**
D - Inside neck diameter	**[mm]**	**52,40**	**+/- 0,30**	**[In]**	**2,063**	**+/- 0,012**
E - Base diameter	**[mm]**	**47,37**	**max**	**[In]**	**1,865**	**max**
F - Flange width	**[mm]**	**2,13**	**+/- 0,25**	**[In]**	**0,084**	**+/- 0,010**
G - Flange angle	**[°]**	**0 - 12**	**-**	**[°]**	**0 - 12**	**-**
H - Neck seaming clearance	**[mm]**	**3,05**	**min**	**[In]**	**0,120**	**min**
I - Flange thickness	**[mm]**	**0,170**	**+/- 0,015**	**[In]**	**0,0067**	**+/- 0,0006**
Inside pressure	**[kPa]**	**620**	**min**	**[psi]**	**90**	**min**
Axial load	**[N]**	**675**	**min**	**[lbf]**	**152**	**min**
Matching END Type	**Type**	**202 END**				
Material	**Type**	**Aluminium Alloy**				
Inside lacquer	**Type**	**Water base**				

Product:	Date:	Type:	Chapter:
ALUMINIUM BEVERAGE CAN	01.01.2022	211/202/202 STD Body/Dome/Neck	1.1.24
	Revision: 6	Approved by:	

CAN - BASIC INFORMATION/South America

1.1.25 ALUMINIUM BEVERAGE CAN 350 ML / 11,8 OZ STD / EOE 202

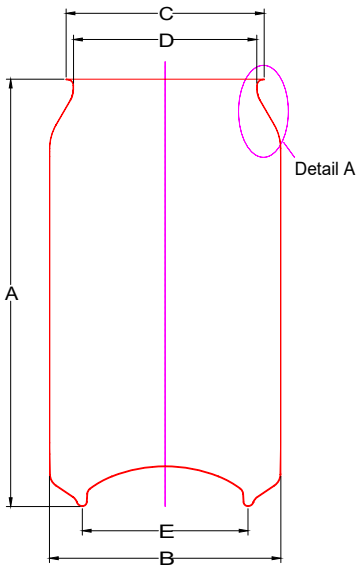


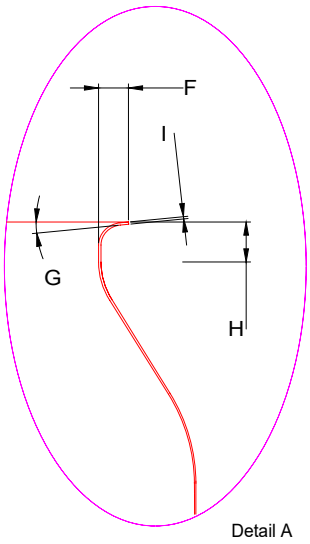
CAN Parameters/Properties						
Units system	Metric			Imperial		
Capacity	[ml]	350	-	[us fl oz]	11,8	-
A - Can height	[mm]	122,22	+/- 0,30	[In]	4,812	+/- 0,012
B - Outside diameter	[mm]	66,15	max	[In]	2,604	max
C - Flange diameter	[mm]	57,50	max	[In]	2,264	max
D - Inside neck diameter	[mm]	52,40	+/- 0,30	[In]	2,063	+/- 0,012
E - Base diameter	[mm]	47,37	max	[In]	1,865	max
F - Flange width	[mm]	2,13	+/- 0,25	[In]	0,084	+/- 0,010
G - Flange angle	[°]	0 - 12	-	[°]	0 - 12	-
H - Neck seaming clearance	[mm]	3,05	min	[In]	0,120	min
I - Flange thickness	[mm]	0,170	+/- 0,015	[In]	0,0067	+/- 0,0006
Inside pressure	[kPa]	620	min	[psi]	90	min
Axial load	[N]	675	min	[lbf]	152	min
Matching END Type	Type	202 END				
Material	Type	Aluminium Alloy				
Inside lacquer	Type	Water base				

Product:	Date:	Type:	Chapter:
ALUMINIUM BEVERAGE CAN	01.01.2022	211/202/202 STD Body/Dome/Neck	1.1.25
	Revision: 6	Approved by:	

CAN - BASIC INFORMATION

1.1.26 ALUMINIUM BEVERAGE CAN 355 ML / 12,0 OZ STD / EOE 202



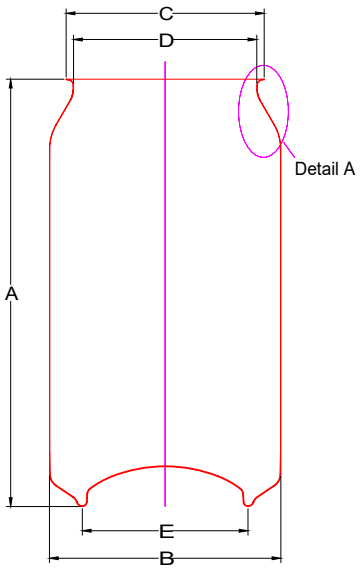


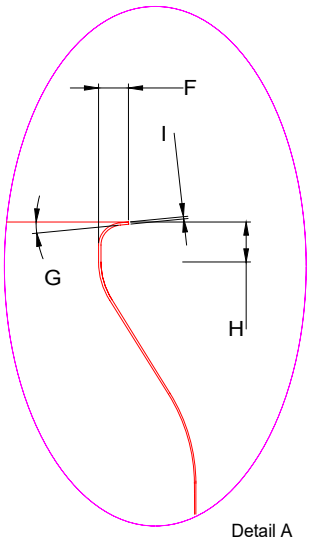
CAN Parameters/Properties						
Units system	**Metric**			**Imperial**		
Capacity	**[ml]**	**355**	**-**	**[us fl oz]**	**12,0**	**-**
A - Can height	**[mm]**	**122,22**	**+/- 0,30**	**[In]**	**4,812**	**+/- 0,012**
B - Outside diameter	**[mm]**	**66,30**	**max**	**[In]**	**2,610**	**max**
C - Flange diameter	**[mm]**	**57,50**	**max**	**[In]**	**2,264**	**max**
D - Inside neck diameter	**[mm]**	**52,40**	**+/- 0,30**	**[In]**	**2,063**	**+/- 0,012**
E - Base diameter	**[mm]**	**47,37**	**max**	**[In]**	**1,865**	**max**
F - Flange width	**[mm]**	**2,13**	**+/- 0,25**	**[In]**	**0,084**	**+/- 0,010**
G - Flange angle	**[°]**	**0 - 12**	**-**	**[°]**	**0 - 12**	**-**
H - Neck seaming clearance	**[mm]**	**3,05**	**min**	**[In]**	**0,120**	**min**
I - Flange thickness	**[mm]**	**0,170**	**+/- 0,015**	**[In]**	**0,0067**	**+/- 0,0006**
Inside pressure	**[kPa]**	**620**	**min**	**[psi]**	**90**	**min**
Axial load	**[N]**	**675**	**min**	**[lbf]**	**152**	**min**
Matching END Type	**Type**	**202 END**				
Material	**Type**	**Aluminium Alloy**				
Inside lacquer	**Type**	**Water base**				

Product:	Date:	Type:	Chapter:
ALUMINIUM BEVERAGE CAN	01.01.2022	211/202/202 STD Body/Dome/Neck	1.1.26
	Revision: 6	Approved by:	

CAN - BASIC INFORMATION/North America

1.1.27 ALUMINIUM BEVERAGE CAN 355 ML / 12,0 OZ STD / EOE 202



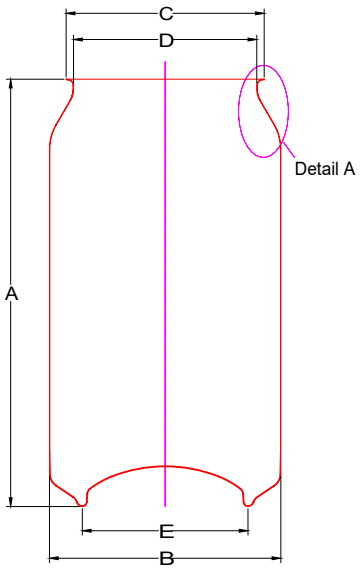


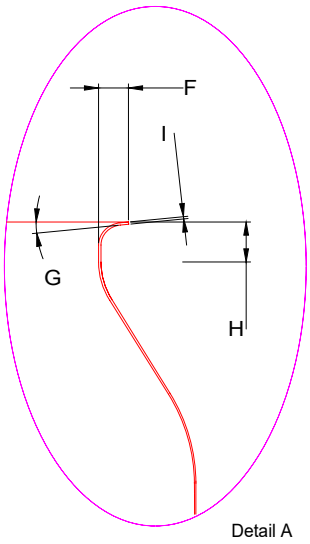
CAN Parameters/Properties						
Units system	**Metric**			**Imperial**		
Capacity	**[ml]**	**355**	**-**	**[us fl oz]**	**12,0**	**-**
A - Can height	**[mm]**	**122,22**	**+/- 0,30**	**[In]**	**4,812**	**+/- 0,012**
B - Outside diameter	**[mm]**	**66,30**	**max**	**[In]**	**2,610**	**max**
C - Flange diameter	**[mm]**	**57,50**	**max**	**[In]**	**2,264**	**max**
D - Inside neck diameter	**[mm]**	**52,40**	**+/- 0,30**	**[In]**	**2,063**	**+/- 0,012**
E - Base diameter	**[mm]**	**47,37**	**max**	**[In]**	**1,865**	**max**
F - Flange width	**[mm]**	**2,11**	**+/- 0,25**	**[In]**	**0,083**	**+/- 0,010**
G - Flange angle	**[°]**	**0 - 12**	**-**	**[°]**	**0 - 12**	**-**
H - Neck seaming clearance	**[mm]**	**3,05**	**min**	**[In]**	**0,120**	**min**
I - Flange thickness	**[mm]**	**0,170**	**+/- 0,015**	**[In]**	**0,0067**	**+/- 0,0006**
Inside pressure	**[kPa]**	**620**	**min**	**[psi]**	**90**	**min**
Axial load	**[N]**	**675**	**min**	**[lbf]**	**152**	**min**
Matching END Type	**Type**	**202 END**				
Material	**Type**	**Aluminium Alloy**				
Inside lacquer	**Type**	**Water base**				

Product:	Date:	Type:	Chapter:
ALUMINIUM BEVERAGE CAN	01.01.2022	211/202/202 STD Body/Dome/Neck	1.1.27
	Revision: 1	Approved by:	

CAN - BASIC INFORMATION/South America

1.1.28 ALUMINIUM BEVERAGE CAN 355 ML / 12,0 OZ STD / EOE 202



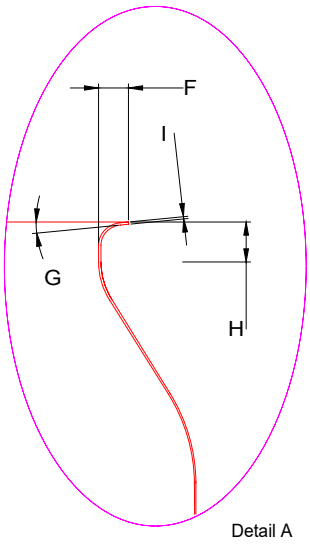


CAN Parameters/Properties						
Units system	**Metric**			**Imperial**		
Capacity	**[ml]**	**355**	**-**	**[us fl oz]**	**12,0**	**-**
A - Can height	**[mm]**	**122,22**	**+/- 0,30**	**[In]**	**4,812**	**+/- 0,012**
B - Outside diameter	**[mm]**	**66,15**	**max**	**[In]**	**2,604**	**max**
C - Flange diameter	**[mm]**	**57,50**	**max**	**[In]**	**2,264**	**max**
D - Inside neck diameter	**[mm]**	**52,40**	**+/- 0,30**	**[In]**	**2,063**	**+/- 0,012**
E - Base diameter	**[mm]**	**47,37**	**max**	**[In]**	**1,865**	**max**
F - Flange width	**[mm]**	**2,13**	**+/- 0,25**	**[In]**	**0,084**	**+/- 0,010**
G - Flange angle	**[°]**	**0 - 12**	**-**	**[°]**	**0 - 12**	**-**
H - Neck seaming clearance	**[mm]**	**3,05**	**min**	**[In]**	**0,120**	**min**
I - Flange thickness	**[mm]**	**0,170**	**+/- 0,015**	**[In]**	**0,0067**	**+/- 0,0006**
Inside pressure	**[kPa]**	**620**	**min**	**[psi]**	**90**	**min**
Axial load	**[N]**	**675**	**min**	**[lbf]**	**152**	**min**
Matching END Type	**Type**	**202 END**				
Material	**Type**	**Aluminium Alloy**				
Inside lacquer	**Type**	**Water base**				

Product:	Date:	Type:	Chapter:
ALUMINIUM BEVERAGE CAN	01.01.2022	211/202/202 STD Body/Dome/Neck	1.1.28
	Revision: 6	Approved by:	

CAN - BASIC INFORMATION

1.1.29 ALUMINIUM BEVERAGE CAN 440 ML / 14,9 OZ STD / EOE 202

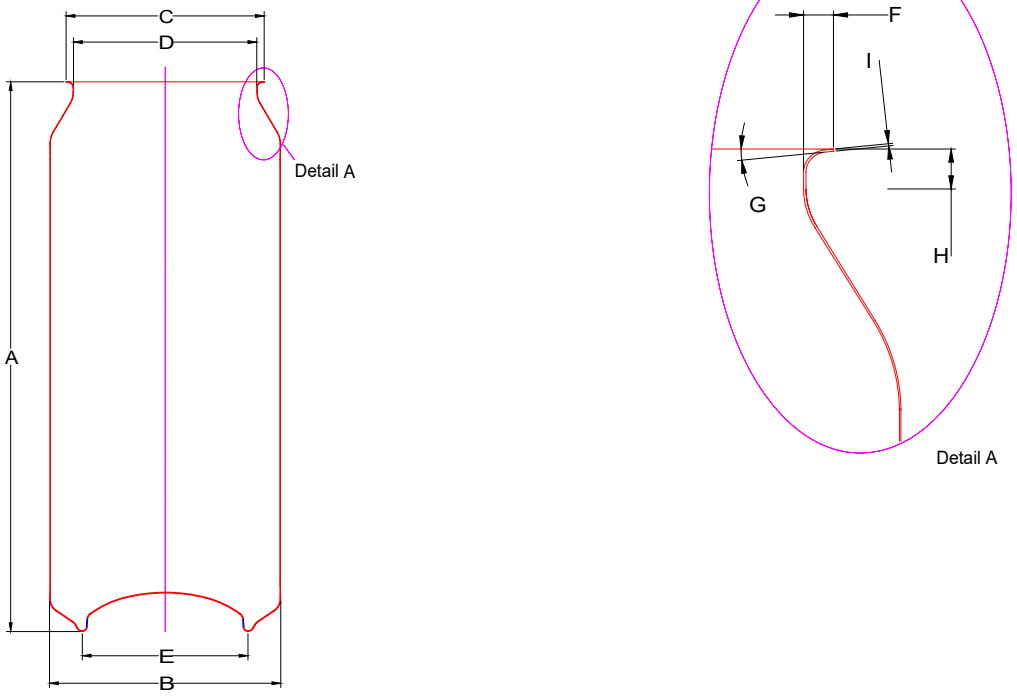


CAN Parameters/Properties						
Units system	**Metric**			**Imperial**		
Capacity	**[ml]**	**440**	**-**	**[us fl oz]**	**14,9**	**-**
A - Can height	**[mm]**	**149,90**	**+/- 0,30**	**[In]**	**5,902**	**+/- 0,012**
B - Outside diameter	**[mm]**	**66,30**	**max**	**[In]**	**2,610**	**max**
C - Flange diameter	**[mm]**	**57,50**	**max**	**[In]**	**2,264**	**max**
D - Inside neck diameter	**[mm]**	**52,40**	**+/- 0,30**	**[In]**	**2,063**	**+/- 0,012**
E - Base diameter	**[mm]**	**47,37**	**max**	**[In]**	**1,865**	**max**
F - Flange width	**[mm]**	**2,13**	**+/- 0,25**	**[In]**	**0,084**	**+/- 0,010**
G - Flange angle	**[°]**	**0 - 12**	**-**	**[°]**	**0 - 12**	**-**
H - Neck seaming clearance	**[mm]**	**3,05**	**min**	**[In]**	**0,120**	**min**
I - Flange thickness	**[mm]**	**0,170**	**+/- 0,015**	**[In]**	**0,0067**	**+/- 0,0006**
Inside pressure	**[kPa]**	**620**	**min**	**[psi]**	**90**	**min**
Axial load	**[N]**	**675**	**min**	**[lbf]**	**152**	**min**
Matching END Type	**Type**	**202 END**				
Material	**Type**	**Aluminium Alloy**				
Inside lacquer	**Type**	**Water base**				

Product:	Date:	Type:	Chapter:
ALUMINIUM BEVERAGE CAN	01.01.2022	211/202/202 STD Body/Dome/Neck	1.1.29
	Revision: 6	Approved by:	

CAN - BASIC INFORMATION/North America

1.1.30 ALUMINIUM BEVERAGE CAN 473 ML/ 16,0 OZ STD / EOE 202

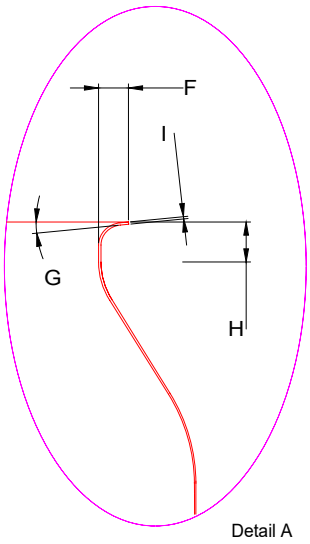


CAN Parameters/Properties						
Units system	**Metric**			**Imperial**		
Capacity	**[ml]**	**473**	**-**	**[us fl oz]**	**16,0**	**-**
A - Can height	**[mm]**	**157,23**	**+/- 0,30**	**[In]**	**6,190**	**+/- 0,012**
B - Outside diameter	**[mm]**	**66,30**	**max**	**[In]**	**2,610**	**max**
C - Flange diameter	**[mm]**	**57,50**	**max**	**[In]**	**2,264**	**max**
D - Inside neck diameter	**[mm]**	**52,40**	**+/- 0,30**	**[In]**	**2,063**	**+/- 0,012**
E - Base diameter	**[mm]**	**47,37**	**max**	**[In]**	**1,865**	**max**
F - Flange width	**[mm]**	**2,11**	**+/- 0,25**	**[In]**	**0,083**	**+/- 0,010**
G - Flange angle	**[°]**	**0 - 12**	**-**	**[°]**	**0 - 12**	**-**
H - Neck seaming clearance	**[mm]**	**3,05**	**min**	**[In]**	**0,120**	**min**
I - Flange thickness	**[mm]**	**0,170**	**+/- 0,015**	**[In]**	**0,0067**	**+/- 0,0006**
Inside pressure	**[kPa]**	**620**	**min**	**[psi]**	**90**	**min**
Axial load	**[N]**	**675**	**min**	**[lbf]**	**152**	**min**
Matching END Type	**Type**	**202 END**				
Material	**Type**	**Aluminium Alloy**				
Inside lacquer	**Type**	**Water base**				

Product:	Date:	Type:	Chapter:
ALUMINIUM BEVERAGE CAN	01.01.2022	211/202/202 STD Body/Dome/Neck	1.1.30
	Revision: 1	Approved by:	

CAN - BASIC INFORMATION/South America

1.1.31 ALUMINIUM BEVERAGE CAN 473 ML/ 16,0 OZ STD / EOE 202

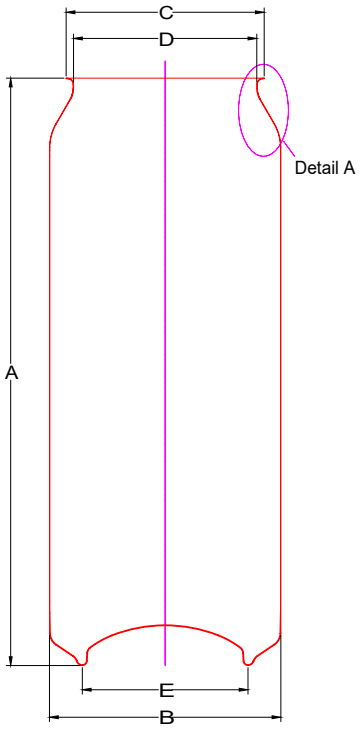


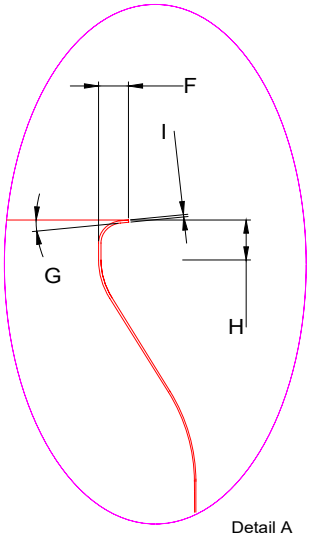
CAN Parameters/Properties						
Units system	**Metric**			**Imperial**		
Capacity	**[ml]**	**473**	**-**	**[us fl oz]**	**16**	**-**
A - Can height	**[mm]**	**157,23**	**+/- 0,30**	**[In]**	**6,190**	**+/- 0,012**
B - Outside diameter	**[mm]**	**66,15**	**max**	**[In]**	**2,604**	**max**
C - Flange diameter	**[mm]**	**57,50**	**max**	**[In]**	**2,264**	**max**
D - Inside neck diameter	**[mm]**	**52,40**	**+/- 0,30**	**[In]**	**2,063**	**+/- 0,012**
E - Base diameter	**[mm]**	**47,37**	**max**	**[In]**	**1,865**	**max**
F - Flange width	**[mm]**	**2,13**	**+/- 0,25**	**[In]**	**0,084**	**+/- 0,010**
G - Flange angle	**[°]**	**0 - 12**	**-**	**[°]**	**0 - 12**	**-**
H - Neck seaming clearance	**[mm]**	**3,05**	**min**	**[In]**	**0,120**	**min**
I - Flange thickness	**[mm]**	**0,170**	**+/- 0,015**	**[In]**	**0,0067**	**+/- 0,0006**
Inside pressure	**[kPa]**	**620**	**min**	**[psi]**	**90**	**min**
Axial load	**[N]**	**675**	**min**	**[lbf]**	**152**	**min**
Matching END Type	**Type**	**202 END**				
Material	**Type**	**Aluminium Alloy**				
Inside lacquer	**Type**	**Water base**				

Product:	Date:	Type:	Chapter:
ALUMINIUM BEVERAGE CAN	01.01.2022	211/202/202 STD Body/Dome/Neck	1.1.31
	Revision: 6	Approved by:	

CAN - BASIC INFORMATION

1.1.32 ALUMINIUM BEVERAGE CAN 500 ML / 16,9 OZ STD / EOE 202



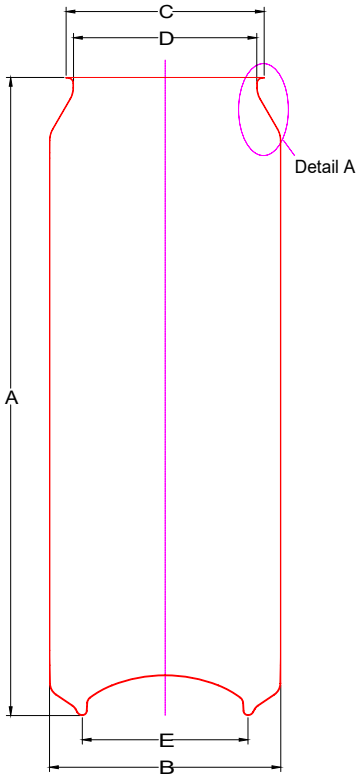


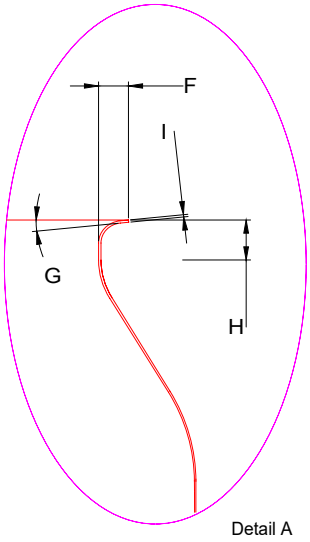
CAN Parameters/Properties						
Units system	Metric			Imperial		
Capacity	[ml]	500	-	[us fl oz]	16,9	-
A - Can height	[mm]	168,00	+/- 0,30	[In]	6,614	+/- 0,012
B - Outside diameter	[mm]	66,30	max	[In]	2,610	max
C - Flange diameter	[mm]	57,50	max	[In]	2,264	max
D - Inside neck diameter	[mm]	52,40	+/- 0,30	[In]	2,063	+/- 0,012
E - Base diameter	[mm]	47,37	max	[In]	1,865	max
F - Flange width	[mm]	2,13	+/- 0,25	[In]	0,084	+/- 0,010
G - Flange angle	[°]	0 - 12	-	[°]	0 - 12	-
H - Neck seaming clearance	[mm]	3,05	min	[In]	0,120	min
I - Flange thickness	[mm]	0,170	+/- 0,015	[In]	0,0067	+/- 0,0006
Inside pressure	[kPa]	620	min	[psi]	90	min
Axial load	[N]	675	min	[lbf]	152	min
Matching END Type	Type	202 END				
Material	Type	Aluminium Alloy				
Inside lacquer	Type	Water base				

Product:	Date:	Type:	Chapter:
ALUMINIUM BEVERAGE CAN	01.01.2022	211/202/202 STD Body/Dome/Neck	1.1.32
	Revision: 6	Approved by:	

CAN - BASIC INFORMATION

1.1.33 ALUMINIUM BEVERAGE CAN 550 ML / 18,6 OZ STD / EOE 202



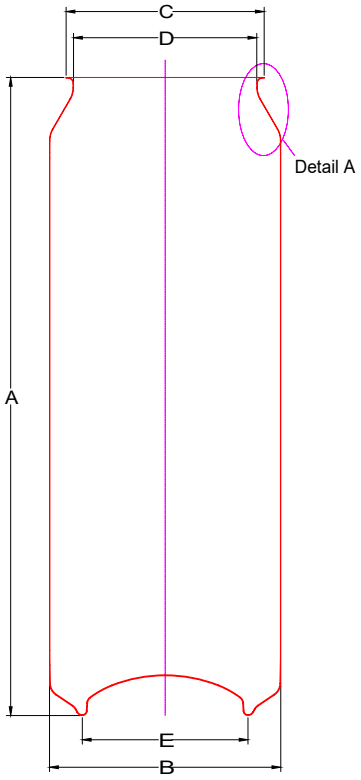


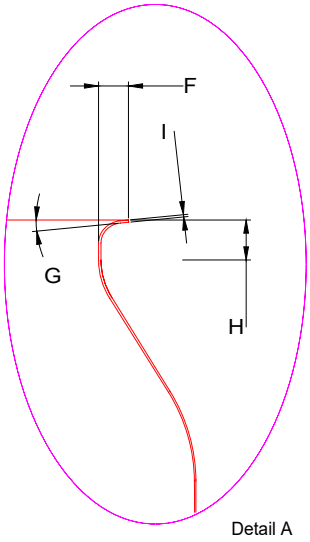
CAN Parameters/Properties						
Units system	Metric			Imperial		
Capacity	[ml]	550	-	[us fl oz]	18,6	-
A - Can height	[mm]	182,65	+/- 0,30	[In]	7,191	+/- 0,012
B - Outside diameter	[mm]	66,30	max	[In]	2,610	max
C - Flange diameter	[mm]	57,50	max	[In]	2,264	max
D - Inside neck diameter	[mm]	52,40	+/- 0,30	[In]	2,063	+/- 0,012
E - Base diameter	[mm]	47,37	max	[In]	1,865	max
F - Flange width	[mm]	2,13	+/- 0,25	[In]	0,084	+/- 0,010
G - Flange angle	[°]	0 - 12	-	[°]	0 - 12	-
H - Neck seaming clearance	[mm]	3,05	min	[In]	0,120	min
I - Flange thickness	[mm]	0,170	+/- 0,015	[In]	0,0067	+/- 0,0006
Inside pressure	[kPa]	620	min	[psi]	90	min
Axial load	[N]	675	min	[lbf]	152	min
Matching END Type	Type	202 END				
Material	Type	Aluminium Alloy				
Inside lacquer	Type	Water base				

Product:	Date:	Type:	Chapter:
ALUMINIUM BEVERAGE CAN	01.01.2022	211/202/202 STD Body/Dome/Neck	1.1.33
	Revision: 6	Approved by:	

CAN - BASIC INFORMATION/South America

1.1.34 ALUMINIUM BEVERAGE CAN 550 ML / 18,6 OZ STD / EOE 202



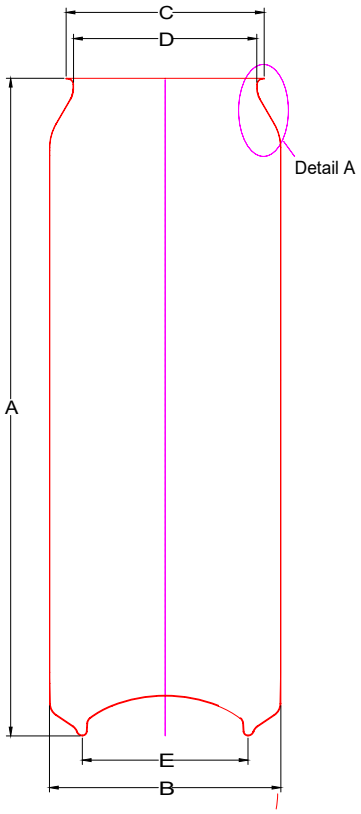


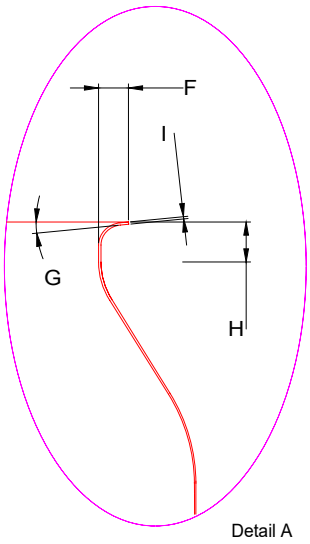
CAN Parameters/Properties						
Units system	Metric			Imperial		
Capacity	[ml]	550	-	[us fl oz]	18,6	-
A - Can height	[mm]	182,50	+/- 0,30	[In]	7,185	+/- 0,012
B - Outside diameter	[mm]	66,15	max	[In]	2,604	max
C - Flange diameter	[mm]	57,50	max	[In]	2,264	max
D - Inside neck diameter	[mm]	52,40	+/- 0,30	[In]	2,063	+/- 0,012
E - Base diameter	[mm]	47,37	max	[In]	1,865	max
F - Flange width	[mm]	2,13	+/- 0,25	[In]	0,084	+/- 0,010
G - Flange angle	[°]	0 - 12	-	[°]	0 - 12	-
H - Neck seaming clearance	[mm]	3,05	min	[In]	0,120	min
I - Flange thickness	[mm]	0,170	+/- 0,015	[In]	0,0067	+/- 0,0006
Inside pressure	[kPa]	620	min	[psi]	90	min
Axial load	[N]	675	min	[lbf]	152	min
Matching END Type	Type	202 END				
Material	Type	Aluminium Alloy				
Inside lacquer	Type	Water base				

Product:	Date:	Type:	Chapter:
ALUMINIUM BEVERAGE CAN	01.01.2022	211/202/202 STD Body/Dome/Neck	1.1.34
	Revision: 6	Approved by:	

CAN - BASIC INFORMATION

1.1.35 ALUMINIUM BEVERAGE CAN 568 ML / 19,2 OZ STD / EOE 202



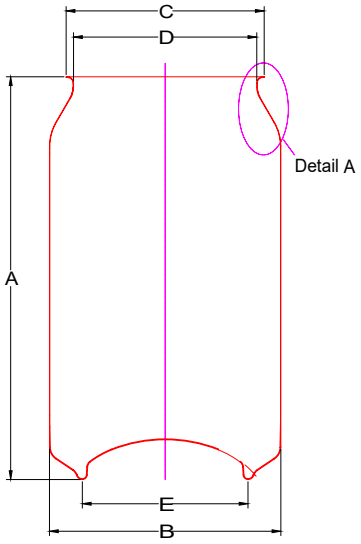


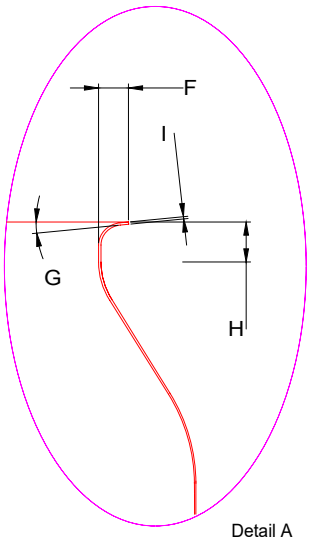
CAN Parameters/Properties						
Units system	**Metric**			**Imperial**		
Capacity	**[ml]**	**568**	**-**	**[us fl oz]**	**19,2**	**-**
A - Can height	**[mm]**	**188,09**	**+/- 0,30**	**[In]**	**7,405**	**+/- 0,012**
B - Outside diameter	**[mm]**	**66,30**	**max**	**[In]**	**2,610**	**max**
C - Flange diameter	**[mm]**	**57,50**	**max**	**[In]**	**2,264**	**max**
D - Inside neck diameter	**[mm]**	**52,40**	**+/- 0,30**	**[In]**	**2,063**	**+/- 0,012**
E - Base diameter	**[mm]**	**47,37**	**max**	**[In]**	**1,865**	**max**
F - Flange width	**[mm]**	**2,13**	**+/- 0,25**	**[In]**	**0,084**	**+/- 0,010**
G - Flange angle	**[°]**	**0 - 12**	**-**	**[°]**	**0 - 12**	**-**
H - Neck seaming clearance	**[mm]**	**3,05**	**min**	**[In]**	**0,120**	**min**
I - Flange thickness	**[mm]**	**0,170**	**+/- 0,015**	**[In]**	**0,0067**	**+/- 0,0006**
Inside pressure	**[kPa]**	**620**	**min**	**[psi]**	**90**	**min**
Axial load	**[N]**	**675**	**min**	**[lbf]**	**152**	**min**
Matching END Type	**Type**	**202 END**				
Material	**Type**	**Aluminium Alloy**				
Inside lacquer	**Type**	**Water base**				

Product:	Date:	Type:	Chapter:
ALUMINIUM BEVERAGE CAN	01.01.2022	211/202/202 STD Body/Dome/Neck	1.1.35
	Revision: 6	Approved by:	

CAN - BASIC INFORMATION

1.1.36 ALUMINIUM BEVERAGE CAN 330 ML / 11,2 OZ STD EMBOSS / EOE 202





CAN Parameters/Properties						
Units system	Metric			Imperial		
Capacity	[ml]	330	-	[us fl oz]	11,2	-
A - Can height	[mm]	115,20	+/- 0,30	[In]	4,535	+/- 0,012
B - Outside diameter	[mm]	66,30	max	[In]	2,610	max
C - Flange diameter	[mm]	57,50	max	[In]	2,264	max
D - Inside neck diameter	[mm]	52,40	+/- 0,30	[In]	2,063	+/- 0,012
E - Base diameter	[mm]	47,37	max	[In]	1,865	max
F - Flange width	[mm]	2,13	+/- 0,25	[In]	0,084	+/- 0,010
G - Flange angle	[°]	0 - 12	-	[°]	0 - 12	-
H - Neck seaming clearance	[mm]	3,05	min	[In]	0,120	min
I - Flange thickness	[mm]	0,170	+/- 0,015	[In]	0,0067	+/- 0,0006
Inside pressure	[kPa]	620	min	[psi]	90	min
Axial load	[N]	550	min	[lbf]	124	min
Matching END Type	Type	202 END				
Material	Type	Aluminium Alloy				
Inside lacquer	Type	Water base				

Product:	Date:	Type:	Chapter:
ALUMINIUM BEVERAGE CAN	01.01.2022	211/202/202 STD EMBOSS Body/Dome/Neck	1.1.36
	Revision: 4	Approved by:	

CAN - BASIC INFORMATION

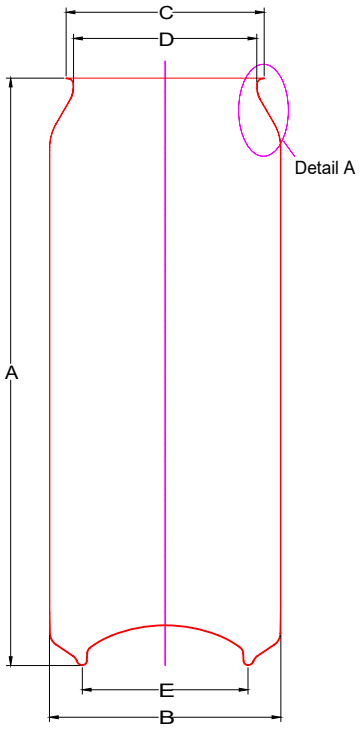
1.1.36 ALUMINIUM BEVERAGE CAN 330 ML / 11,2 OZ STD EMBOSS / EOE 202

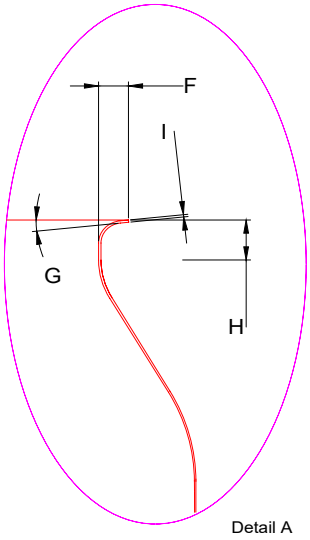
Unit system	Metric		USCS	
Visual Emboss Wideness	mm	~0,8	[in]	~0,031
Movement Tolerance	mm	1,25	[in]	0,049
Corner Radius	mm	>1	[in]	>0,039
Embossed area enlarged in comparison to the original graphic	mm	1	[in]	0,039
Min. distance between two embossed elements	mm	2	[in]	0,08
Emboss Depth (according to the indicated measuring points)	mm	0,25	[in]	0,010
Resgistration mark for canpossitioning: rectangle min (bottom of the can, contrasted area, free of disturbing graphic)	mm	8x5	[in]	0,315 x 0,2

Product:	Date:	Type:	Chapter:
ALUMINIUM BEVERAGE CAN	01.01.2022	211/202/202 STD EMBOSS Body/Dome/Neck	1.1.36
	Revision: 4	Approved by:	

CAN - BASIC INFORMATION

1.1.37 ALUMINIUM BEVERAGE CAN 500 ML / 16,9 OZ STD EMBOSS / EOE 202





CAN Parameters/Properties						
Units system	**Metric**			**Imperial**		
Capacity	**[ml]**	**500**	**-**	**[us fl oz]**	**16,9**	**-**
A - Can height	**[mm]**	**168,00**	**+/- 0,30**	**[In]**	**6,614**	**+/- 0,012**
B - Outside diameter	**[mm]**	**66,30**	**max**	**[In]**	**2,610**	**max**
C - Flange diameter	**[mm]**	**57,50**	**max**	**[In]**	**2,264**	**max**
D - Inside neck diameter	**[mm]**	**52,40**	**+/- 0,30**	**[In]**	**2,063**	**+/- 0,012**
E - Base diameter	**[mm]**	**47,37**	**max**	**[In]**	**1,865**	**max**
F - Flange width	**[mm]**	**2,13**	**+/- 0,25**	**[In]**	**0,084**	**+/- 0,010**
G - Flange angle	**[°]**	**0 - 12**	**-**	**[°]**	**0 - 12**	**-**
H - Neck seaming clearance	**[mm]**	**3,05**	**min**	**[In]**	**0,120**	**min**
I - Flange thickness	**[mm]**	**0,170**	**+/- 0,015**	**[In]**	**0,0067**	**+/- 0,0006**
Inside pressure	**[kPa]**	**620**	**min**	**[psi]**	**90**	**min**
Axial load	**[N]**	**550**	**min**	**[lbf]**	**124**	**min**
Matching END Type	**Type**	**202 END**				
Material	**Type**	**Aluminium Alloy**				
Inside lacquer	**Type**	**Water base**				

Product:	Date:	Type:	Chapter:
ALUMINIUM BEVERAGE CAN	01.01.2022	211/202/202 STD EMBOSS Body/Dome/Neck	1.1.37
	Revision: 4	Approved by:	

CAN - BASIC INFORMATION

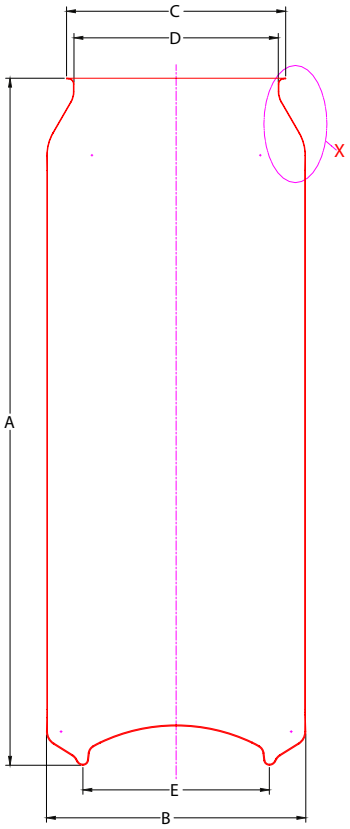
1.1.37 ALUMINiUM BEVERAGE CAN 500 ML / 16,9 OZ STD EMBOSS / EOE 202

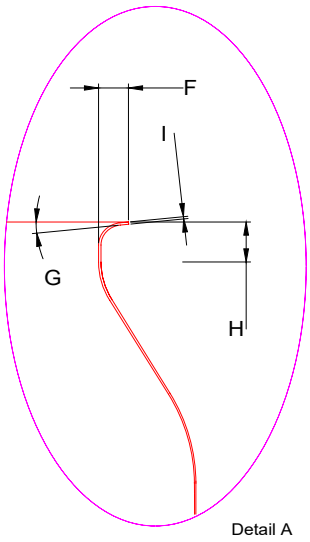
Unit system	Metric		USCS	
Visual Emboss Wideness	[mm]	~0,8	[in]	~0,031
Movement Tolerance	[mm]	1,25	[in]	0,049
Corner Radius	[mm]	>1	[in]	>0,039
Embossed area enlarged in comparison to the original graphic	[mm]	1	[in]	0,039
Min. distance between two embossed elements	[mm]	2	[in]	0,08
Emboss Depth (according to the indicated measuring points)	[mm]	0,25	[in]	0,010
Resgistration mark for canpossitioning: rectangle min (bottom of the can, contrasted area, free of disturbing graphic)	[mm]	8x5	[in]	0,315 x 0,2

Product:	Date:	Type:	Chapter:
ALUMINIUM BEVERAGE CAN	01.01.2022	211/202/202 STD EMBOSS Body/Dome/Neck	1.1.37
	Revision: 4	Approved by:	

CAN - BASIC INFORMATION/North America

1.1.38 ALUMINIUM BEVERAGE CAN 710 ML / 24,0 OZ / EOE 206





CAN Parameters/Properties						
Units system	Metric			Imperial		
Capacity	[ml]	710	-	[us fl oz]	24,0	-
A - Can height	[mm]	193,29	+/- 0,30	[In]	7,610	+/- 0,012
B - Outside diameter	[mm]	73,00	max	[In]	2,874	max
C - Flange diameter	[mm]	62,40	max	[In]	2,457	max
D - Inside neck diameter	[mm]	57,40	+/- 0,30	[In]	2,260	+/- 0,012
E - Base diameter	[mm]	52,45	max	[In]	2,065	max
F - Flange width	[mm]	2,11	+/- 0,25	[In]	0,083	+/- 0,010
G - Flange angle	[°]	0 - 12	-	[°]	0 - 12	-
H - Neck seaming clearance	[mm]	3,81	min	[In]	0,150	min
I - Flange thickness	[mm]	0,180	+/- 0,015	[In]	0,0071	+/- 0,0006
Inside pressure	[kPa]	620	min	[psi]	90	min
Axial load	[N]	675	min	[lbf]	152	min
Matching END Type	Type	206 END				
Material	Type	Aluminium Alloy				
Inside lacquer	Type	Water base				

Product:	Date:	Type:	Chapter:
ALUMINIUM BEVERAGE CAN	01.01.2022	300/206/206 Body/Dome/Neck	1.1.38
	Revision: 1	Approved by:	

INITIAL ACCEPTANCE OF CAN BATCH

1.1.39 ENAMEL RATER SPECIFICATION

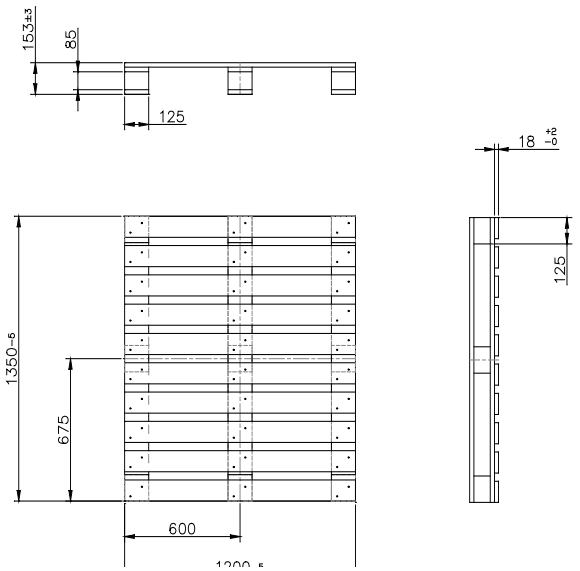
Watertightness of internal lacquer coating.
In order to assure measurement correctness, it is recommended to collect a new batch of samples, not damaged by previous measurements. Examination shall be performed only on not deformed cans. The results of the obtained measurements should be compared to the specifications for a given type of beverage. Assessment of internal varnish coating integrity is determined by metal exposure (enamel rater) test. Enamel rater is electrochemical method, using sodium chloride solution and performed with the application of a test voltage set at 6.3 VDC. A batch does not meet requirements if the allowable integral current factor for the internal liner coating has been exceeded in more than one can or if the average for the sample set is higher than the one given in the table below.

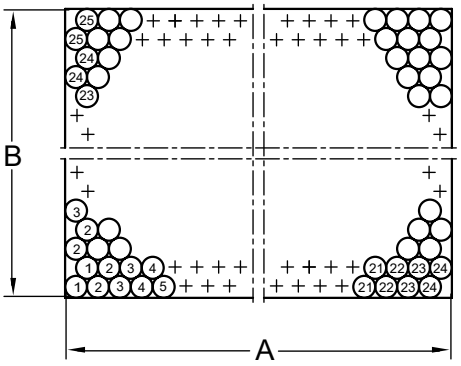
Product	Allowable value of impermeability currents in the internal coating [mA]	
	Average value	Individual maximum value
Category 1: standard beer with alcohol content ≤ 6% vol., non–alcoholic beer	**10**	**40**
Category 2: soft drinks (excluding tonic), soft drinks with juices, strong beer with alcohol content > 6% vol., ice tea drinks	**2**	**17**
Category 3: High aggressive drinks: - juices, coffee - juices, soft drinks with alcohol addition - beers with juices - energetic drinks - energetic drinks with alcohol, whey - beverages with milk products - isotonic drinks - carbonated and not carbonated mineral water - tonics - bread drink - low alcoholic carbonated drinks: ciders, wines, aromatized wine-based drinks, aromatized wine-product coctails including not pasteurized, chemically preserved beverages - hard seltzers	**2**	**15**

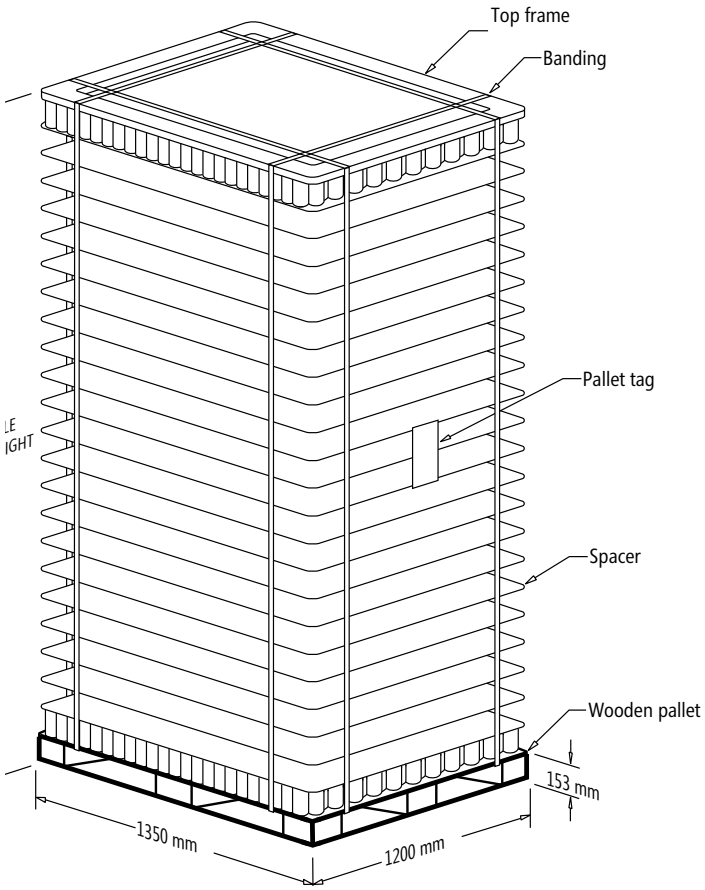
CAN PALLETIZATION

CAN - PALLETIZATION

1.2 PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER
1.2.1 200 ML SLIM - SWEDISH PALLET





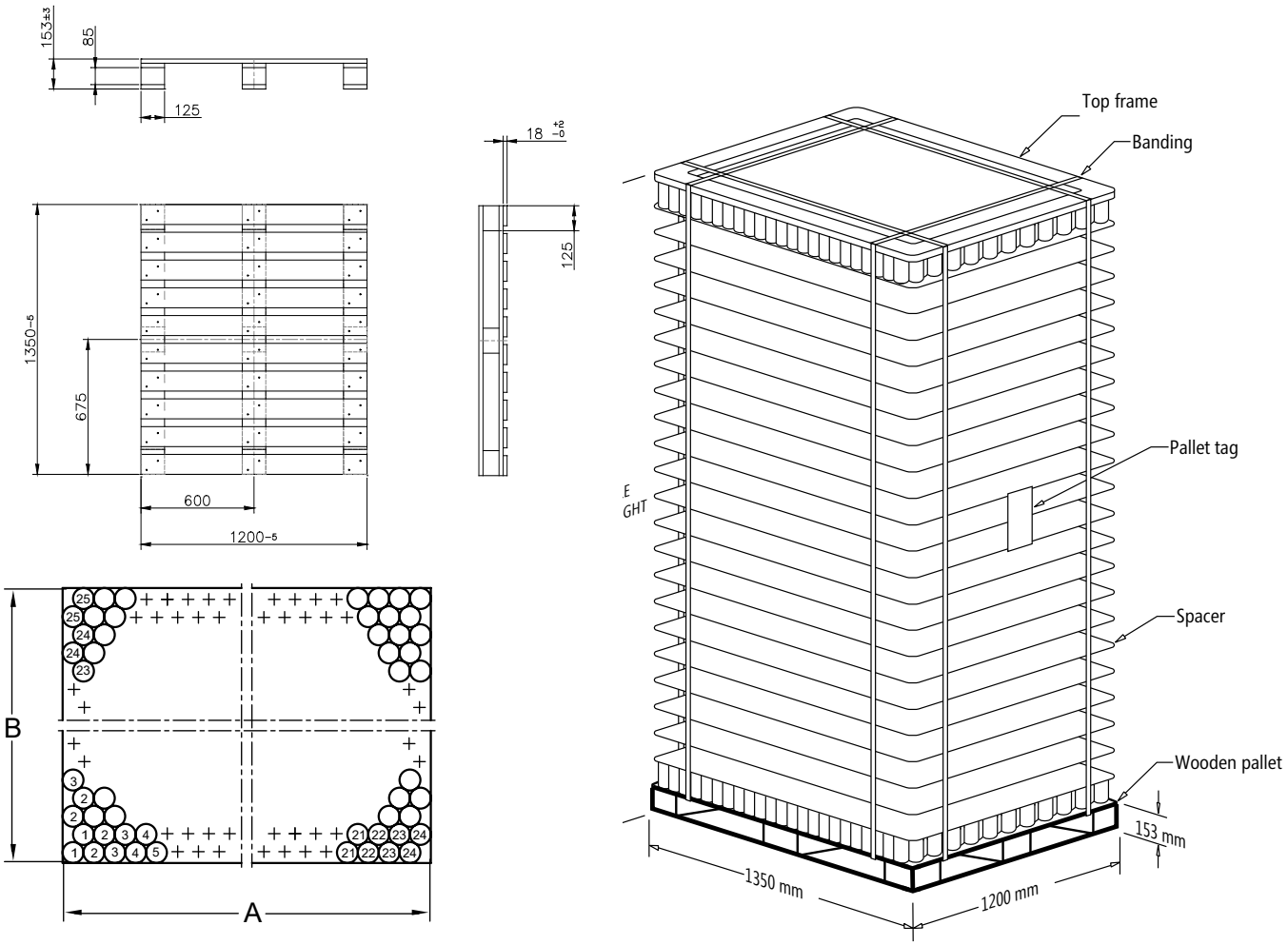


NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

W- Wood frame		Swedish pallet					
		1350 x 1200 x 153					
	Pallete type	Wood					
	Frame dimensions	1350 x 1200					
	Frame type	W	W	W	W	W	W
200ml	Cans per layer	600	600	600	600	600	600
	Number of layers	20	21	22	23	24	25
	Cans per pallet	12000	12600	13200	13800	14400	15000
	Pallet height incl. pallet	2427	2539	2651	2763	2875	2988

Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	200 ml Slim	1.2.1
	Revision: 5	Approved by:	

1.2.2 250 ML SLIM - SWEDISH PALLET



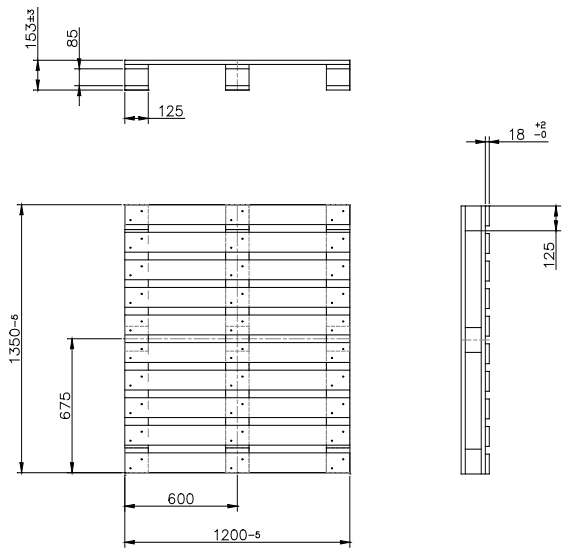
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

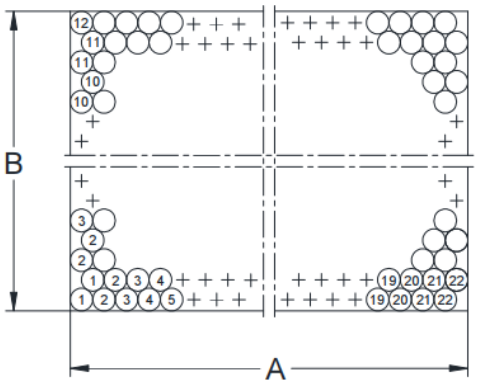
W- Wood frame		Swedish pallet					
		1350 x 1200 x 153					
	Pallete type	Wood					
	Frame dimensions	1350 x 1200					
	Frame type	W	W	W	W	W	W
250ml	Cans per layer	600	600	600	600	600	600
	Number of layers	15	16	17	18	19	20
	Cans per pallet	9000	9600	10200	10800	11400	12000
	Pallet height incl. pallet	2208	2343	2478	2613	2748	2883

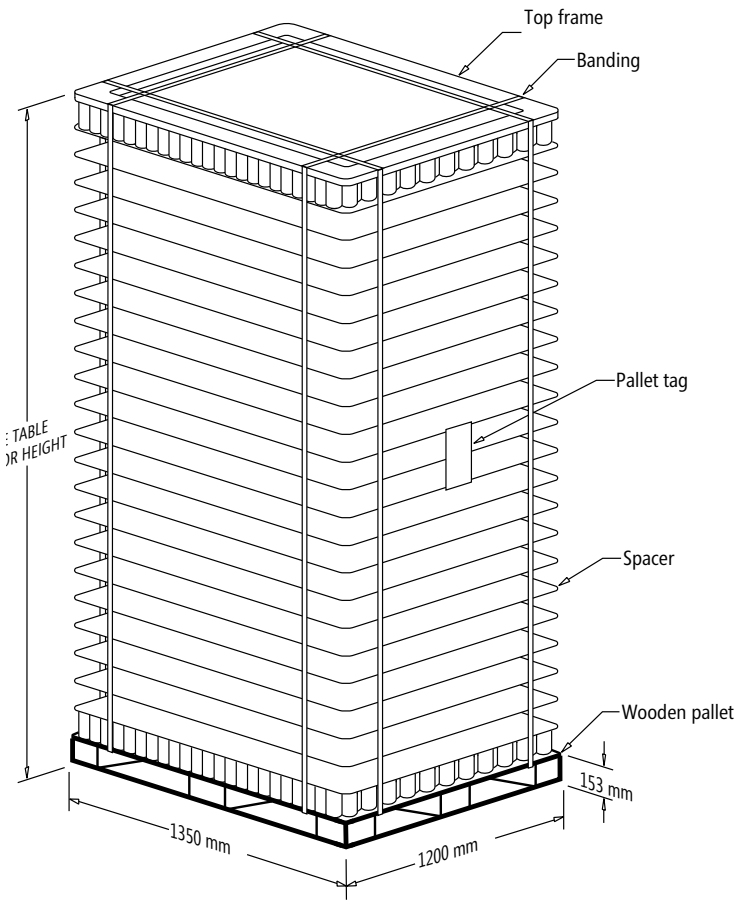
Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	250 ml Slim	1.2.2
	Revision: 5	Approved by:	

CAN - PALLETIZATION

1.2.3 330 ML FIT - SWEDISH PALLET





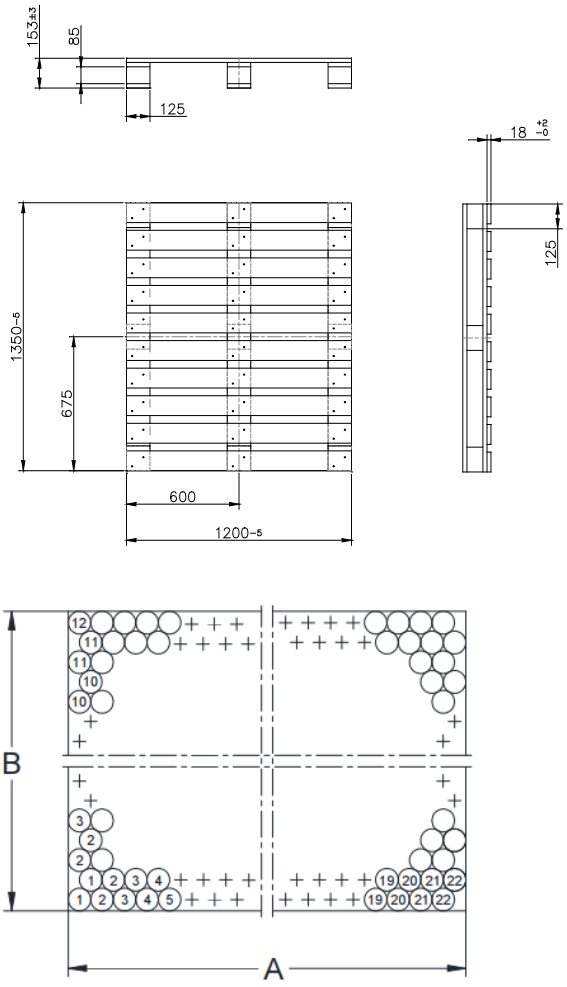


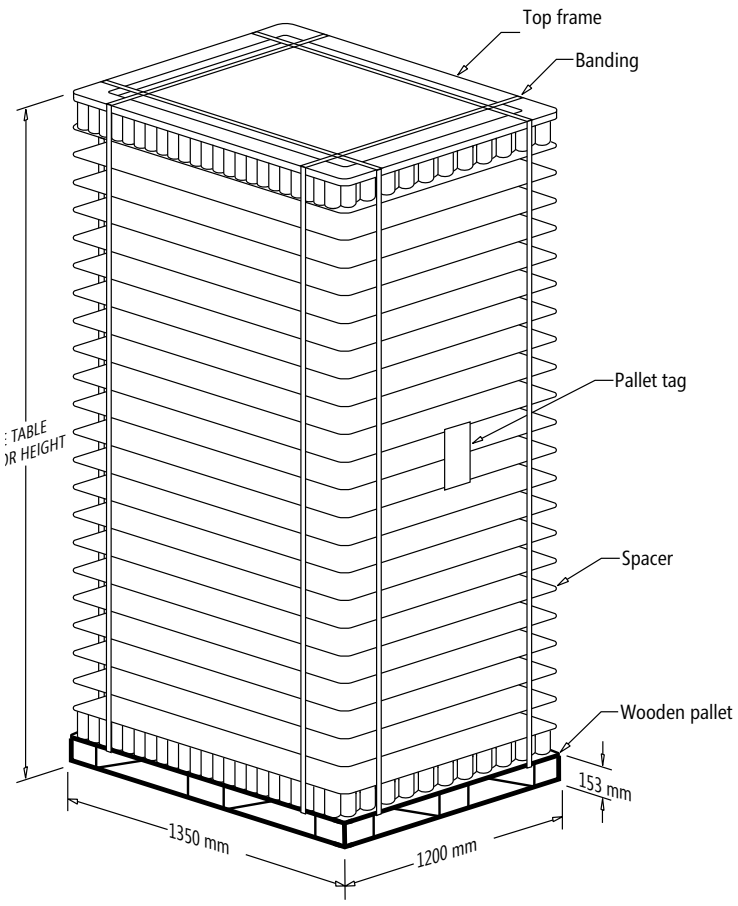
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

W- Wood frame		Swedish pallet					
		1350 x 1200 x 153					
	Pallete type	Wood					
	Frame dimensions	1350 x 1200					
	Frame type	W	W	W	W	W	W
330ml	Cans per layer	506	506	506	506	506	506
	Number of layers	14	15	16	17	18	19
	Cans per pallet	7084	7590	8096	8602	9108	9614
	Pallet height incl. pallet	2232	2379	2525	2671	2818	2964

Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.06.2021	330 ml FIT	1.2.3
	Revision: 5	Approved by:	

1.2.4 355 ML FIT- SWEDISH PALLET





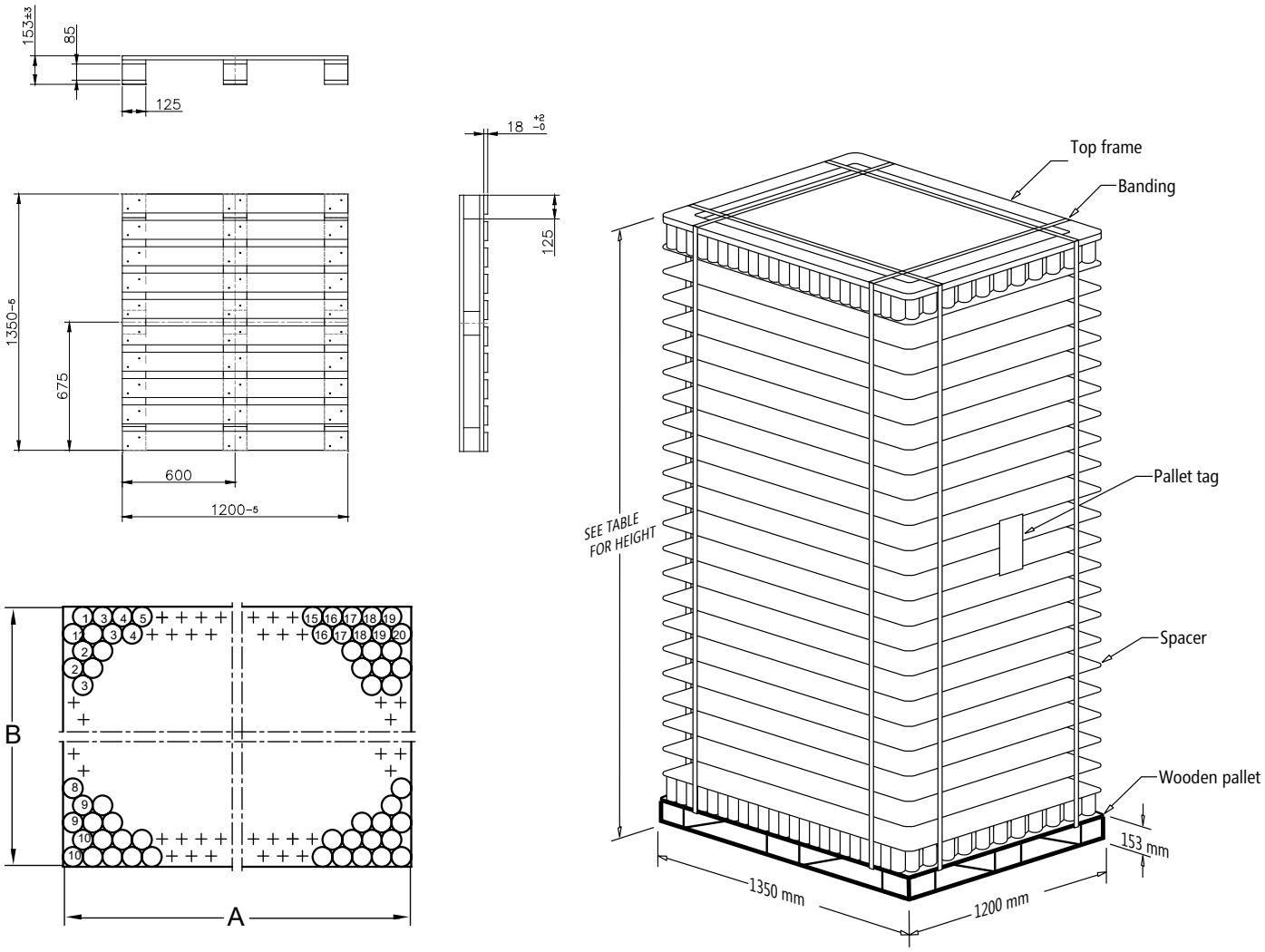
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

W- Wood frame		Swedish pallet				
		1350 x 1200 x 153				
	Pallete type	Wood				
	Frame dimensions	1350 x 1200				
	Frame type	W	W	W	W	W
355ml	Cans per layer	506	506	506	506	506
	Number of layers	14	15	16	17	18
	Cans per pallet	7084	7590	8096	8602	9108
	Pallet height incl. pallet	2363	2520	2676	2833	2989

Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	05.06.2023	355 ml FIT	1.2.4
	Revision: 5	Approved by:	

CAN - PALLETIZATION

1.2.5 449 ML LONGFIT - SWEDISH PALLET

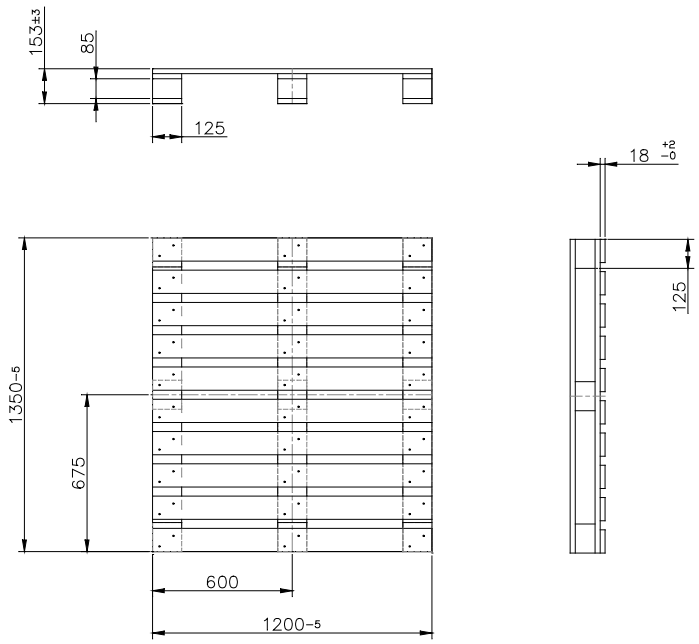


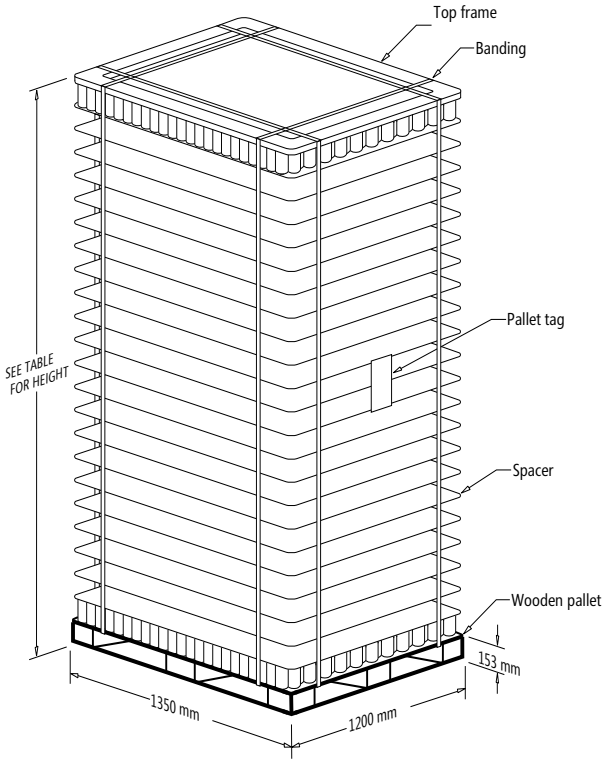
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

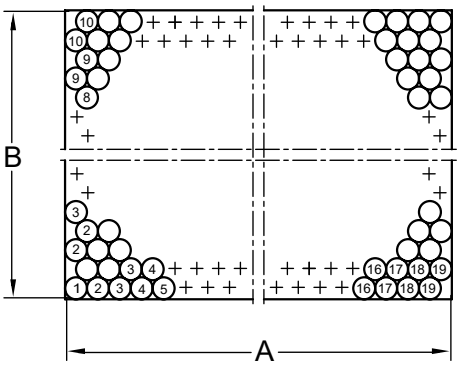
W- Wood frame		Swedish pallet					
		1350 x 1200 x 153					
	Pallete type	Wood					
	Frame dimensions	1350 x 1200					
	Frame type	W	W	W	W	W	W
449 ml	Cans per layer	390	390	390	390	390	390
	Number of layers	11	12	13	14	15	16
	Cans per pallet	4290	4680	5070	5460	5850	6240
	Pallet height incl. pallet	2042	2211	2380	2549	2718	2887

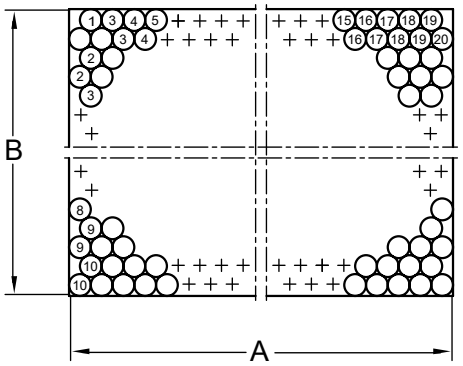
Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	449 ml LongFIT	1.2.5
	Revision: 5	Approved by:	

1.2.6 330 ML STD - SWEDISH PALLET









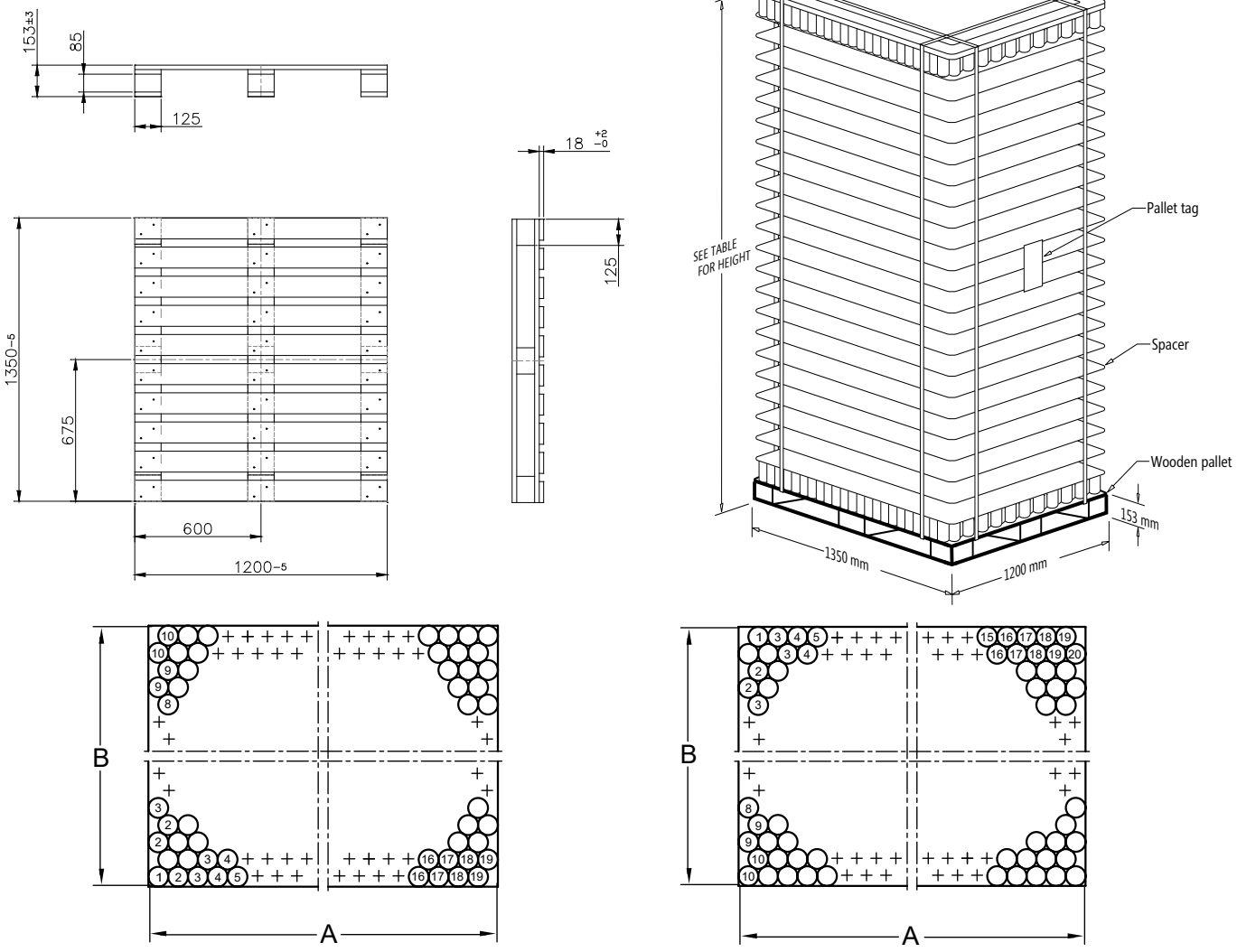
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

W- Wood frame		Swedish pallet											
		1350 x 1200 x 153											
		Pallete type	Wood										
		Frame dimensions	1350 x 1200										
		Frame type	W		W		W		W		W		W	
330 ml Typ A	330 ml Typ B	Cans per layer	380	390	380	390	380	390	380	390	380	390	380	390
		Number of layers	18	18	19	19	20	20	21	21	22	22	23	23
		Cans per pallet	6840	7020	7220	7410	7600	7800	7980	8190	8360	8580	8740	8970
		Pallet height incl. pallet	2274	2274	2390	2390	2507	2507	2623	2623	2739	2739	2855	2855

Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	330 ml STD	1.2.6
	Revision: 5	Approved by:	

CAN - PALLETIZATION

1.2.7 355 ML STD - SWEDISH PALLET

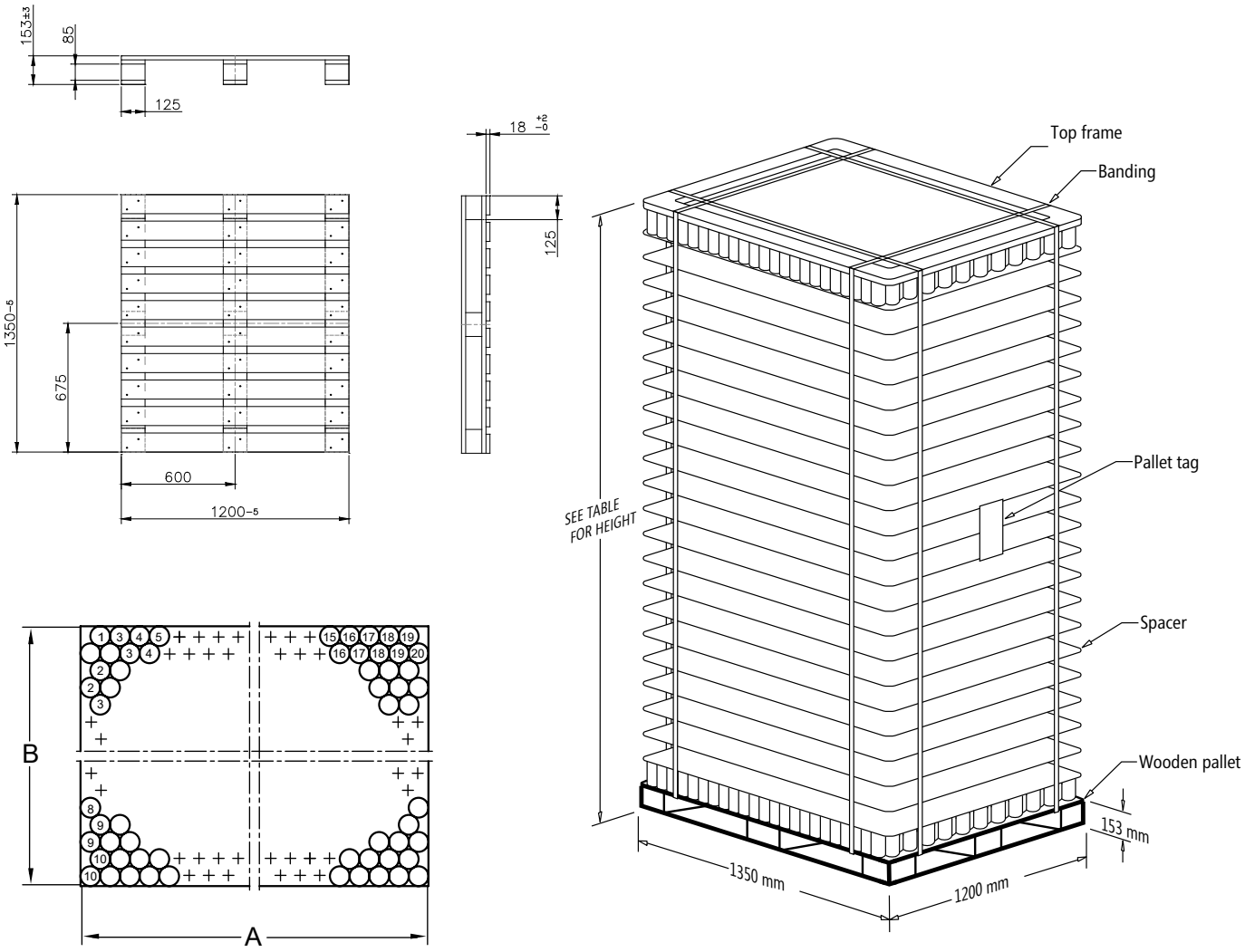


NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

W- Wood frame			Swedish pallet											
			1350 x 1200 x 153											
		Pallete type	Wood											
		Frame dimensions	1350 x 1200											
		Frame type	W		W		W		W		W		W	
355 ml Typ A	355 ml Typ B	Cans per layer	380	390	380	390	380	390	380	390	380	390	380	390
		Number of layers	18	18	19	19	20	20	21	21	22	22	23	23
		Cans per pallet	6840	7020	7220	7410	7600	7800	7980	8190	8360	8580	8740	8970
		Pallet height incl. pallet	2400	2400	2523	2523	2647	2647	2770	2770	2893	2893	3016	3016

Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	355 ml STD	1.2.7
	Revision: 5	Approved by:	

1.2.8 440 ML STD - SWEDISH PALLET



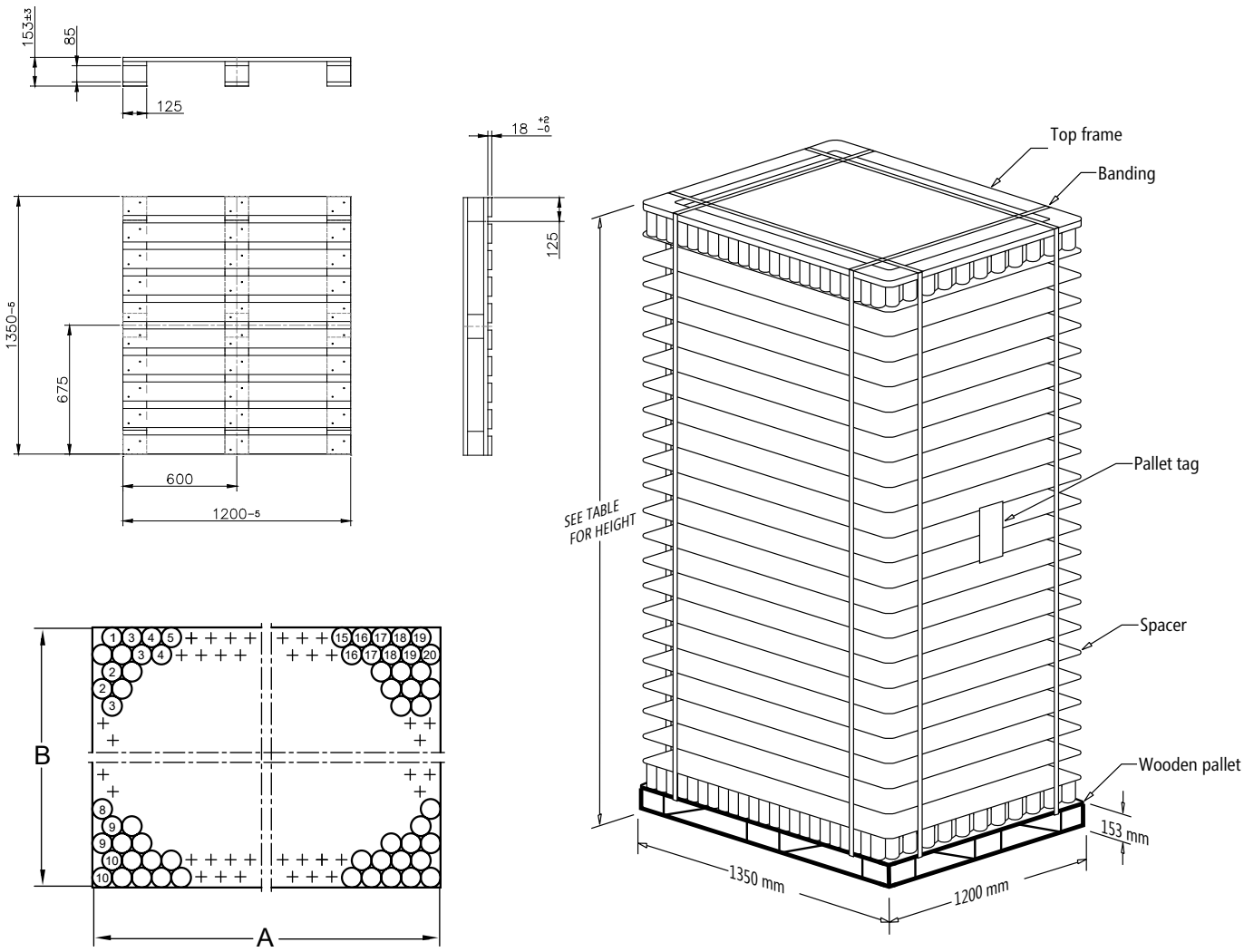
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

W- Wood frame		Swedish pallet					
		1350 x 1200 x 153					
	Pallete type	Wood					
	Frame dimensions	1350 x 1200					
	Frame type	W	W	W	W	W	W
440 ml	Cans per layer	390	390	390	390	390	390
	Number of layers	13	14	15	16	17	18
	Cans per pallet	5070	5460	5850	6240	6630	7020
	Pallet height incl. pallet	2144	2295	2446	2597	2748	2899

Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	440 ml STD	1.2.8
	Revision: 5	Approved by:	

CAN - PALLETIZATION

1.2.9 500 ML STD - SWEDISH PALLET

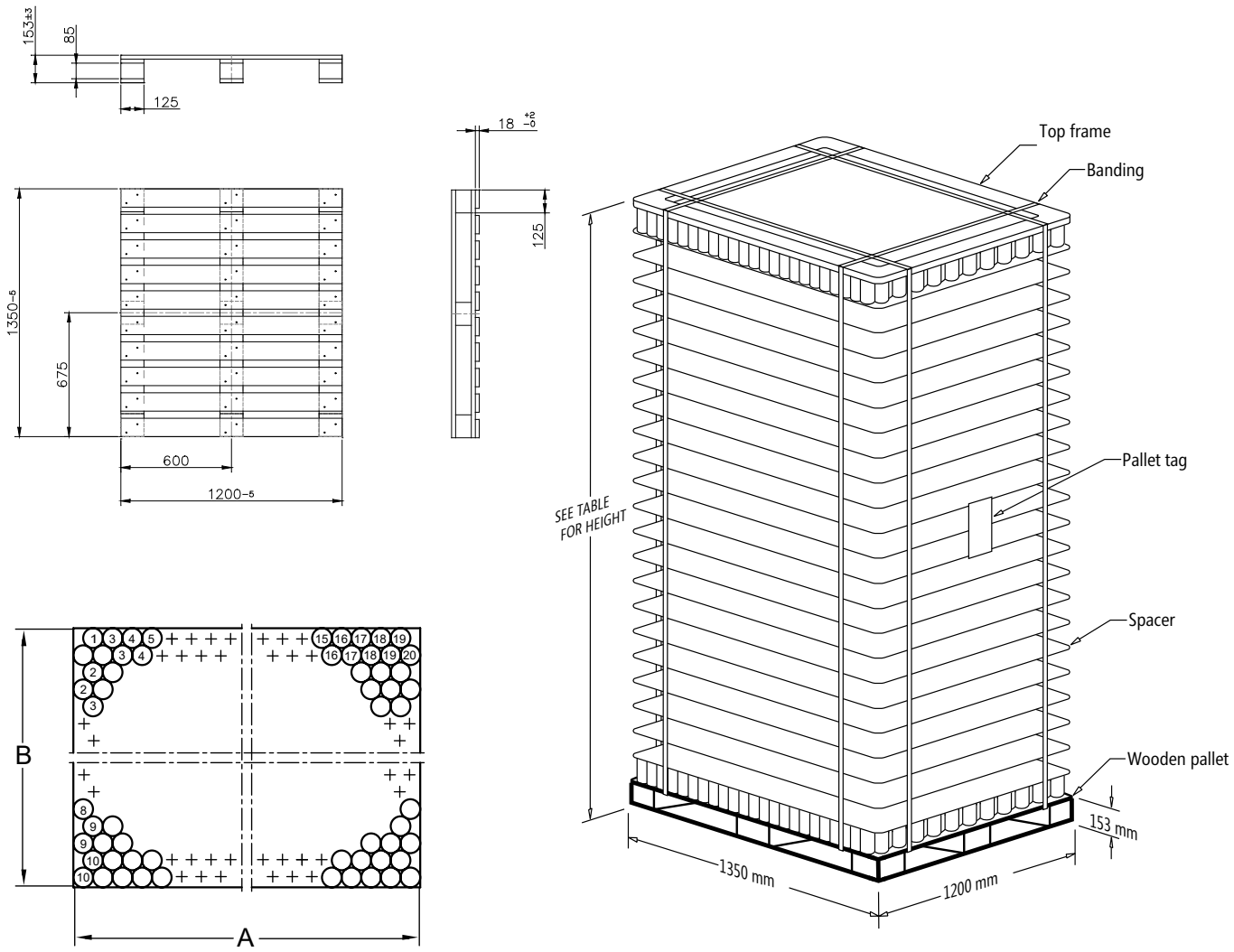


NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

W- Wood frame		Swedish pallet					
		1350 x 1200 x 153					
	Pallete type	Wood					
	Frame dimensions	1350 x 1200					
	Frame type	W	W	W	W	W	W
500 ml	Cans per layer	390	390	390	390	390	390
	Number of layers	11	12	13	14	15	16
	Cans per pallet	4290	4680	5070	5460	5850	6240
	Pallet height incl. pallet	2042	2211	2380	2549	2718	2887

Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	500 ml STD	1.2.9
	Revision: 5	Approved by:	

1.2.10 550 ML STD - SWEDISH PALLET



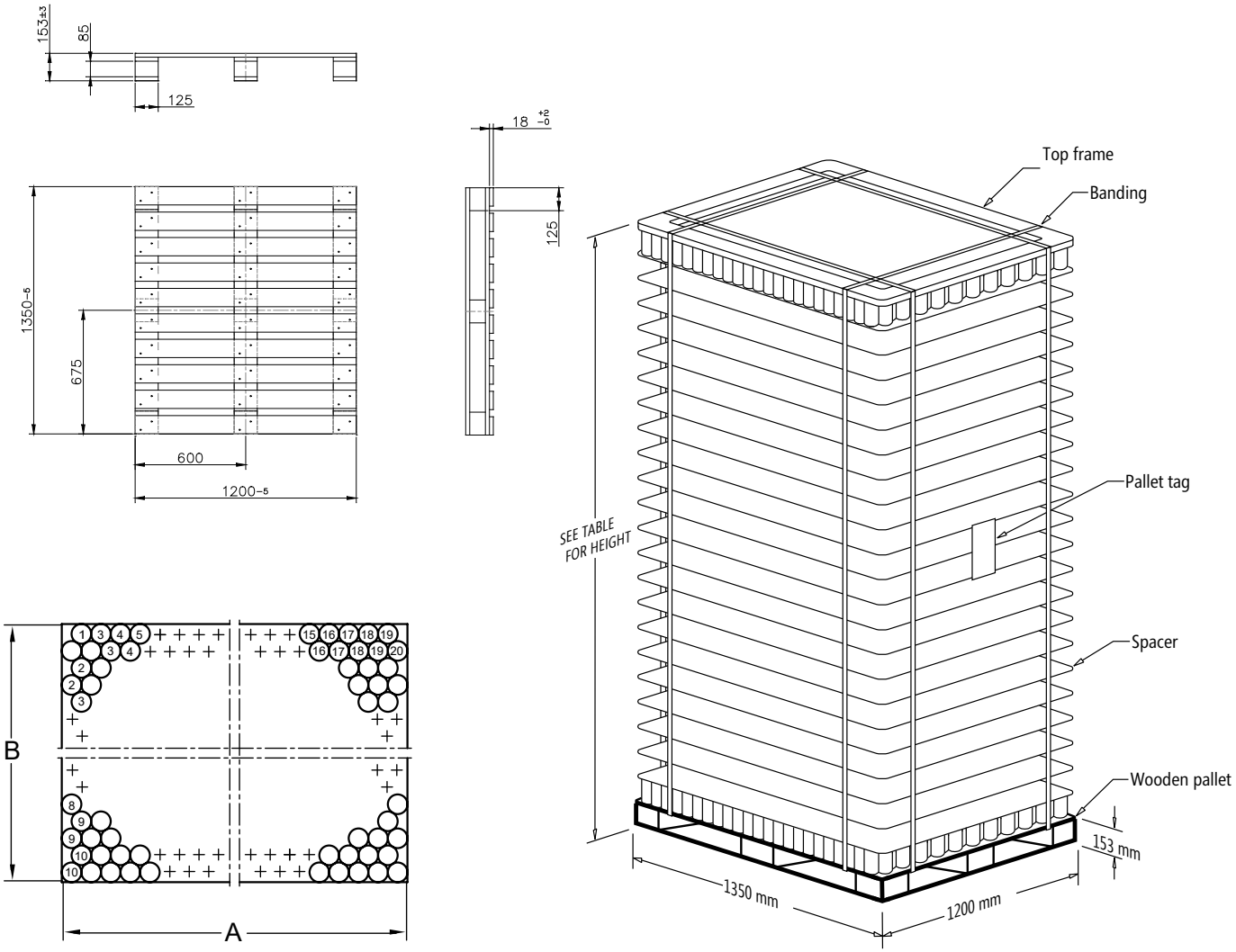
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

W- Wood frame		Swedish pallet					
		1350 x 1200 x 153					
	Pallete type	Wood					
	Frame dimensions	1350 x 1200					
	Frame type	W	W	W	W	W	W
550 ml	Cans per layer	390	390	390	390	390	390
	Number of layers	10	11	12	13	14	15
	Cans per pallet	3900	4290	4680	5070	5460	5850
	Pallet height incl. pallet	2019	2203	2386	2570	2754	2937

Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	550 ml STD	1.2.10
	Revision: 5	Approved by:	

CAN - PALLETIZATION

1.2.11 568 ML STD - SWEDISH PALLET

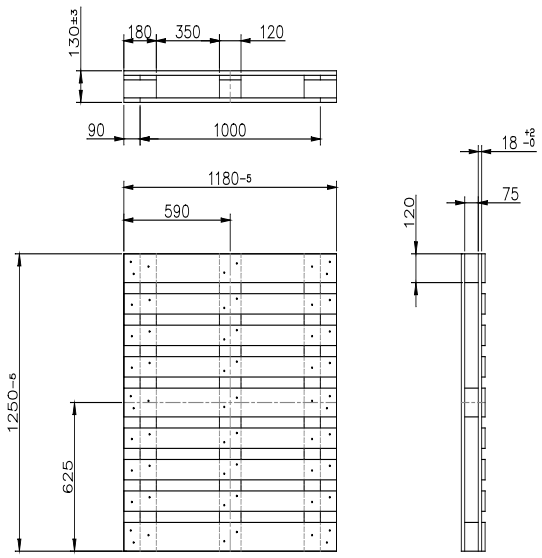


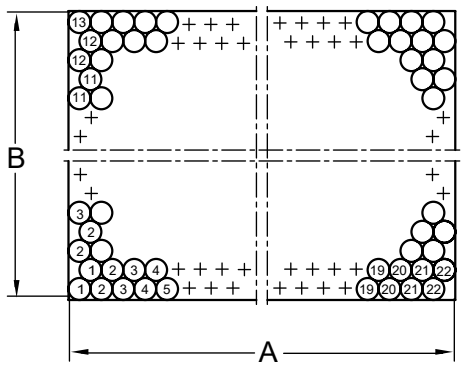
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

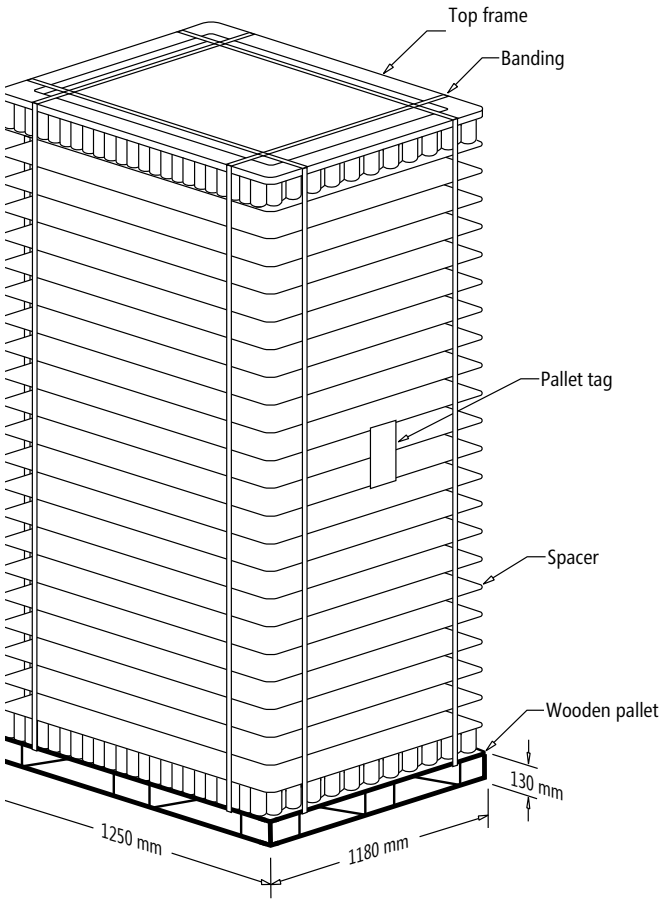
W- Wood frame		Swedish pallet					
		1350 x 1200 x 153					
	Pallete type	Wood					
	Frame dimensions	1350 x 1200					
	Frame type	W	W	W	W	W	W
568 ml	Cans per layer	390	390	390	390	390	390
	Number of layers	9	10	11	12	13	14
	Cans per pallet	3510	3900	4290	4680	5070	5460
	Pallet height incl. pallet	1884	2073	2262	2452	2641	2830

Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	568 ml STD	1.2.11
	Revision: 5	Approved by:	

1.2.12 150 ML SLIM- GERMAN PALLET







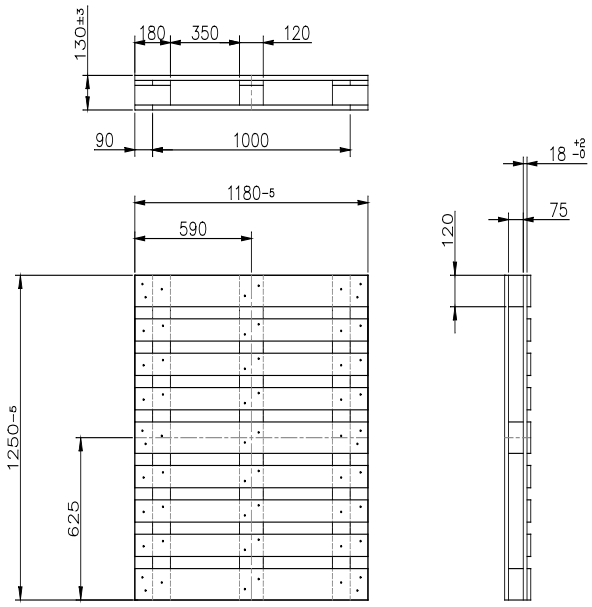
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

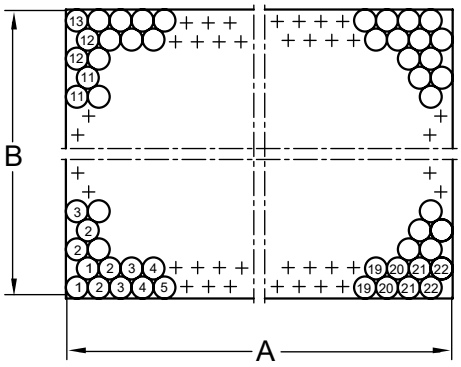
M - Steel frame 1265x1195 W- Wood frame 1250x1180		German pallet					
		1250 x 1180 x 130					
	Pallete type	Wood					
	Frame dimensions	1250x1180 / 1265x1195					
	Frame type	M, W	M, W	M, W	M, W	M, W	M, W
150 ml	Cans per layer	550	550	550	550	550	550
	Number of layers	26	27	28	29	30	31
	Cans per pallet	14300	14850	15400	15950	16500	17050
	Pallet height incl. pallet	2481	2571	2660	2749	2839	2928

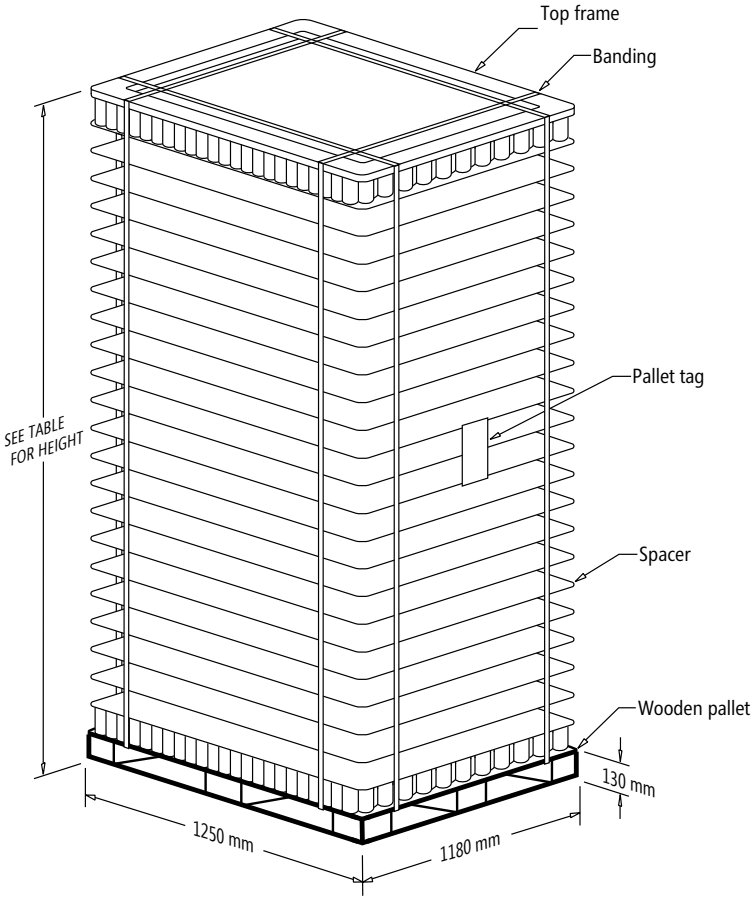
Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	150 ml Slim	1.2.12
	Revision: 5	Approved by:	

CAN - PALLETIZATION

1.2.13 200 ML SLIM - GERMAN PALLET







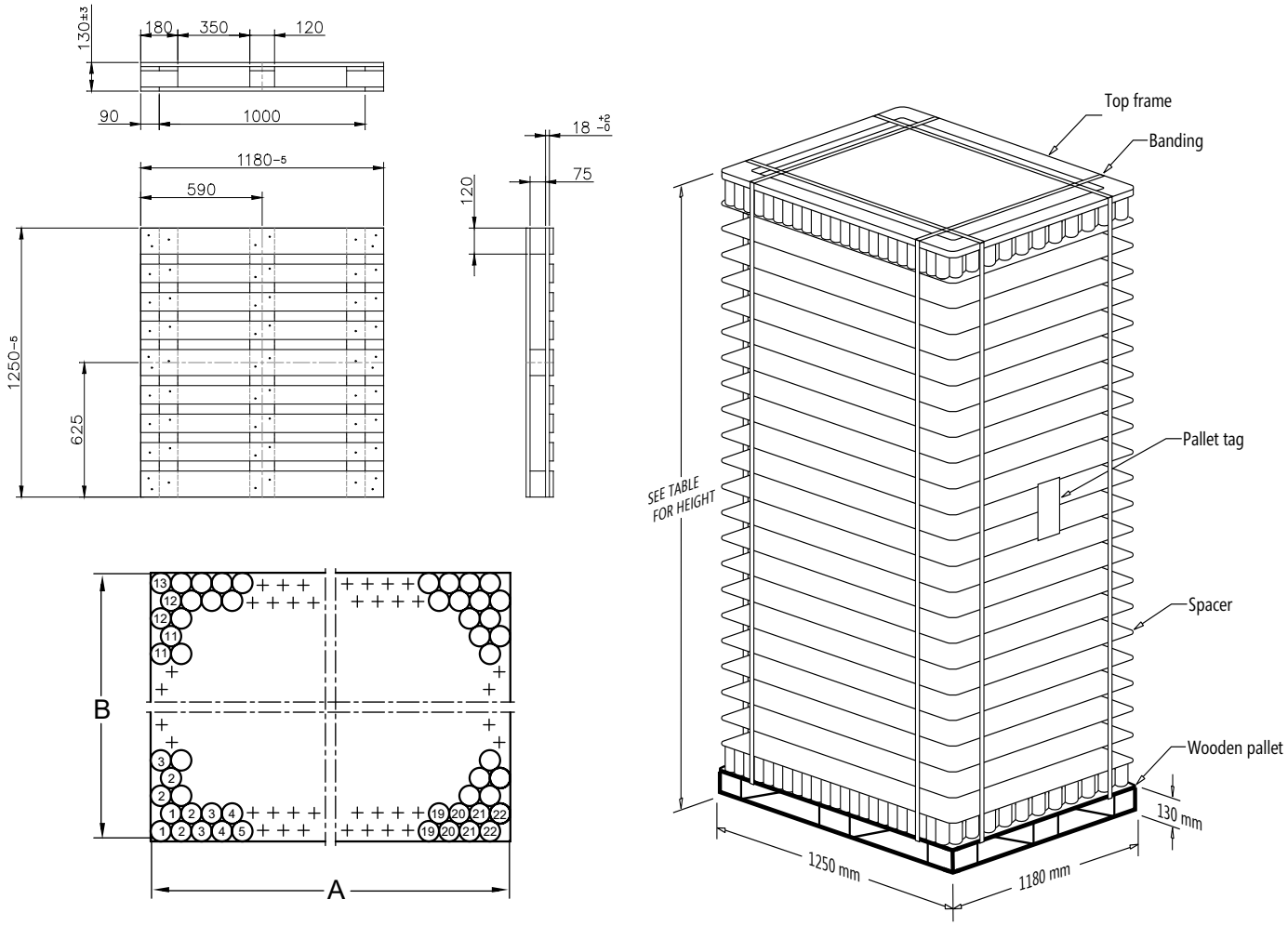
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

M - Steel frame 1265x1195 W- Wood frame 1250x1180		German pallet					
		1250 x 1180 x 130					
	Pallete type	Wood					
	Frame dimensions	1250x1180 / 1265x1195					
	Frame type	M, W	M, W	M, W	M, W	M, W	M, W
200 ml	Cans per layer	550	550	550	550	550	550
	Number of layers	20	21	22	23	24	25
	Cans per pallet	11000	11550	12100	12650	13200	13750
	Pallet height incl. pallet	2404	2516	2628	2740	2852	2965

Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	200 ml Slim	1.2.13
	Revision: 5	Approved by:	

CAN - PALLETIZATION

1.2.14 250 ML SLIM- GERMAN PALLET



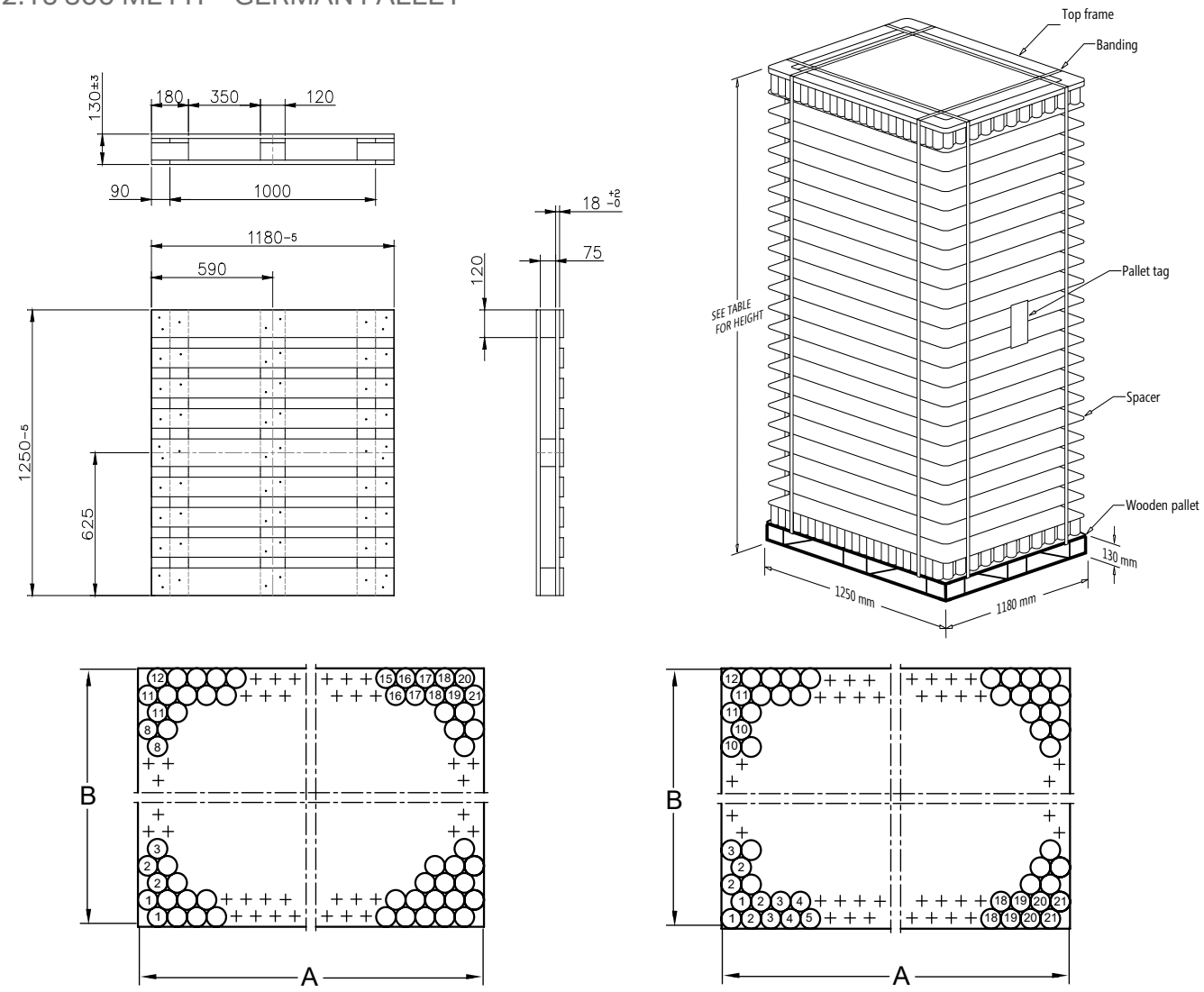
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

M - Steel frame 1265x1195 W- Wood frame 1250x1180		German pallet					
		1250 x 1180 x 130					
	Pallete type	Wood					
	Frame dimensions	1250x1180 / 1265x1195					
	Frame type	M, W	M, W	M, W	M, W	M, W	M, W
250 ml	Cans per layer	550	550	550	550	550	550
	Number of layers	15	16	17	18	19	20
	Cans per pallet	8250	8800	9350	9900	10450	11000
	Pallet height incl. pallet	2185	2320	2455	2590	2725	2860

Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	250 ml Slim	1.2.14
	Revision: 5	Approved by:	

CAN - PALLETIZATION

1.2.15 300 ML FIT - GERMAN PALLET



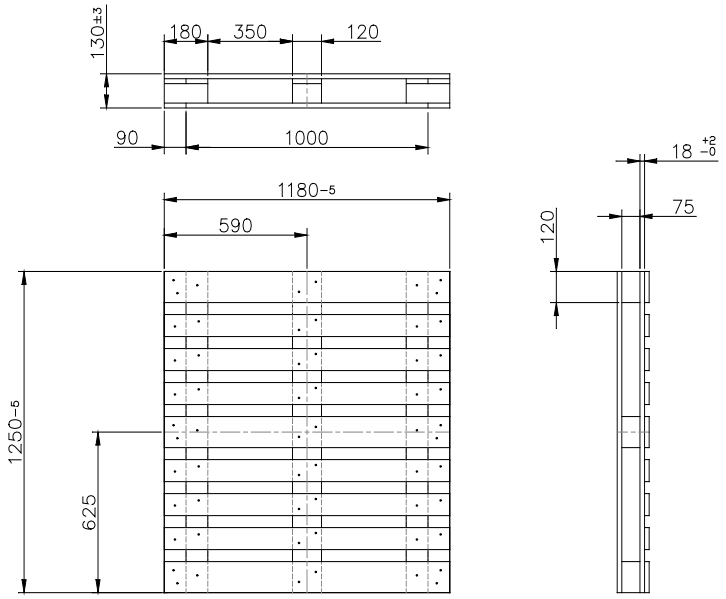
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

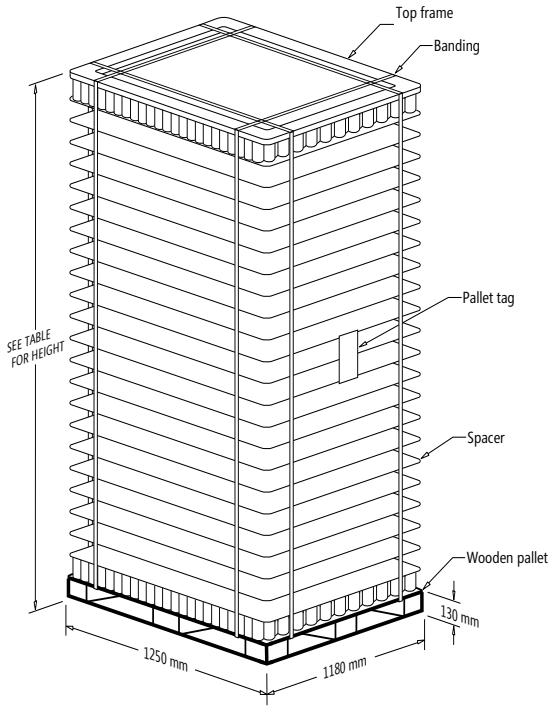
M - Steel frame 1265x1195 W- Wood frame 1250x1180		German pallet											
		1250 x 1180 x 130											
	Pallete type	Wood											
	Frame dimensions	1250x1180 / 1265x1195											
	Frame type	W		W		W		W		W		W	
300 ml	Cans per layer	471	483	471	483	471	483	471	483	471	483	471	483
	Number of layers	16		17		18		19		20		21	
	Cans per pallet	7536	7728	8007	8211	8478	8694	8949	9177	9420	9660	10143	10143
	Pallet height incl. pallet	2318		2453		2588		2723		2858		2992	

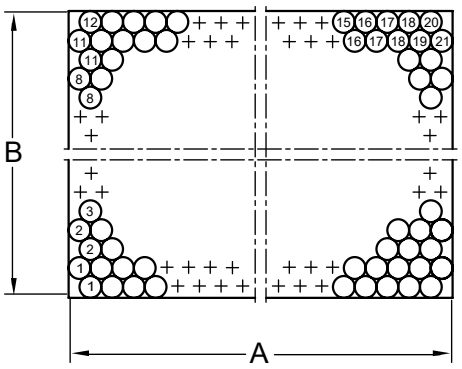
Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	300 ml FIT	1.2.15
	Revision: 5	Approved by:	

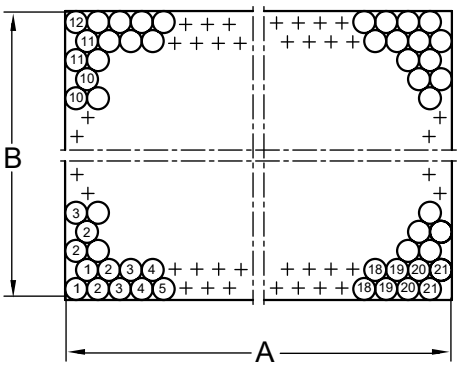
CAN - PALLETIZATION

1.2.16 330 ML FIT - GERMAN PALLET









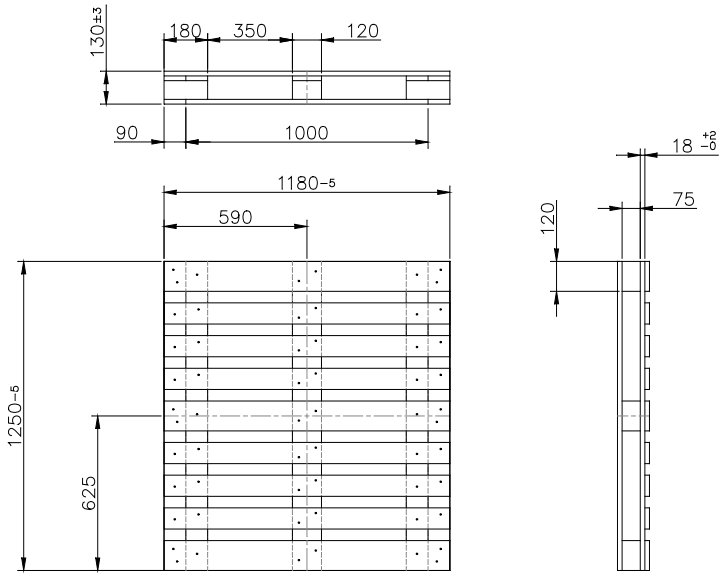
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

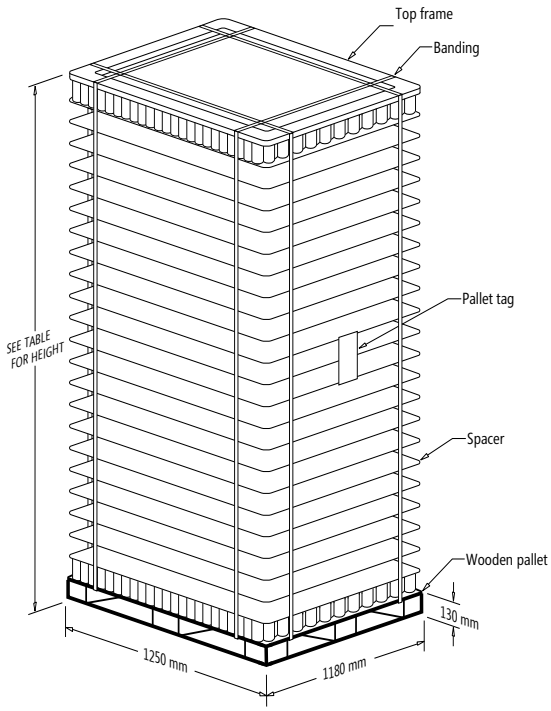
M - Steel frame 1265x1195 W- Wood frame 1250x1180		German pallet 1250 x 1180 x 130											
	Pallete type	Wood											
	Frame dimensions	1250x1180 / 1265x1195											
	Frame type	W		W		W		W		W		W	
330 ml	Cans per layer	471	483	471	483	471	483	471	483	471	483	471	483
	Number of layers	14		15		16		17		18		19	
	Cans per pallet	6594	6762	7065	7245	7536	7728	8007	8211	8478	8694	8949	9177
	Pallet height incl. pallet	2209		2356		2502		2648		2795		2941	

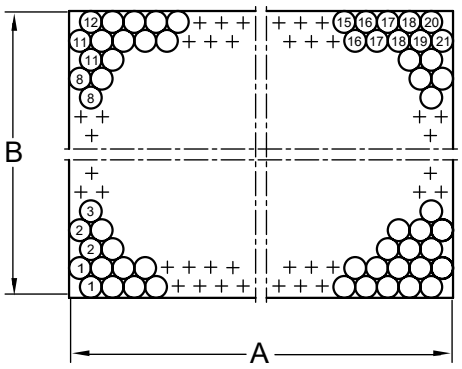
Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	330 ml FIT	1.2.16
	Revision: 5	Approved by:	

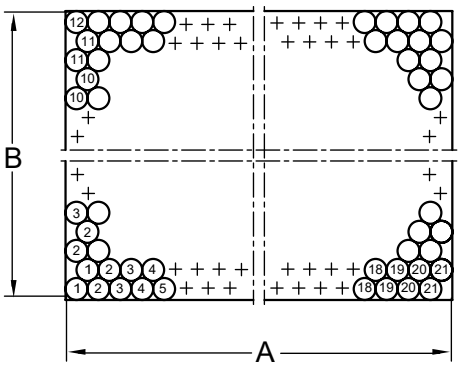
CAN - PALLETIZATION

1.2.17 355 ML FIT - GERMAN PALLET







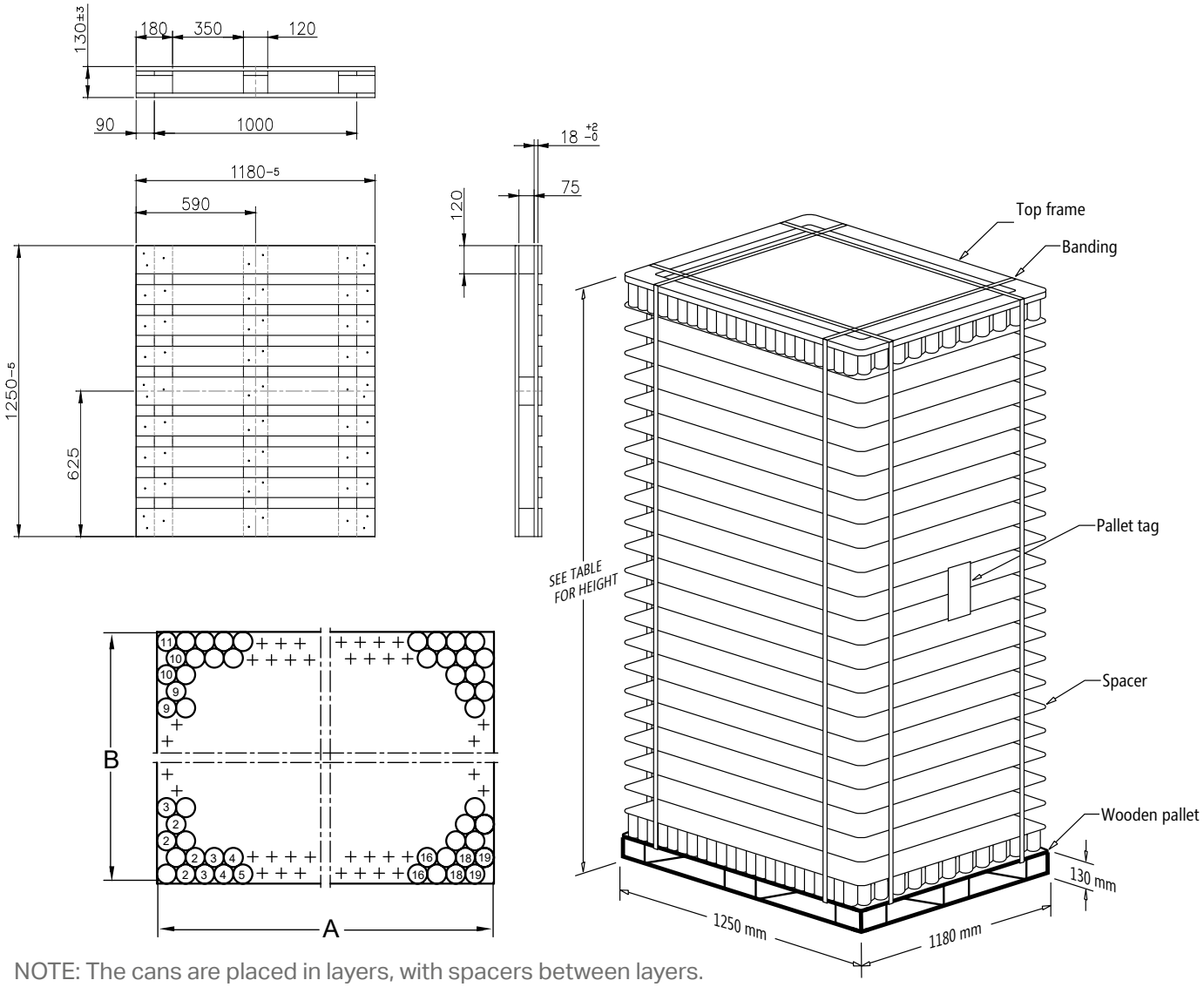


NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

M - Steel frame 1265x1195 W- Wood frame 1250x1180		German pallet 1250 x 1180 x 130											
	Pallete type	Wood											
	Frame dimensions	1250x1180 / 1265x1195											
	Frame type	W		W		W		W		W		W	
355 ml	Cans per layer	471	483	471	483	471	483	471	483	471	483	471	483
	Number of layers	13		14		15		16		17		18	
	Cans per pallet	6123	6279	6594	6762	7065	7245	7536	7728	8007	8210	8478	8694
	Pallet height incl. pallet	2208		2366		2524		2881		2839		2996	

Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	355 ml FIT	1.2.17
	Revision: 5	Approved by:	

1.2.18 449 ML LONGFIT- GERMAN PALLET



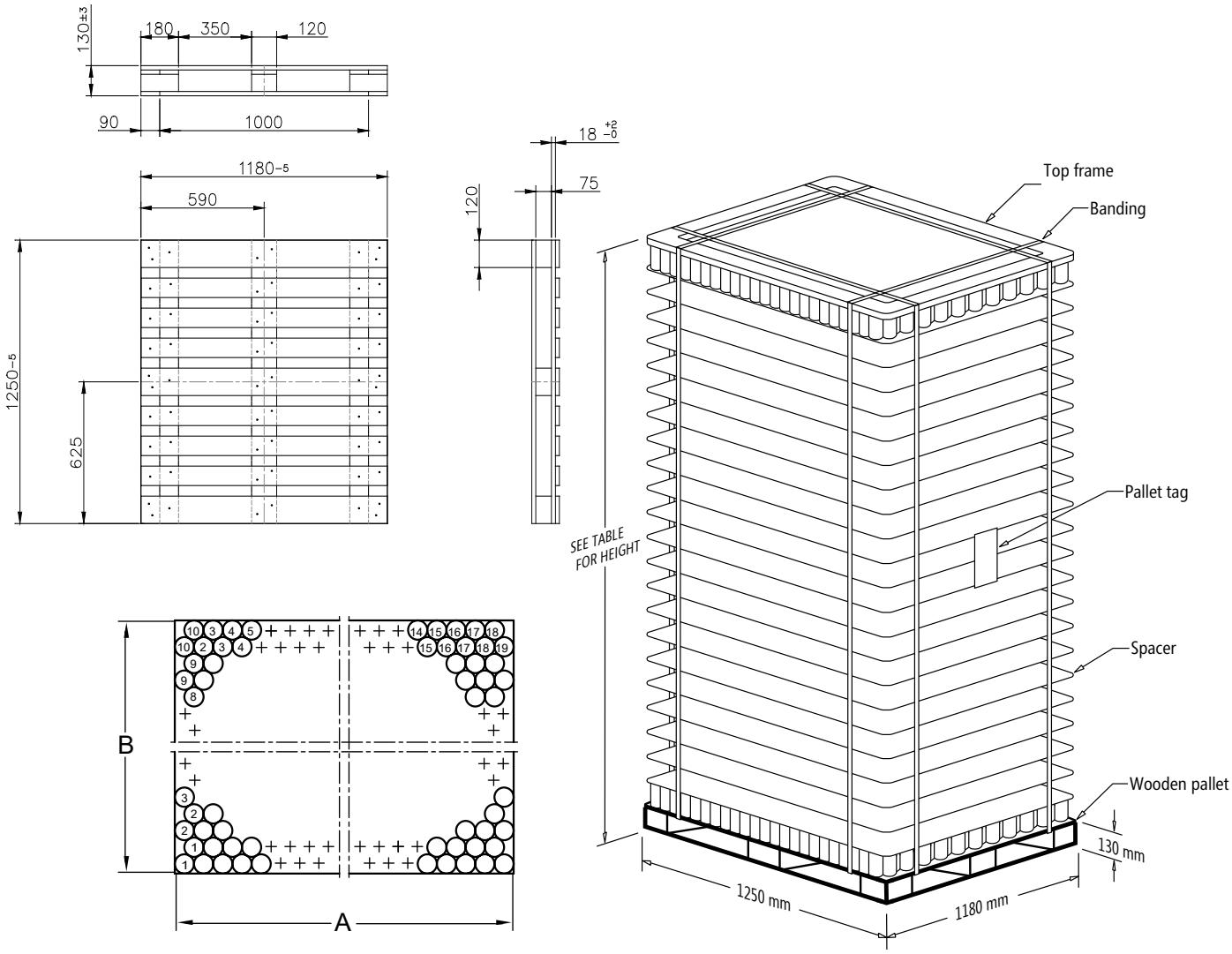
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

W- Wood frame		German pallet					
		1250 x 1180 x 130					
	Pallete type	Wood					
	Frame dimensions	1250 x 1180					
	Frame type	W	W	W	W	W	W
449 ml	Cans per layer	399	399	399	399	399	399
	Number of layers	11	12	13	14	15	16
	Cans per pallet	4389	4788	5187	5586	5985	6384
	Pallet height incl. pallet	2019	2188	2357	2526	2695	2864

Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	19.08.2021	449 ml LongFIT	1.2.18
	Revision: 5	Approved by:	

CAN - PALLETIZATION

1.2.19 449 ML LONGFIT - GERMAN PALLET

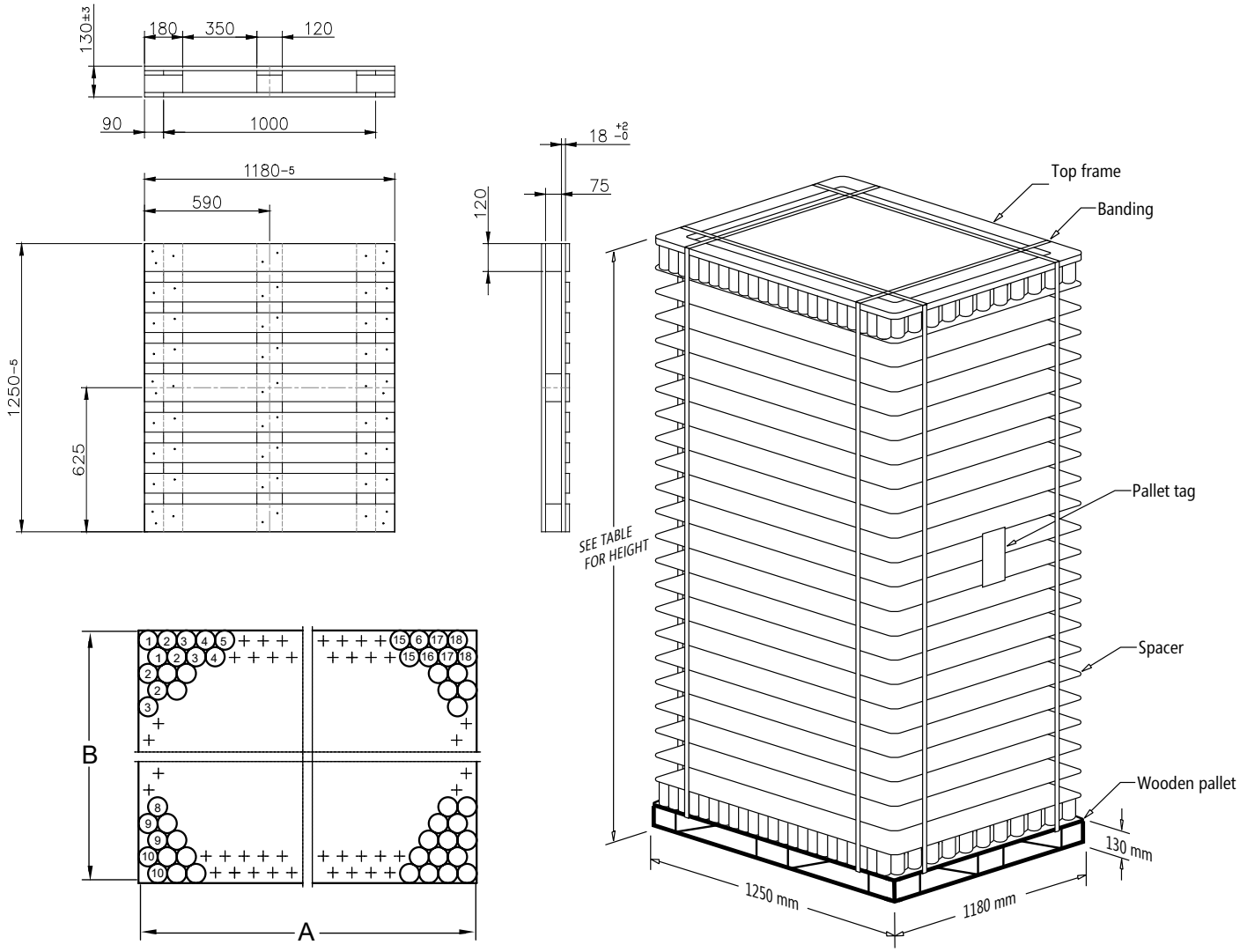


NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

W- Wood frame		German pallet					
		1250 x 1180 x 130					
	Pallete type	Wood					
	Frame dimensions	1250 x 1180					
	Frame type	W	W	W	W	W	W
449 ml	Cans per layer	370	370	370	370	370	370
	Number of layers	11	12	13	14	15	16
	Cans per pallet	4070	4440	4810	5180	5550	5920
	Pallet height incl. pallet	2019	2188	2357	2526	2695	2864

Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	09.08.2021	449 ml LongFIT	1.2.19
	Revision: 5	Approved by:	

1.2.20 330 ML STD - GERMAN PALLET



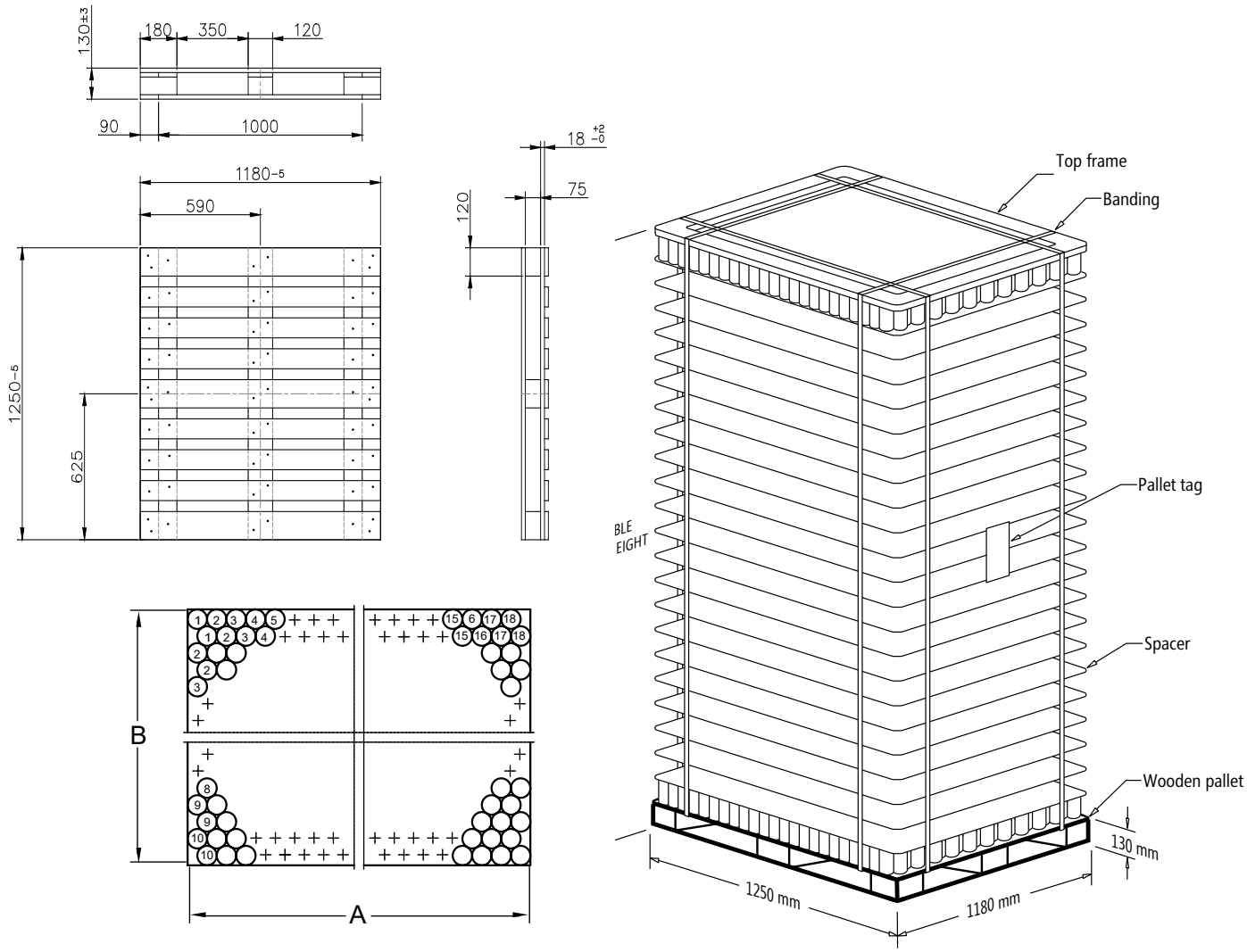
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

M - Steel frame 1265x1195 W- Wood frame 1250x1180		German pallet					
		1250 x 1180 x 130					
	Pallete type	Wood					
	Frame dimensions	1250x1180 / 1265x1195					
	Frame type	W	W	W	W	W	W
330 ml	Cans per layer	360	360	360	360	360	360
	Number of layers	18	19	20	21	22	23
	Cans per pallet	6480	6840	7200	7560	7920	8280
	Pallet height incl. pallet	2251	2367	2484	2600	2716	2832

Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	330 ml STD	1.2.20
	Revision: 5	Approved by:	

CAN - PALLETIZATION

1.2.21 440 ML STD - GERMAN PALLET



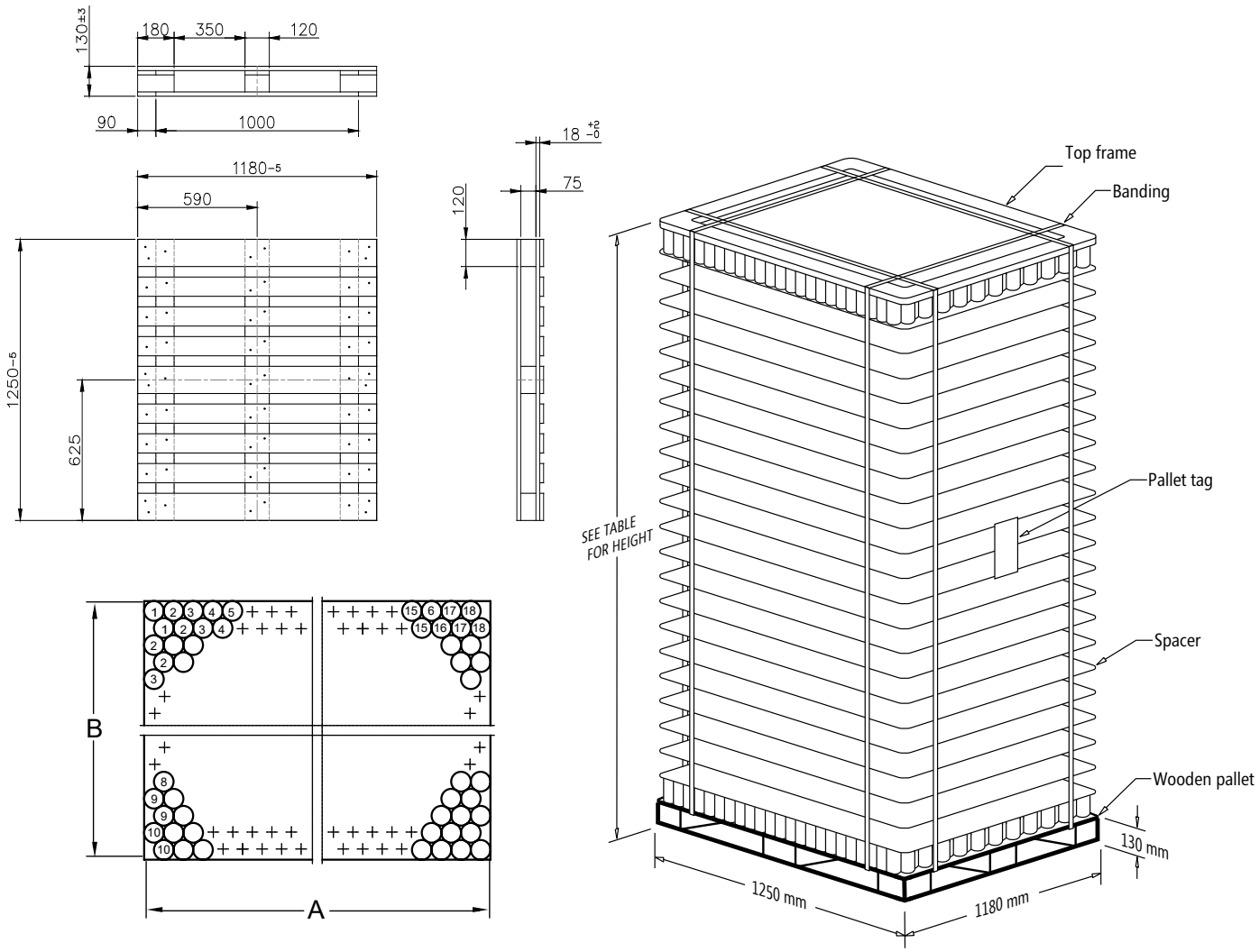
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

M - Steel frame 1265x1195 W- Wood frame 1250x1180		German pallet 1250 x 1180 x 130					
	Pallete type	Wood					
	Frame dimensions	1250x1180 / 1265x1195					
	Frame type	W	W	W	W	W	W
440 ml	Cans per layer	360	360	360	360	360	360
	Number of layers	13	14	15	16	17	18
	Cans per pallet	4680	5040	5400	5760	6120	6480
	Pallet height incl. pallet	2121	2272	2423	2574	2725	2876

Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	440 ml STD	1.2.21
	Revision: 5	Approved by:	

CAN - PALLETIZATION

1.2.22 500 ML STD - GERMAN PALLET



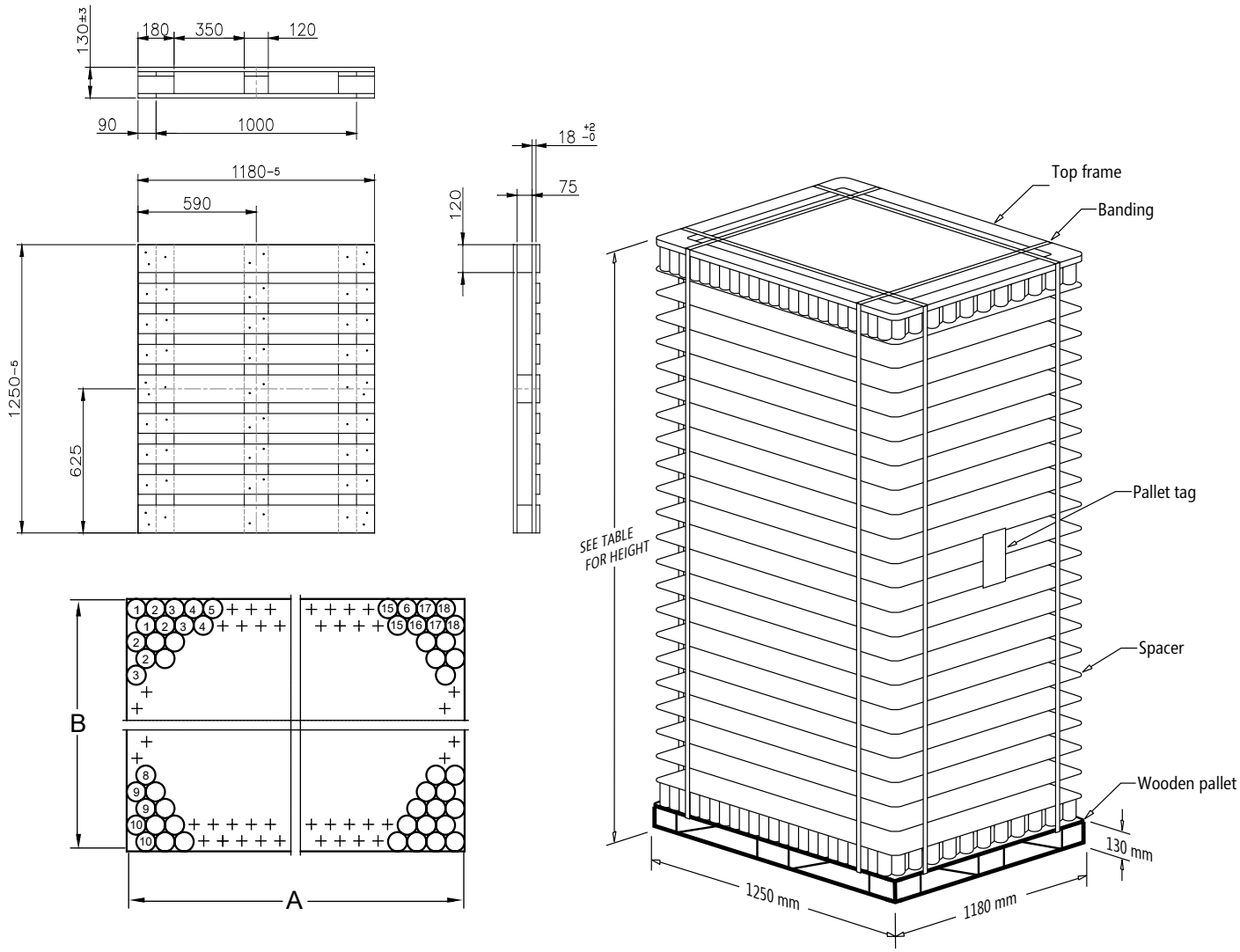
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

M - Steel frame 1265x1195 W- Wood frame 1250x1180		German pallet					
		1250 x 1180 x 130					
	Pallete type	Wood					
	Frame dimensions	1250x1180 / 1265x1195					
	Frame type	W	W	W	W	W	W
500 ml	Cans per layer	360	360	360	360	360	360
	Number of layers	11	12	13	14	15	16
	Cans per pallet	3960	4320	4680	5040	5400	5760
	Pallet height incl. pallet	2019	2188	2357	2526	2695	2864

Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	500 ml STD	1.2.22
	Revision: 5	Approved by:	

CAN - PALLETIZATION

1.2.23 550 ML STD - GERMAN PALLET



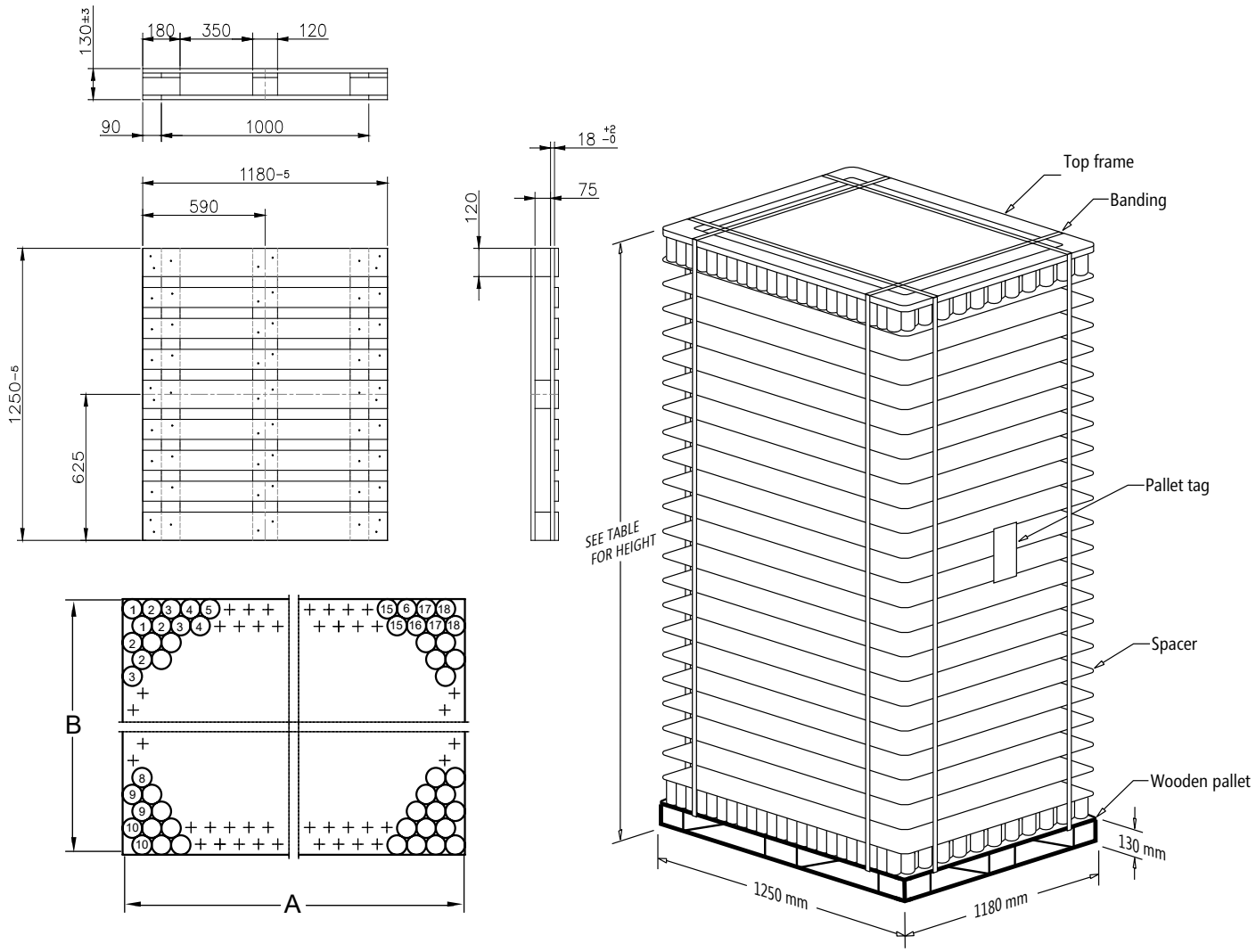
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

M - Steel frame 1265x1195 W- Wood frame 1250x1180		German pallet					
		1250 x 1180 x 130					
	Pallete type	Wood					
	Frame dimensions	1250x1180 / 1265x1195					
	Frame type	W	W	W	W	W	W
550 ml	Cans per layer	360	360	360	360	360	360
	Number of layers	10	11	12	13	14	15
	Cans per pallet	3600	3960	4320	4680	5040	5400
	Pallet height incl. pallet	1996	2180	2363	2547	2731	2914

Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	550 ml STD	1.2.23
	Revision: 5	Approved by:	

CANPACK

1.2.24 568 ML STD - GERMAN PALLET



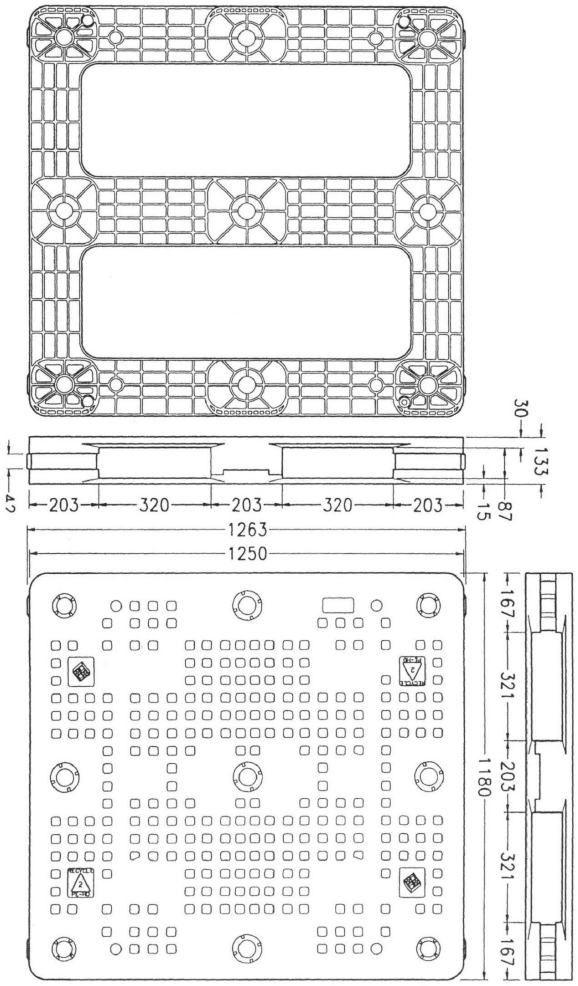
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

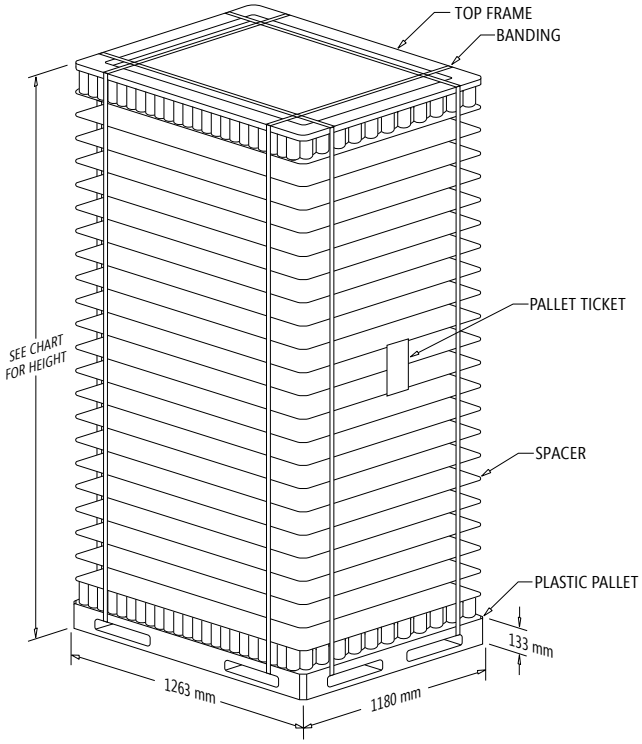
M - Steel frame 1265x1195 W- Wood frame 1250x1180		German pallet					
		1250 x 1180 x 130					
	Pallete type	Wood					
	Frame dimensions	1250x1180 / 1265x1195					
	Frame type	W	W	W	W	W	W
568 ml	Cans per layer	360	360	360	360	360	360
	Number of layers	10	11	12	13	14	15
	Cans per pallet	3600	3960	4320	4680	5040	5400
	Pallet height incl. pallet	2050	2239	2429	2618	2807	2996

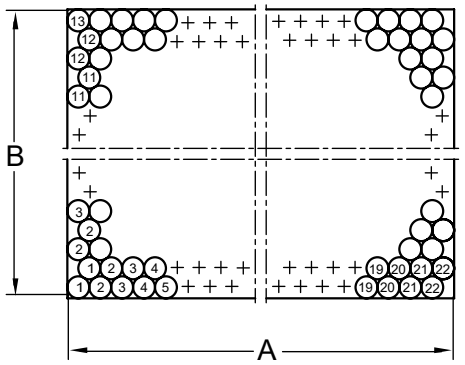
Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	568 ml STD	1.2.24
	Revision: 5	Approved by:	

CAN - PALLETIZATION

1.2.25 150 ML SLIM - GERMAN PLASTIC PALLET





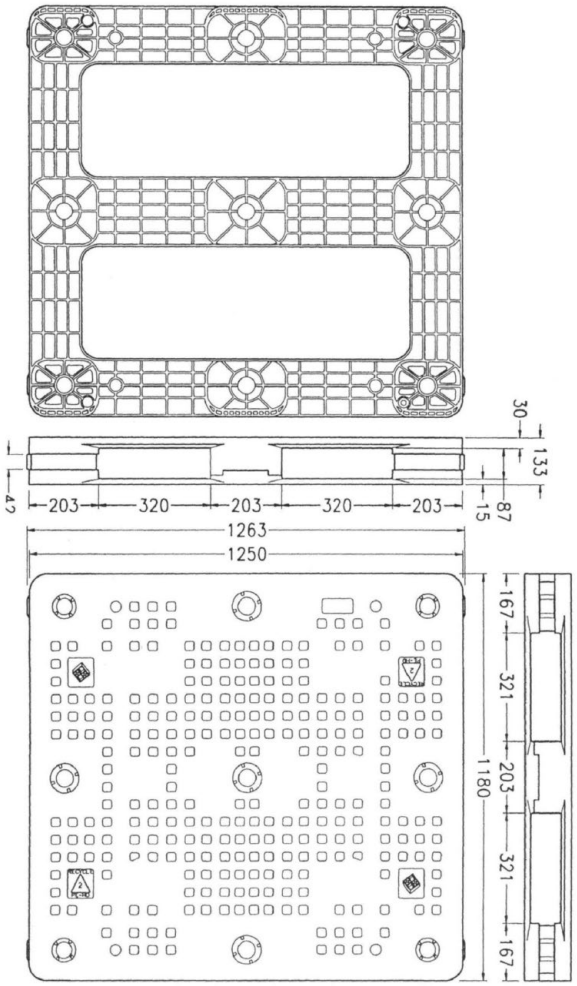


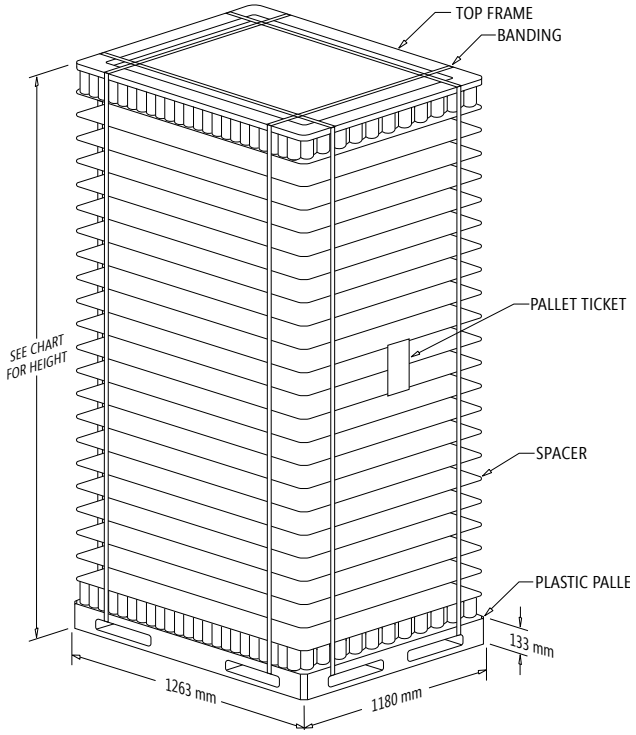
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

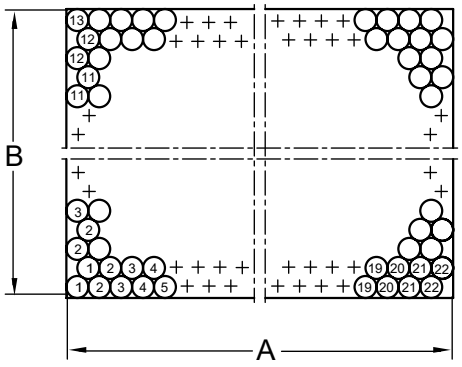
M - Steel frame 1265x1195 W- Wood frame 1250x1180		German pallet					
		1250 x 1180 x 133					
	Pallete type	Plastic					
	Frame dimensions	1250x1180 / 1265x1195					
	Frame type	M, W	M, W	M, W	M, W	M, W	M, W
150 ml	Cans per layer	550	550	550	550	550	550
	Number of layers	26	27	28	29	30	31
	Cans per pallet	14300	14850	15400	15950	16500	17050
	Pallet height incl. pallet	2484	2574	2663	2751	2842	2931

Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	150 ml Slim	1.2.25
	Revision: 5	Approved by:	

1.2.26 200 MLSLIM - GERMAN PLASTIC PALLET







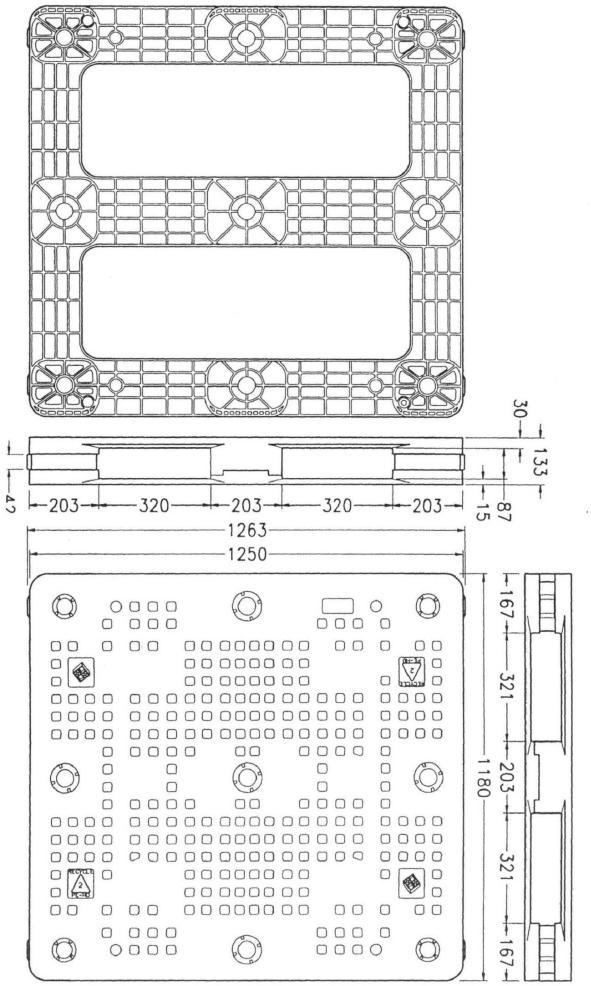
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

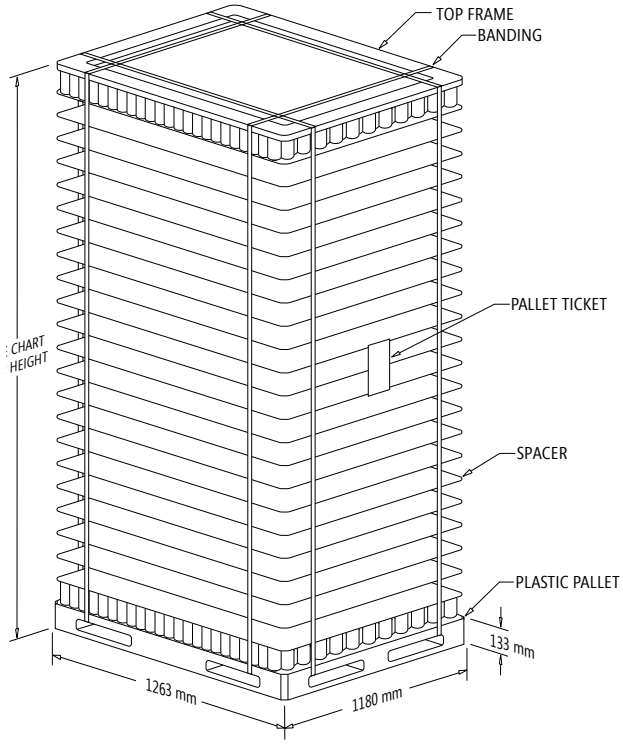
M - Steel frame 1265x1195 W- Wood frame 1250x1180		German pallet					
		1250 x 1180 x 133					
	Pallete type	Plastic					
	Frame dimensions	1250x1180 / 1265x1195					
	Frame type	M, W	M, W	M, W	M, W	M, W	M, W
200 ml	Cans per layer	550	550	550	550	550	550
	Number of layers	20	21	22	23	24	25
	Cans per pallet	11000	11550	12100	12650	13200	13750
	Pallet height incl. pallet	2407	2519	2631	2743	2855	2968

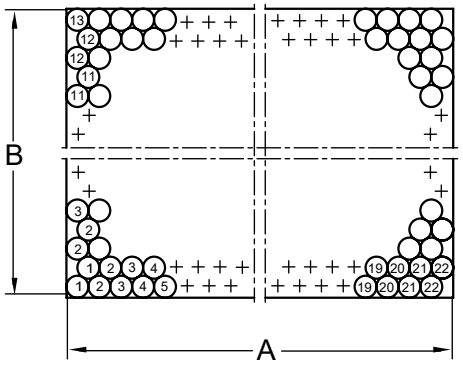
Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	200 ml Slim	1.2.26
	Revision: 5	Approved by:	

CAN - PALLETIZATION

1.2.27 250 ML SLIM - GERMAN PLASTIC PALLET







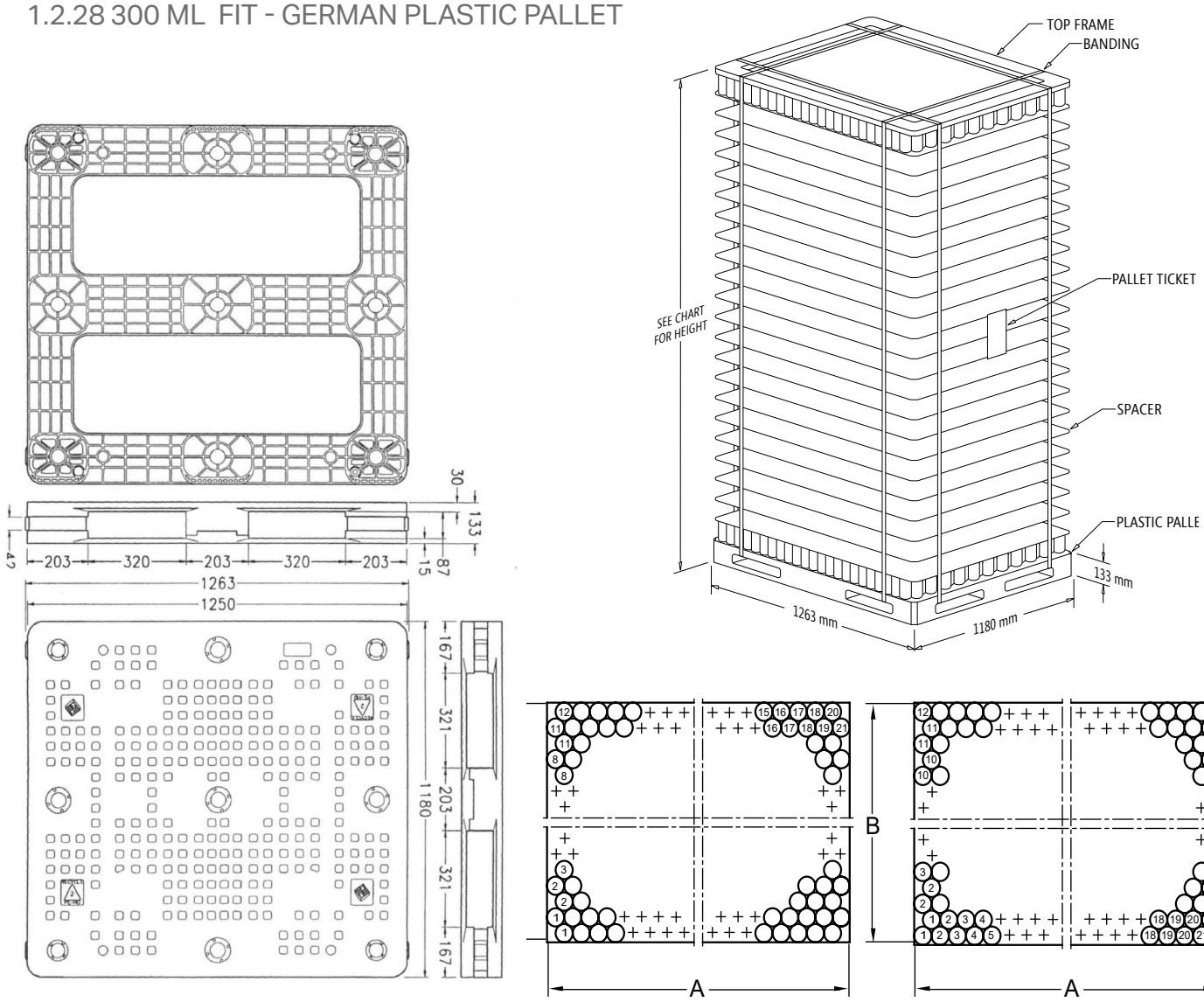
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

M - Steel frame 1265x1195 W- Wood frame 1250x1180		German pallet					
		1250 x 1180 x 133					
	Pallete type	Plastic					
	Frame dimensions	1250x1180 / 1265x1195					
	Frame type	M, W	M, W	M, W	M, W	M, W	M, W
250 ml	Cans per layer	550	550	550	550	550	550
	Number of layers	15	16	17	18	19	20
	Cans per pallet	8250	8800	9350	9900	10450	11000
	Pallet height incl. pallet	2188	2323	2458	2593	2728	2863

Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	250 ml Slim	1.2.27
	Revision: 5	Approved by:	

CAN - PALLETIZATION

1.2.28 300 ML FIT - GERMAN PLASTIC PALLET



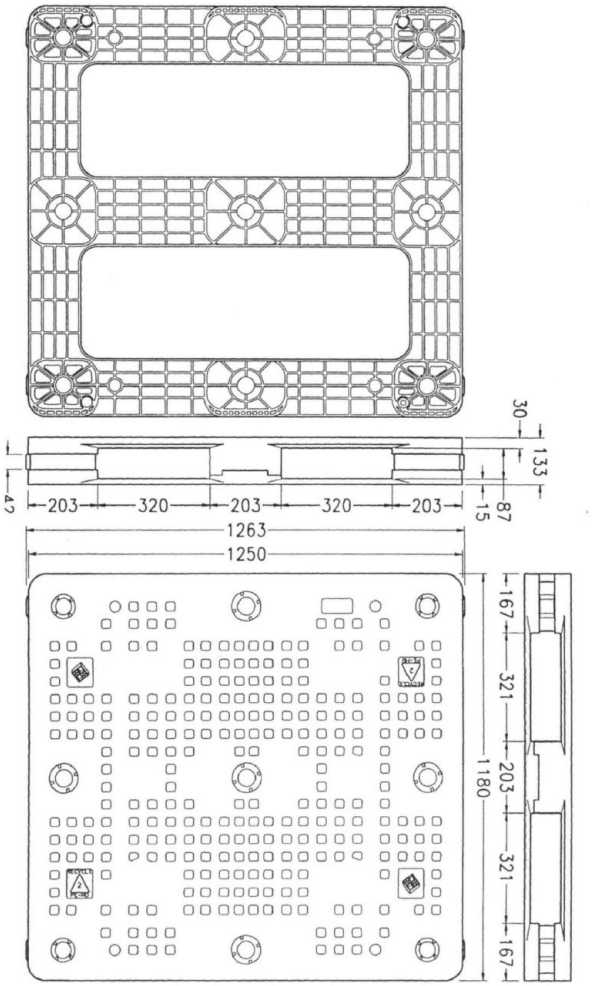
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

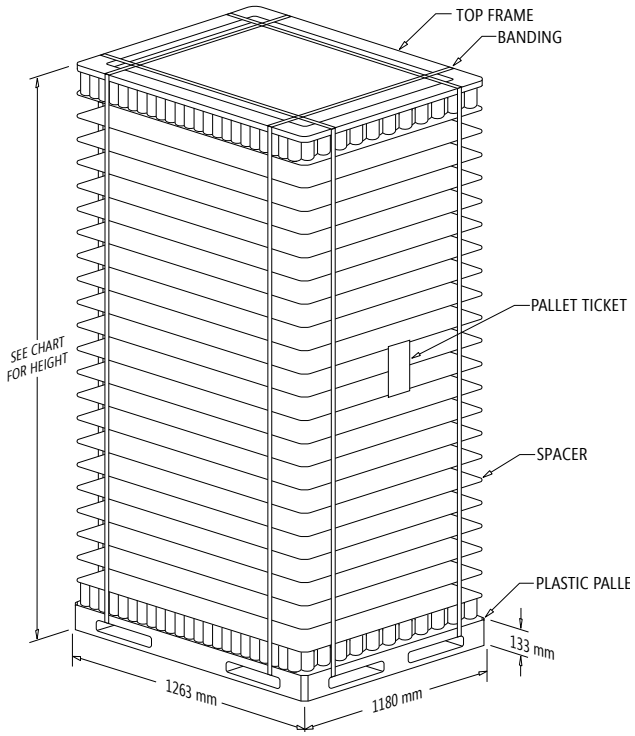
M - Steel frame		German pallet											
		1250 x 1180 x 133											
	Pallete type	Plastic											
	Frame dimensions	1265x1195											
	Frame type	M		M		M		M		M		M	
300 ml	Cans per layer	471	483	471	483	471	483	471	483	471	483	471	483
	Number of layers	16		17		18		19		20		21	
	Cans per pallet	7536	7728	8007	8211	8478	8694	8949	9177	9420	9660	10143	10143
	Pallet height incl. pallet	2321		2456		2591		2726		2861		2995	

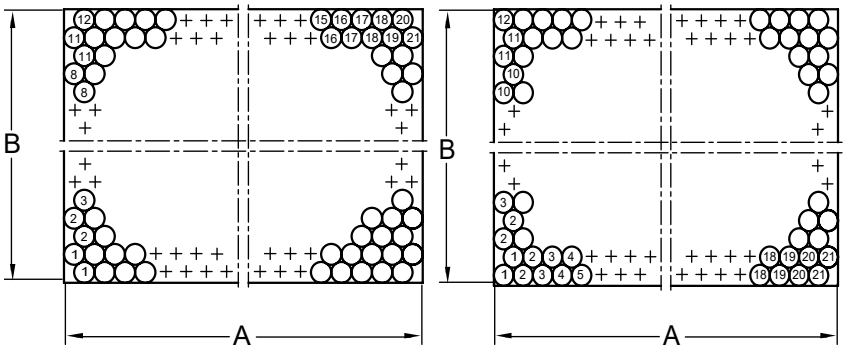
Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	300 ml FIT	1.2.28
	Revision: 5	Approved by:	

CAN - PALLETIZATION

1.2.29 330 ML FIT - GERMAN PLASTIC PALLET







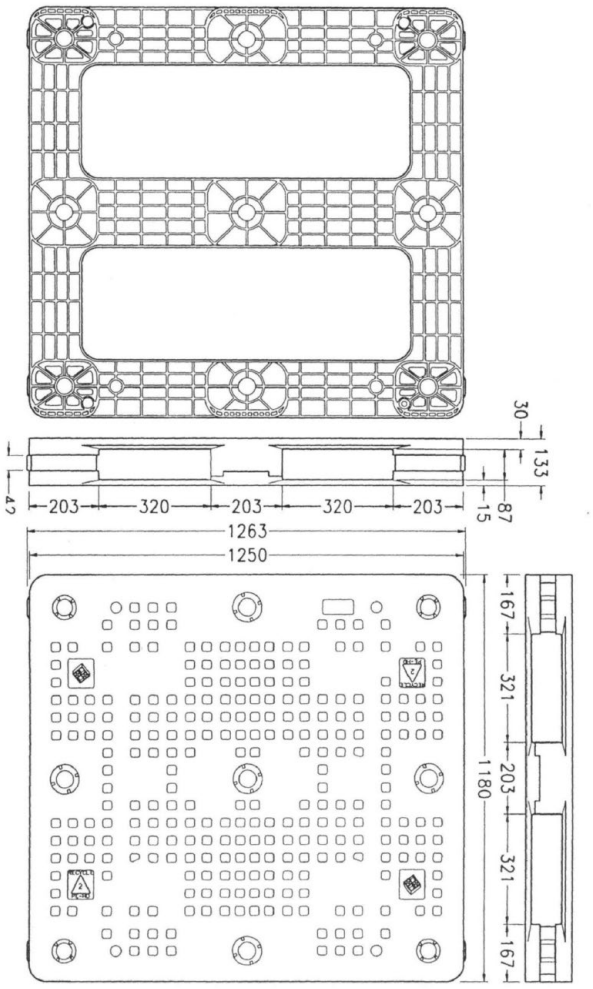
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

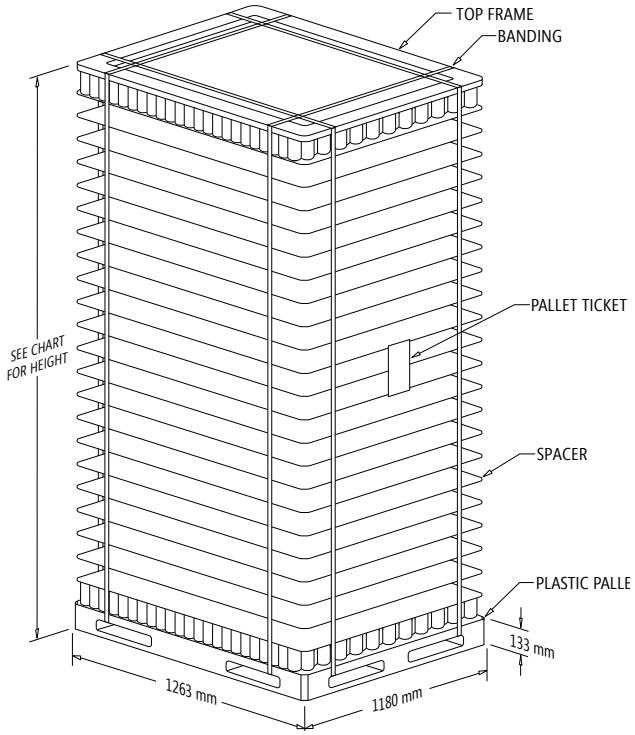
M - Steel frame		German pallet											
		1250 x 1180 x 133											
	Pallete type	Plastic											
	Frame dimensions	1265x1195											
	Frame type	M		M		M		M		M		M	
330 ml	Cans per layer	471	483	471	483	471	483	471	483	471	483	471	483
	Number of layers	14		15		16		17		18		196594	
	Cans per pallet	6594	6762	7065	7245	7536	7728	8007	8211	8478	8694	8949	9177
	Pallet height incl. pallet	2212		2359		2505		2651		2798		2944	

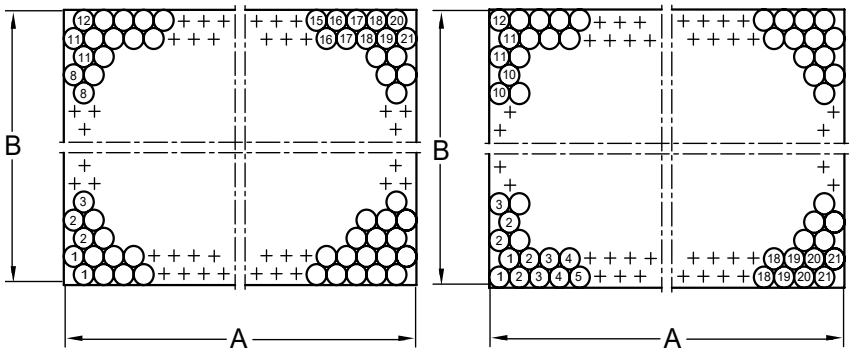
Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	330 ml FIT	1.2.29
	Revision: 5	Approved by:	

CANPACK

1.2.30 355 ML FIT - GERMAN PLASTIC PALLET







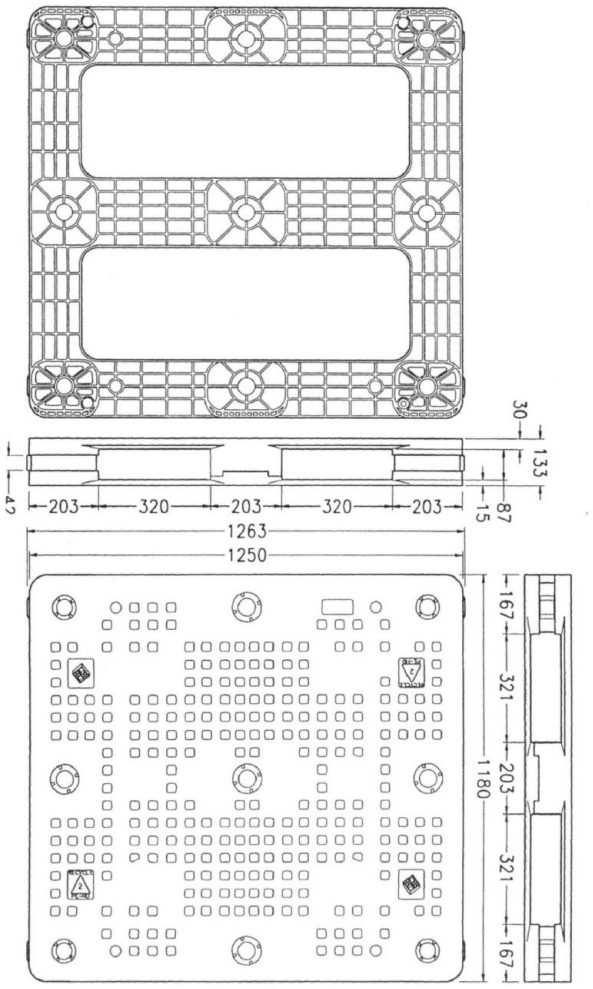
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

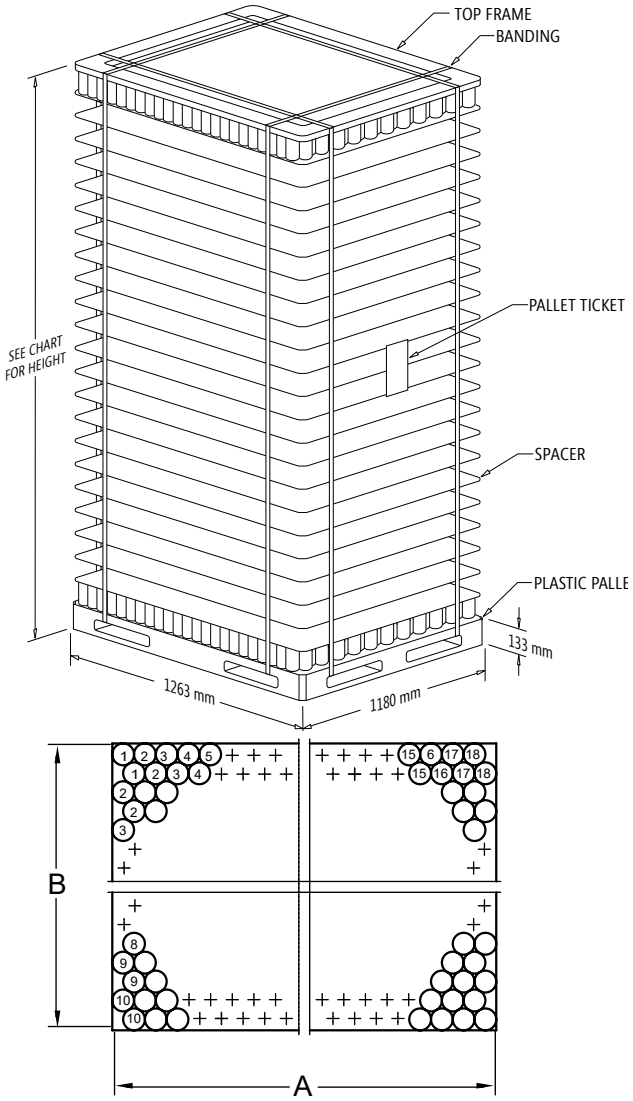
M - Steel frame		German pallet											
		1250 x 1180 x 133											
	Pallete type	Plastic											
	Frame dimensions	1265x1195											
	Frame type	M		M		M		M		M		M	
355 ml	Cans per layer	471	483	471	483	471	483	471	483	471	483	471	483
	Number of layers	13		14		15		16		17		18	
	Cans per pallet	6123	6279	6594	6762	7065	7245	7536	7728	8007	8210	8478	8694
	Pallet height incl. pallet	2211		2369		2527		2884		2842		2999	

Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	355 ml FIT	1.2.30
	Revision: 5	Approved by:	

CAN - PALLETIZATION

1.2.31 330 ML STD - GERMAN PLASTIC PALLET



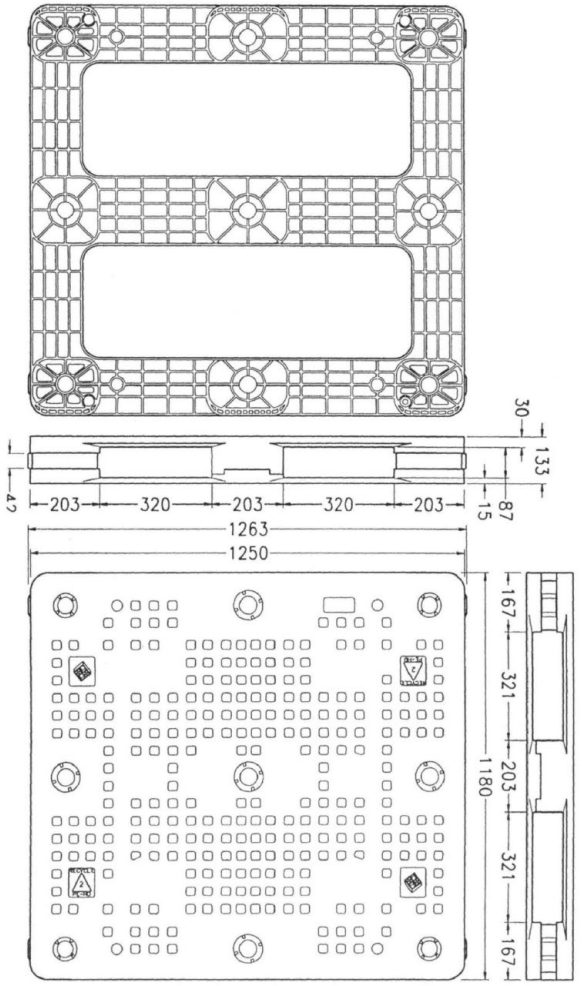


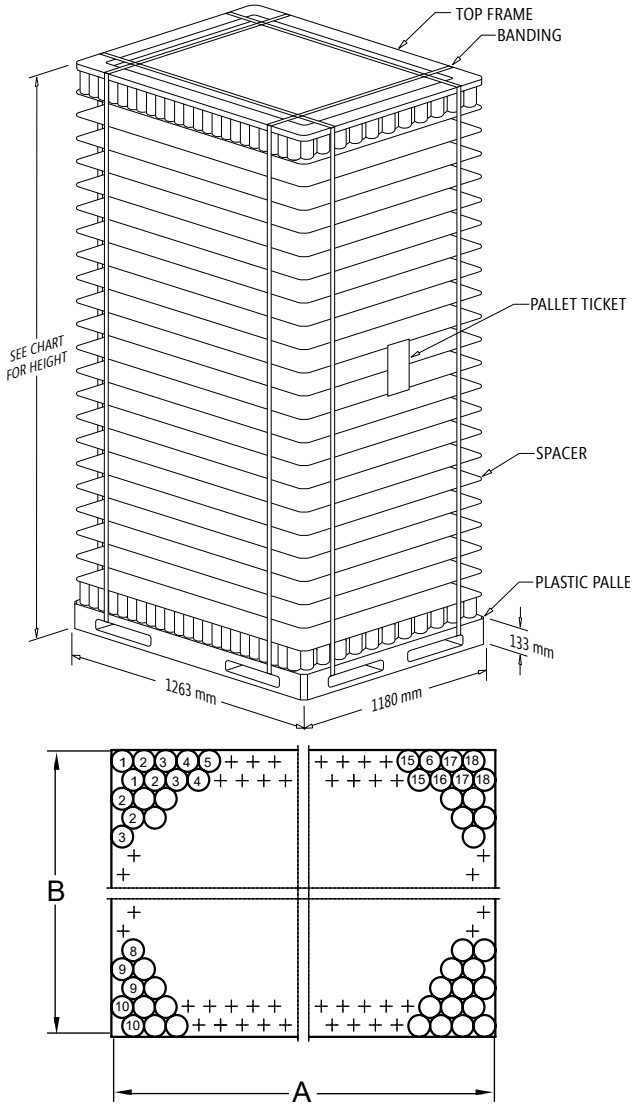
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

M - Steel frame		German pallet					
		1250 x 1180 x 133					
	Pallete type	Plastic					
	Frame dimensions	1265x1195					
	Frame type	M	M	M	M	M	M
330 ml	Cans per layer	360	360	360	360	360	360
	Number of layers	18	19	20	21	22	23
	Cans per pallet	6480	6840	7200	7560	7920	8280
	Pallet height incl. pallet	2254	2370	2487	2603	2719	2835

Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	330 ml STD	1.2.31
	Revision: 5	Approved by:	

1.2.32 355 ML STD - GERMAN PLASTIC PALLET





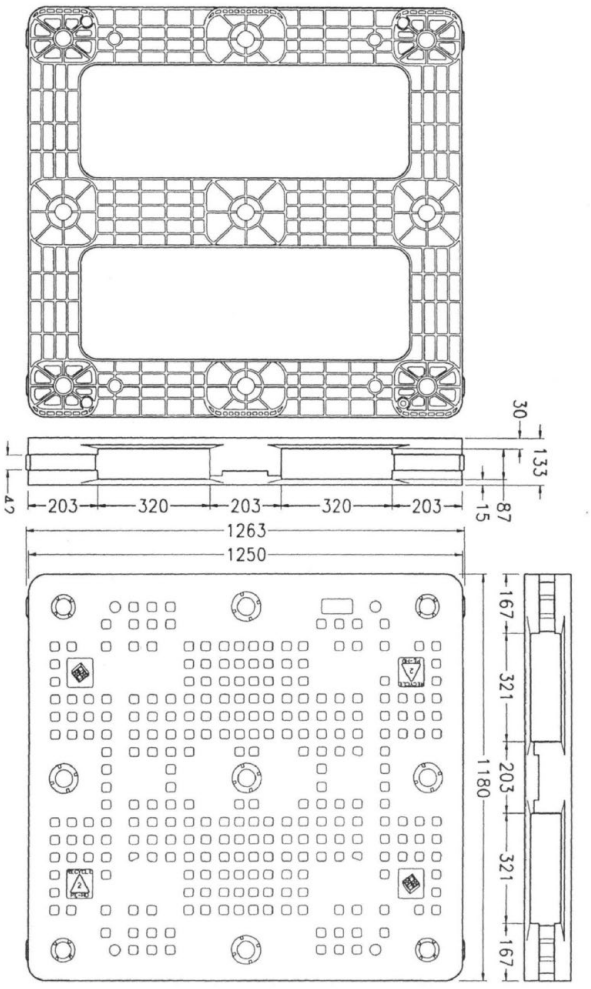
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

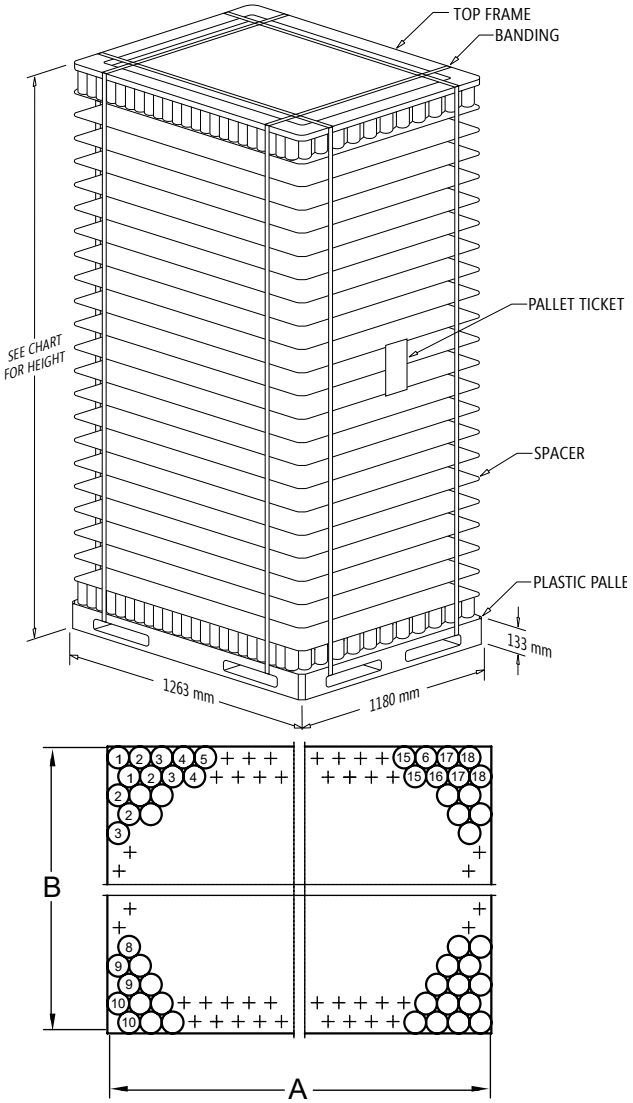
M - Steel frame		German pallet					
		1250 x 1180 x 133					
	Pallete type	Plastic					
	Frame dimensions	1265x1195					
	Frame type	M	M	M	M	M	M
355 ml	Cans per layer	360	360	360	360	360	360
	Number of layers	18	19	20	21	22	23
	Cans per pallet	6480	6840	7200	7560	7920	8280
	Pallet height incl. pallet	2380	2503	2627	2750	2873	2996

Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	355 ml STD	1.2.32
	Revision: 5	Approved by:	

CAN - PALLETIZATION

1.2.33 440 ML STD - GERMAN PLASTIC PALLET





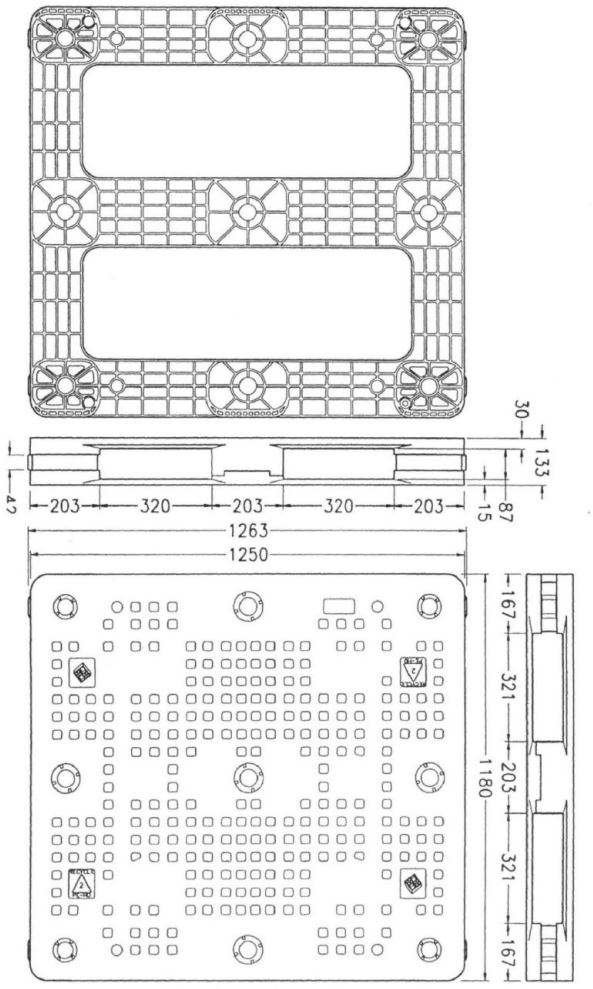
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

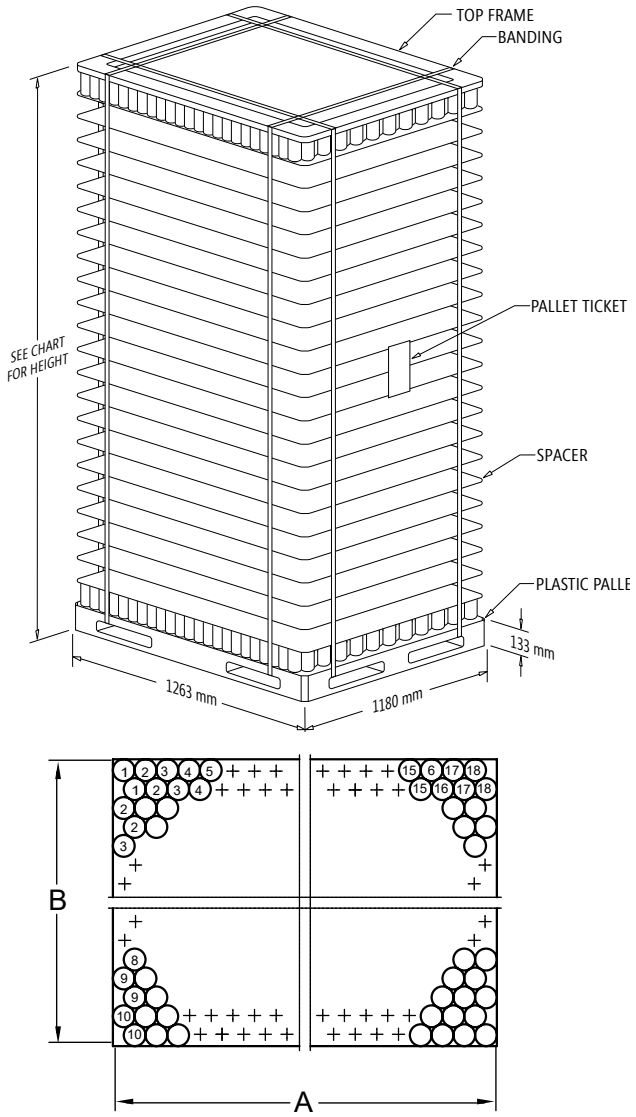
M - Steel frame		German pallet					
		1250 x 1180 x 133					
	Pallete type	Plastic					
	Frame dimensions	1265x1195					
	Frame type	M	M	M	M	M	M
440 ml	Cans per layer	360	360	360	360	360	360
	Number of layers	13	14	15	16	17	18
	Cans per pallet	4680	5040	5400	5760	6120	6480
	Pallet height incl. pallet	2124	2275	2426	2577	2728	2879

Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	440 ml STD	1.2.33
	Revision: 5	Approved by:	

CAN - PALLETIZATION

1.2.34 500 ML STD - GERMAN PLASTIC PALLET





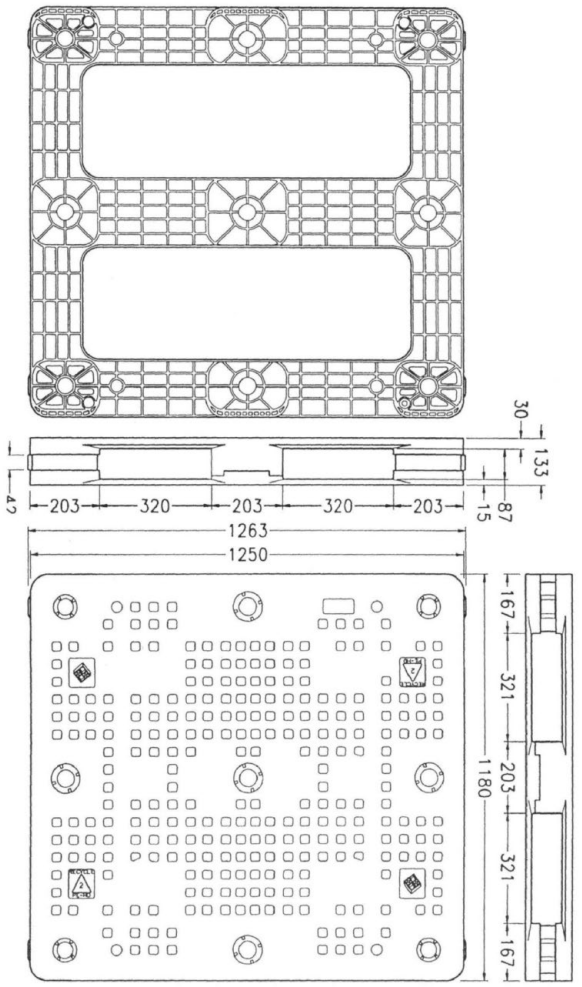
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

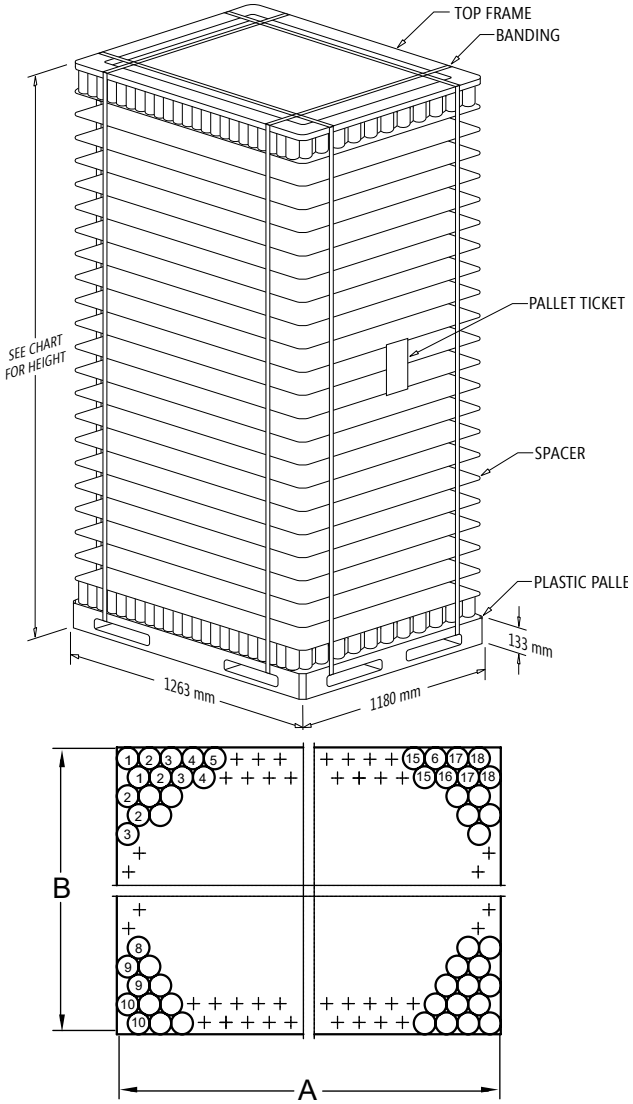
M - Steel frame		German pallet					
		1250 x 1180 x 133					
	Pallete type	Plastic					
	Frame dimensions	1265x1195					
	Frame type	M	M	M	M	M	M
500 ml	Cans per layer	360	360	360	360	360	360
	Number of layers	11	12	13	14	15	16
	Cans per pallet	3960	4320	4680	5040	5400	5760
	Pallet height incl. pallet	2022	2191	2360	2529	2698	2867

Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	500 ml STD	1.2.34
	Revision: 5	Approved by:	

CAN - PALLETIZATION

1.2.35 550 ML STD - GERMAN PLASTIC PALLET





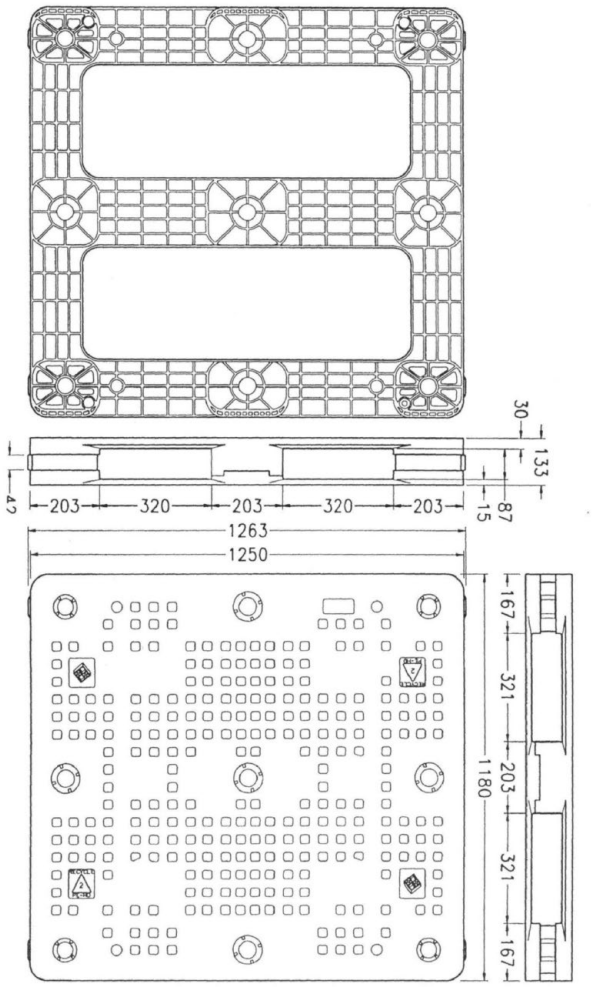
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

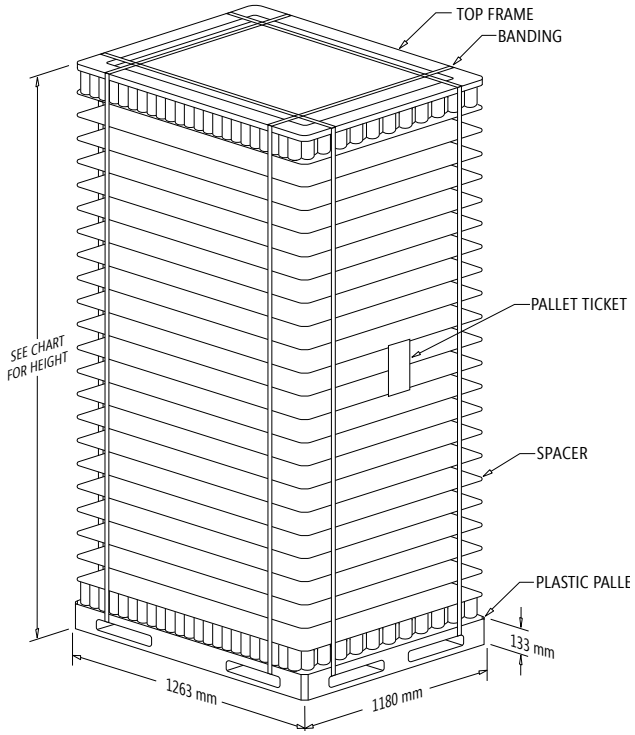
M - Steel frame		German pallet					
		1250 x 1180 x 133					
	Pallete type	Plastic					
	Frame dimensions	1265x1195					
	Frame type	M	M	M	M	M	M
550 ml	Cans per layer	360	360	360	360	360	360
	Number of layers	10	11	12	13	14	15
	Cans per pallet	3600	3960	4320	4680	5040	5400
	Pallet height incl. pallet	1999	2183	2366	2550	2734	2917

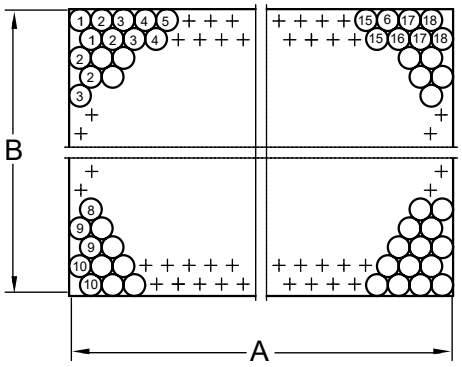
Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	550 ml STD	1.2.35
	Revision: 5	Approved by:	

CAN - PALLETIZATION

1.2.36 568 ML STD - GERMAN PLASTIC PALLET







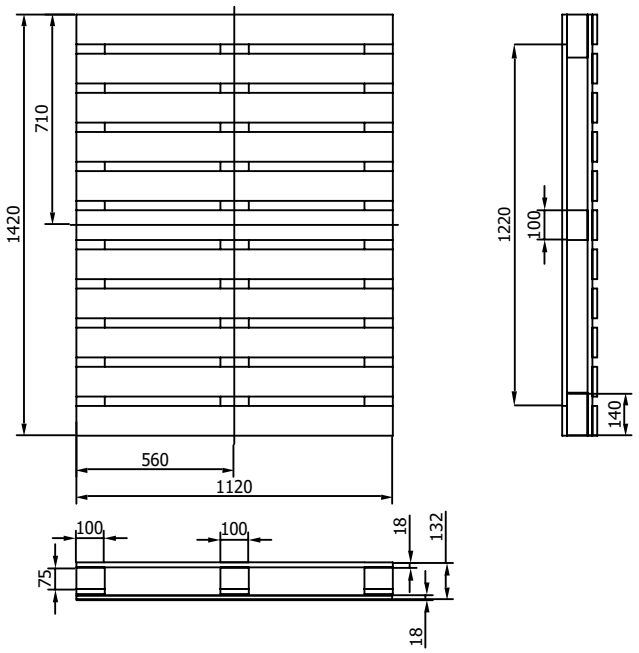
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

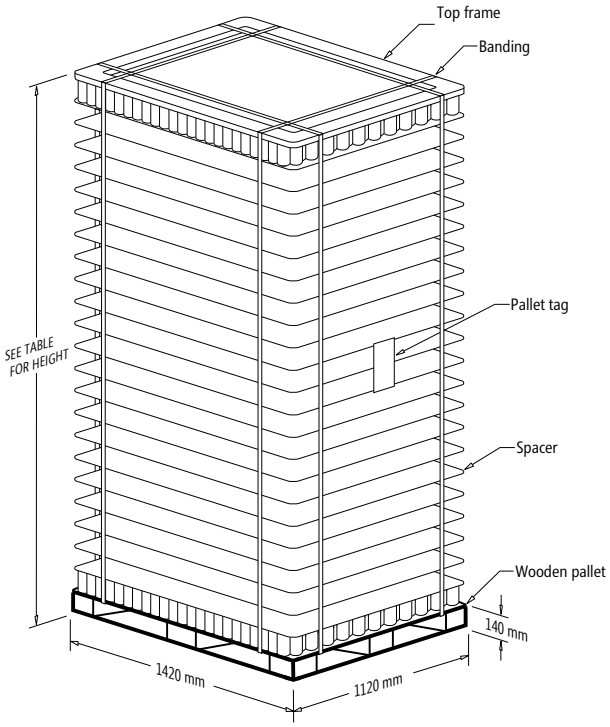
M - Steel frame		German pallet					
		1250 x 1180 x 133					
	Pallete type	Plastic					
	Frame dimensions	1265x1195					
	Frame type	M	M	M	M	M	M
568 ml	Cans per layer	360	360	360	360	360	360
	Number of layers	10	11	12	13	14	15
	Cans per pallet	3600	3960	4320	4680	5040	5400
	Pallet height incl. pallet	2053	2242	2432	2621	2810	2999

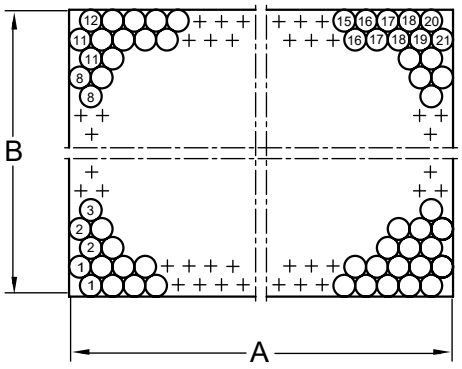
Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	568 ml STD	1.2.36
	Revision: 5	Approved by:	

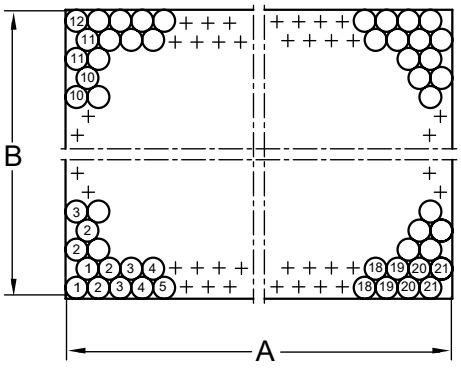
CAN - PALLETIZATION

1.2.37 150 ML SLIM - SPANISH PALLET









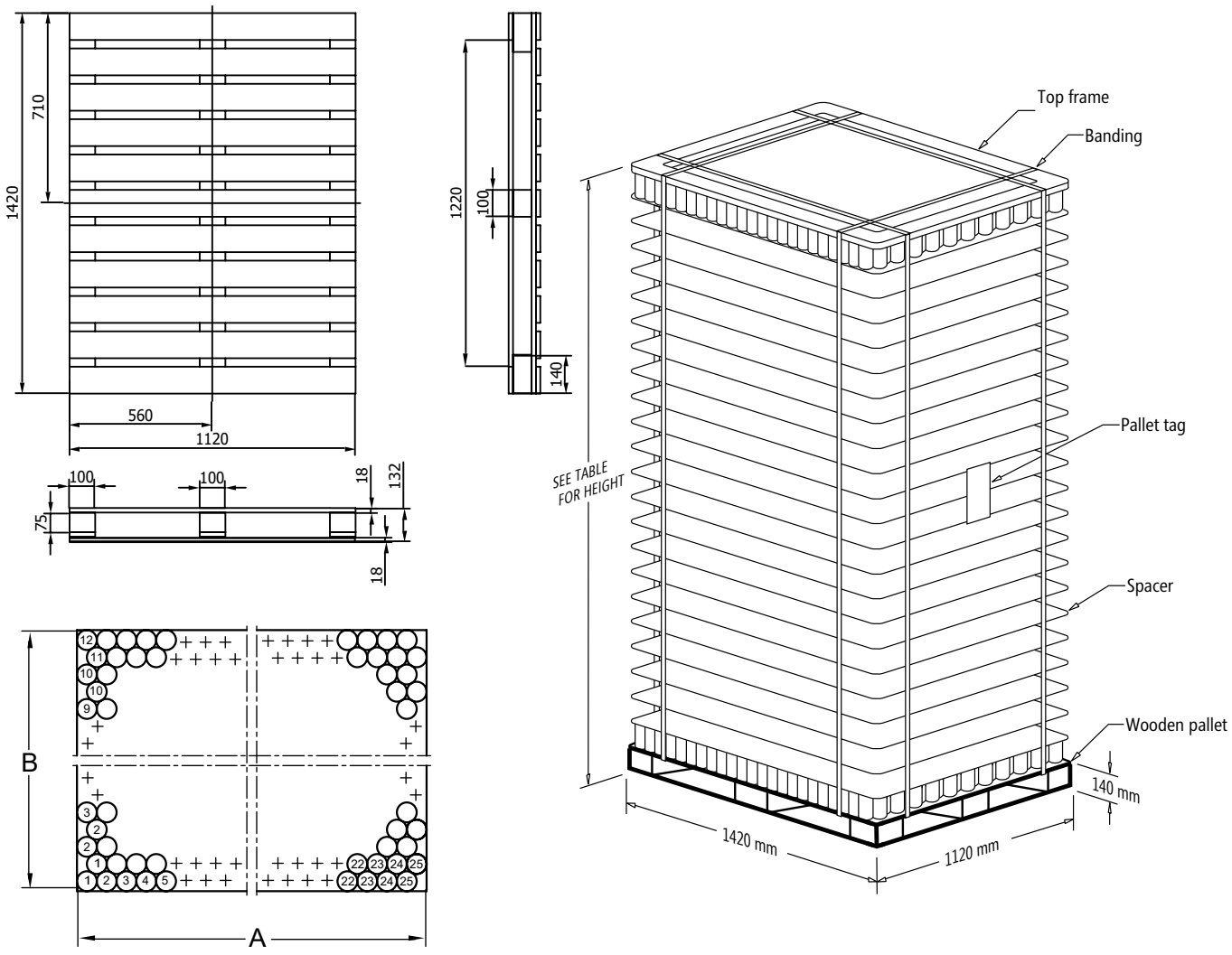
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

M - Steel frame		Spanish pallet					
		1420 x 1120 x 132					
	Pallete type	Wood					
	Frame dimensions	1420x1120					
	Frame type	M	M	M	M	M	M
150 ml	Cans per layer	575	575	575	575	575	575
	Number of layers	26	27	28	29	30	31
	Cans per pallet	14950	15525	16100	16675	17250	17825
	Pallet height incl. pallet	2483	2573	2662	2751	2841	2930

Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	150 ml Slim	1.2.37
	Revision: 5	Approved by:	

CAN - PALLETIZATION

1.2.38 185 ML SLIM - SPANISH PALLET



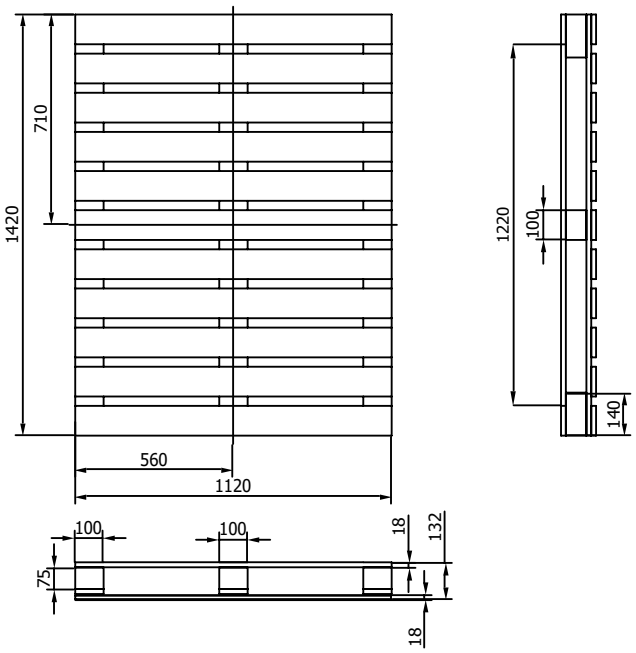
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

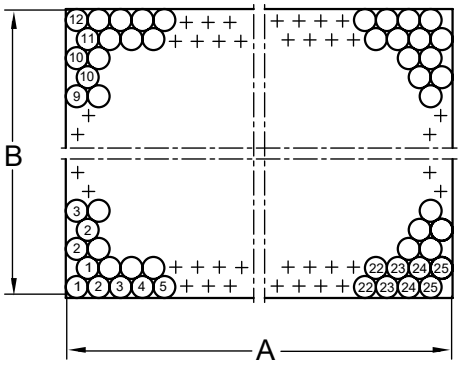
M - Steel frame		Spanish pallet					
		1420 x 1120 x 132					
	Pallete type	Wood					
	Frame dimensions	1420x1120					
	Frame type	M	M	M	M	M	M
185 ml	Cans per layer	575	575	575	575	575	575
	Number of layers	20	21	22	23	24	25
	Cans per pallet	11500	12075	12650	13225	13800	14375
	Pallet height incl. pallet	2249	2353	2458	2562	2667	2771

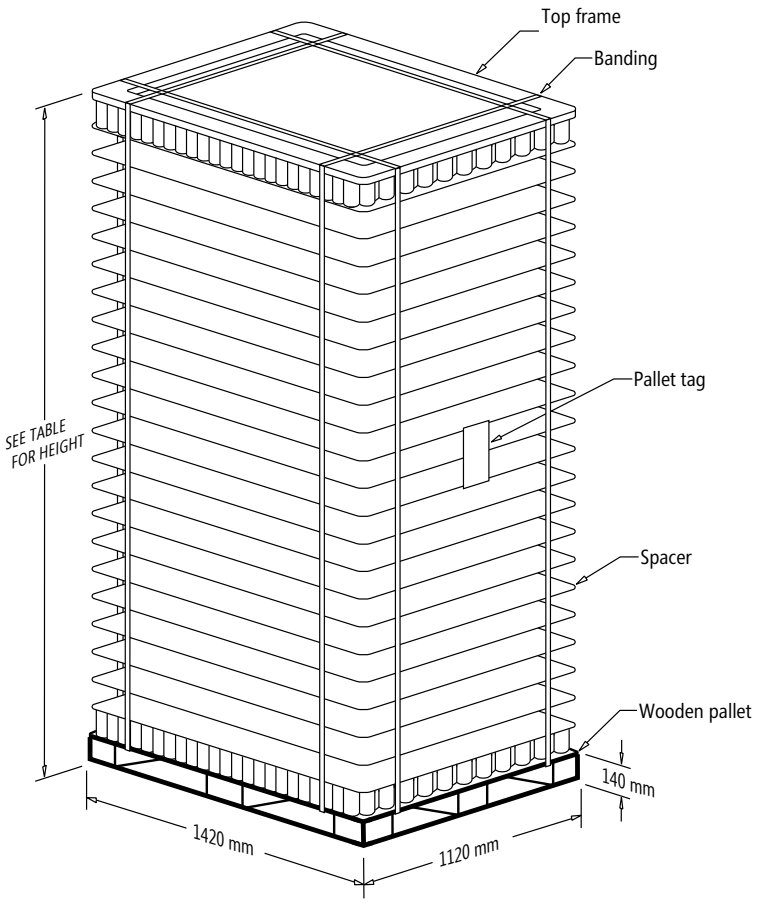
Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	185 ml Slim	1.2.38
	Revision: 5	Approved by:	

CAN - PALLETIZATION

1.2.39 200 ML SLIM - SPANISH PALLET







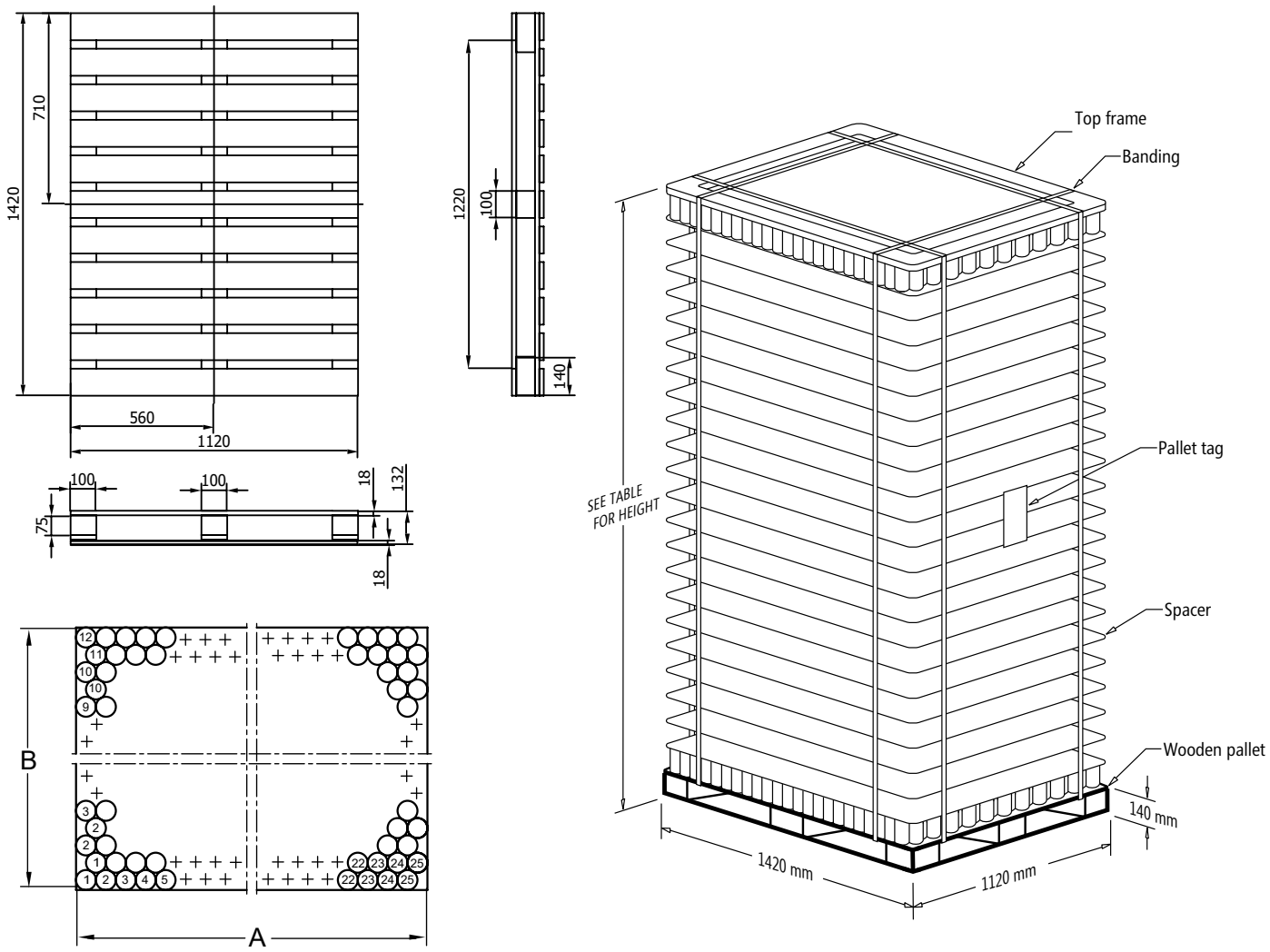
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

M - Steel frame		Spanish pallet					
		1420 x 1120 x 132					
	Pallete type	Wood					
	Frame dimensions	1420x1120					
	Frame type	M	M	M	M	M	M
200 ml	Cans per layer	575	575	575	575	575	575
	Number of layers	20	21	22	23	24	25
	Cans per pallet	11500	12075	12650	13225	13800	14375
	Pallet height incl. pallet	2406	2518	2630	2742	2854	2967

Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	200 ml Slim	1.2.39
	Revision: 5	Approved by:	

CAN - PALLETIZATION

1.2.40 240 ML SLIM - SPANISH PALLET



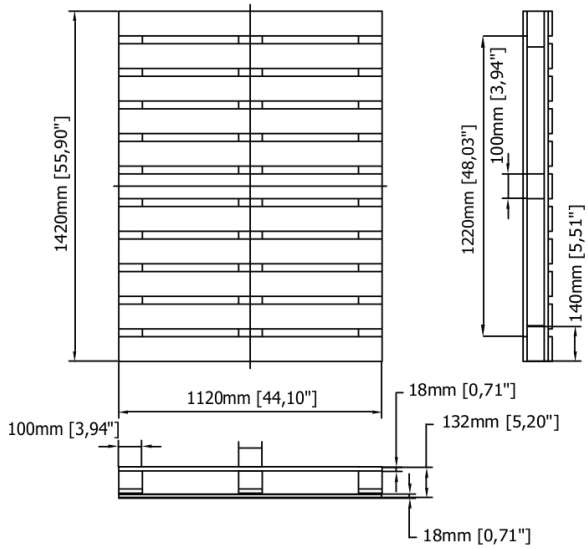
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

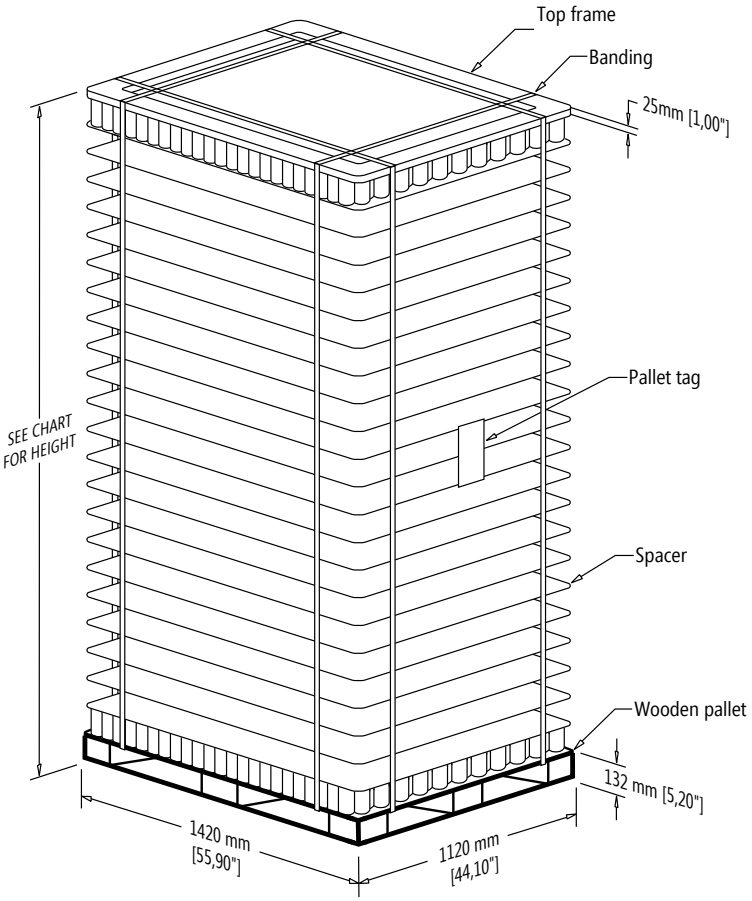
M - Steel frame		Spanish pallet					
		1420 x 1120 x 132					
	Pallete type	Wood					
	Frame dimensions	1420x1120					
	Frame type	M	M	M	M	M	M
240 ml	Cans per layer	575	575	575	575	575	575
	Number of layers	15	16	17	18	19	20
	Cans per pallet	8625	9200	9775	10350	10925	11500
	Pallet height incl. pallet	2127	2258	2389	2520	2651	2782

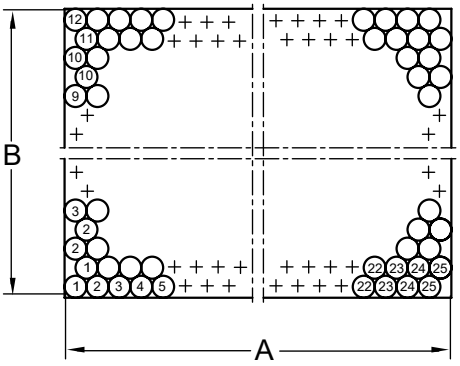
Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	240 ml Slim	1.2.40
	Revision: 5	Approved by:	

CAN - PALLETIZATION

1.2.41 250 ML / 8,5 OZ SLIM - SPANISH PALLET







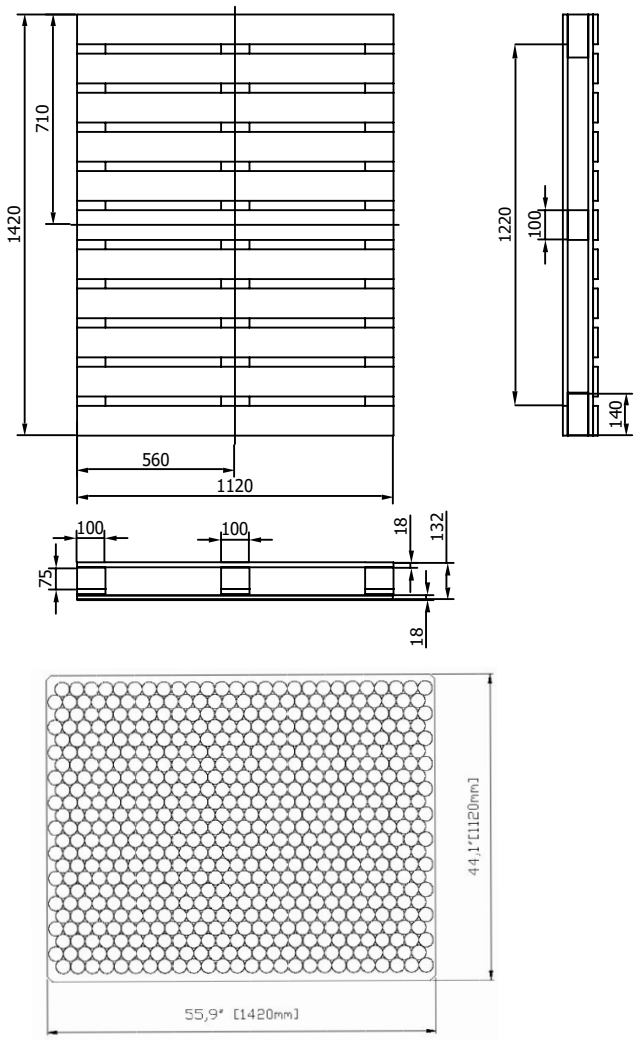
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

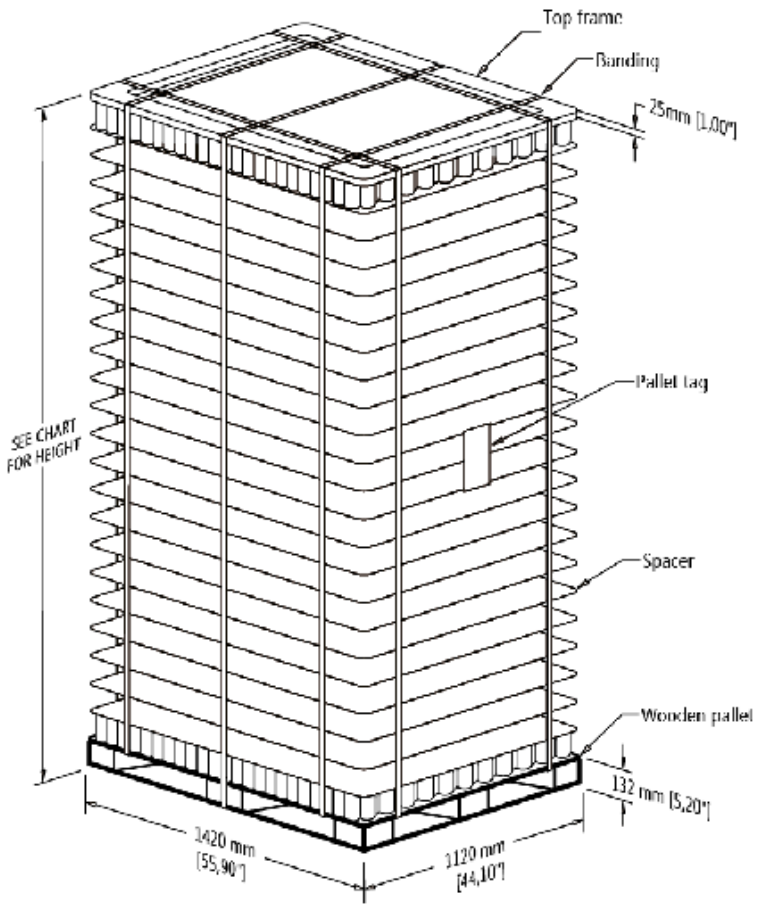
M - Steel Frame P - Plastic Frame W - Wooden Frame		Spanish pallet							
		1420mm [55,90"] x 1120mm [44,10"] x 132mm [5,20"]							
	Pallete type	Wood							
	Frame dimensions	1420mm [55,90"] x 1120mm [44,10"]							
	Frame type	M/P/W		M/P/W		M/P/W		M/P/W	
250 ml 8,5 oz	Cans per layer	575		575		575		575	
	Number of layers	17		18		19		20	
	Cans per pallet	9775		10350		10925		11500	
	Pallet height incl. pallet	2457 mm	96,73"	2592 mm	102,05"	2727 mm	107,36"	2862 mm	112,68"

Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	250 ml Slim 8,5 oz	1.2.41
	Revision: 5	Approved by:	

CANPACK

1.2.42 250 ML SLIM / 8,5 OZ SLIM - SPANISH PALLET / 2ND LAYOUT ARRANGEMENT





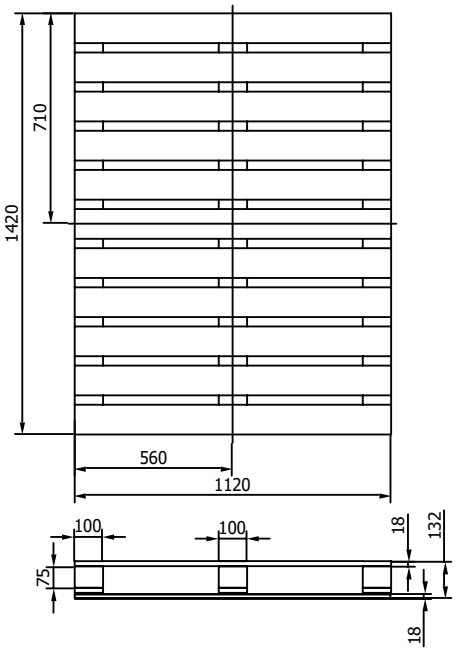
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

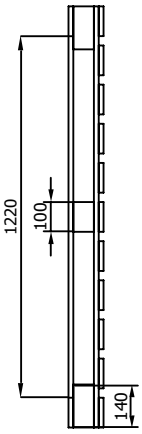
M - Steel Frame P - Plastic Frame W - Wooden Frame		Spanish pallet		
		1420mm [55,90"] x 1120mm [44,10"] x 132mm [5,20"]		
	Pallete type	Wood		
	Frame dimensions	1420mm [55,90"] x 1120mm [44,10"]		
	Frame type	M/P/W		
250 ml	Cans per layer	598		
	Number of layers	17		
	Cans per pallet	10166		
	Pallet height incl. pallet	2457mm		

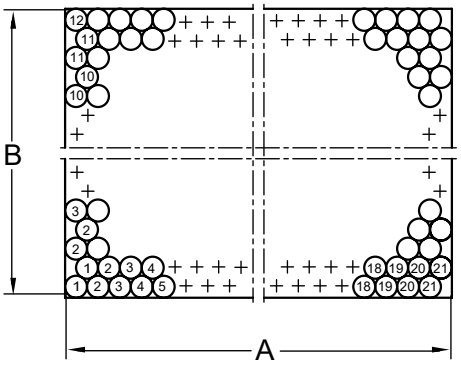
Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	17.08.2023	250 ml Slim	1.2.42
	Revision: 1	Approved by:	

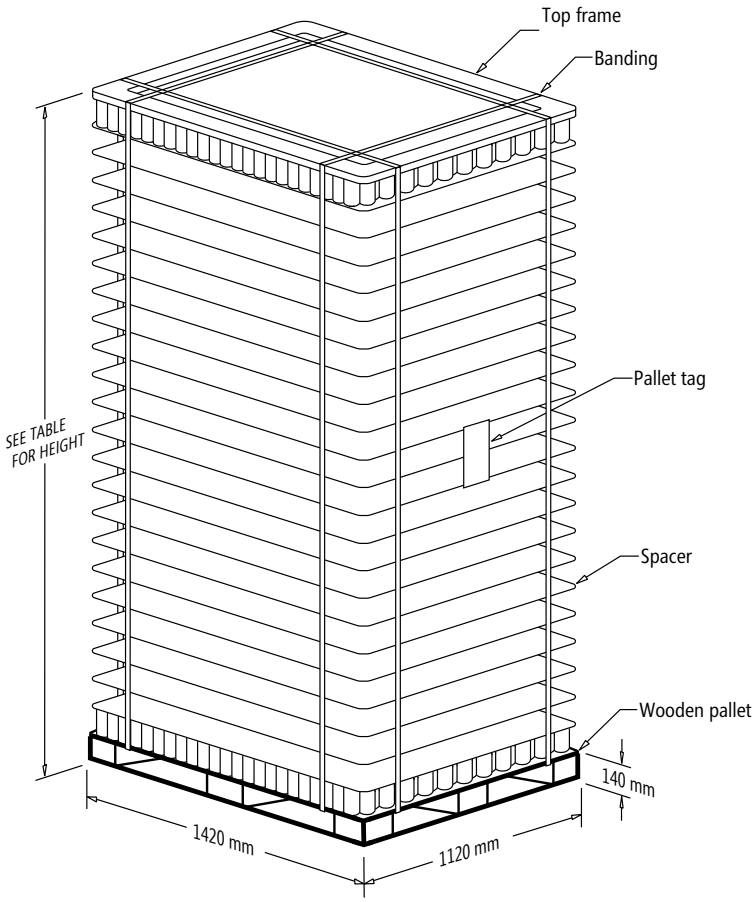
CAN - PALLETIZATION

1.2.43 200 ML FIT - SPANISH PALLET









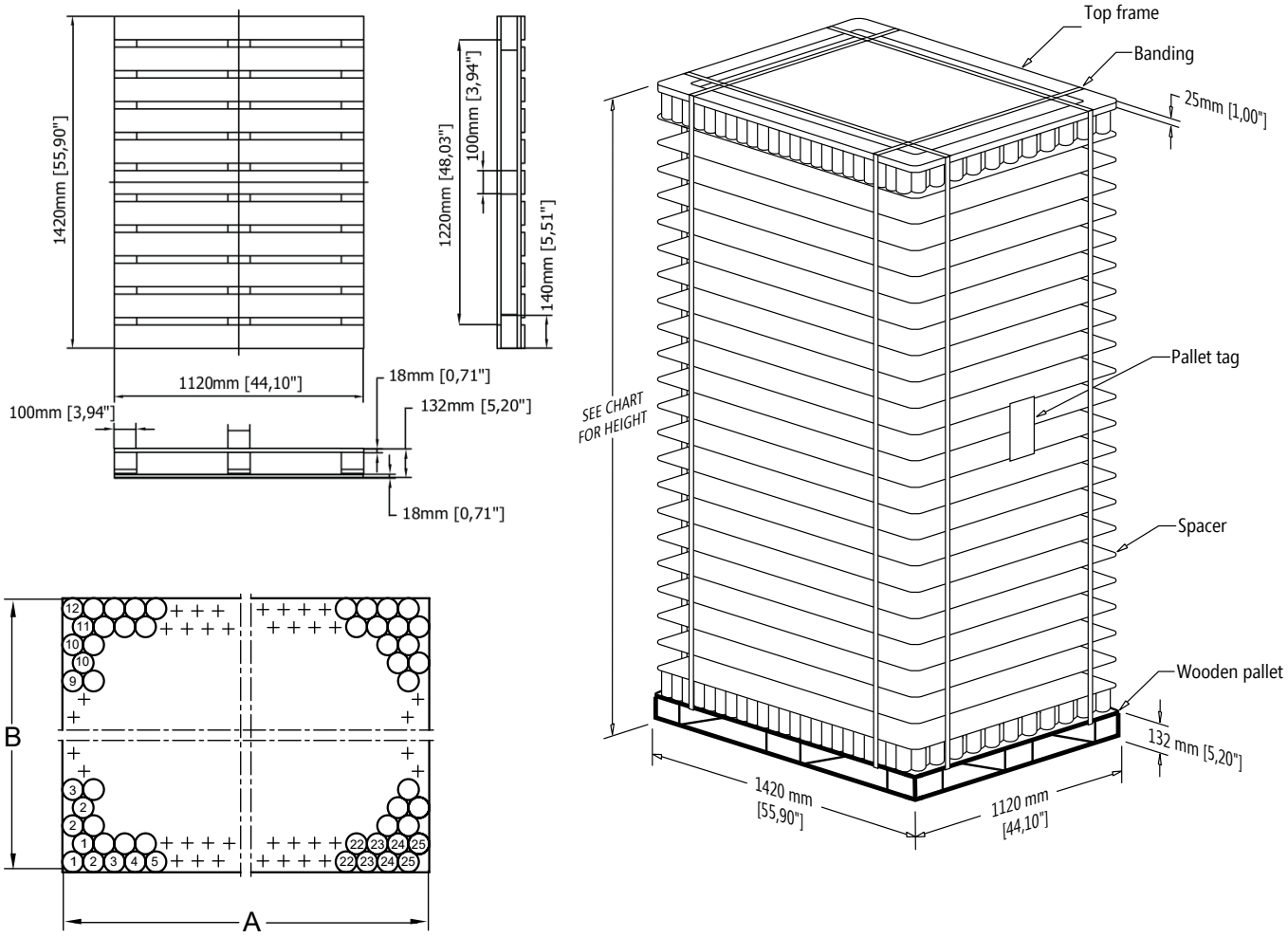
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

M - Steel frame		Spanish pallet					
		1420 x 1120 x 132					
	Pallete type	Wood					
	Frame dimensions	1420x1120					
	Frame type	W	W	W	W	W	W
200 ml	Cans per layer	483	483	483	483	483	483
	Number of layers	24	25	26	27	28	29
	Cans per pallet	11592	12075	12558	13041	13524	14007
	Pallet height incl. pallet	2448	2543	2638	2733	2828	2923

Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	200 ml FIT	1.2.43
	Revision: 5	Approved by:	

CAN - PALLETIZATION / BRAZIL

1.2.44 269 ML / 9,1 OZ FIT - SPANISH PALLET



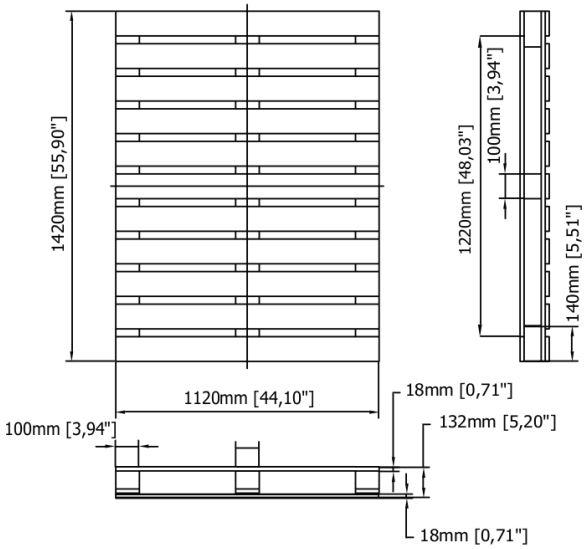
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

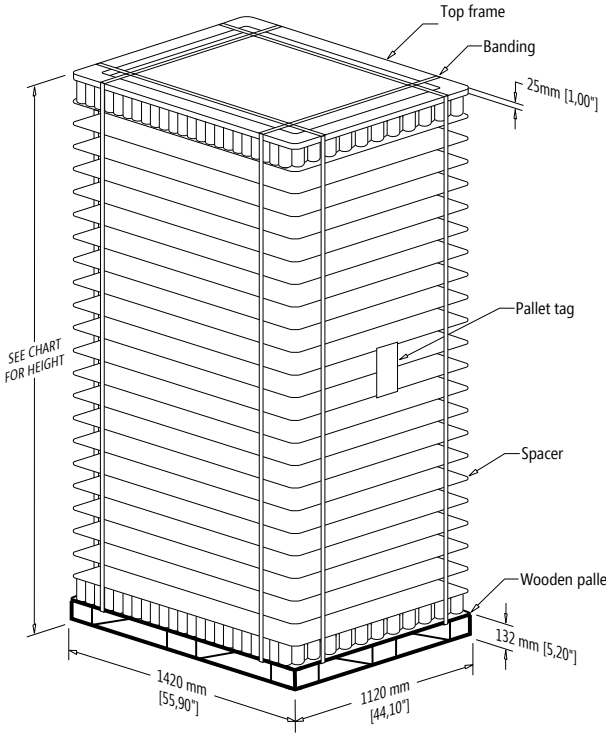
M - Steel Frame P - Plastic Frame W - Wooden Frame		Spanish pallet							
		1420mm [55,90"] x 1120mm [44,10"] x 132mm [5,20"]							
	Pallete type	Wood							
	Frame dimensions	1420mm [55,90"] x 1120mm [44,10"]							
	Frame type	M/P/W		M/P/W		M/P/W		M/P/W	
269 ml 9,1 oz	Cans per layer	528		528		528		528	
	Number of layers	19		20		21		22	
	Cans per pallet	10032		10560		11088		11616	
	Pallet height incl. pallet	2450 mm	96,46"	2600 mm	102,36"	2750 mm	108,27"	2900 mm	114,17"'

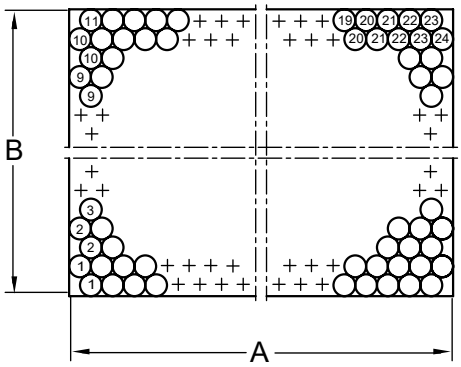
Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	269 ml FIT 9,1 oz	1.2.44
	Revision: 5	Approved by:	

CAN - PALLETIZATION

1.2.45 269 ML / 9,1 OZ FIT - SPANISH PALLET / 2ND LAYOUT ARRANGEMENT (330 FIT PATTERN)





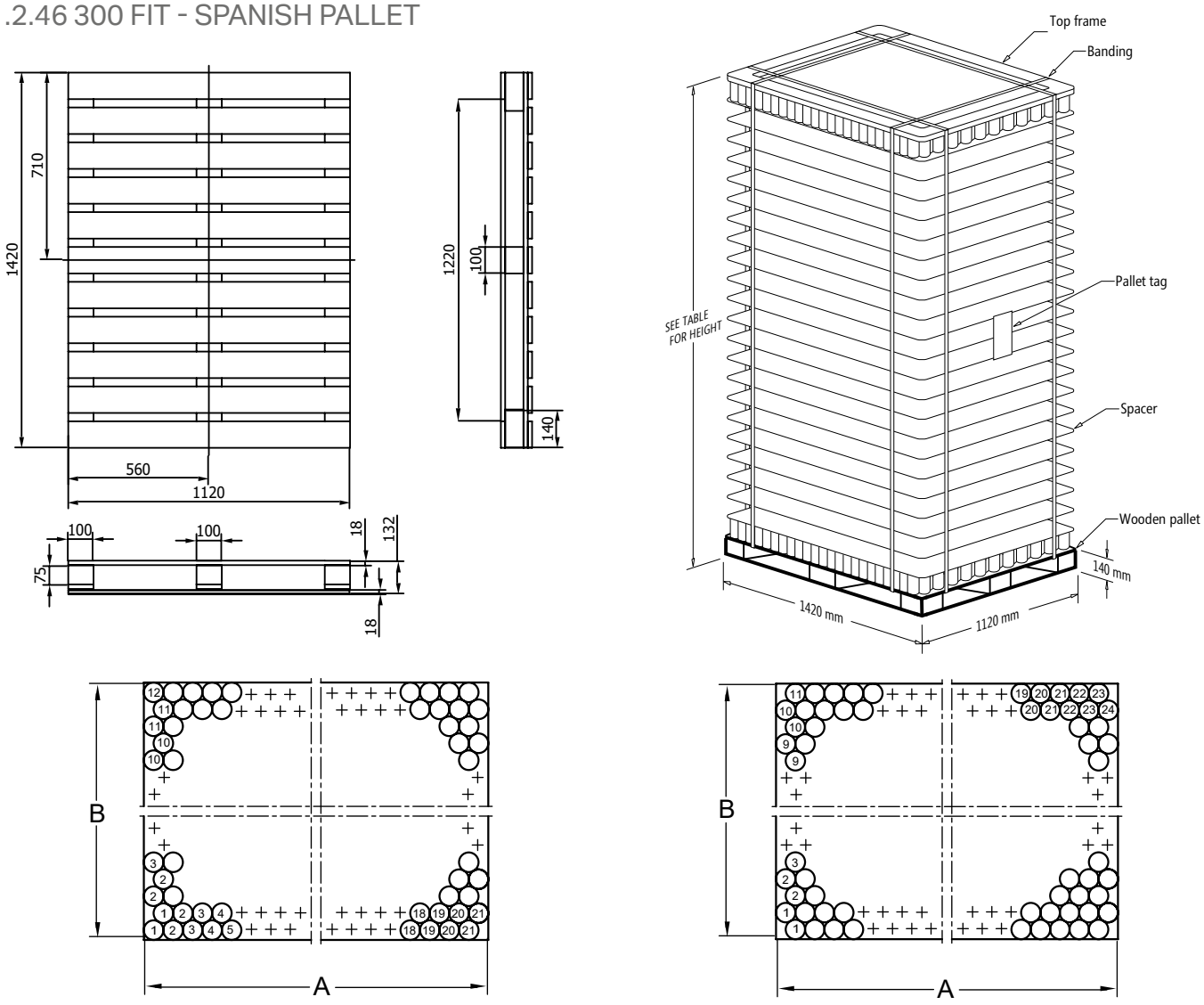


NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

M - Steel Frame P - Plastic Frame W - Wooden Frame		Spanish pallet				
		1420mm [55,90'] x 1120mm [44,10'] x 132mm [5,20']				
	Pallete type	Wood				
	Frame dimensions	1420mm [55,90"] x 1120mm [44,10"]				
	Frame type	M/P/W	M/P/W	M/P/W	M/P/W	M/P/W
269 ml 9,1 oz	Cans per layer	493	493	493	493	493
	Number of layers	18	19	20	21	22
	Cans per pallet	8874	9367	9860	10353	10846
	Pallet height incl. pallet	2300mm	2450mm	2600mm	2750mm	2900mm

Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	20.09.2023	269 ml FIT 9,1 oz (330 FIT Pattern)	1.2.45
	Revision: 1	Approved by:	

1.2.46 300 FIT - SPANISH PALLET



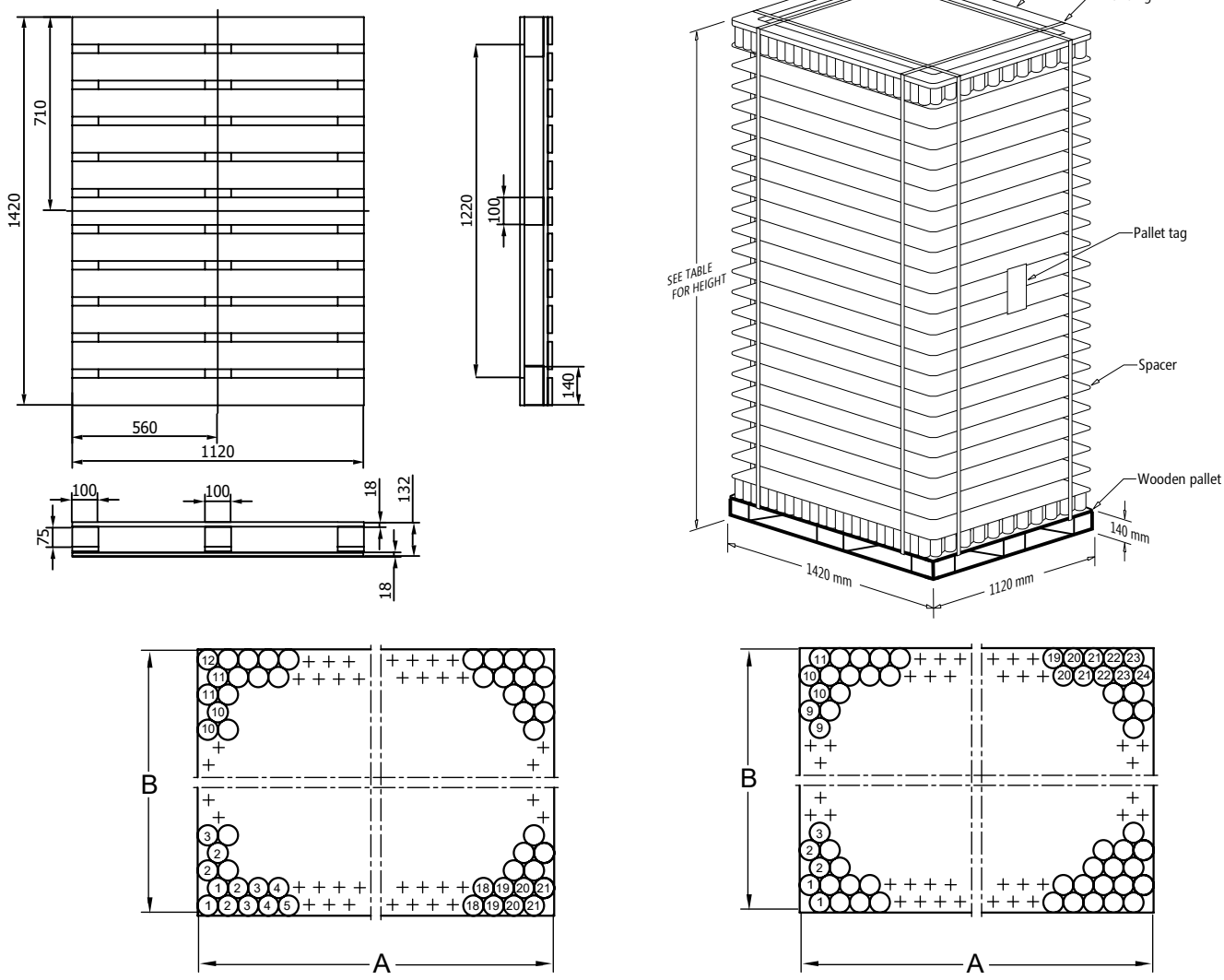
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

M - Steel frame		Spanish pallet											
		1420 x 1120 x 132											
	Pallete type	Wood											
	Frame dimensions	1420x1120											
	Frame type	W		W		W		W		W		W	
300 ml	Cans per layer	483	493	483	493	483	493	483	493	483	493	483	493
	Number of layers	15		16		17		18		19		20	
	Cans per pallet	7245	7395	7728	7888	8211	8381	8694	8874	9177	9367	9660	9860
	Pallet height incl. pallet	2185		2320		2455		2590		2725		2860	

Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	300 FIT	1.2.46
	Revision: 5	Approved by:	

CAN - PALLETIZATION

1.2.47 330 FIT - SPANISH PALLET



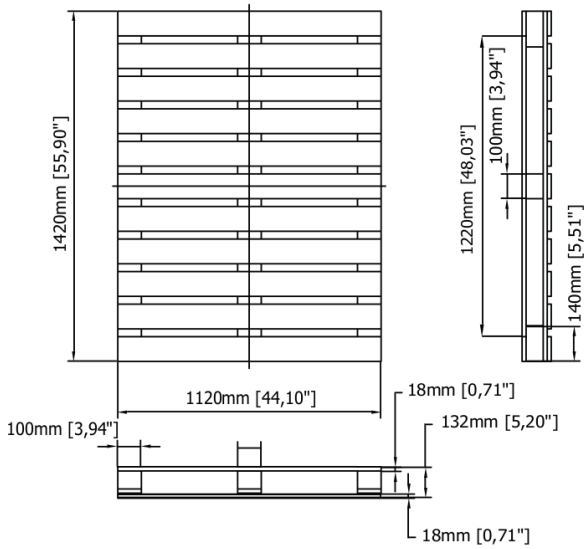
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

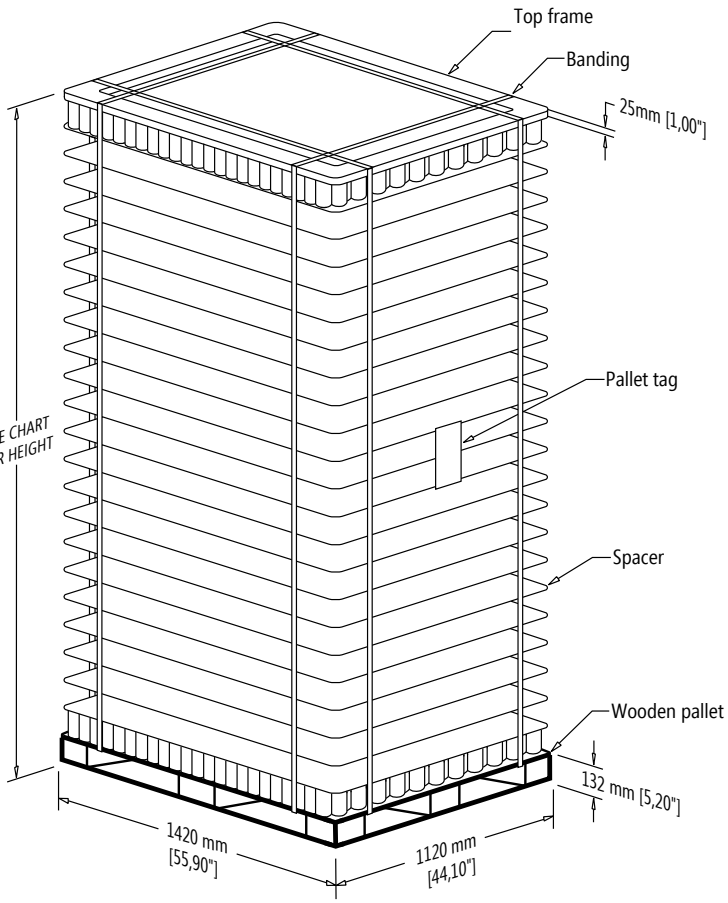
M - Steel frame		Spanish pallet											
		1420 x 1120 x 132											
	Pallete type	Wood											
	Frame dimensions	1420x1120											
	Frame type	W		W		W		W		W		W	
330 ml	Cans per layer	483	493	483	493	483	493	483	493	483	493	483	493
	Number of layers	14		15		16		17		18		19	
	Cans per pallet	6762	6902	7245	7395	7728	7888	8211	8381	8694	8874	9177	9367
	Pallet height incl. pallet	2211		2358		2504		2650		2797		2943	

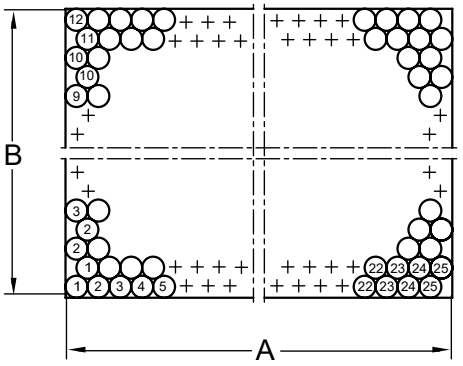
Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	330 FIT	1.2.47
	Revision: 5	Approved by:	

CAN - PALLETIZATION

1.2.48 355 ML / 12 OZ FIT - SPANISH PALLET







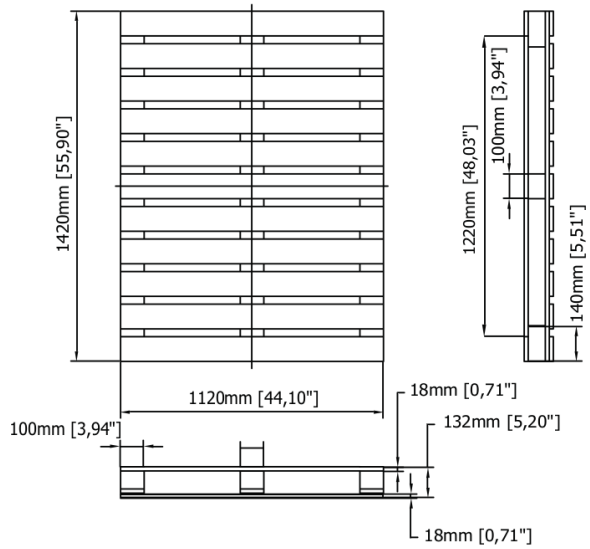
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

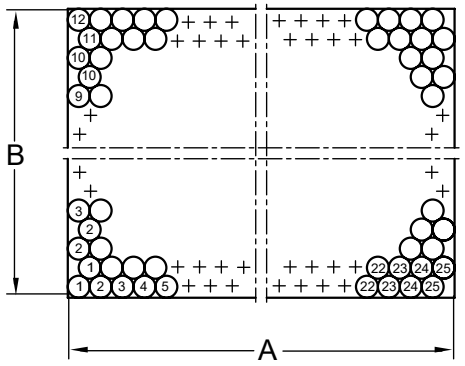
M - Steel Frame P - Plastic Frame W - Wooden Frame		Spanish pallet							
		1420mm [55,90"] x 1120mm [44,10"] x 132mm [5,20"]							
	Pallete type	Wood							
	Frame dimensions	1420mm [55,90"] x 1120mm [44,10"]							
	Frame type	M/P/W		M/P/W		M/P/W		M/P/W	
355 ml 12 oz	Cans per layer	483		483		483		483	
	Number of layers	15		16		17		18	
	Cans per pallet	7245		7728		8211		8694	
	Pallet height incl. pallet	2526 mm	99,45"	2683	105,63"	2841	111,85"	2998	118,03"

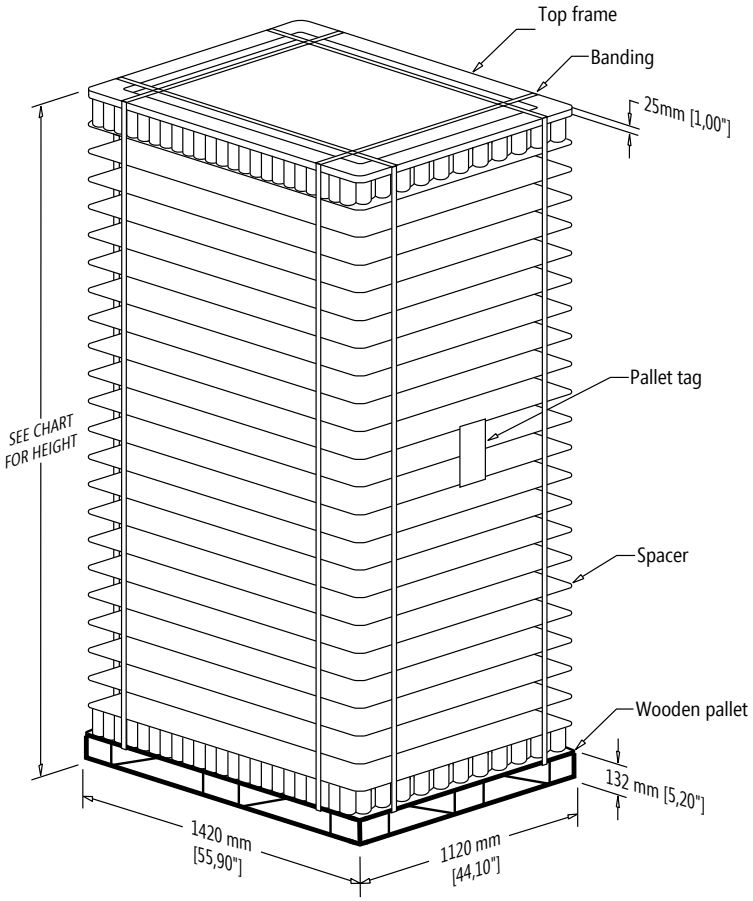
Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	355 FIT 12 oz	1.2.48
	Revision: 5	Approved by:	

CAN - PALLETIZATION

1.2.49 355 ML / 12 OZ FIT - SPANISH PALLET







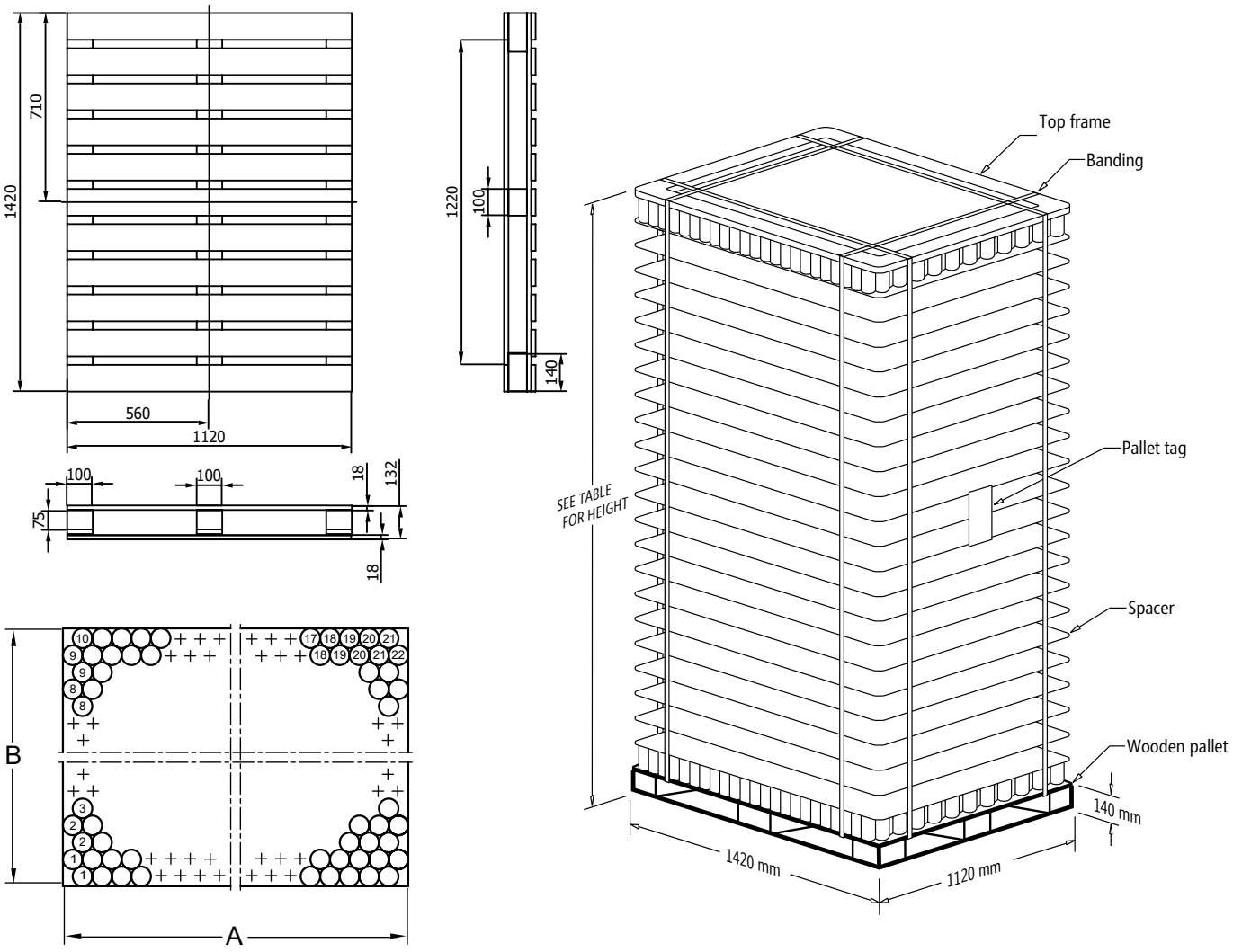
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

M - Steel Frame P - Plastic Frame W - Wooden Frame		Spanish pallet							
		1420mm [55,90"] x 1120mm [44,10"] x 132mm [5,20"]							
	Pallete type	Wood							
	Frame dimensions	1420mm [55,90"] x 1120mm [44,10"]							
	Frame type	M/P/W		M/P/W		M/P/W		M/P/W	
355 ml 12 oz	Cans per layer	493		493		493		493	
	Number of layers	15		16		17		18	
	Cans per pallet	7395		7888		8381		8874	
	Pallet height incl. pallet	2526 mm	99,45"	2683	105,63"	2841	111,85"	2998	118,03"

Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	355 FIT 12 oz	1.2.49
	Revision: 5	Approved by:	

CAN - PALLETIZATION

1.2.50 449 ML LONGFIT - SPANISH PALLET



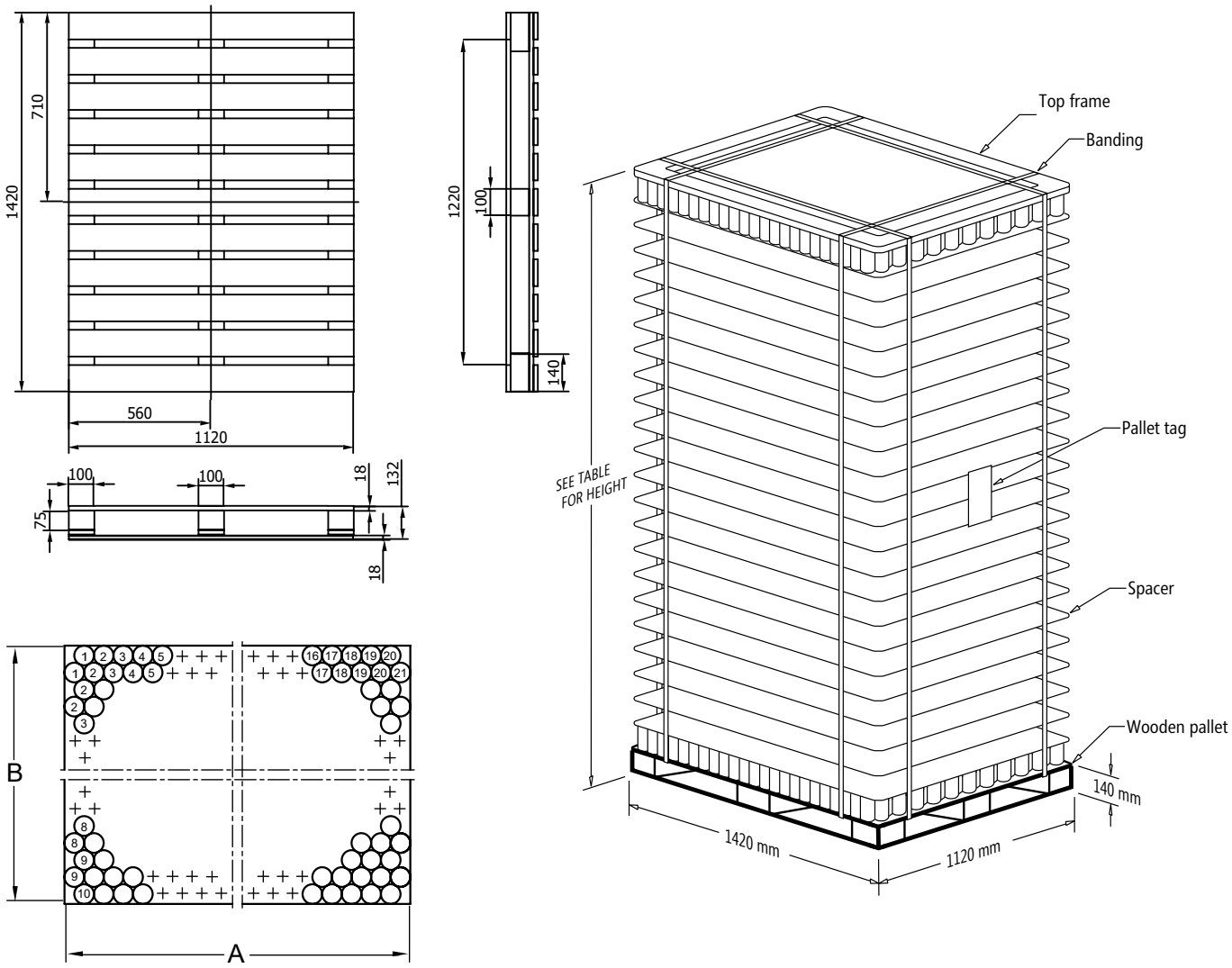
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

M - Steel frame P - Plastic frame		Spanish pallet 1420 x 1120 x 132					
	Pallete type	Wood					
	Frame dimensions	1420x1120					
	Frame type	M, P	M, P	M, P	M, P	M, P	M, P
449 ml	Cans per layer	408	408	408	408	408	408
	Number of layers	11	12	13	14	15	16
	Cans per pallet	4488	4896	5304	5712	6120	6528
	Pallet height incl. pallet	2021	2190	2359	2528	2697	2866

Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	449 ml LongFIT	1.2.50
	Revision: 5	Approved by:	

CAN - PALLETIZATION

1.2.51 300 ML STD - SPANISH PALLET



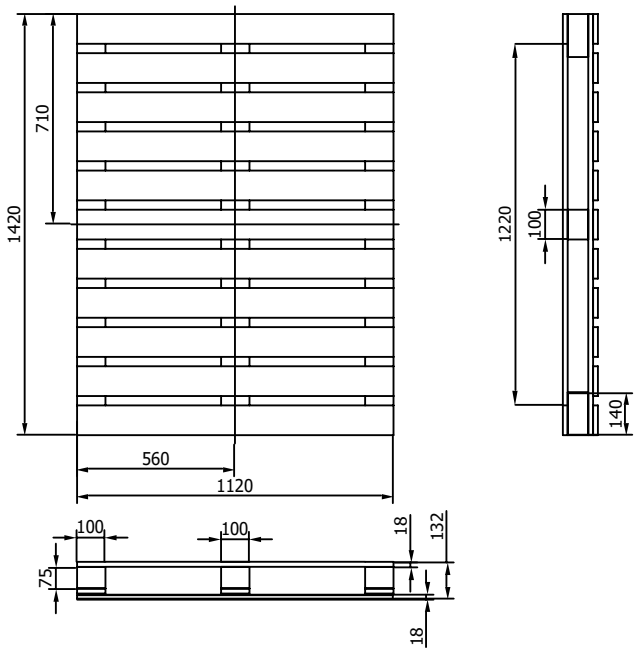
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

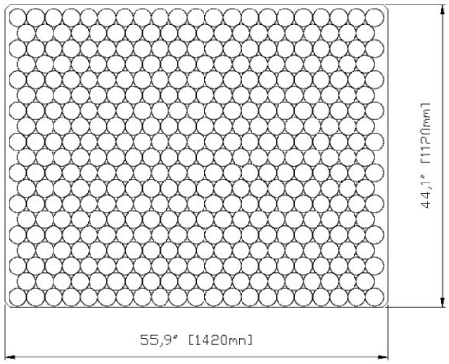
M - Steel frame		Spanish pallet					
		1420 x 1120 x 132					
	Pallete type	Wood					
	Frame dimensions	1420x1120					
	Frame type	M, W	M, W	M, W	M, W	M, W	M, W
300 ml	Cans per layer	389	389	389	389	389	389
	Number of layers	22	23	24	25	26	27
	Cans per pallet	8558	8947	9336	9725	10114	10503
	Pallet height incl. pallet	2521	2628	2736	2843	2951	3058

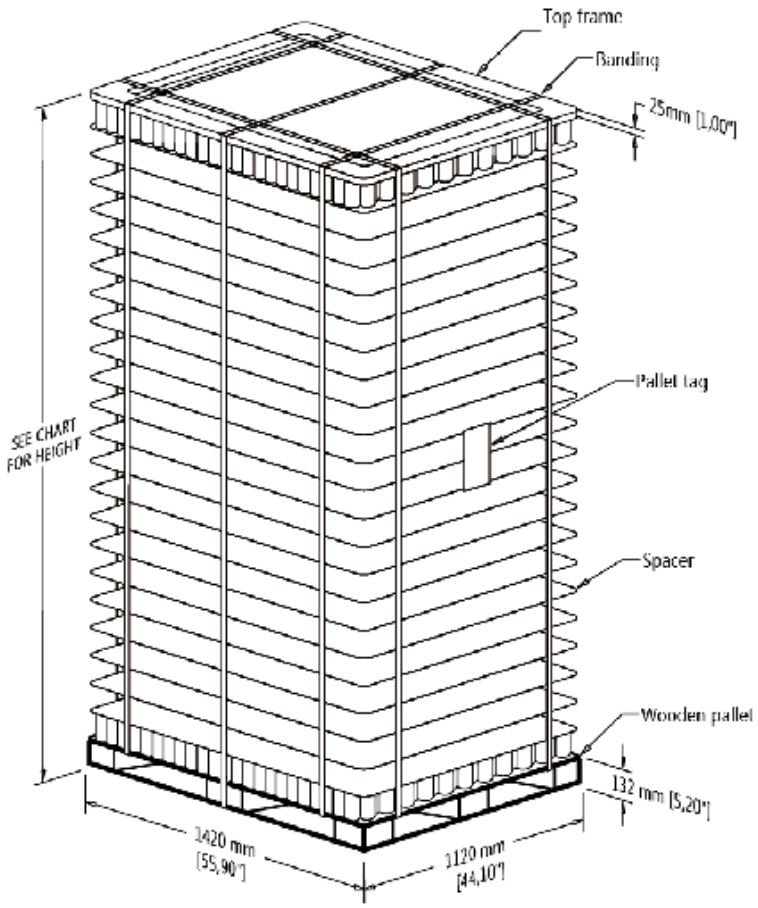
Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	300 ml STD	1.2.51
	Revision: 5	Approved by:	

CAN - PALLETIZATION

1.2.52 300 ML STD - SPANISH PALLET / 2ND LAYOUT ARRANGEMENT







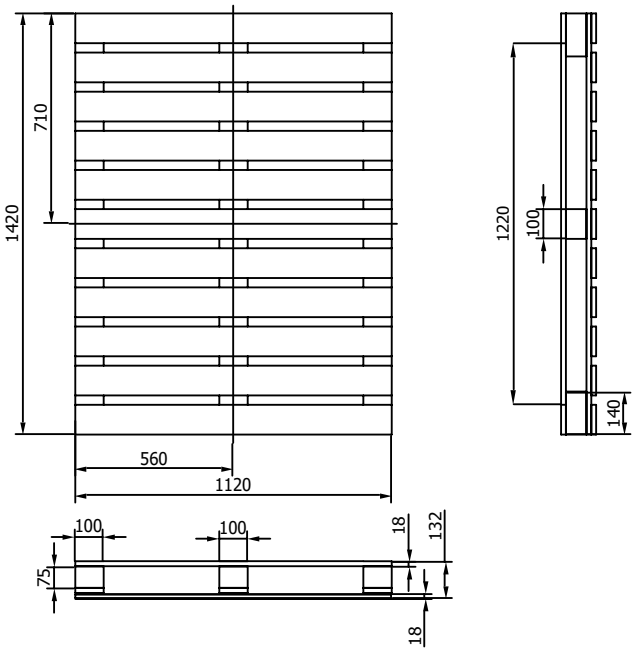
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

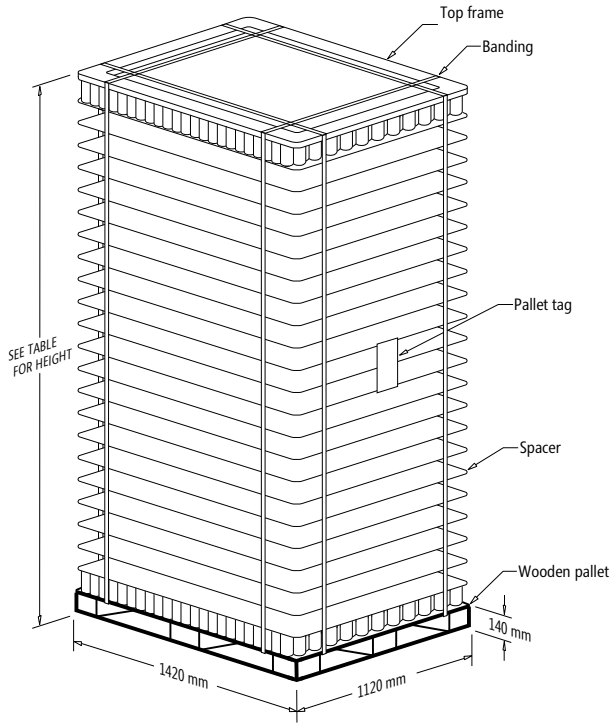
M - Steel frame		Spanish pallet		
		1420mm [55,90"] x 1120mm [44,10"] x 132mm [5,20"]		
	Pallete type	Wood		
	Frame dimensions	1420mm [55,90"] x1120mm [44,10"]		
	Frame type	M, W		
300 ml	Cans per layer	390		
	Number of layers	22		
	Cans per pallet	8580		
	Pallet height incl. pallet	2521		

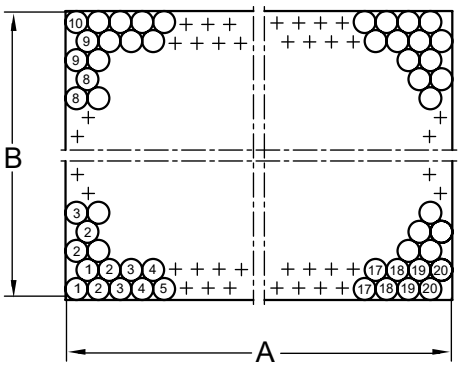
Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	17.08.2023	300 ml STD	1.2.52
	Revision: 5	Approved by:	

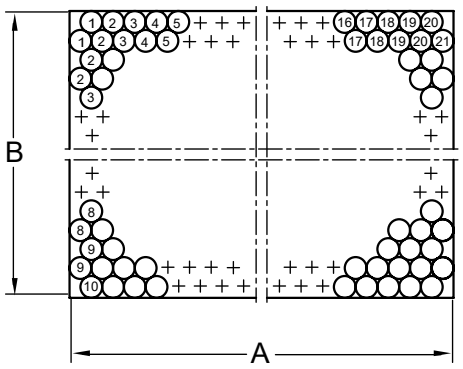
CAN - PALLETIZATION

1.2.53 330 ML STD - SPANISH PALLET









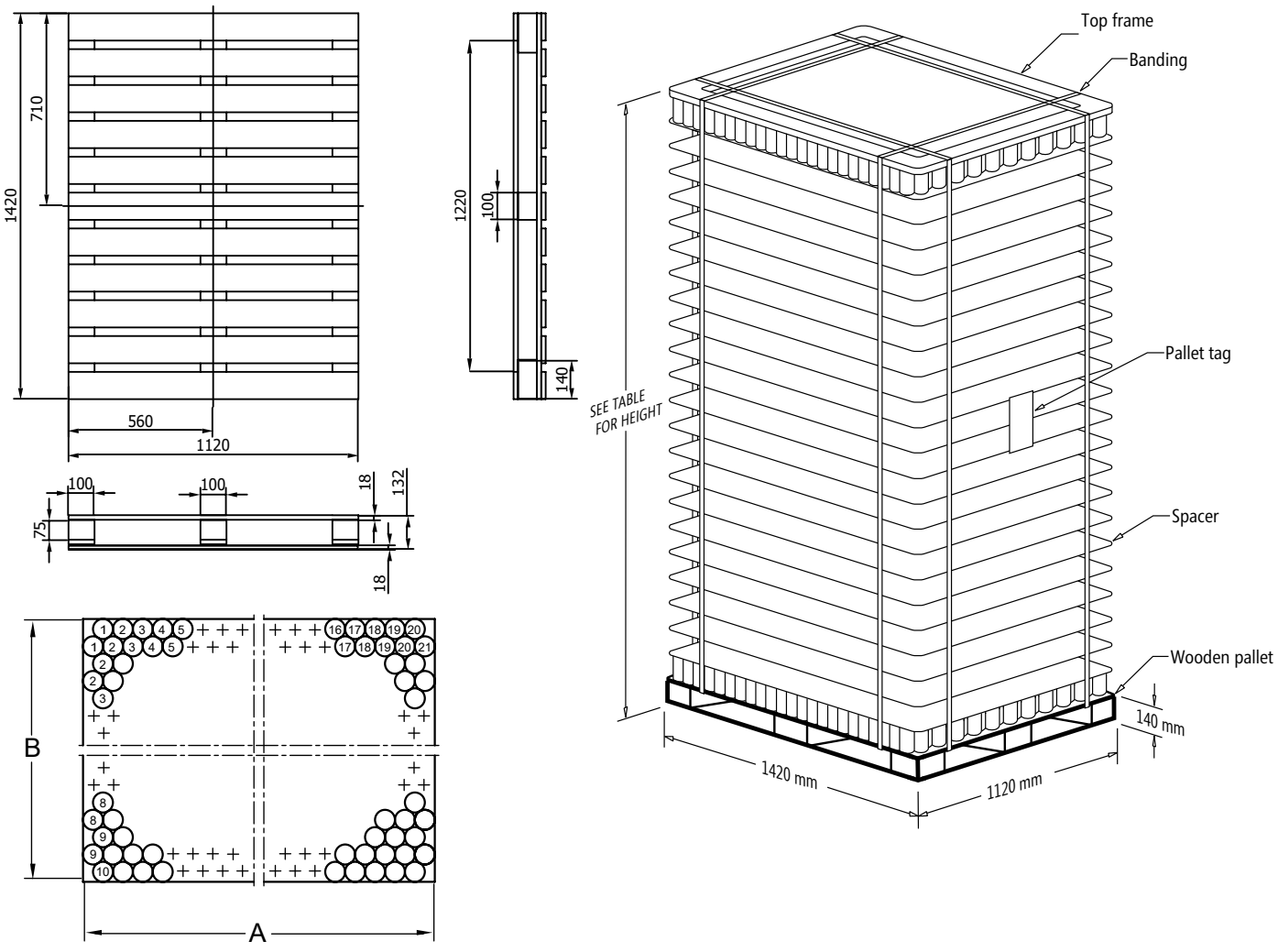
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

M - Steel frame		Spanish pallet											
		1420 x 1120 x 132											
	Pallete type	Wood											
	Frame dimensions	1420x1120											
	Frame type	M, W		M, W		M, W		M, W		M, W		M, W	
330 ml	Cans per layer	380	389	380	389	380	389	380	389	380	389	380	389
	Number of layers	18		19		20		21		22		23	
	Cans per pallet	6840	7002	7220	7391	7600	7780	7980	8169	8360	8558	8740	8947
	Pallet height incl. pallet	2253		2369		2486		2602		2718		2834	

Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	330 ml STD	1.2.53
	Revision: 5	Approved by:	

CAN - PALLETIZATION

1.2.54 350 ML STD - SPANISH PALLET



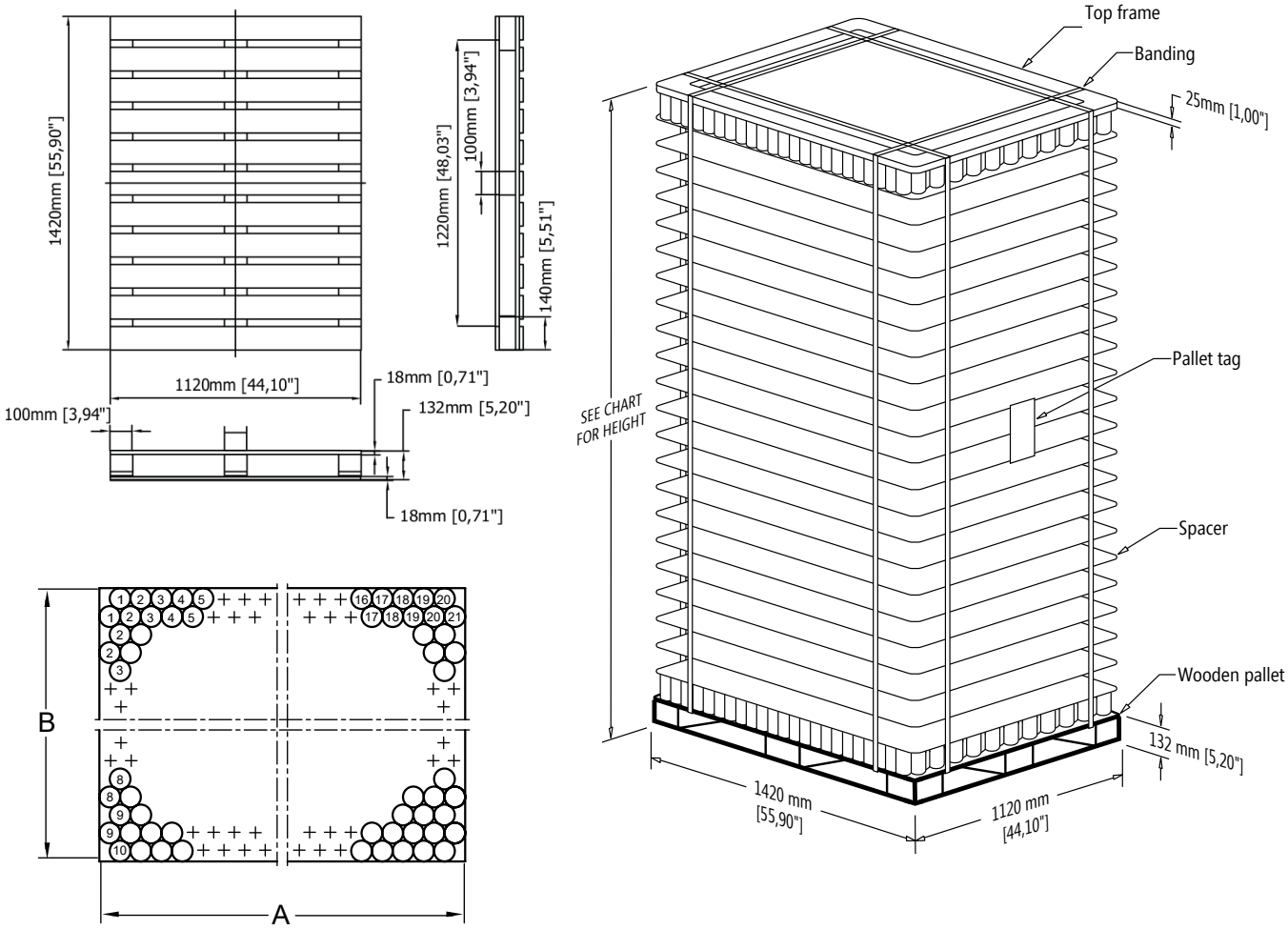
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

M - Steel frame		Spanish pallet					
		1420 x 1120 x 132					
	Pallete type	Wood					
	Frame dimensions	1420x1120					
	Frame type	M, W	M, W	M, W	M, W	M, W	M, W
350 ml	Cans per layer	389	389	389	389	389	389
	Number of layers	17	18	19	20	21	22
	Cans per pallet	6613	7002	7391	7780	8169	8558
	Pallet height incl. pallet	2256	2379	2502	2626	2749	2872

Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	350 ml STD	1.2.54
	Revision: 5	Approved by:	

CAN - PALLETIZATION

1.2.55 355 ML / 12 OZ STD - SPANISH PALLET



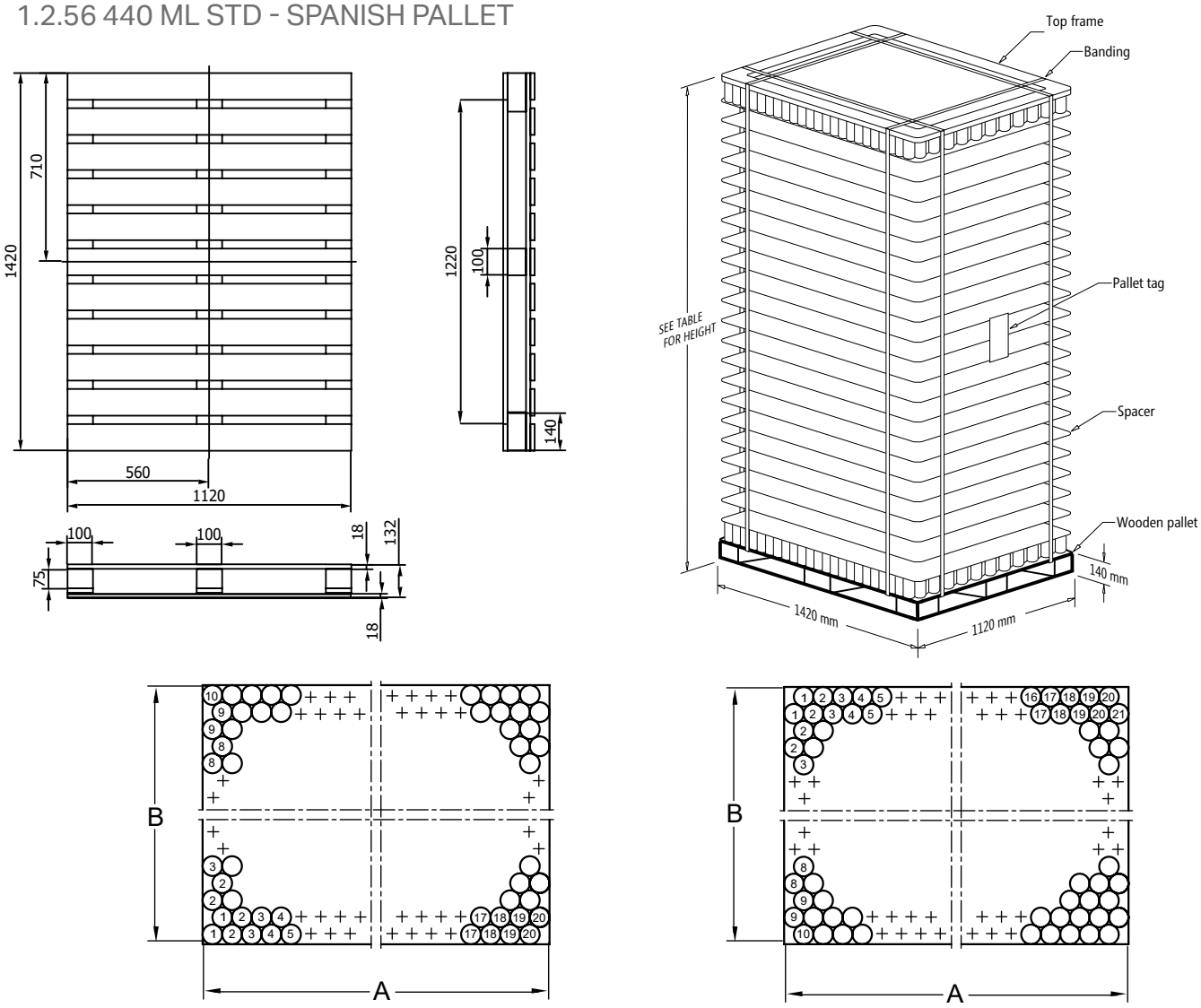
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

M - Steel Frame P - Plastic Frame W - Wooden Frame		Spanish pallet							
		1420mm [55,90"] x 1120mm [44,10"] x 132mm [5,20"]							
	Pallete type	Wood							
	Frame dimensions	1420mm [55,90"] x 1120mm [44,10"]							
	Frame type	M/P/W		M/P/W		M/P/W		M/P/W	
355 ml 12 oz	Cans per layer	389		389		389		389	
	Number of layers	19		20		21		22	
	Cans per pallet	7391		7780		8169		8558	
	Pallet height incl. pallet	2502 mm	98,50"	2626 mm	103,39"	2749 mm	108,23"	2872 mm	113,07"

Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	355 ml STD 12 oz	1.2.55
	Revision: 5	Approved by:	

CAN - PALLETIZATION

1.2.56 440 ML STD - SPANISH PALLET



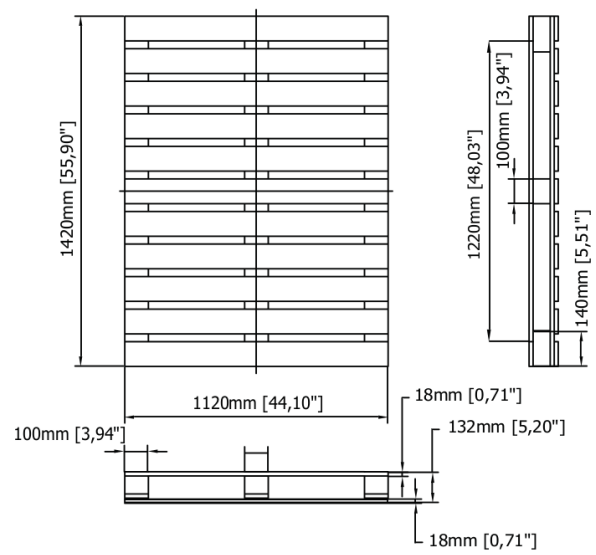
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

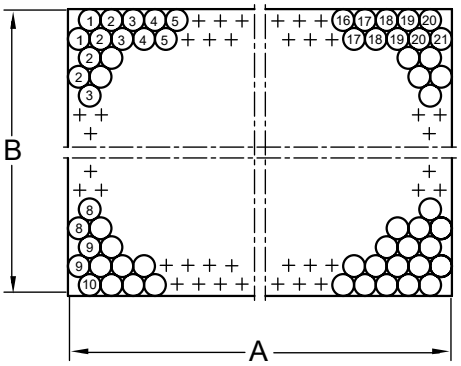
M - Steel frame		Spanish pallet											
		1420 x 1120 x 132											
	Pallete type	Wood											
	Frame dimensions	1420x1120											
	Frame type	M, W		M, W		M, W		M, W		M, W		M, W	
440 ml	Cans per layer	380	389	380	389	380	389	380	389	380	389	380	389
	Number of layers	11		12		13		14		15		16	
	Cans per pallet	4180	4279	4560	4668	4940	5057	5320	5446	5700	5835	6080	6224
	Pallet height incl. pallet	1821		1972		2123		2274		2425		2576	

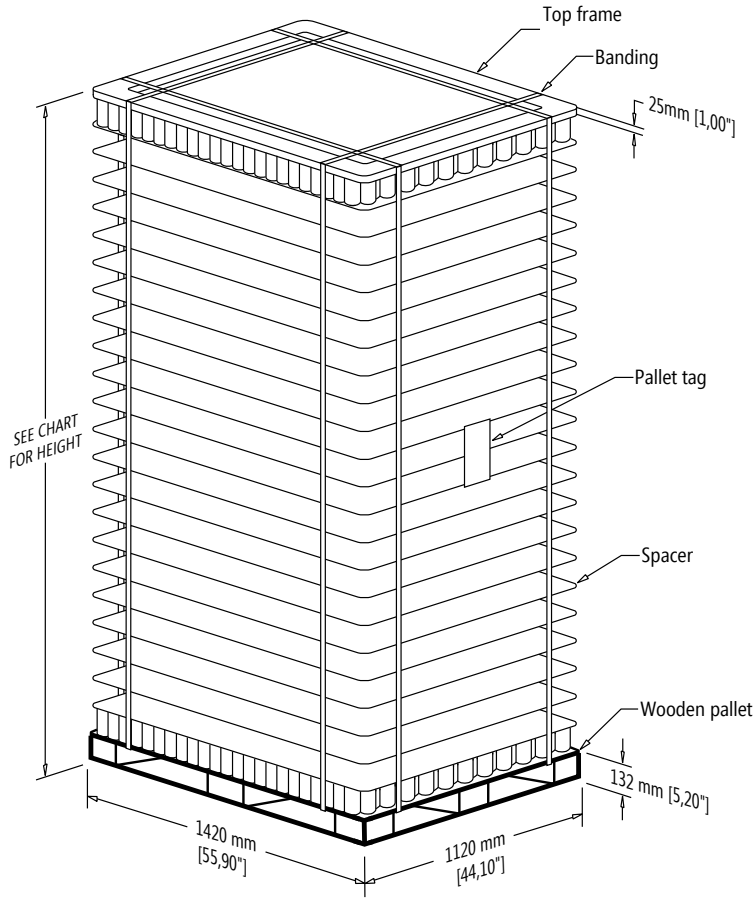
Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	440 ml STD	1.2.56
	Revision: 5	Approved by:	

CAN - PALLETIZATION

1.2.57 473 ML / 16 OZ STD - SPANISH PALLET







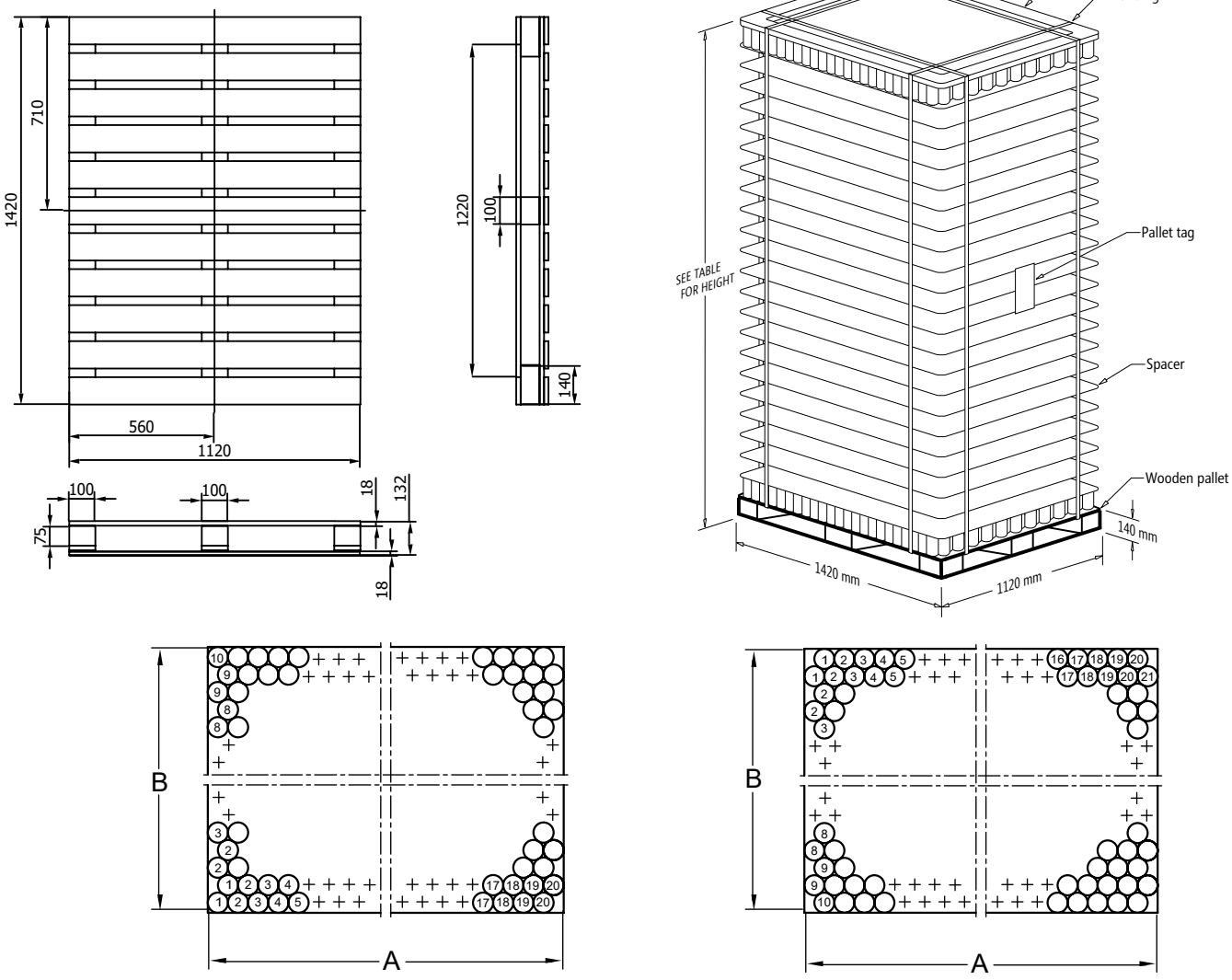
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

M - Steel Frame P - Plastic Frame W - Wooden Frame		Spanish pallet							
		1420mm [55,90"] x 1120mm [44,10"] x 132mm [5,20"]							
	Pallete type	Wood							
	Frame dimensions	1420mm [55,90"] x 1120mm [44,10"]							
	Frame type	M/P/W		M/P/W		M/P/W		M/P/W	
473 ml 16 oz	Cans per layer	389		389		389		389	
	Number of layers	14		15		16		17	
	Cans per pallet	5446		5835		6224		6613	
	Pallet height incl. pallet	2372 mm	93,38"	2535 mm	99,80"	2693 mm	106,02"	2851 mm	112,24"

Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON.	01.05.2020	473 ml STD 16 oz	1.2.57
	Revision: 5	Approved by:	

CAN - PALLETIZATION

1.2.58 500 ML STD - SPANISH PALLET



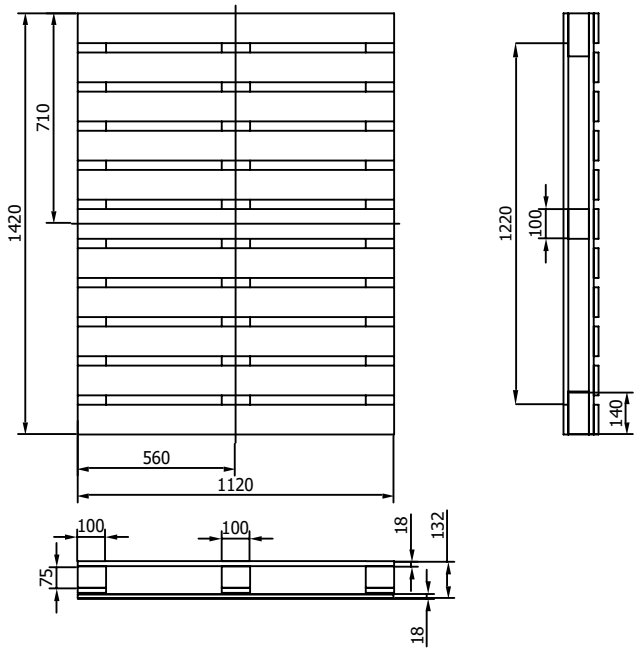
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

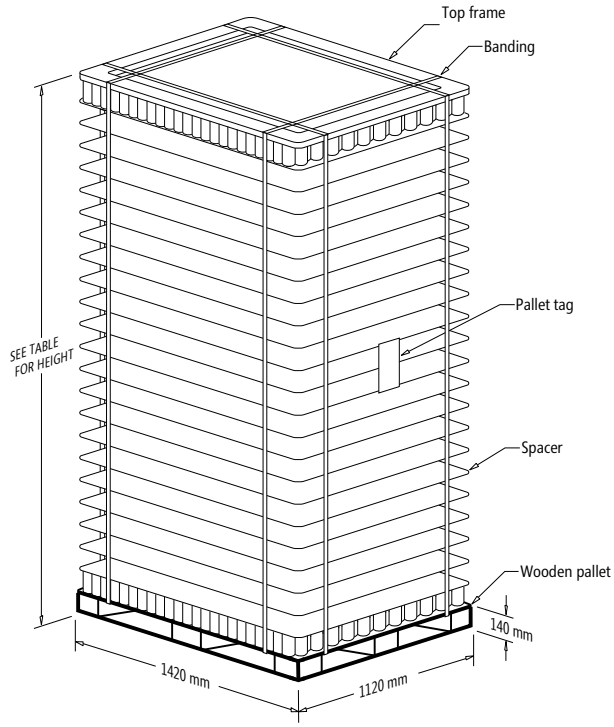
M - Steel frame		Spanish pallet											
		1420 x 1120 x 132											
	Pallete type	Wood											
	Frame dimensions	1420x1120											
	Frame type	M, W		M, W		M, W		M, W		M, W		M, W	
500 ml	Cans per layer	380	389	380	389	380	389	380	389	380	389	380	389
	Number of layers	11		12		13		14		15		16	
	Cans per pallet	4180	4279	4560	4668	4940	5057	5320	5446	5700	5835	6080	6224
	Pallet height incl. pallet	2021		2190		2359		2528		2697		2866	

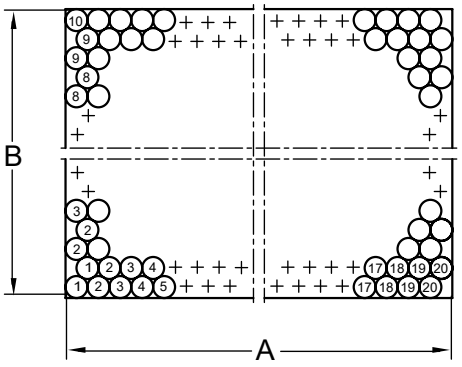
Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	500 ml STD	1.2.58
	Revision: 5	Approved by:	

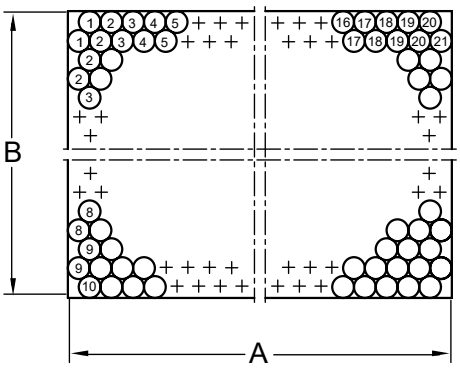
CAN - PALLETIZATION

1.2.59 550 ML STD - SPANISH PALLET









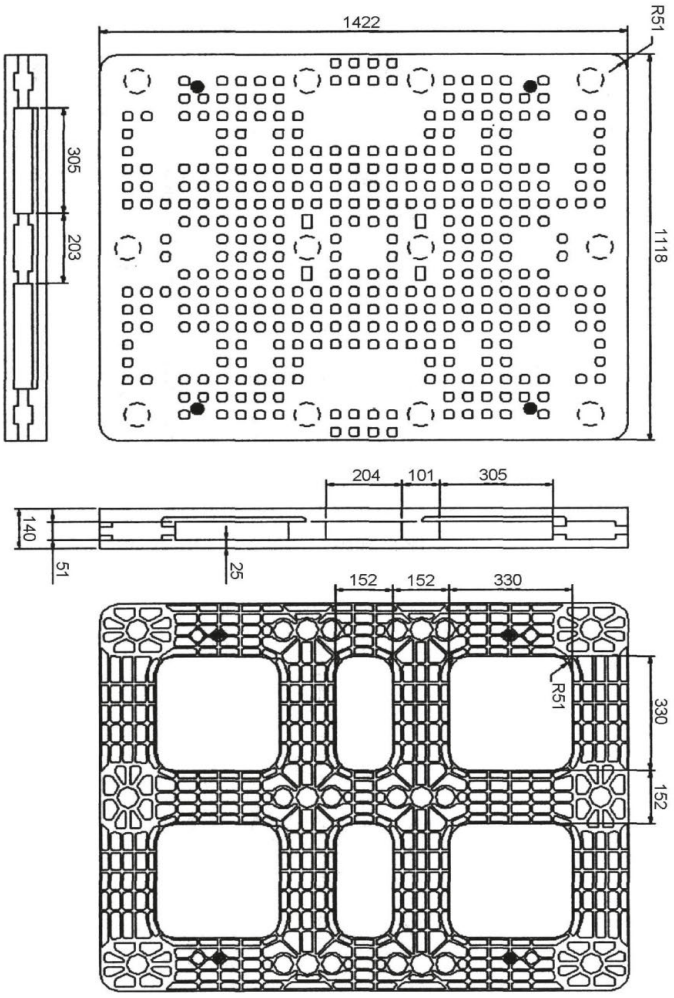
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

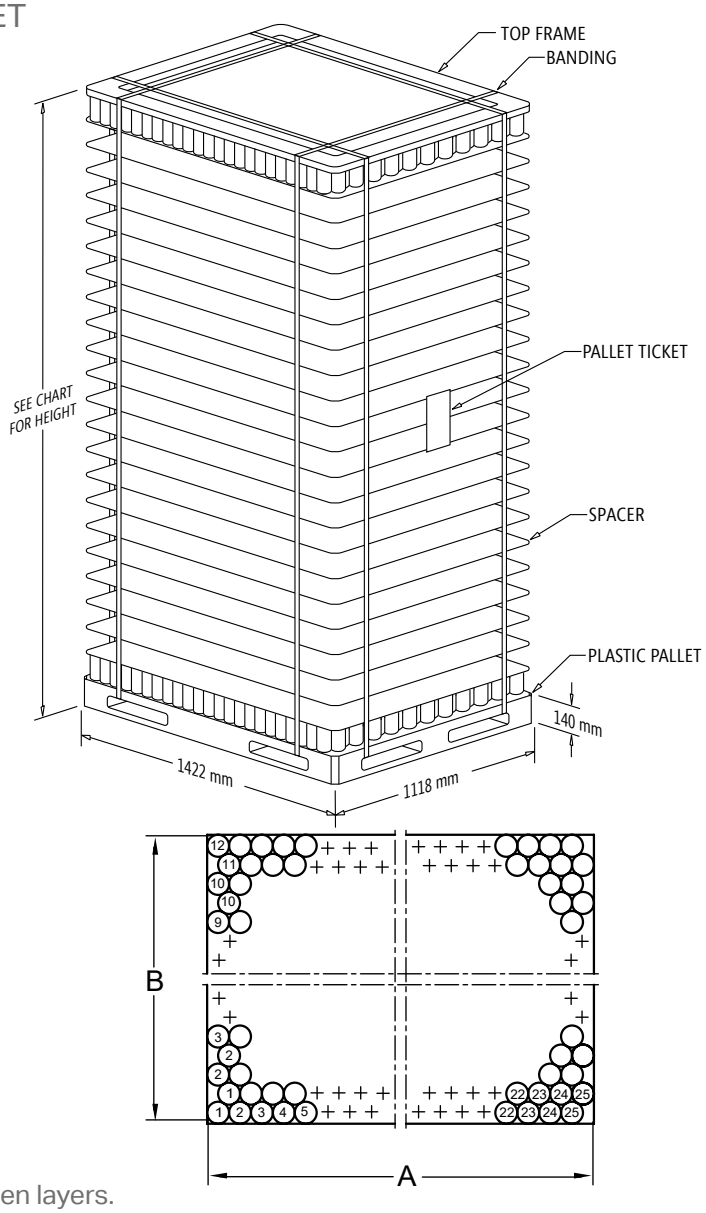
M - Steel frame		Spanish pallet											
		1420 x 1120 x 132											
	Pallete type	Wood											
	Frame dimensions	1420x1120											
	Frame type	M, W		M, W		M, W		M, W		M, W		M, W	
550 ml	Cans per layer	380	389	380	389	380	389	380	389	380	389	380	389
	Number of layers	10		11		12		13		14		15	
	Cans per pallet	3800	3890	4180	4279	4560	4668	4940	5057	5320	5446	5700	5835
	Pallet height incl. pallet	1998		2182		2365		2549		2733		2916	

Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	550 ml STD	1.2.59
	Revision: 5	Approved by:	

CAN - PALLETIZATION

1.2.60 150 ML SLIM - SPANISH PLASTIC PALLET





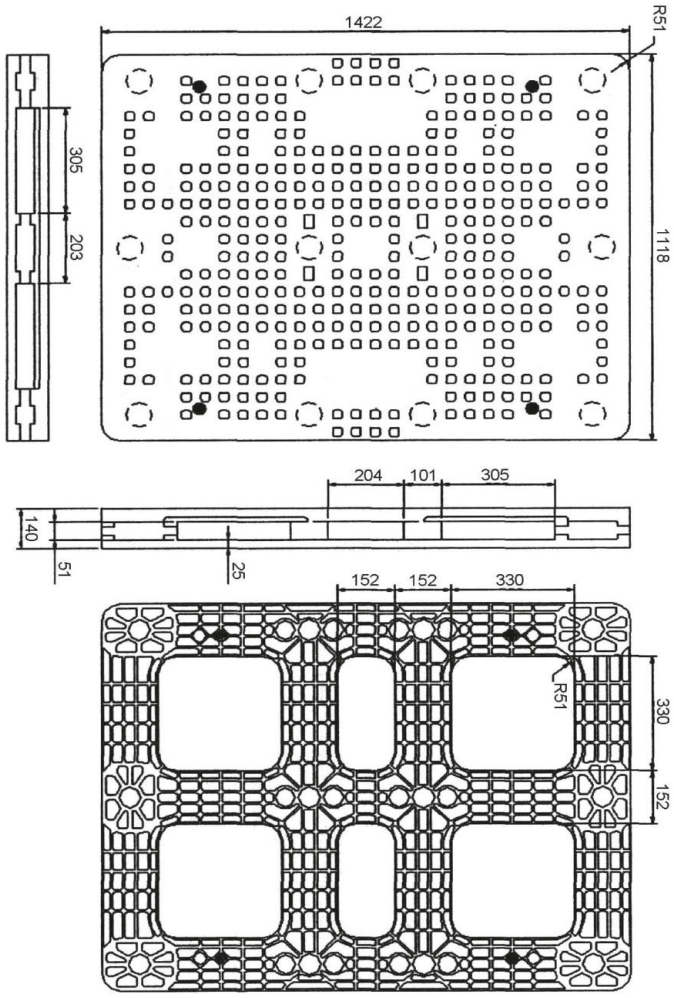
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

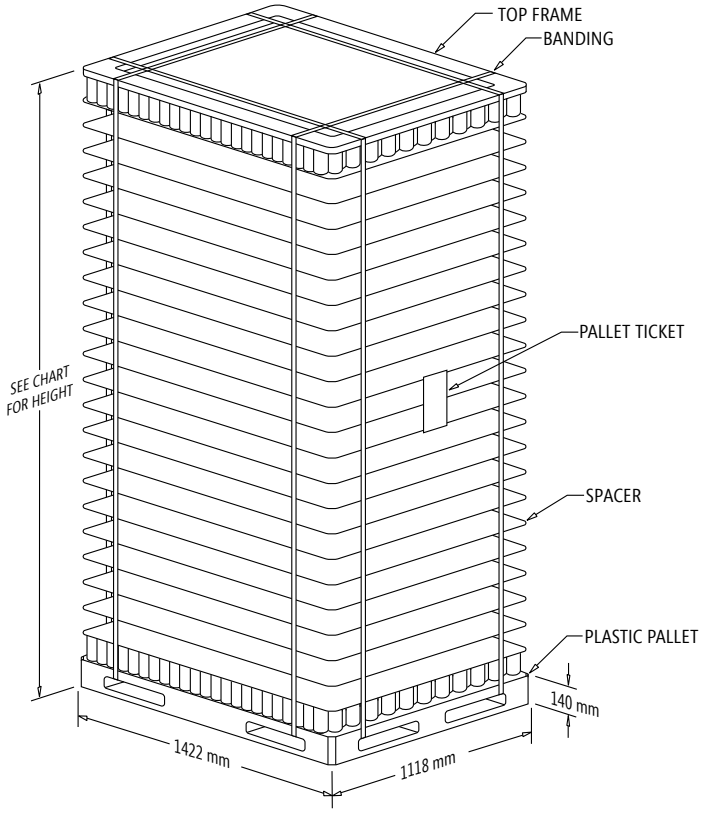
M - Steel frame		Spanish pallet - plastic					
		1420 x 1120 x 140					
	Pallete type	Plastic					
	Frame dimensions	1420x1120					
	Frame type	M	M	M	M	M	M
150 ml	Cans per layer	575	575	575	575	575	575
	Number of layers	26	27	28	29	30	31
	Cans per pallet	14950	15525	16100	16675	17250	17825
	Pallet height incl. pallet	2483	2573	2662	2751	2841	2930

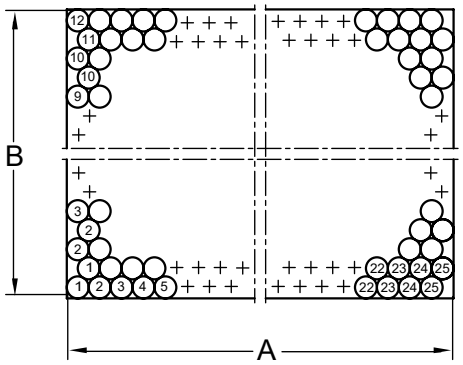
Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	150 ml Slim	1.2.60
	Revision: 5	Approved by:	

CAN - PALLETIZATION

1.2.61 200 ML SLIM - SPANISH PLASTIC PALLET







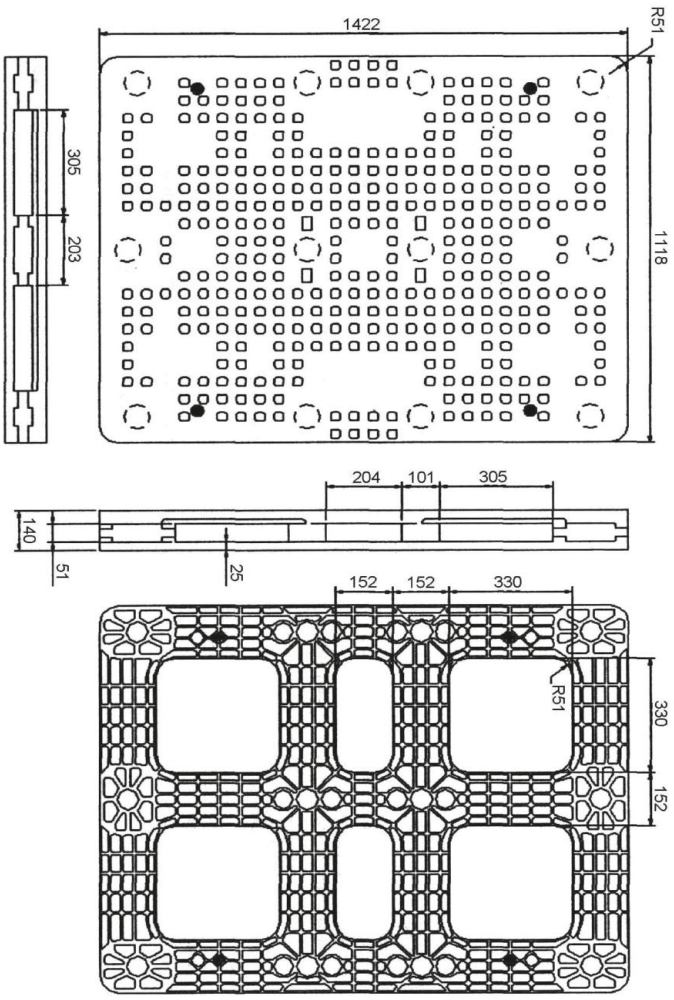
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

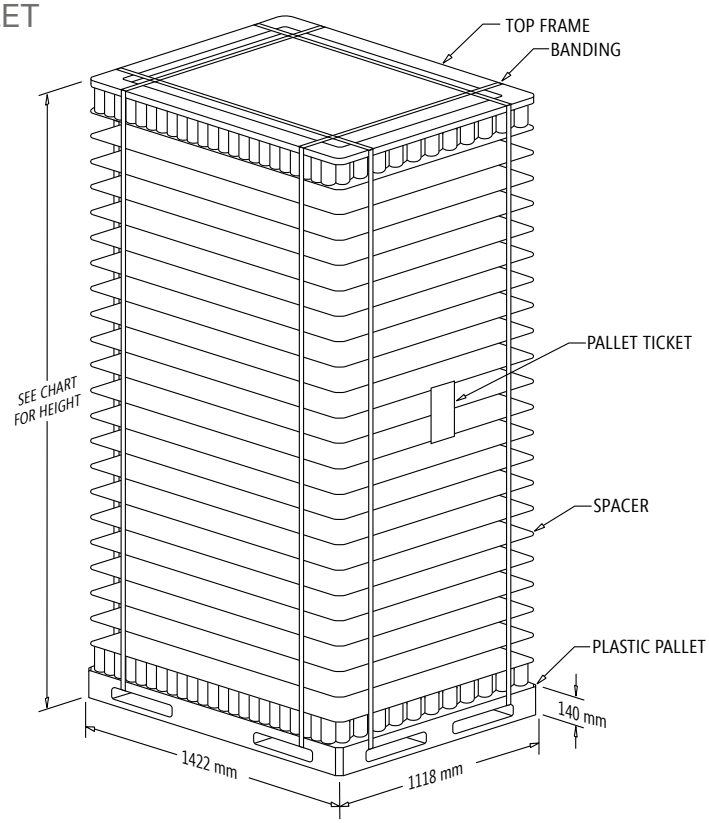
M - Steel frame		Spanish pallet - plastic					
		1420 x 1120 x 140					
	Pallete type	Plastic					
	Frame dimensions	1420x1120					
	Frame type	M	M	M	M	M	M
200 ml	Cans per layer	575	575	575	575	575	575
	Number of layers	20	21	22	23	24	25
	Cans per pallet	11500	12075	12650	13225	13800	14375
	Pallet height incl. pallet	2406	2518	2630	2742	2854	2967

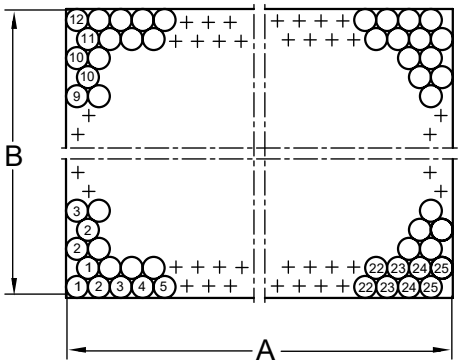
Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	200 ml Slim	1.2.61
	Revision: 5	Approved by:	

CAN - PALLETIZATION

1.2.62 240 ML SLIM - SPANISH PLASTIC PALLET







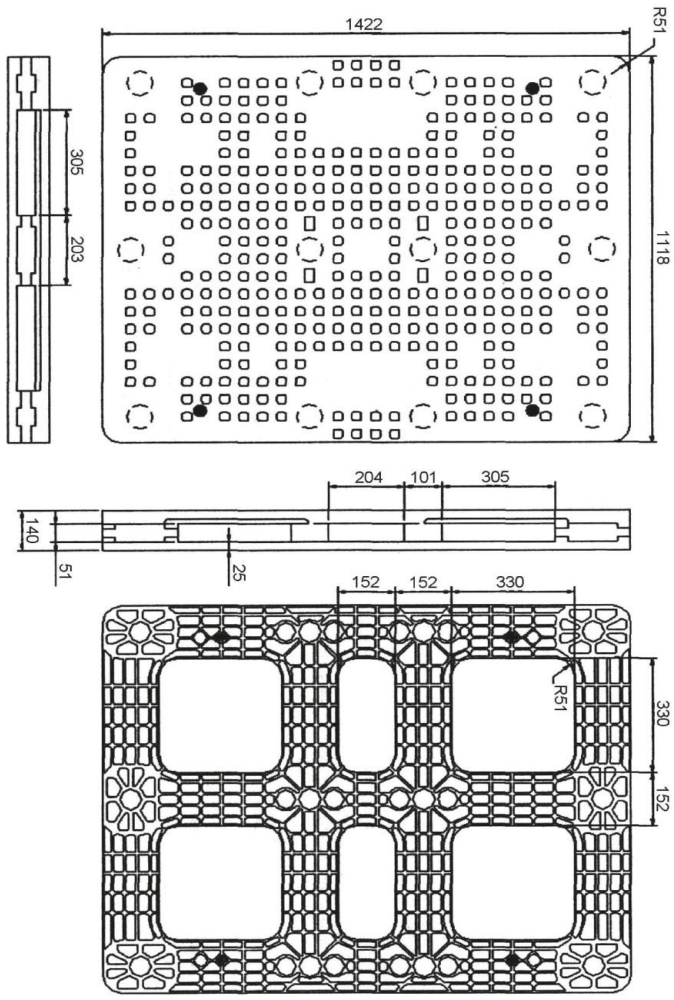
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

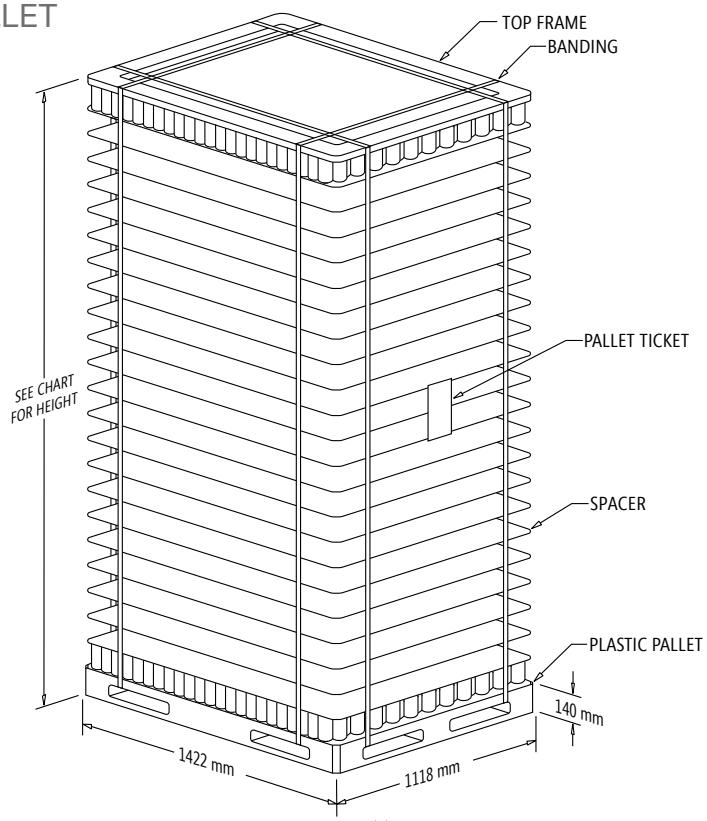
M - Steel frame		Spanish pallet - plastic					
		1420 x 1120 x 140					
	Pallete type	Plastic					
	Frame dimensions	1420x1120					
	Frame type	M	M	M	M	M	M
240 ml	Cans per layer	575	575	575	575	575	575
	Number of layers	15	16	17	18	19	20
	Cans per pallet	8625	9200	9775	10350	10925	11500
	Pallet height incl. pallet	2127	2258	2389	2520	2651	2782

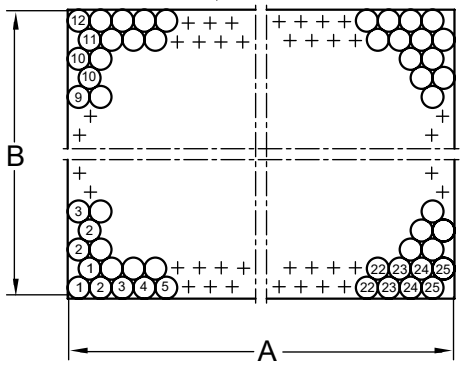
Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	240 ml Slim	1.2.62
	Revision: 5	Approved by:	

CAN - PALLETIZATION

1.2.63 250 ML 250 SLIM - SPANISH PLASTIC PALLET







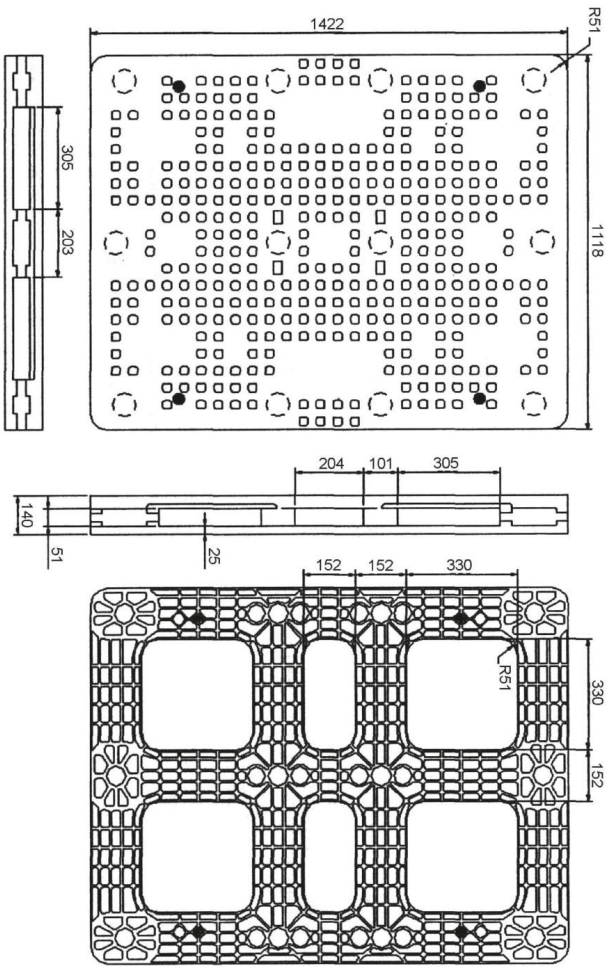
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

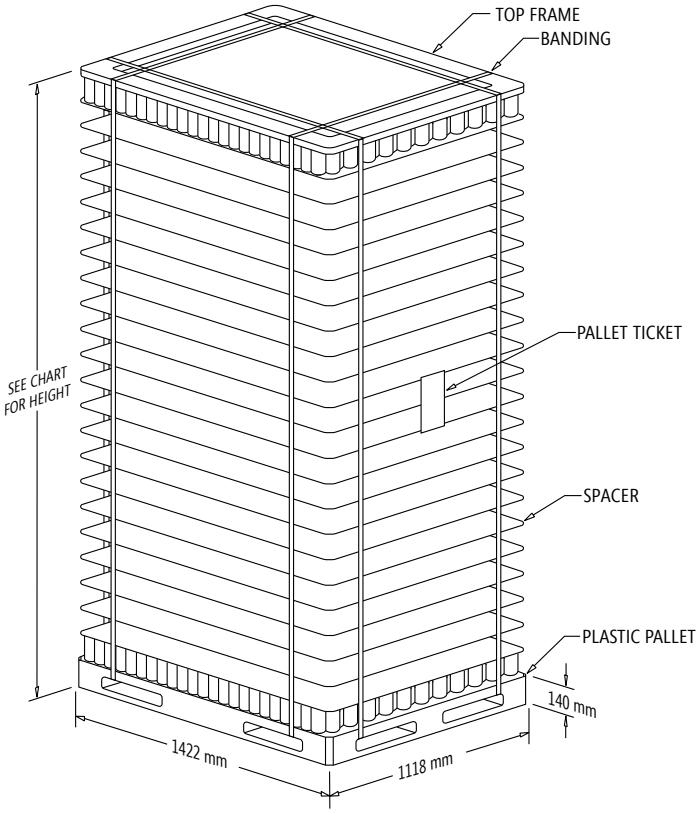
M - Steel frame		Spanish pallet - plastic					
		1420 x 1120 x 140					
	Pallete type	Plastic					
	Frame dimensions	1420x1120					
	Frame type	M	M	M	M	M	M
250 ml	Cans per layer	575	575	575	575	575	575
	Number of layers	15	16	17	18	19	20
	Cans per pallet	8625	9200	9775	10350	10925	11500
	Pallet height incl. pallet	2187	2322	2457	2592	2727	2862

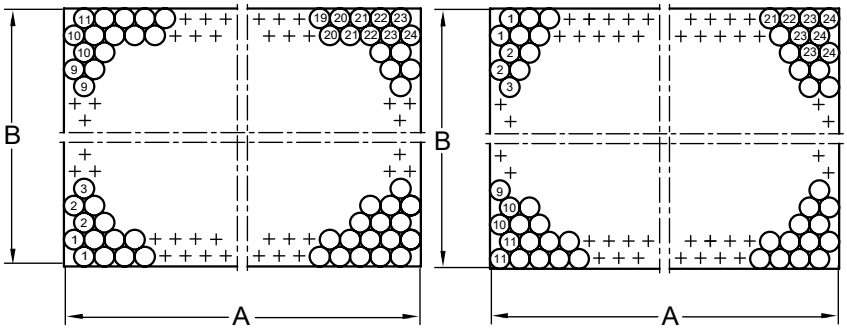
Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	250 ml Slim	1.2.63
	Revision: 5	Approved by:	

CAN - PALLETIZATION

1.2.64 269 ML FIT - SPANISH PLASTIC PALLET







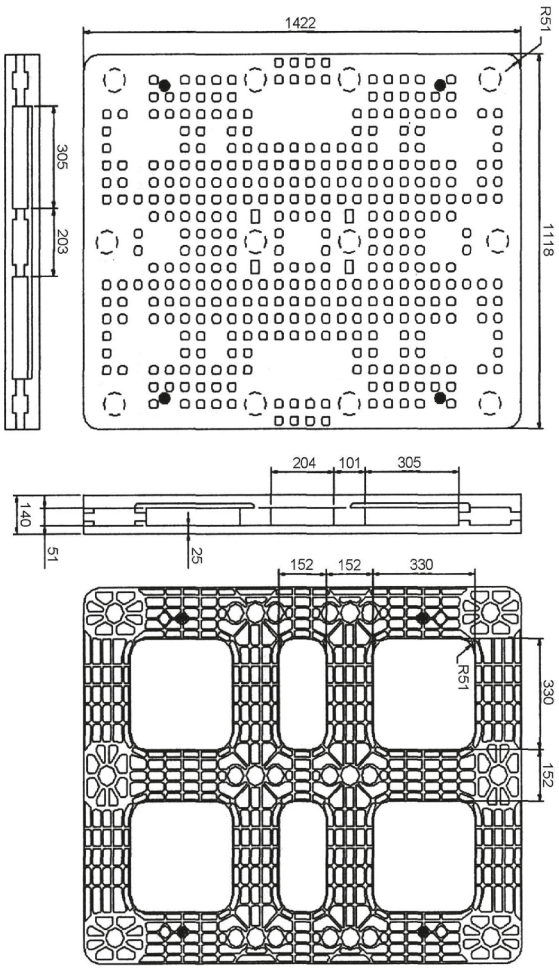
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

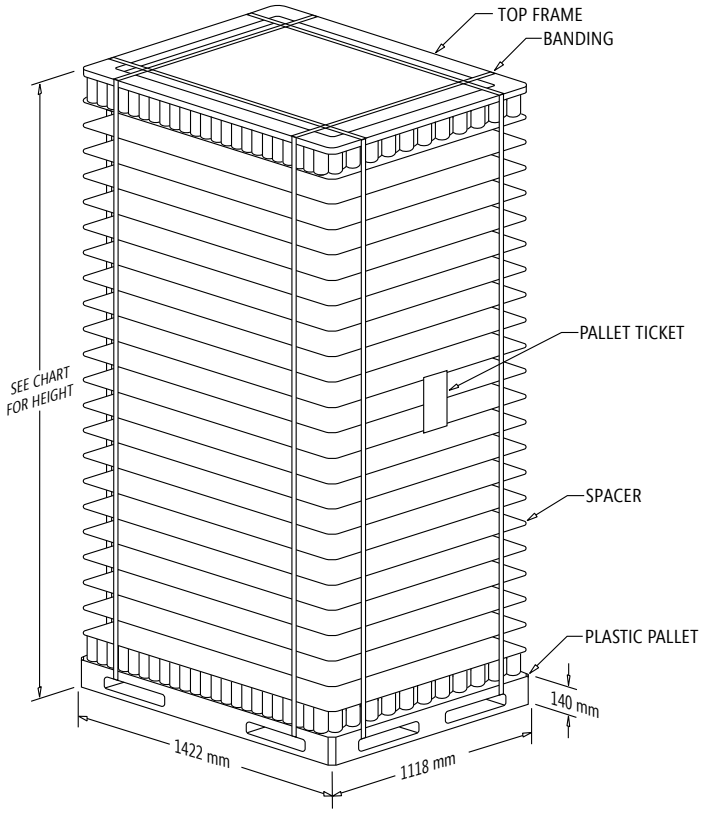
M - Steel frame P - Plastic frame		Spanish pallet - plastic 1420 x 1120 x 140									
	Pallete type	Plastic									
	Frame dimensions	1420x1120									
	Frame type	M, P		M, P		M, P		M, P		M, P	
269 ml	Cans per layer	493	528	493	528	493	528	493	528	493	528
	Number of layers	17		18		19		20		21	
	Cans per pallet	8381	8976	8874	9504	9367	10032	9860	10560	10353	11088
	Pallet height incl. pallet	2257		2380		2503		2626		2749	

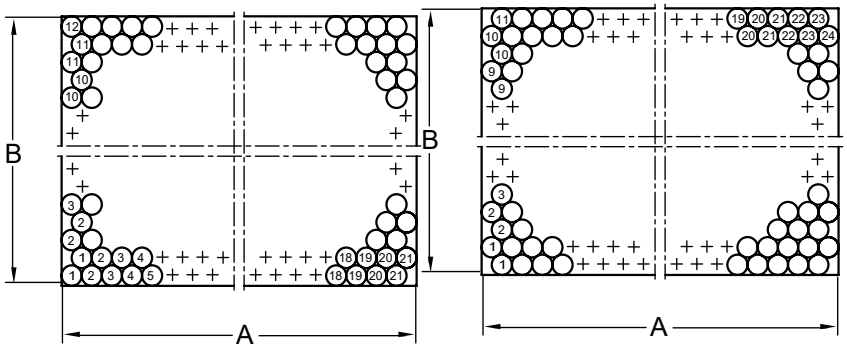
Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	20.09.2023	269 ml FIT	1.2.64
	Revision: 6	Approved by:	

CAN - PALLETIZATION

1.2.65 300 ML FIT- SPANISH PLASTIC PALLET







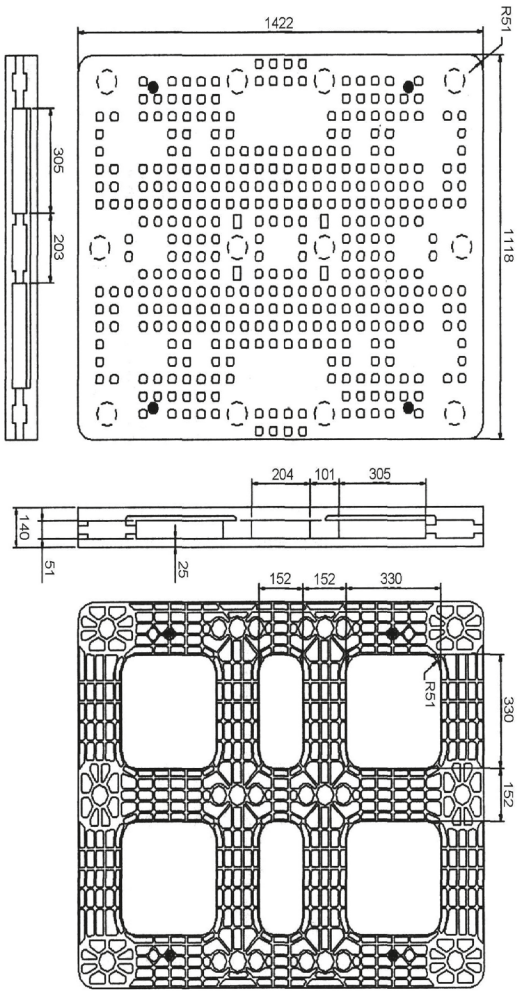
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

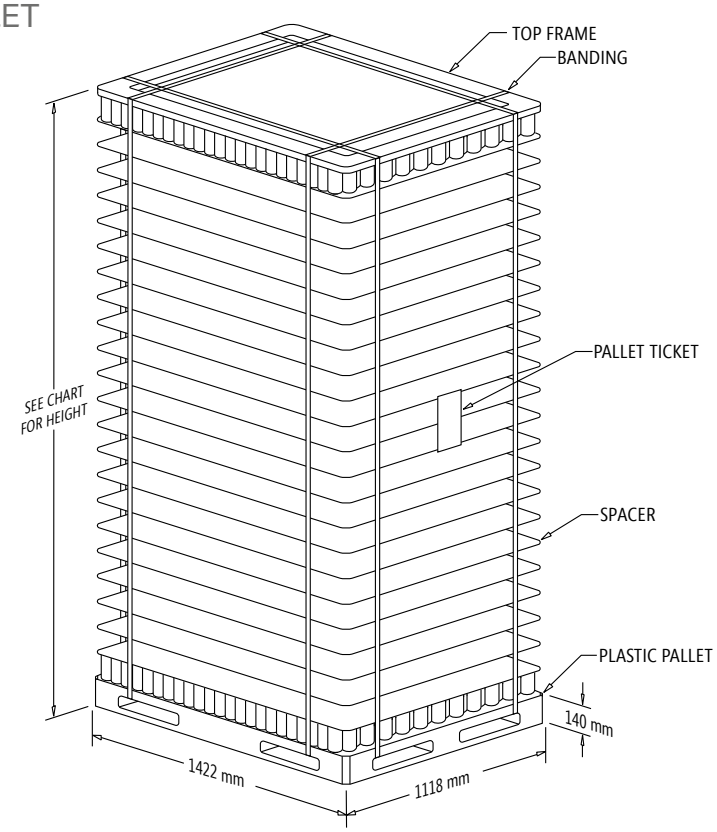
M - Steel frame		Spanish pallet - plastic											
		1420 x 1120 x 140											
	Pallete type	Plastic											
	Frame dimensions	1420x1120											
	Frame type	W		W		W		W		W		W	
300 ml	Cans per layer	483	493	483	493	483	493	483	493	483	493	483	493
	Number of layers	15		16		17		18		19		20	
	Cans per pallet	7245	7395	7728	7888	8211	8381	8694	8874	9177	9367	9660	9860
	Pallet height incl. pallet	2185		2320		2455		2590		2725		2860	

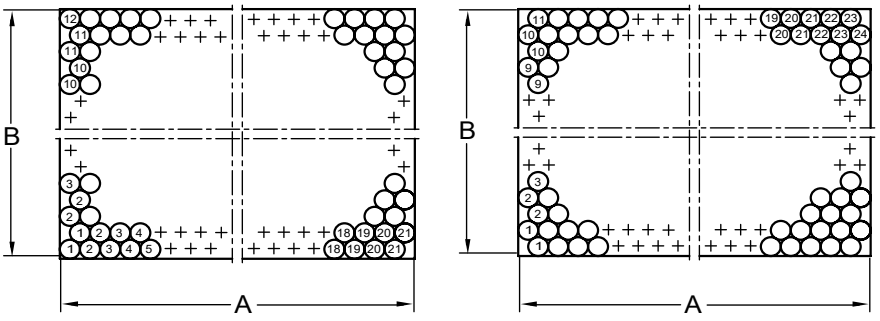
Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	300 ml FIT	1.2.65
	Revision: 5	Approved by:	

CAN - PALLETIZATION

1.2.66 330 ML FIT- SPANISH PLASTIC PALLET







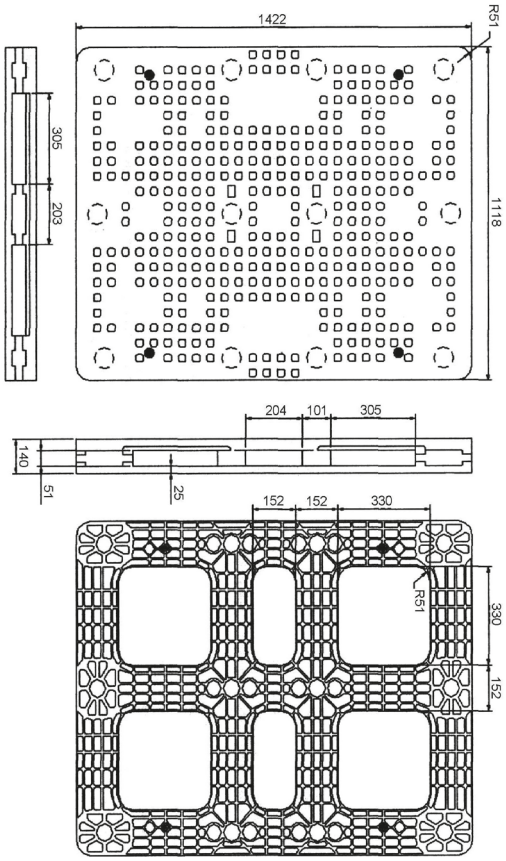
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

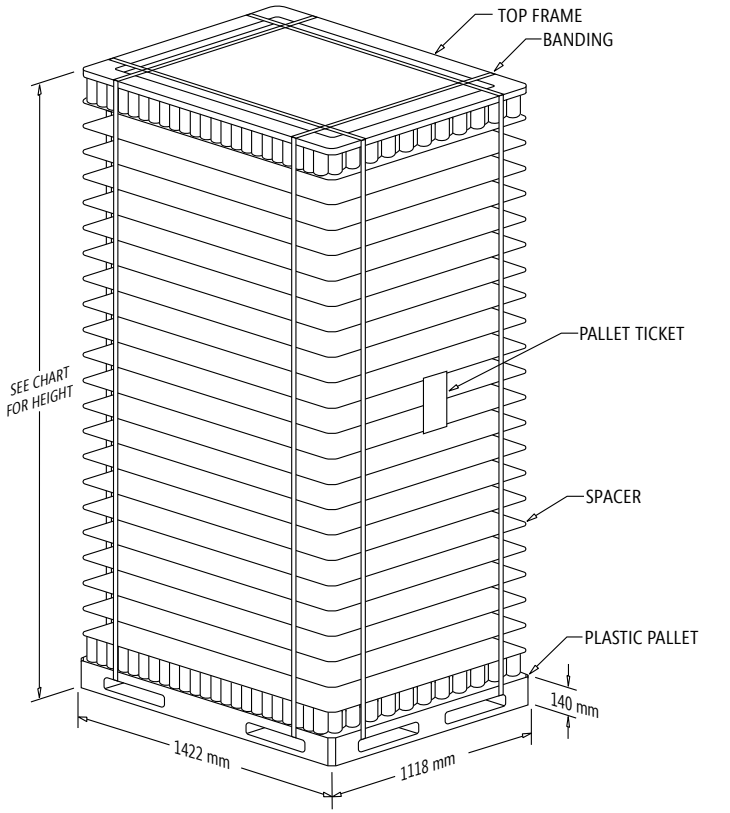
M - Steel frame		Spanish pallet - plastic											
		1420 x 1120 x 140											
	Pallete type	Plastic											
	Frame dimensions	1420x1120											
	Frame type	W		W		W		W		W		W	
330 ml	Cans per layer	483	493	483	493	483	493	483	493	483	493	483	493
	Number of layers	14		15		16		17		18		19	
	Cans per pallet	6762	6902	7245	7395	7728	7888	8211	8381	8694	8874	9177	9367
	Pallet height incl. pallet	2211		2358		2504		2650		2797		2943	

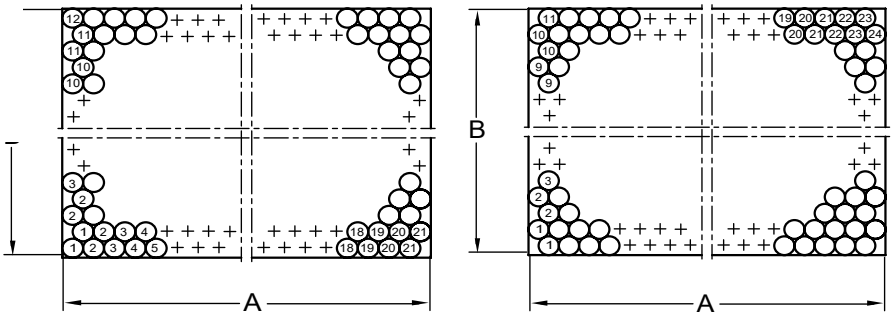
Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	330 ml FIT	1.2.66
	Revision: 5	Approved by:	

CAN - PALLETIZATION

1.2.67 355 ML FIT- SPANISH PLASTIC PALLET







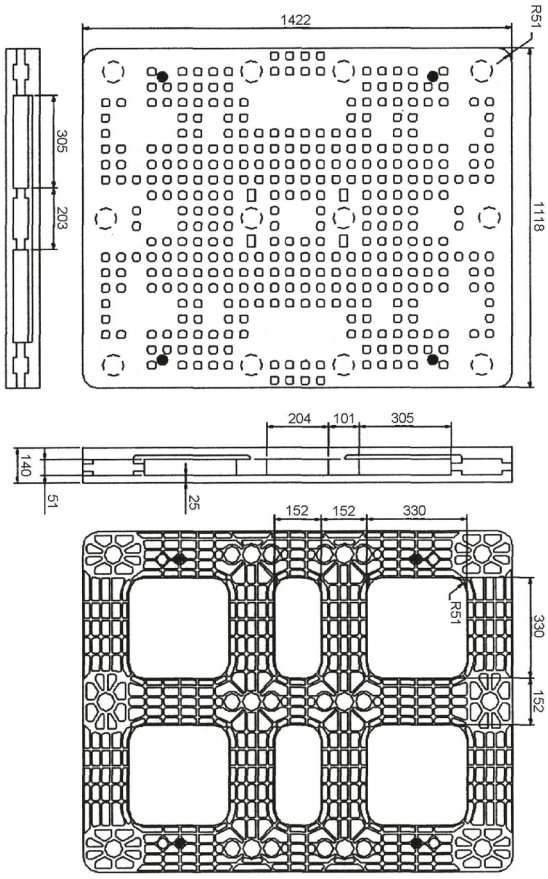
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

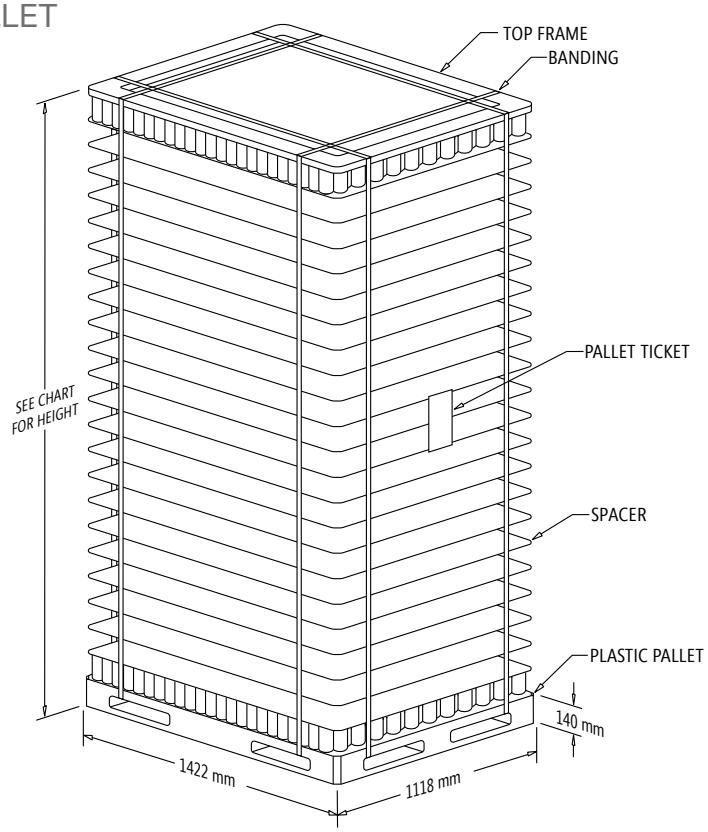
M - Steel frame		Spanish pallet - plastic											
		1420 x 1120 x 140											
	Pallete type	Plastic											
	Frame dimensions	1420x1120											
	Frame type	W		W		W		W		W		W	
355 ml	Cans per layer	483	493	483	493	483	493	483	493	483	493	483	493
	Number of layers	13		14		15		16		17		18	
	Cans per pallet	6279	6409	6762	6902	7245	7395	7728	7888	8211	8381	8694	8874
	Pallet height incl. pallet	2210		2368		2526		2683		2841		2998	

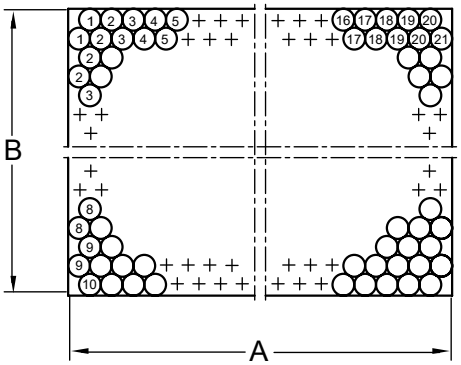
Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	355 ml FIT	1.2.67
	Revision: 5	Approved by:	

CAN - PALLETIZATION

1.2.68 300 ML STD - SPANISH PLASTIC PALLET







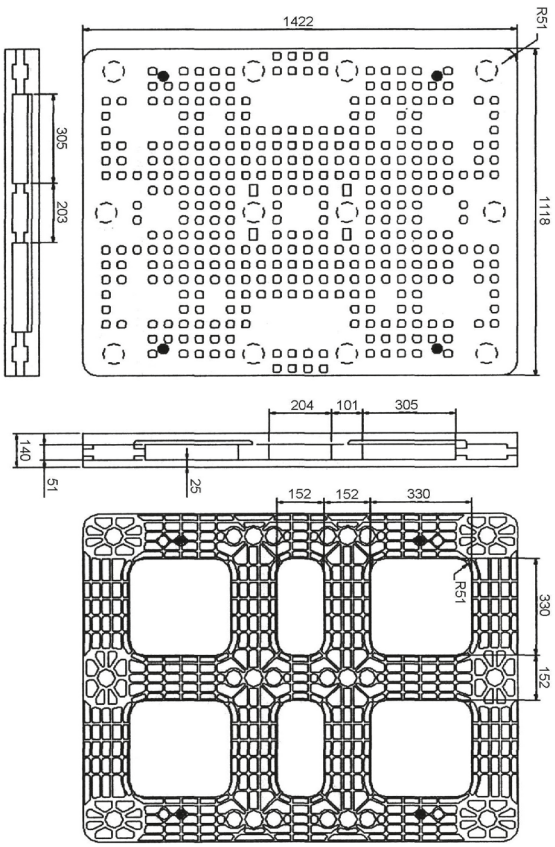
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

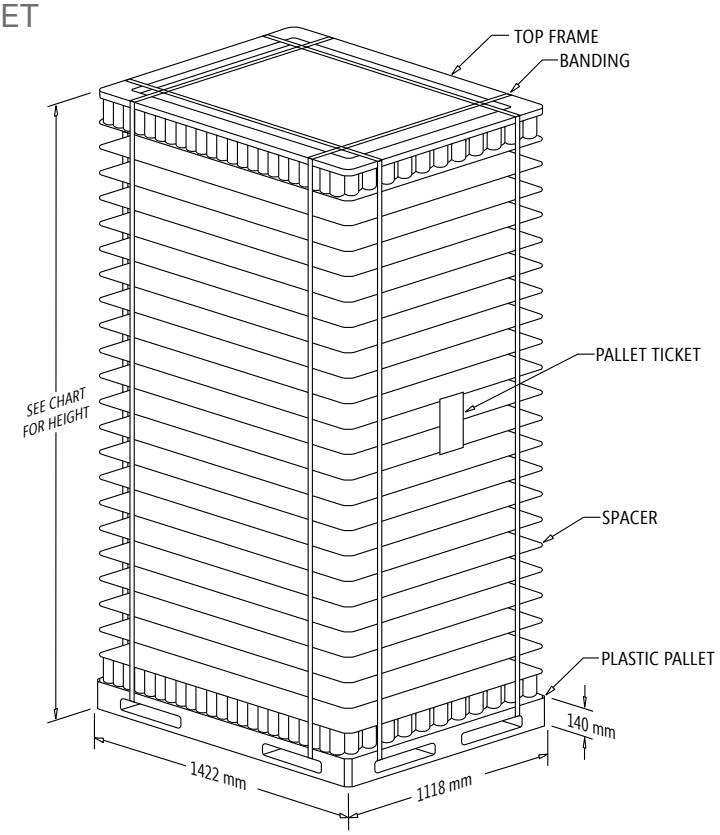
M - Steel frame		Spanish pallet -plastic					
		1420 x 1120 x 140					
	Pallete type	Plastic					
	Frame dimensions	1420x1120					
	Frame type	M, W	M, W	M, W	M, W	M, W	M, W
300 ml	Cans per layer	389	389	389	389	389	389
	Number of layers	22	23	24	25	26	27
	Cans per pallet	8558	8947	9336	9725	10114	10503
	Pallet height incl. pallet	2521	2628	2736	2843	2951	3058

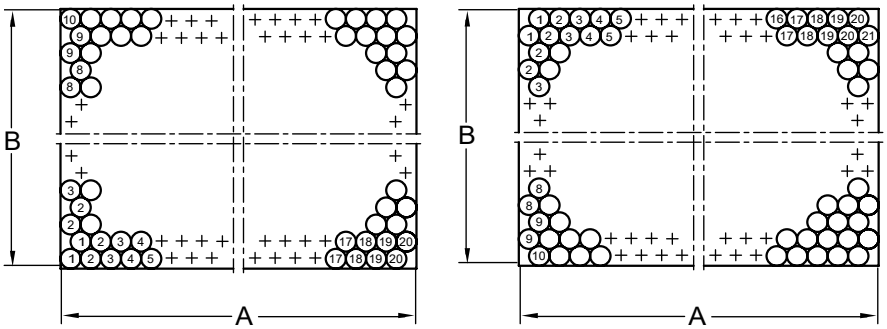
Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	300 ml STD	1.2.68
	Revision: 5	Approved by:	

CAN - PALLETIZATION

1.2.69 330 ML STD - SPANISH PLASTIC PALLET







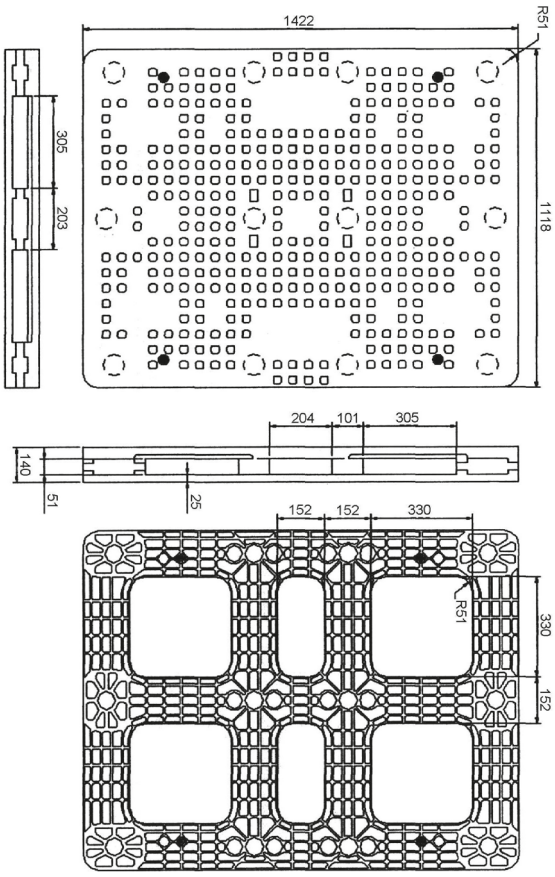
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

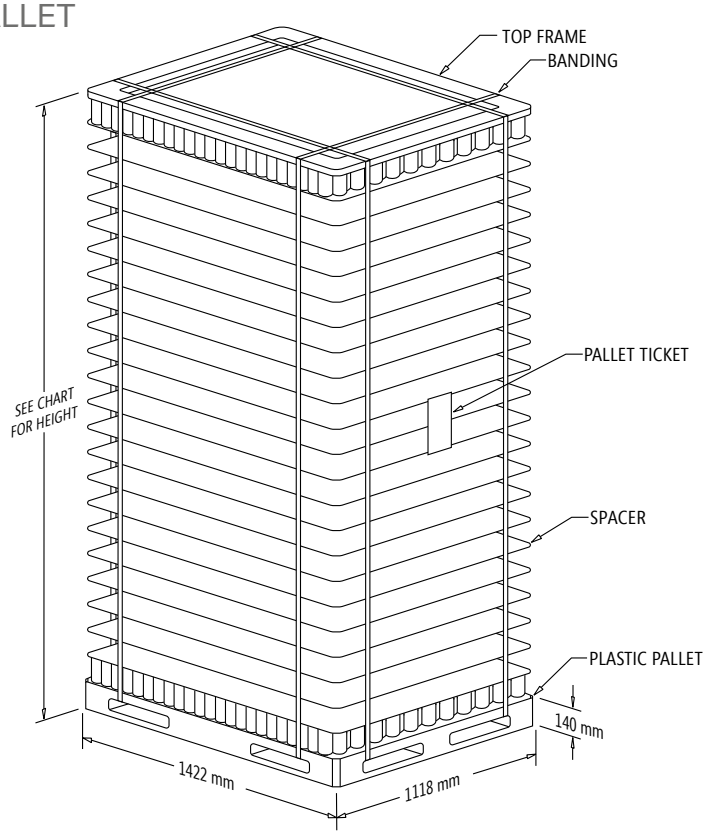
M - Steel frame		Spanish pallet -plastic											
		1420 x 1120 x 140											
	Pallete type	Plastic											
	Frame dimensions	1420x1120											
	Frame type	M, W		M, W		M, W		M, W		M, W		M, W	
330 ml	Cans per layer	380	389	380	389	380	389	380	389	380	389	380	389
	Number of layers	18		19		20		21		22		23	
	Cans per pallet	6840	7002	7220	7391	7600	7780	7980	8169	8360	8558	8740	8947
	Pallet height incl. pallet	2253		2369		2486		2602		2718		2834	

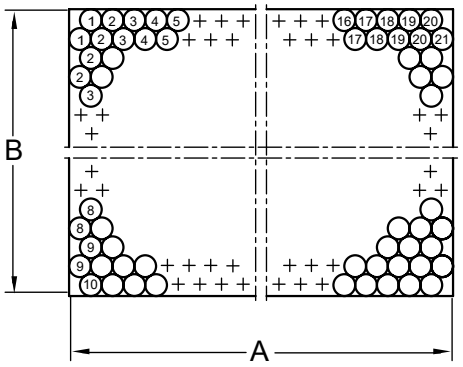
Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	330 ml STD	1.2.69
	Revision: 5	Approved by:	

CAN - PALLETIZATION

1.2.70 350 ML STD - SPANISH PLASTIC PALLET







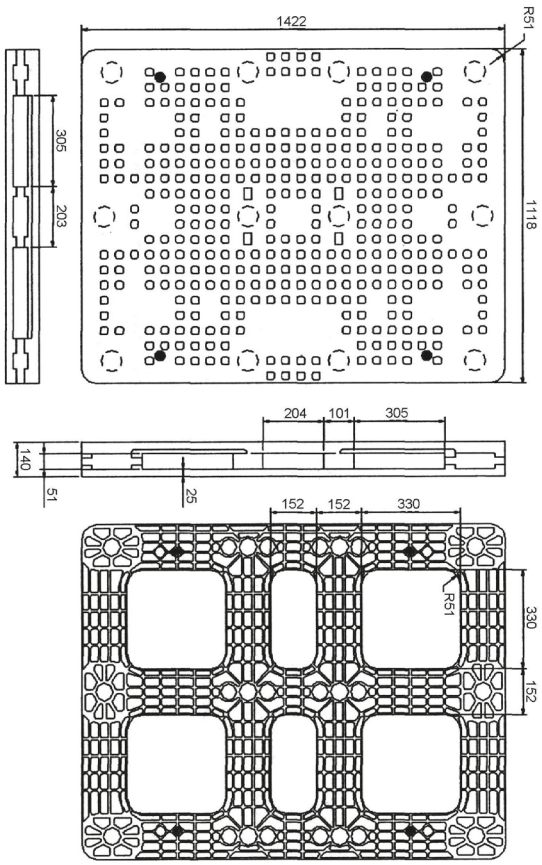
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

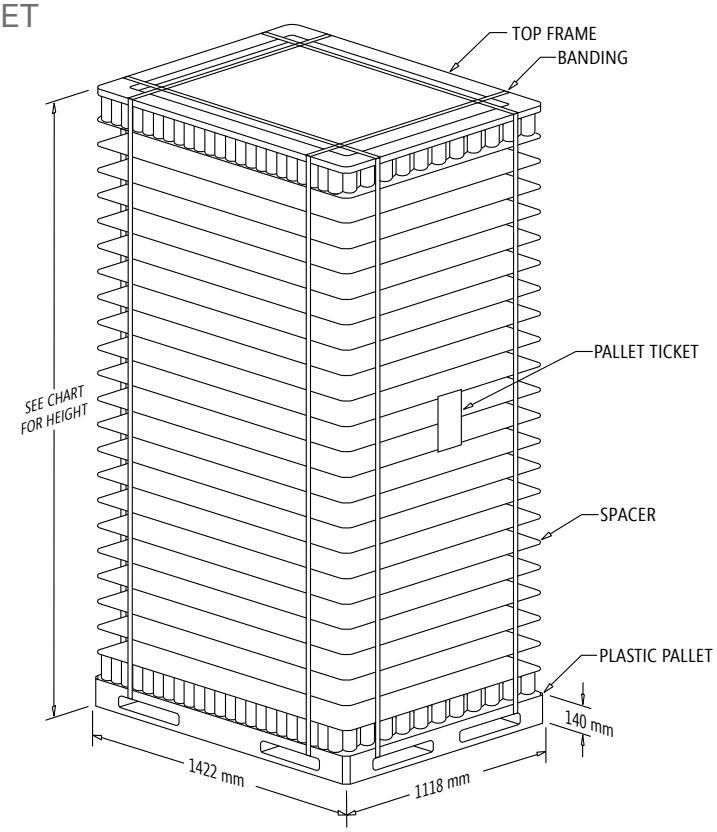
M - Steel frame		Spanish pallet -plastic					
		1420 x 1120 x 140					
	Pallete type	Plastic					
	Frame dimensions	1420x1120					
	Frame type	M, W	M, W	M, W	M, W	M, W	M, W
350 ml	Cans per layer	389	389	389	389	389	389
	Number of layers	17	18	19	20	21	22
	Cans per pallet	6613	7002	7391	7780	8169	8558
	Pallet height incl. pallet	2256	2379	2502	2626	2749	2872

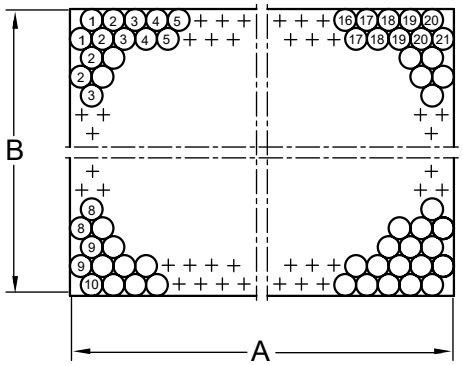
Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	350 ml STD	1.2.70
	Revision: 5	Approved by:	

CAN - PALLETIZATION

1.2.71 355 ML STD - SPANISH PLASTIC PALLET







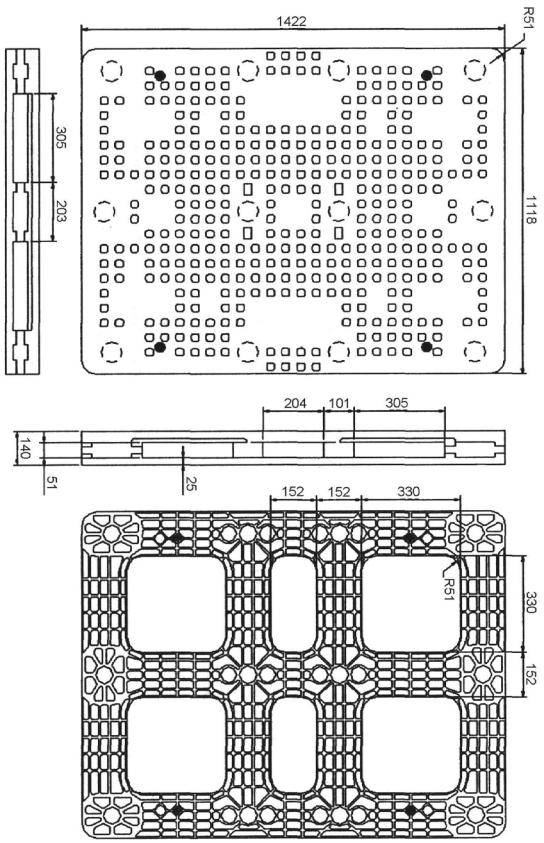
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

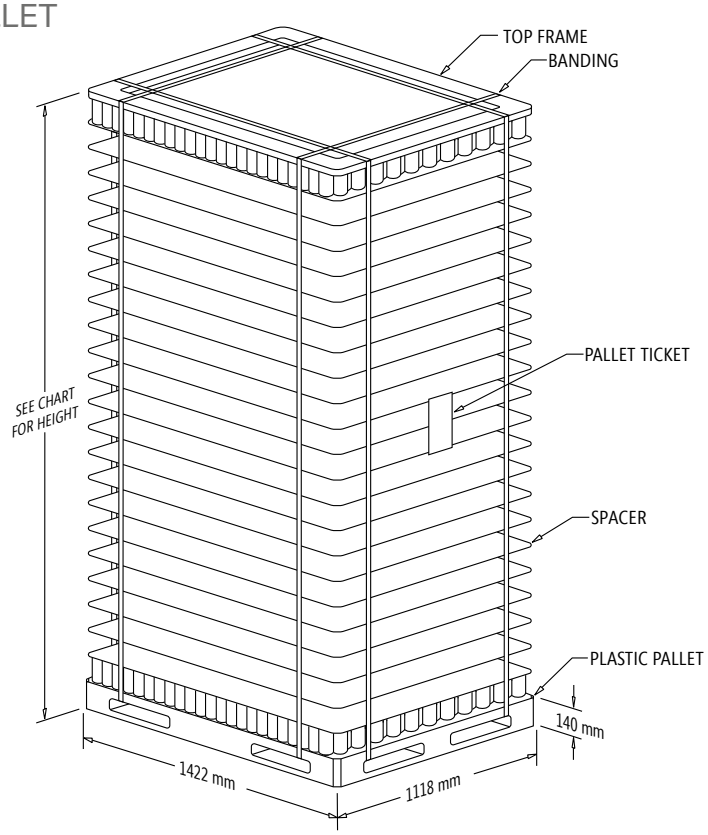
M - Steel frame		Spanish pallet -plastic					
		1420 x 1120 x 140					
	Pallete type	Plastic					
	Frame dimensions	1420x1120					
	Frame type	M, W	M, W	M, W	M, W	M, W	M, W
355 ml	Cans per layer	389	389	389	389	389	389
	Number of layers	17	18	19	20	21	22
	Cans per pallet	6613	7002	7391	7780	8169	8558
	Pallet height incl. pallet	2256	2379	2502	2626	2749	2872

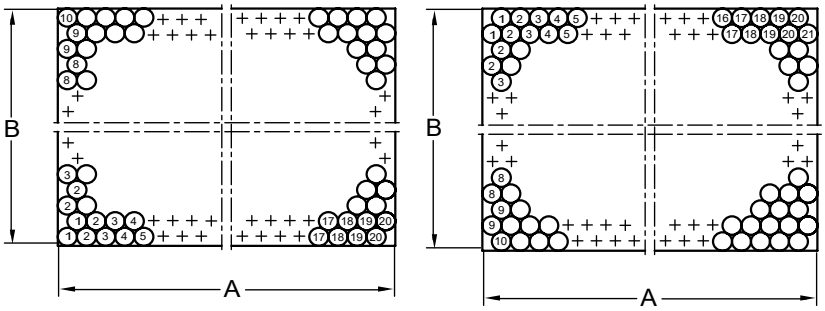
Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	355 ml STD	1.2.71
	Revision: 5	Approved by:	

CAN - PALLETIZATION

1.2.72 440 ML STD - SPANISH PLASTIC PALLET







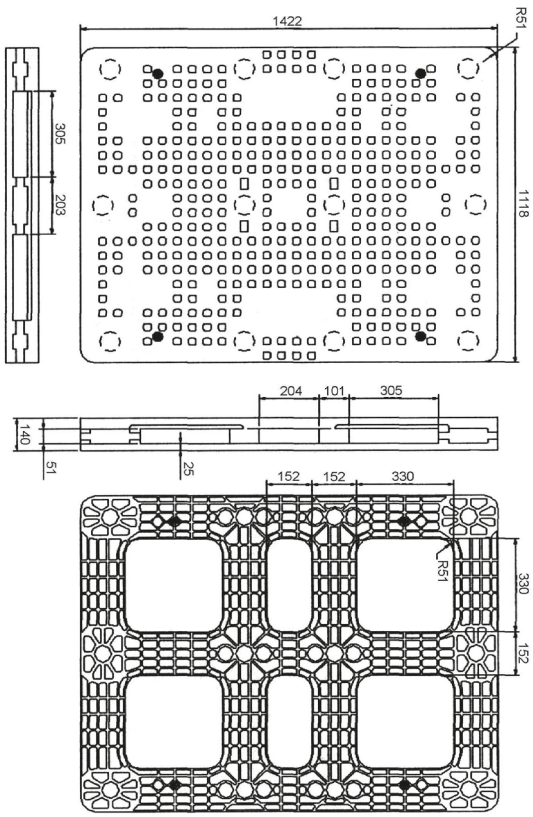
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

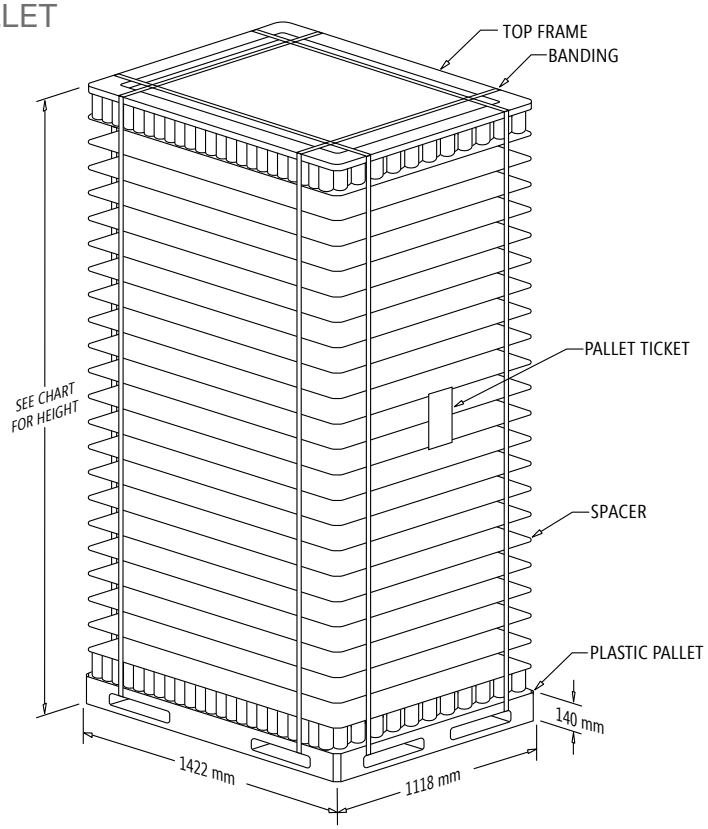
M - Steel frame		Spanish pallet -plastic											
		1420 x 1120 x 140											
	Pallete type	Plastic											
	Frame dimensions	1420x1120											
	Frame type	M, W		M, W		M, W		M, W		M, W		M, W	
440 ml	Cans per layer	380	389	380	389	380	389	380	389	380	389	380	389
	Number of layers	11		12		13		14		15		16	
	Cans per pallet	4180	4279	4560	4668	4940	5057	5320	5446	5700	5835	6080	6224
	Pallet height incl. pallet	1821		1972		2123		2274		2425		2576	

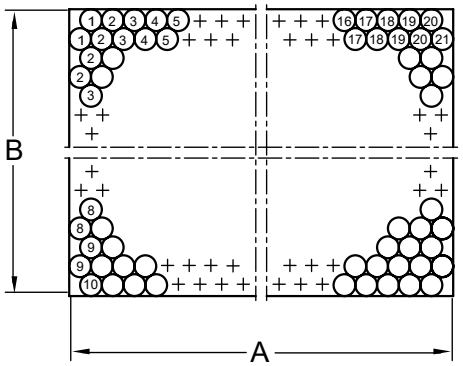
Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	440 ml STD	1.2.72
	Revision: 5	Approved by:	

CAN - PALLETIZATION

1.2.73 473 ML STD - SPANISH PLASTIC PALLET







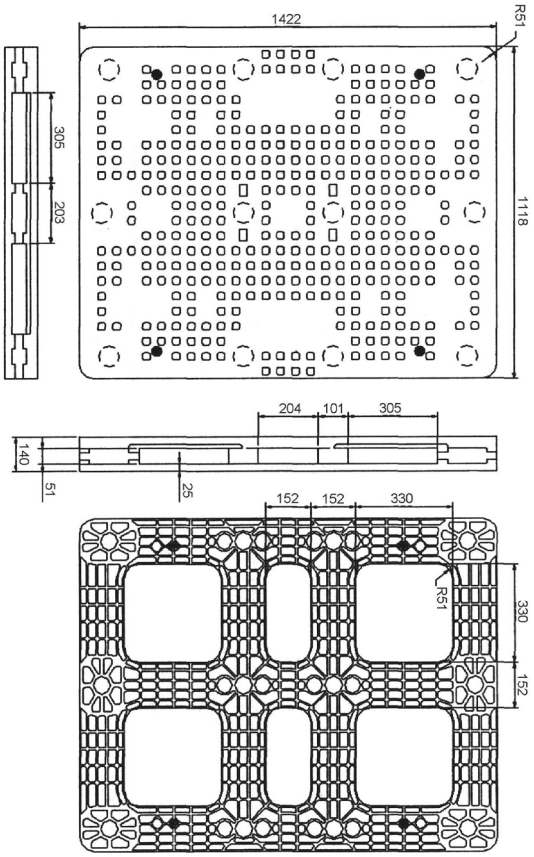
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

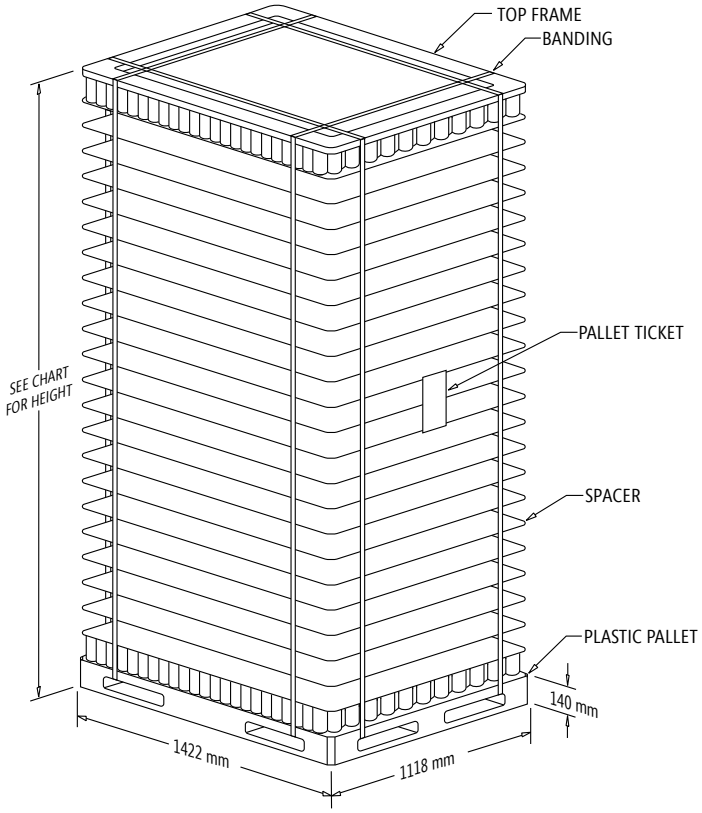
M - Steel frame		Spanish pallet -plastic					
		1420 x 1120 x 140					
	Pallete type	Plastic					
	Frame dimensions	1420x1120					
	Frame type	M, W	M, W	M, W	M, W	M, W	M, W
473 ml	Cans per layer	389	389	389	389	389	389
	Number of layers	11	12	13	14	15	16
	Cans per pallet	4279	4668	5057	5446	5835	6224
	Pallet height incl. pallet	1875	2034	2193	2352	2511	2670

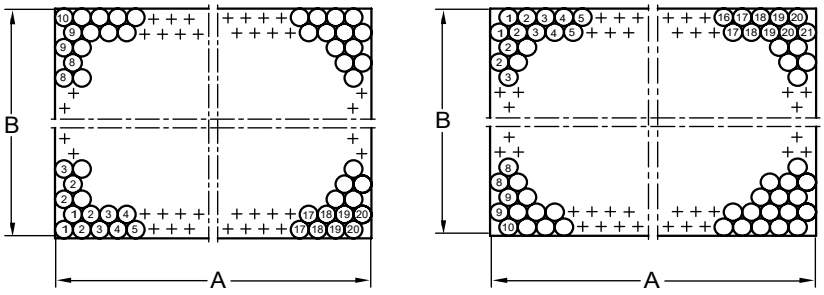
Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	473 ml STD	1.2.73
	Revision: 5	Approved by:	

CAN - PALLETIZATION

1.2.74 500 ML STD - SPANISH PLASTIC PALLET







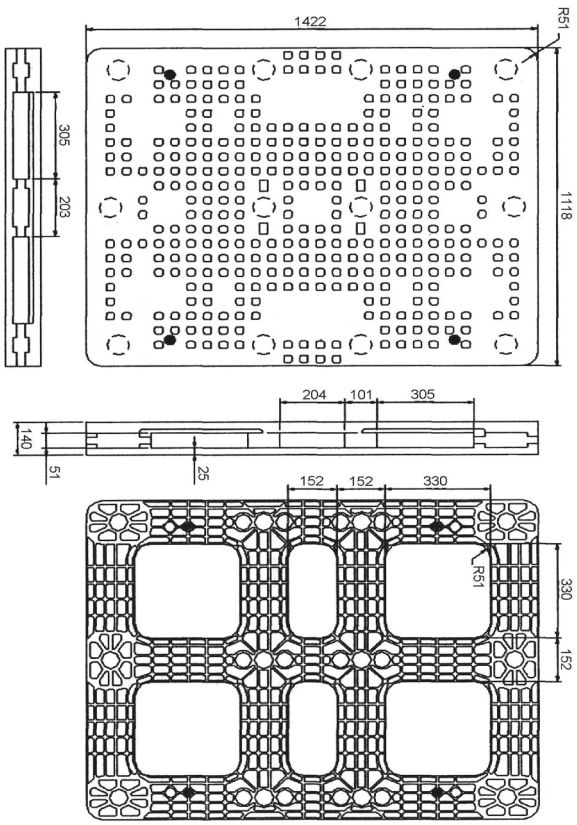
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

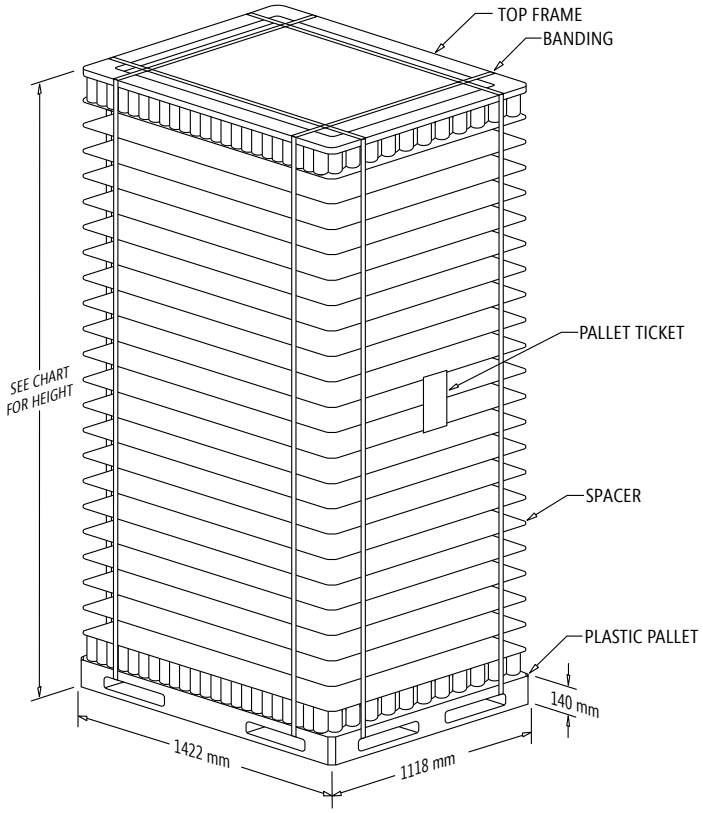
M - Steel frame		Spanish pallet											
		1420 x 1120 x 140											
	Pallete type	Plastic											
	Frame dimensions	1420x1120											
	Frame type	M, W		M, W		M, W		M, W		M, W		M, W	
500 ml	Cans per layer	380	389	380	389	380	389	380	389	380	389	380	389
	Number of layers	11		12		13		14		15		16	
	Cans per pallet	4180	4279	4560	4668	4940	5057	5320	5446	5700	5835	6080	6224
	Pallet height incl. pallet	2021		2190		2359		2528		2697		2866	

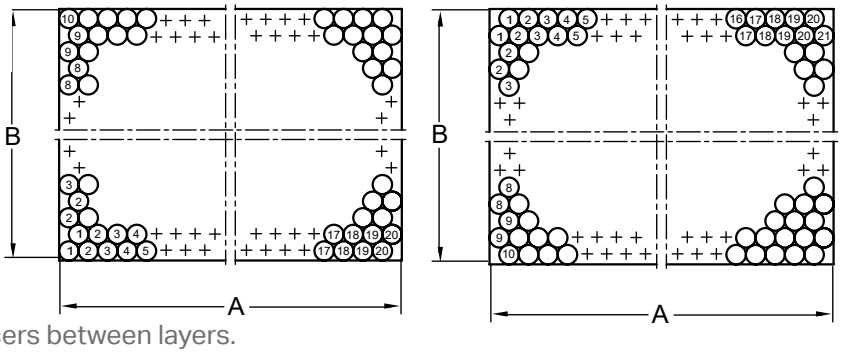
Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	500 ml STD	1.2.74
	Revision: 5	Approved by:	

CAN - PALLETIZATION

1.2.75 550 ML STD - SPANISH PLASTIC PALLET





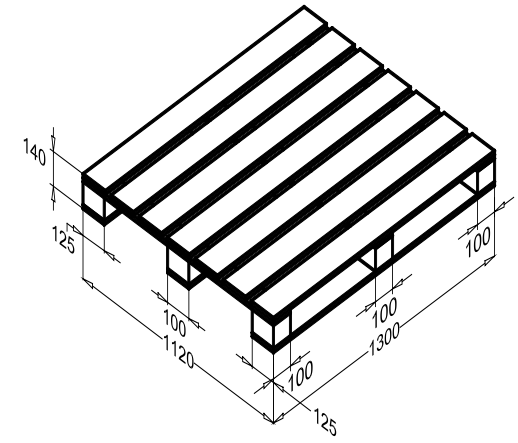


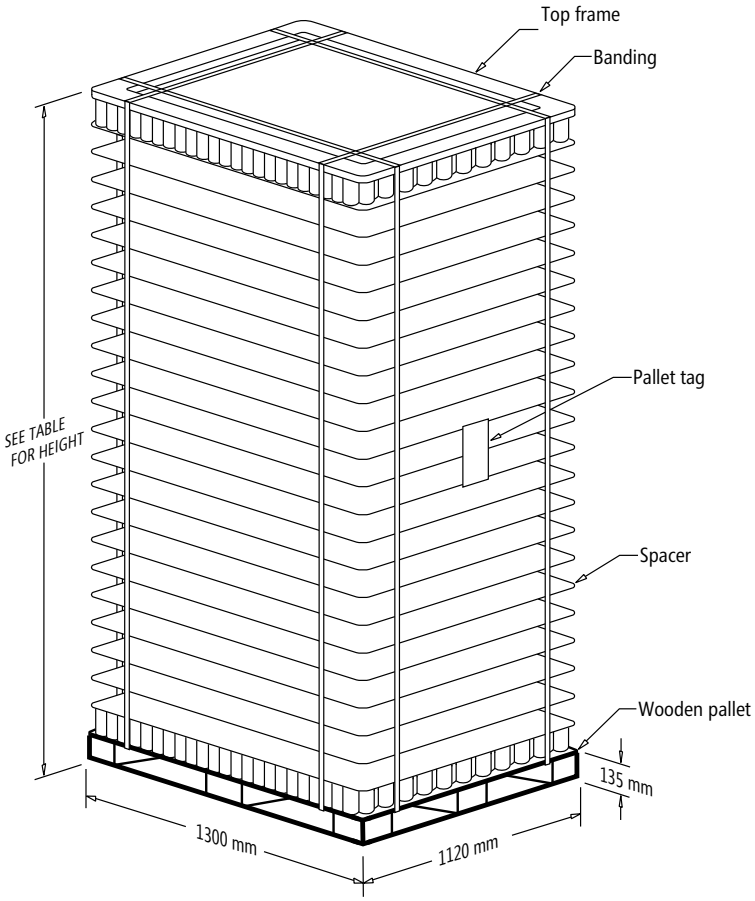
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

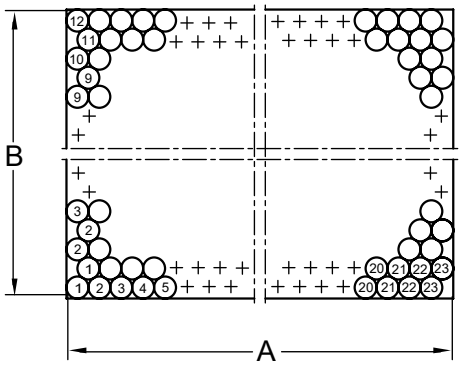
M - Steel frame		Spanish pallet											
		1420 x 1120 x 140											
	Pallete type	Plastic											
	Frame dimensions	1420x1120											
	Frame type	M, W		M, W		M, W		M, W		M, W		M, W	
550 ml	Cans per layer	380	389	380	389	380	389	380	389	380	389	380	389
	Number of layers	10		11		12		13		14		15	
	Cans per pallet	3800	3890	4180	4279	4560	4668	4940	5057	5320	5446	5700	5835
	Pallet height incl. pallet	1998		2182		2365		2549		2733		2916	

Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	550 ml STD	1.2.75
	Revision: 5	Approved by:	

1.2.76 150 ML SLIM - U.K. PALLET







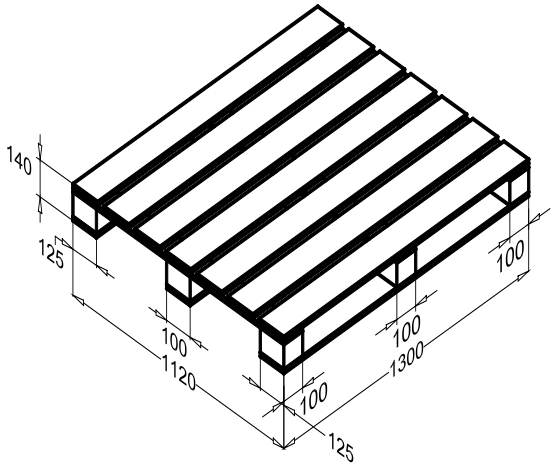
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

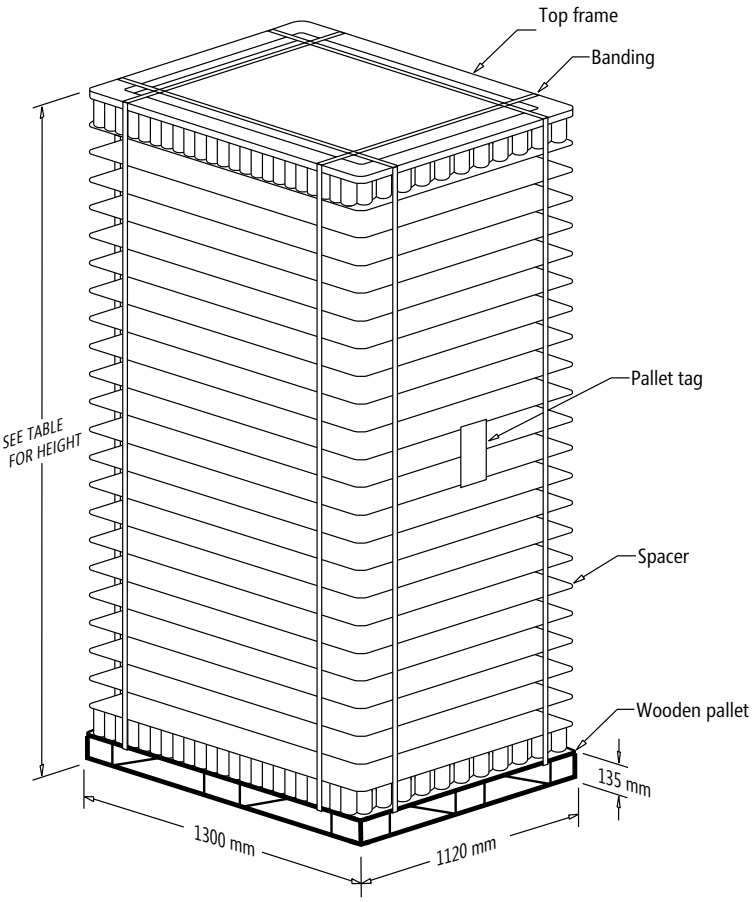
W- Wood frame		U.K. pallet					
		1300 x 1120 x 140					
	Pallete type	Wood					
	Frame dimensions	1300 x 1120					
	Frame type	W	W	W	W	W	W
150 ml	Cans per layer	529	529	529	529	529	529
	Number of layers	26	27	28	29	30	31
	Cans per pallet	13754	14283	14812	15341	15870	16399
	Pallet height incl. pallet	2491	2581	2670	2759	2849	2938

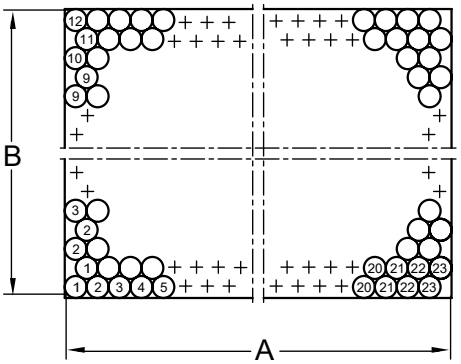
Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	150 ml Slim	1.2.76
	Revision: 5	Approved by:	

CAN - PALLETIZATION

1.2.77 200 ML SLIM - U.K. PALLET







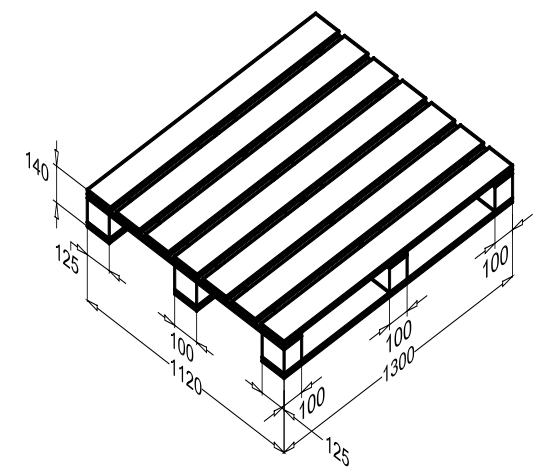
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

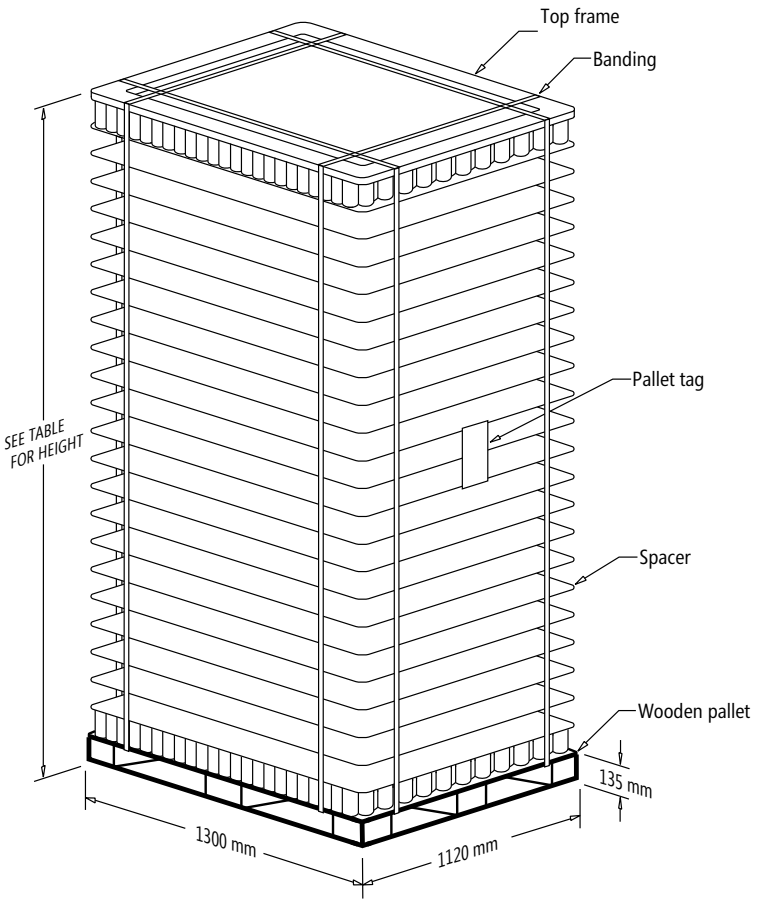
W- Wood frame		U.K. pallet					
		1300 x 1120 x 140					
	Pallete type	Wood					
	Frame dimensions	1300 x 1120					
	Frame type	W	W	W	W	W	W
200 ml	Cans per layer	529	529	529	529	529	529
	Number of layers	20	21	22	23	24	25
	Cans per pallet	10580	11109	11638	12167	12696	13225
	Pallet height incl. pallet	2414	2526	2638	2750	2862	2975

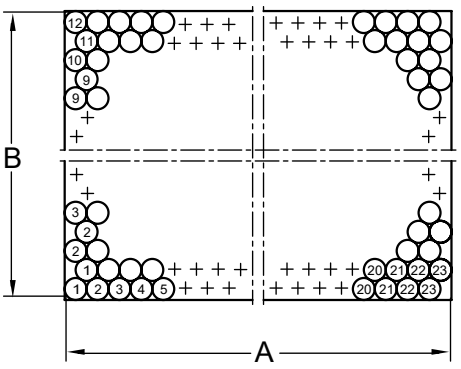
Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	200 ml Slim	1.2.77
	Revision: 5	Approved by:	

CAN - PALLETIZATION

1.2.78 250 ML SLIM - U.K. PALLET







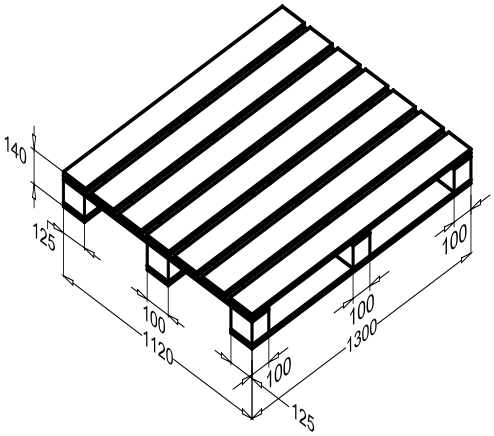
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

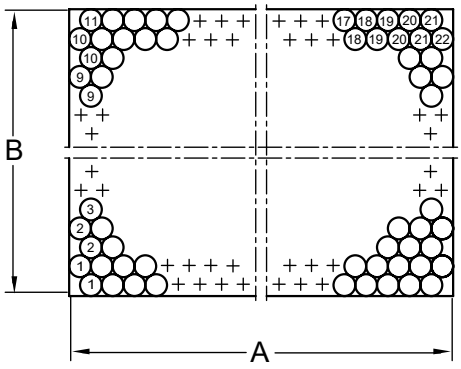
W- Wood frame		U.K. pallet					
		1300 x 1120 x 140					
	Pallete type	Wood					
	Frame dimensions	1300 x 1120					
	Frame type	W	W	W	W	W	W
250 ml	Cans per layer	529	529	529	529	529	529
	Number of layers	15	16	17	18	19	20
	Cans per pallet	7935	8464	8993	9522	10051	10580
	Pallet height incl. pallet	2195	2330	2465	2600	2735	2870

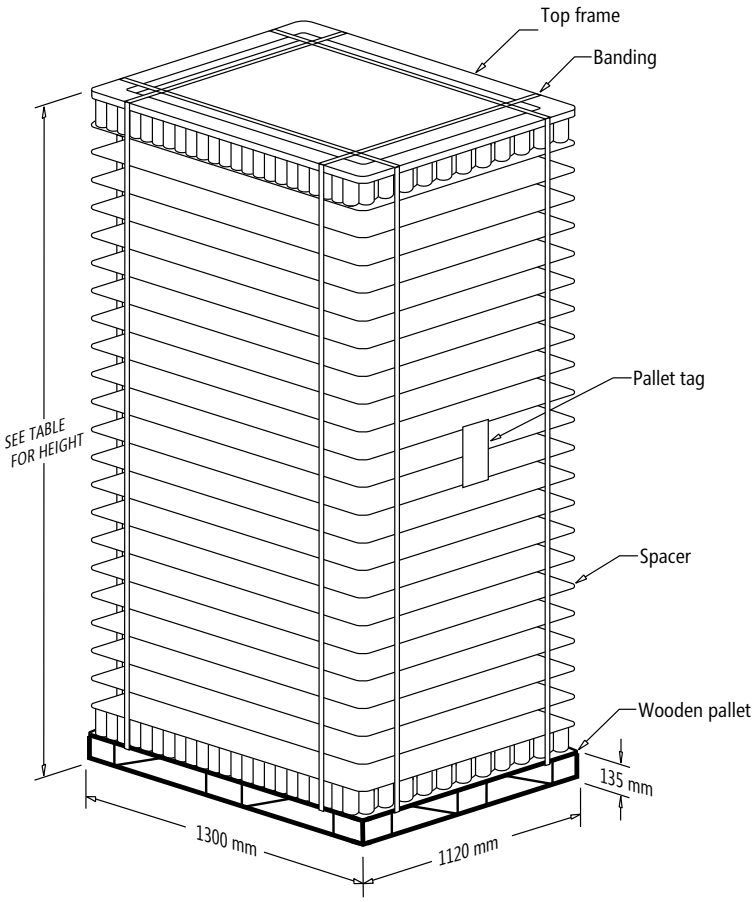
Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	250 ml Slim	1.2.78
	Revision: 5	Approved by:	

CAN - PALLETIZATION

1.2.79 330 ML FIT - U.K. PALLET







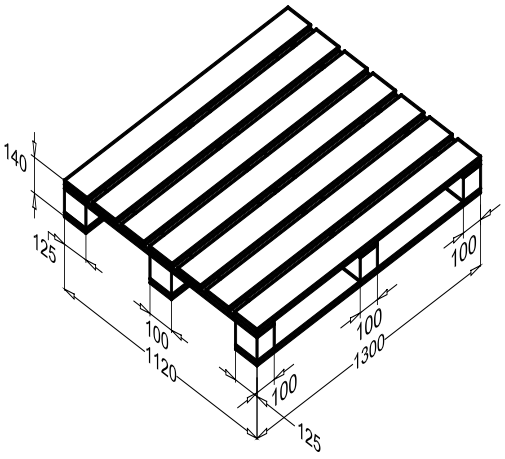
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

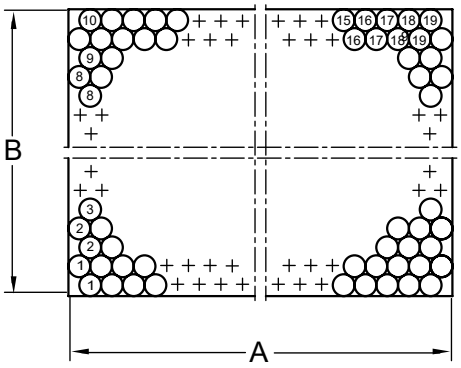
W- Wood frame		U.K. pallet					
		1300 x 1120 x 140					
	Pallete type	Wood					
	Frame dimensions	1300 x 1120					
	Frame type	W	W	W	W	W	W
330 ml	Cans per layer	451	451	451	451	451	451
	Number of layers	14	15	16	17	18	19
	Cans per pallet	6314	6765	7216	7667	8118	8569
	Pallet height incl. pallet	2206	2351	2497	2642	2788	2933

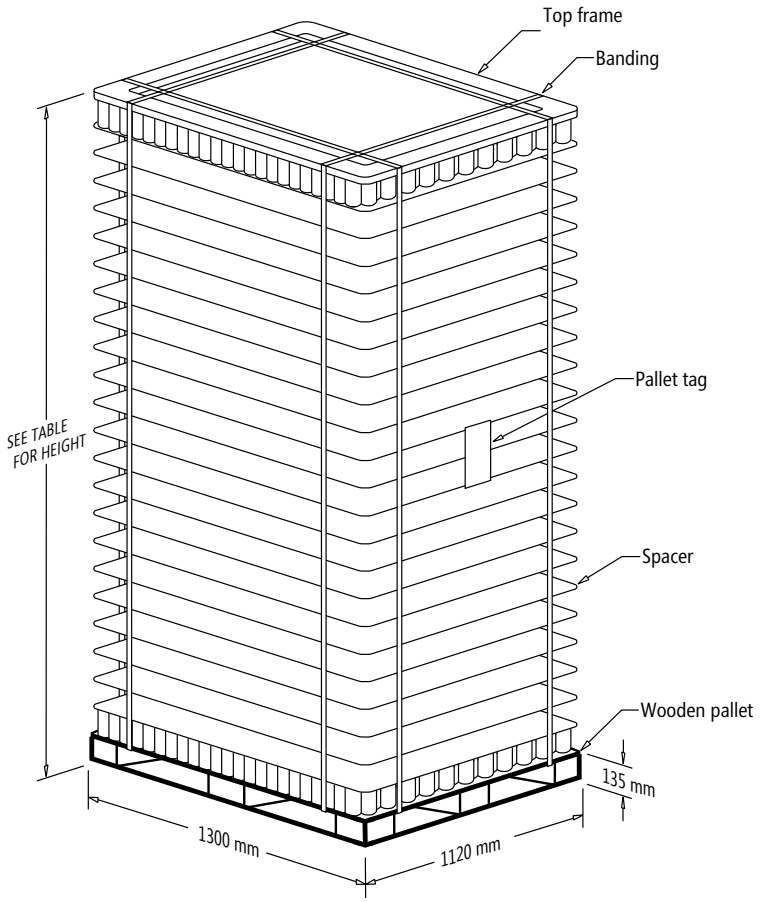
Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	330 ml FIT	1.2.79
	Revision: 5	Approved by:	

CAN - PALLETIZATION

1.2.80 449 ML LONGFIT - U.K. PALLET







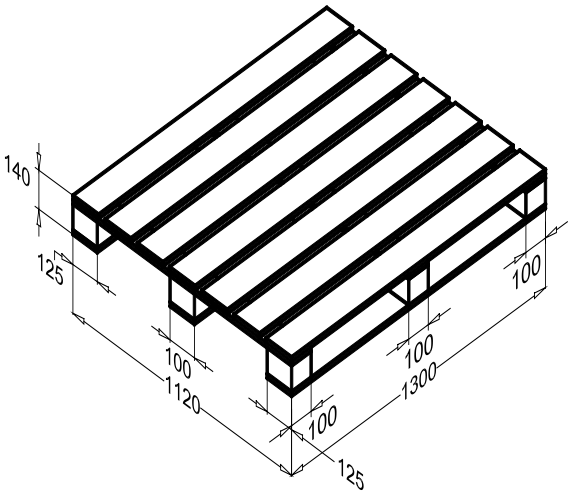
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

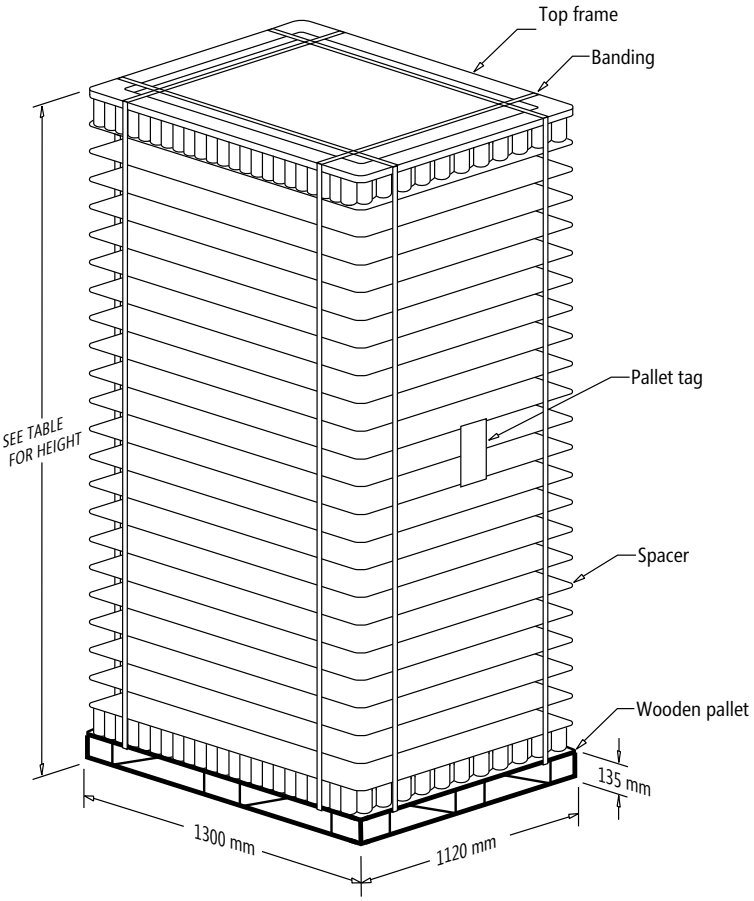
W- Wood frame		U.K. pallet					
		1300 x 1120 x 140					
	Pallete type	Wood					
	Frame dimensions	1300 x 1120					
	Frame type	W	W	W	W	W	W
449 ml	Cans per layer	370	370	370	370	370	370
	Number of layers	11	12	13	14	15	16
	Cans per pallet	4070	4440	4810	5180	5550	5920
	Pallet height incl. pallet	2029	2198	2367	2536	2705	2874

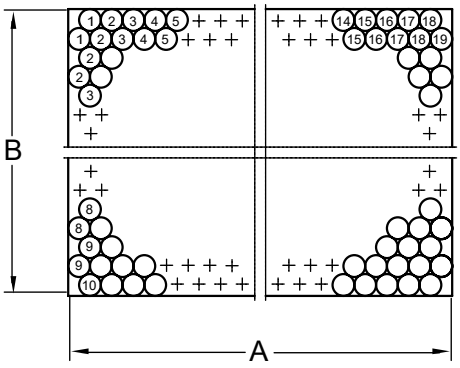
Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	449 ml LongFIT	1.2.80
	Revision: 5	Approved by:	

CAN - PALLETIZATION

1.2.81 330 ML STD - U.K. PALLET







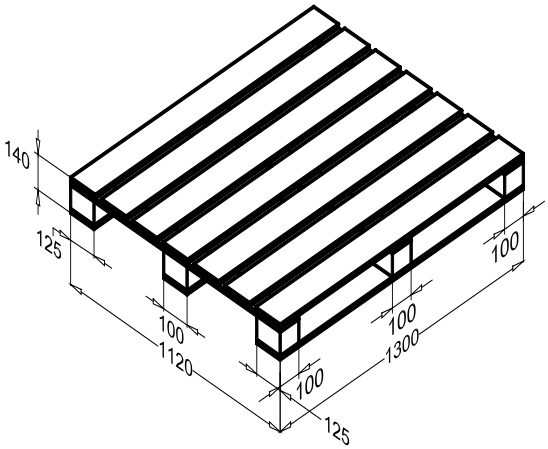
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

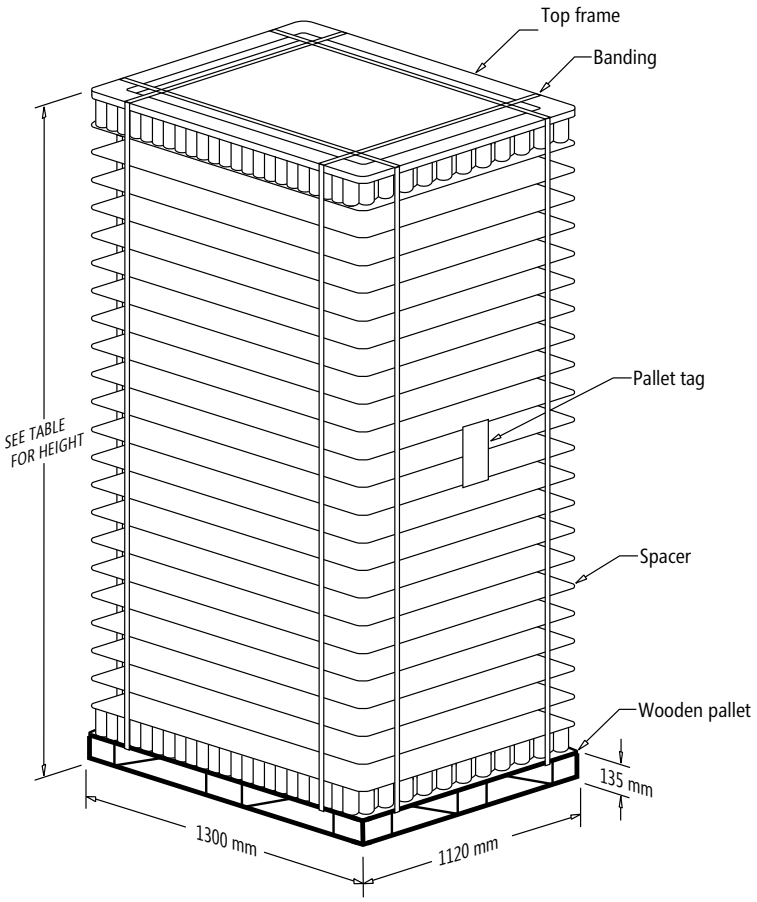
W- Wood frame		U.K. pallet					
		1300 x 1120 x 140					
	Pallete type	Wood					
	Frame dimensions	1300 x 1120					
	Frame type	W	W	W	W	W	W
330 ml	Cans per layer	351	351	351	351	351	351
	Number of layers	18	19	20	21	22	23
	Cans per pallet	6318	6669	7020	7371	7722	8073
	Pallet height incl. pallet	2261	2377	2494	2600	2716	2832

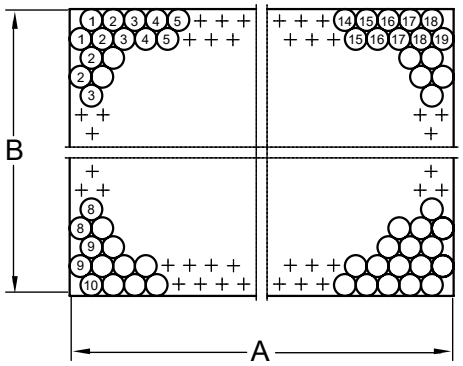
Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	330 ml STD	1.2.81
	Revision: 5	Approved by:	

CANPACK

1.2.82 440 ML STD - U.K. PALLET







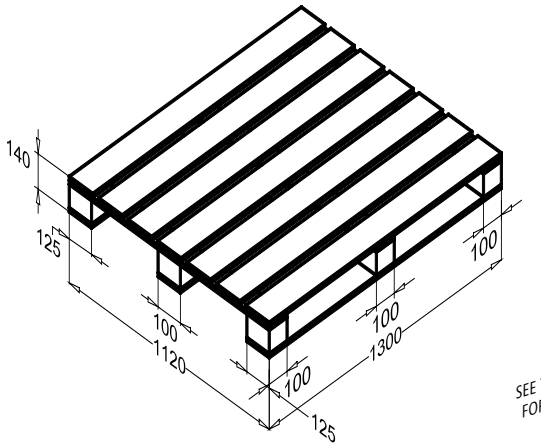
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

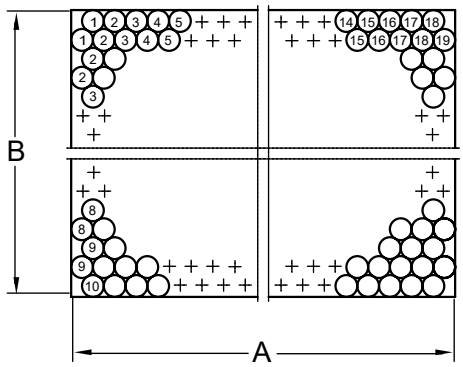
W- Wood frame		U.K. pallet					
		1300 x 1120 x 140					
	Pallete type	Wood					
	Frame dimensions	1300 x 1120					
	Frame type	W	W	W	W	W	W
440 ml	Cans per layer	351	351	351	351	351	351
	Number of layers	13	14	15	16	17	18
	Cans per pallet	4563	4914	5265	5616	5967	6318
	Pallet height incl. pallet	2131	2282	2433	2584	2735	2886

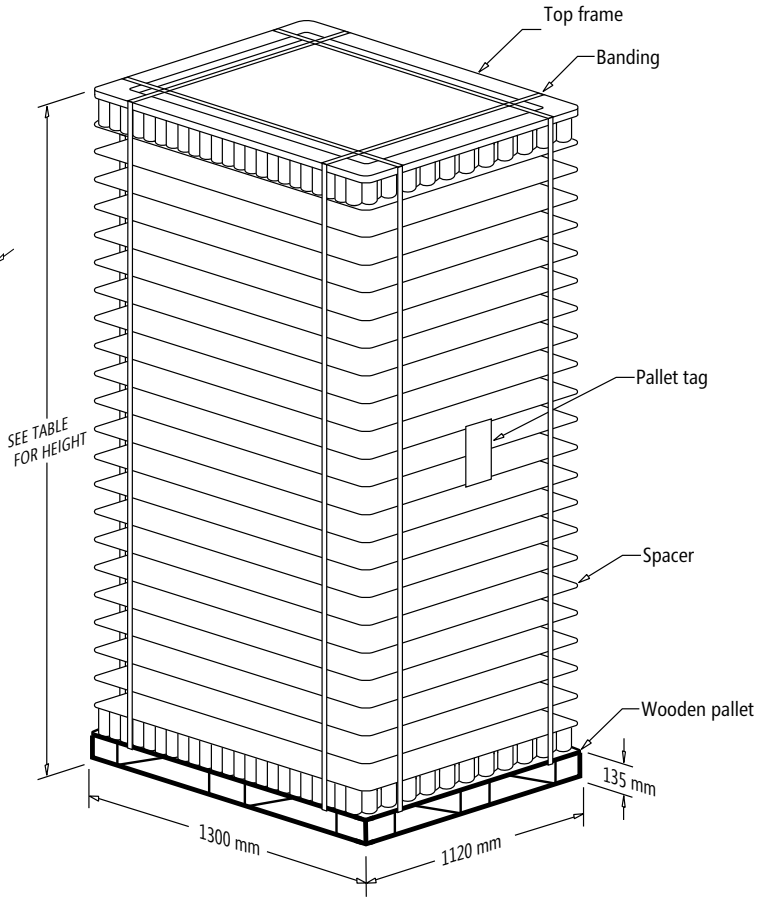
Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	440 ml STD	1.2.82
	Revision: 5	Approved by:	

CAN - PALLETIZATION

1.2.83 500 ML STD - U.K. PALLET





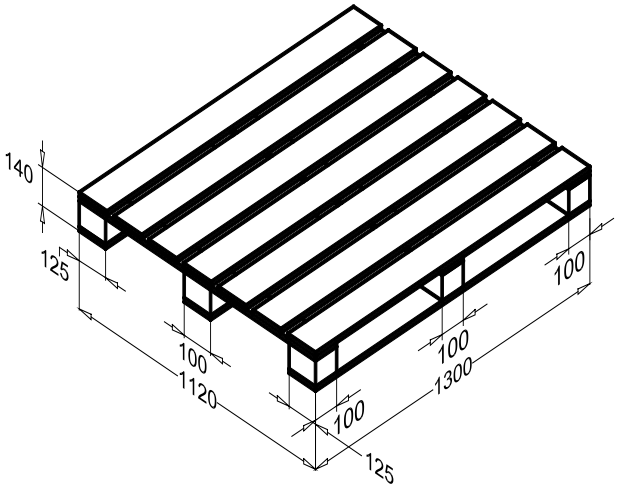


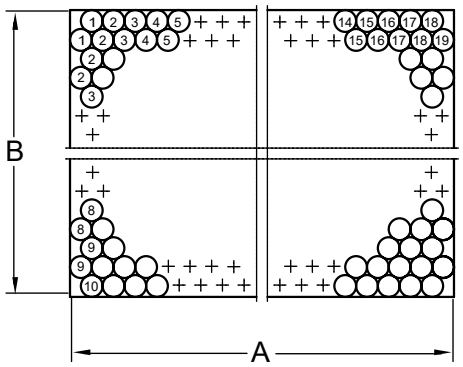
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

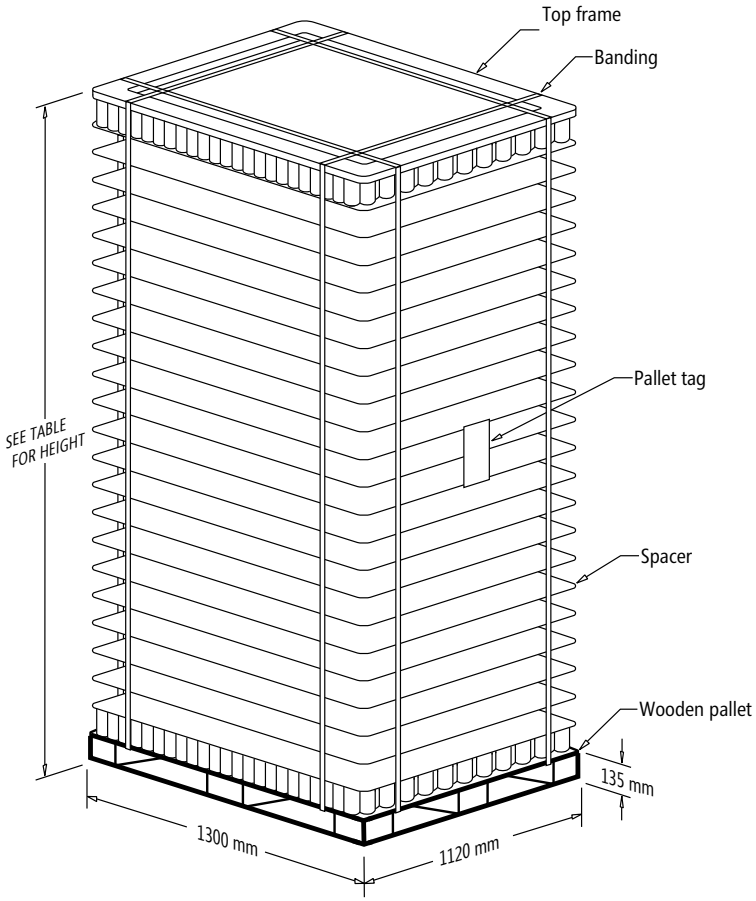
W- Wood frame		U.K. pallet					
		1300 x 1120 x 140					
	Pallete type	Wood					
	Frame dimensions	1300 x 1120					
	Frame type	W	W	W	W	W	W
500 ml	Cans per layer	351	351	351	351	351	351
	Number of layers	11	12	13	14	15	16
	Cans per pallet	3861	4212	4563	4914	5265	5616
	Pallet height incl. pallet	2029	2198	2367	2536	2705	2874

Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	500 ml STD	1.2.83
	Revision: 5	Approved by:	

1.2.84 550 ML STD - U.K. PALLET







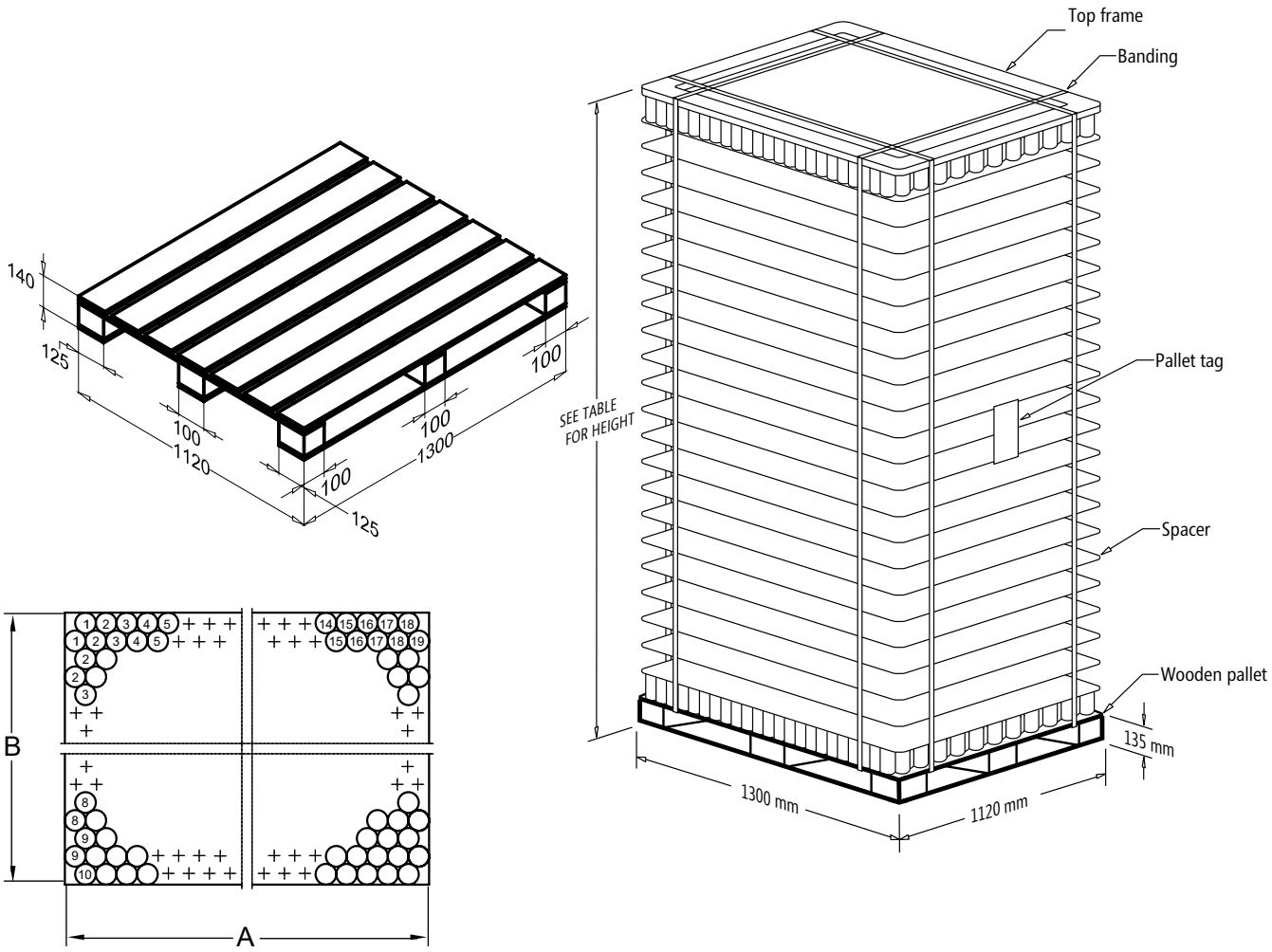
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

W- Wood frame		U.K. pallet					
		1300 x 1120 x 140					
	Pallete type	Wood					
	Frame dimensions	1300 x 1120					
	Frame type	W	W	W	W	W	W
550 ml	Cans per layer	351	351	351	351	351	351
	Number of layers	10	11	12	13	14	15
	Cans per pallet	3510	3861	4212	4563	4914	5265
	Pallet height incl. pallet	2006	2190	2373	2557	2741	2924

Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	550 ml STD	1.2.84
	Revision: 5	Approved by:	

CAN - PALLETIZATION

1.2.85 568 ML STD - U.K. PALLET



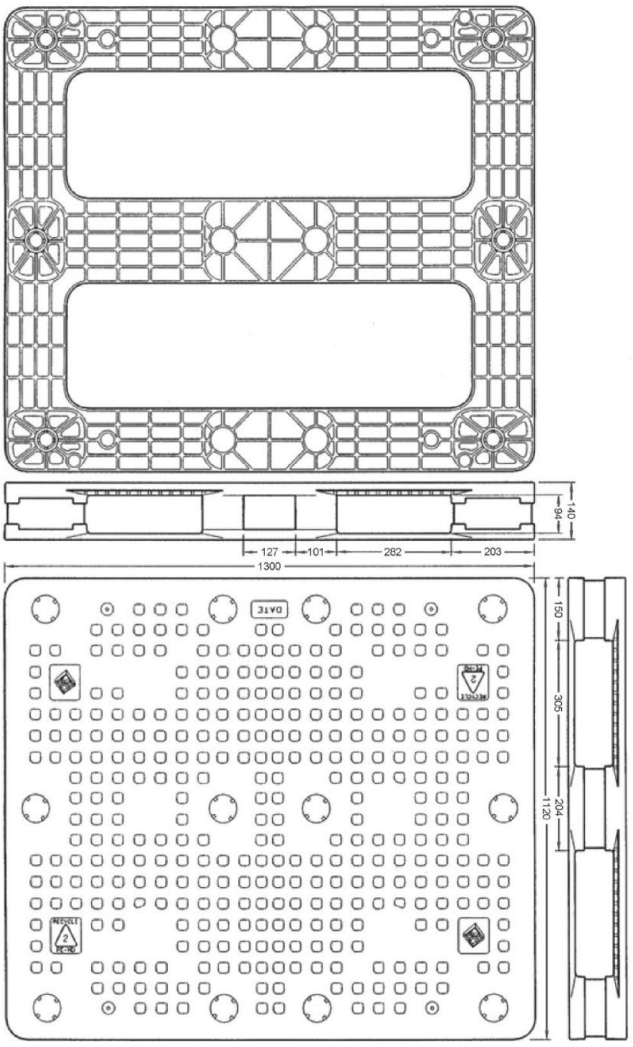
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

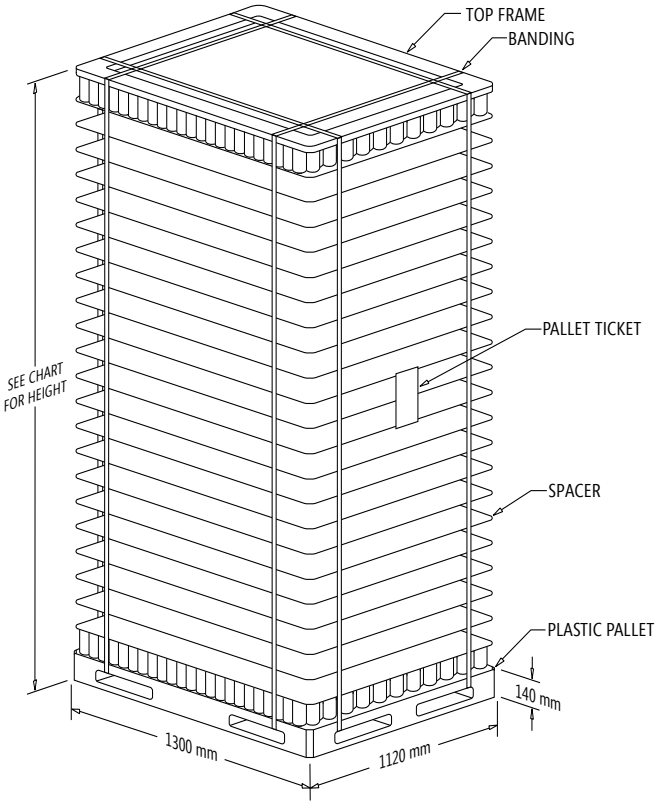
W- Wood frame		U.K. pallet					
		1300 x 1120 x 140					
	Pallete type	Wood					
	Frame dimensions	1300 x 1120					
	Frame type	W	W	W	W	W	W
568ml	Cans per layer	351	351	351	351	351	351
	Number of layers	10	11	12	13	14	15
	Cans per pallet	3510	3861	4212	4563	4914	5265
	Pallet height incl. pallet	2061	2250	2440	2630	2820	3007

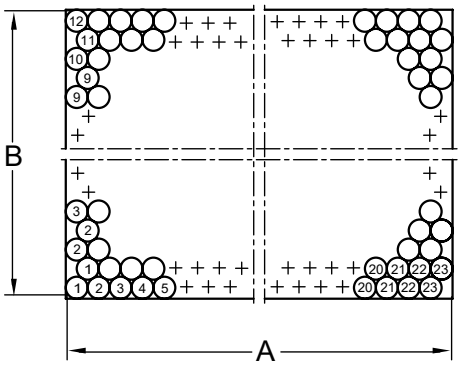
Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	568 ml STD	1.2.85
	Revision: 5	Approved by:	

CANPACK

1.2.86 150 ML SLIM - U.K. PLASTIC PALLET







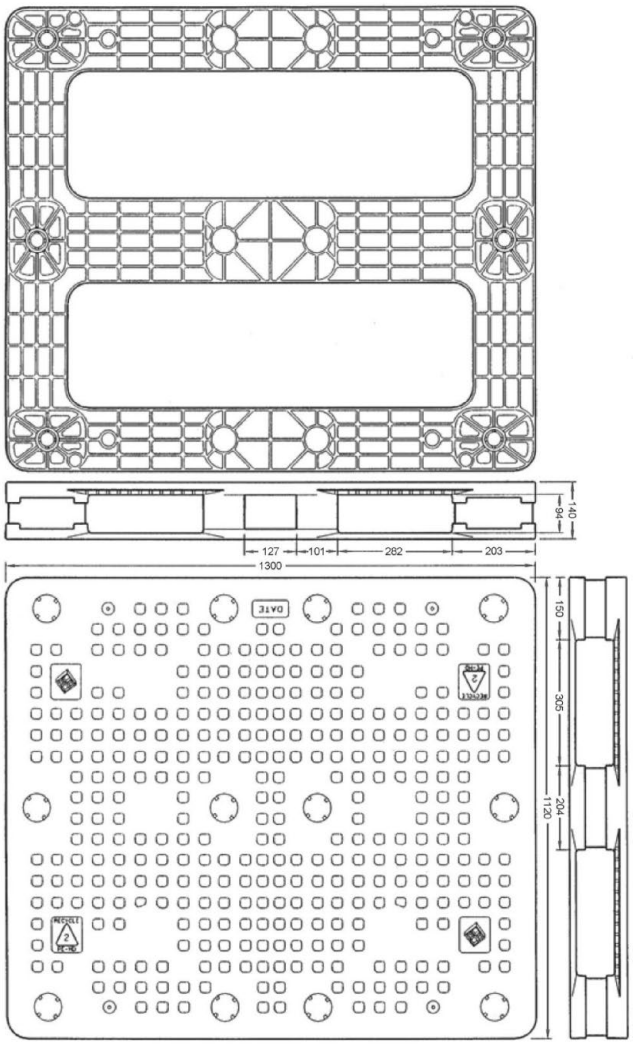
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

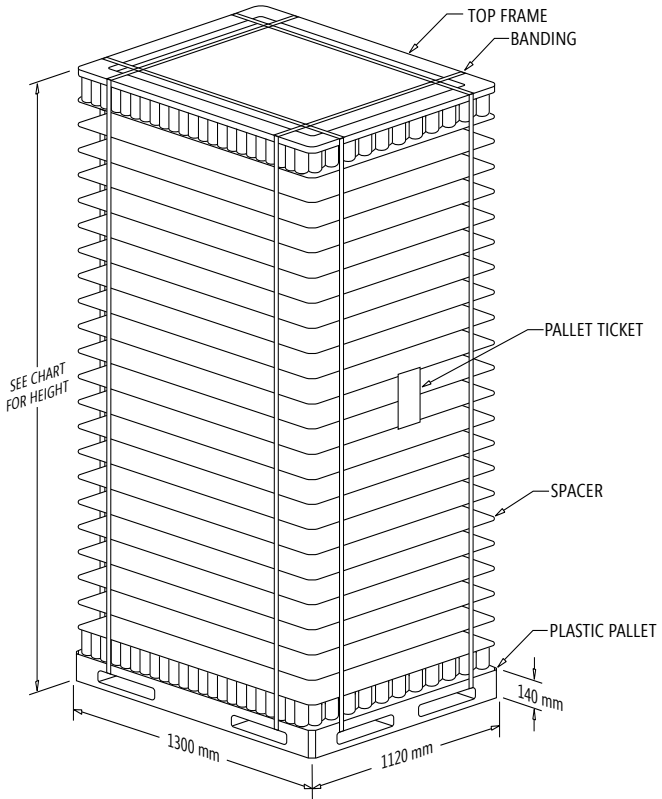
P- Plastic frame		U.K. pallet					
		1300 x 1120 x 140					
	Pallete type	Plastic					
	Frame dimensions	1300 x 1120					
	Frame type	P	P	P	P	P	P
150 ml	Cans per layer	529	529	529	529	529	529
	Number of layers	26	27	28	29	30	31
	Cans per pallet	13754	14283	14812	15341	15870	16399
	Pallet height incl. pallet	2491	2581	2670	2759	2849	2938

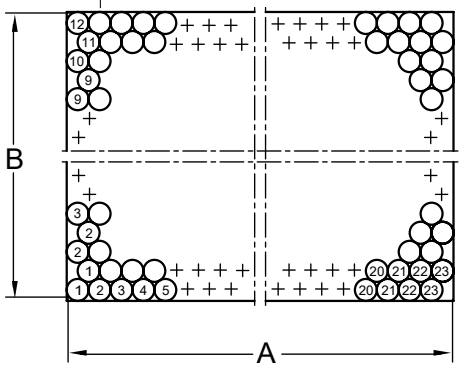
Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	150 ml Slim	1.2.86
	Revision: 5	Approved by:	

CAN - PALLETIZATION

1.2.87 200 ML SLIM - U.K. PLASTIC PALLET







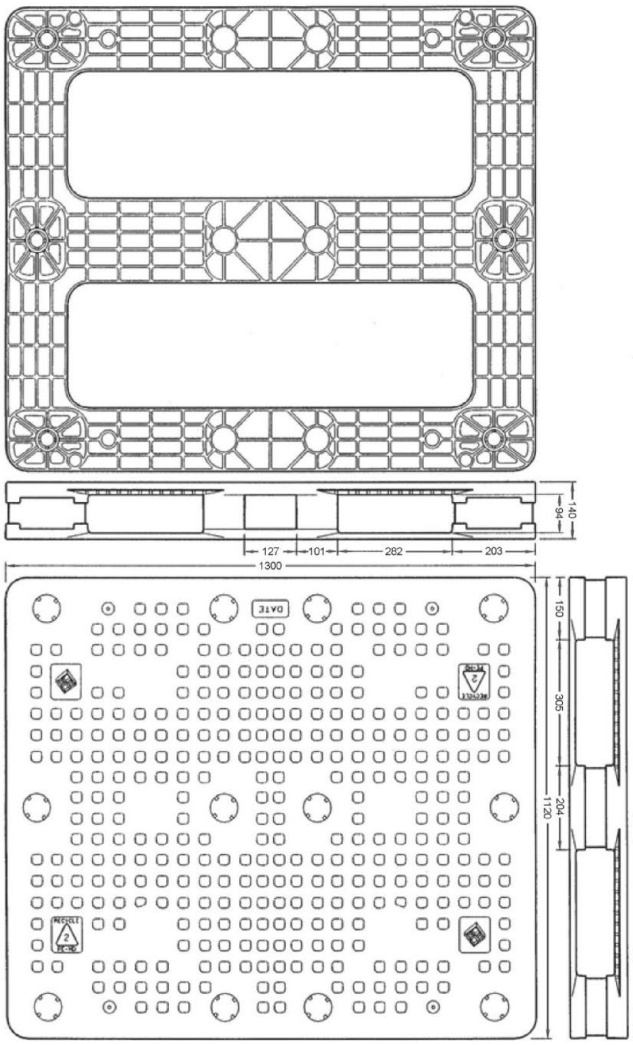
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

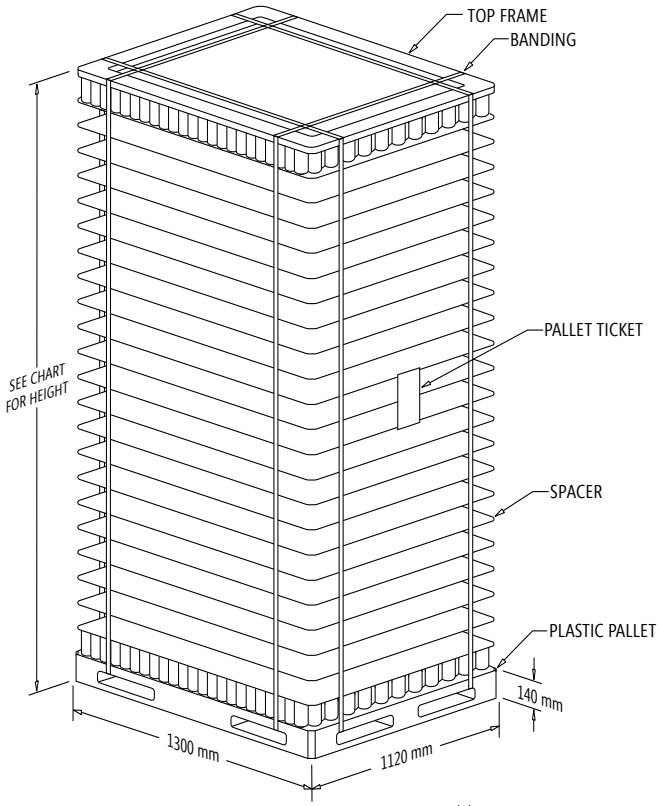
P- Plastic frame		U.K. pallet					
		1300 x 1120 x 140					
	Pallete type	Plastic					
	Frame dimensions	1300 x 1120					
	Frame type	P	P	P	P	P	P
200 ml	Cans per layer	529	529	529	529	529	529
	Number of layers	20	21	22	23	24	25
	Cans per pallet	10580	11109	11638	12167	12696	13225
	Pallet height incl. pallet	2414	2526	2638	2750	2862	2975

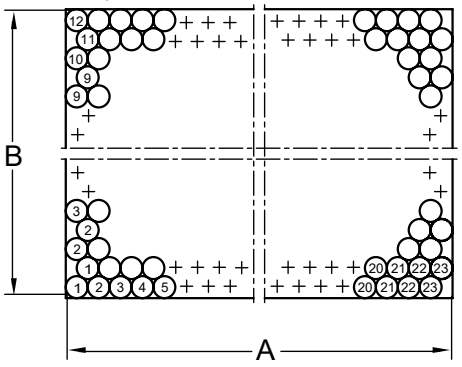
Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	200 ml Slim	1.2.87
	Revision: 5	Approved by:	

CAN - PALLETIZATION

1.2.88 250 ML SLIM - U.K. PLASTIC PALLET







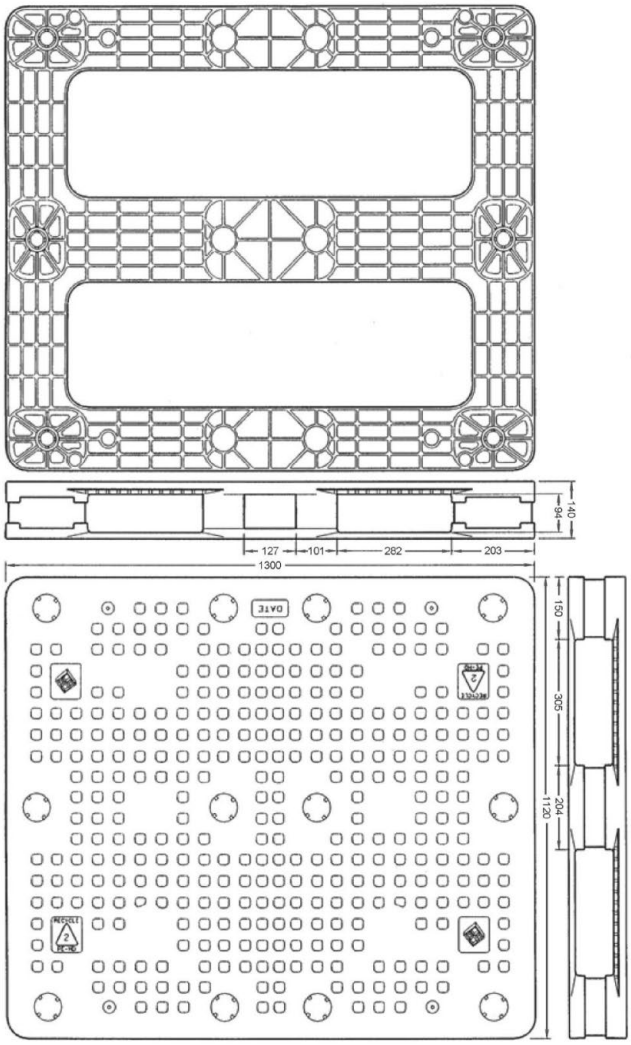
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

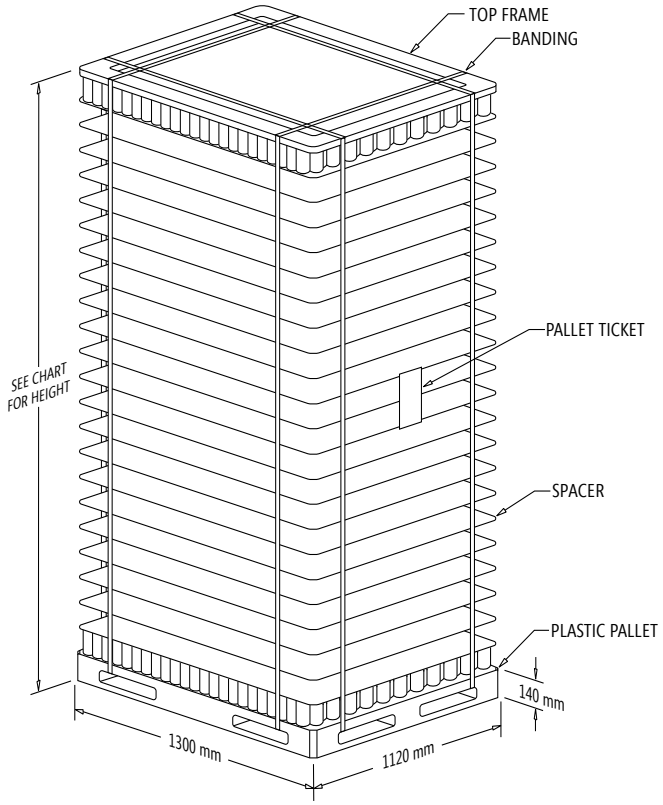
P- Plastic frame		U.K. pallet					
		1300 x 1120 x 140					
	Pallete type	Plastic					
	Frame dimensions	1300 x 1120					
	Frame type	P	P	P	P	P	P
250 ml	Cans per layer	529	529	529	529	529	529
	Number of layers	15	16	17	18	19	20
	Cans per pallet	7935	8464	8993	9522	10051	10580
	Pallet height incl. pallet	2195	2330	2465	2600	2735	2870

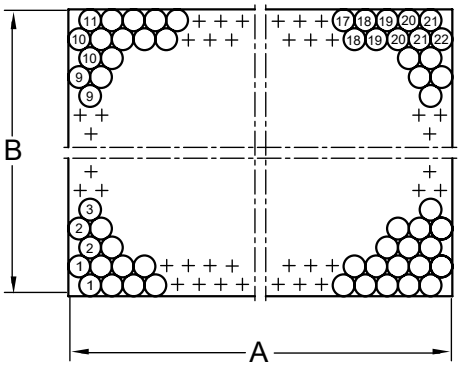
Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	250 ml Slim	1.2.88
	Revision: 5	Approved by:	

CAN - PALLETIZATION

1.2.89 330 ML FIT - U.K. PLASTIC PALLET





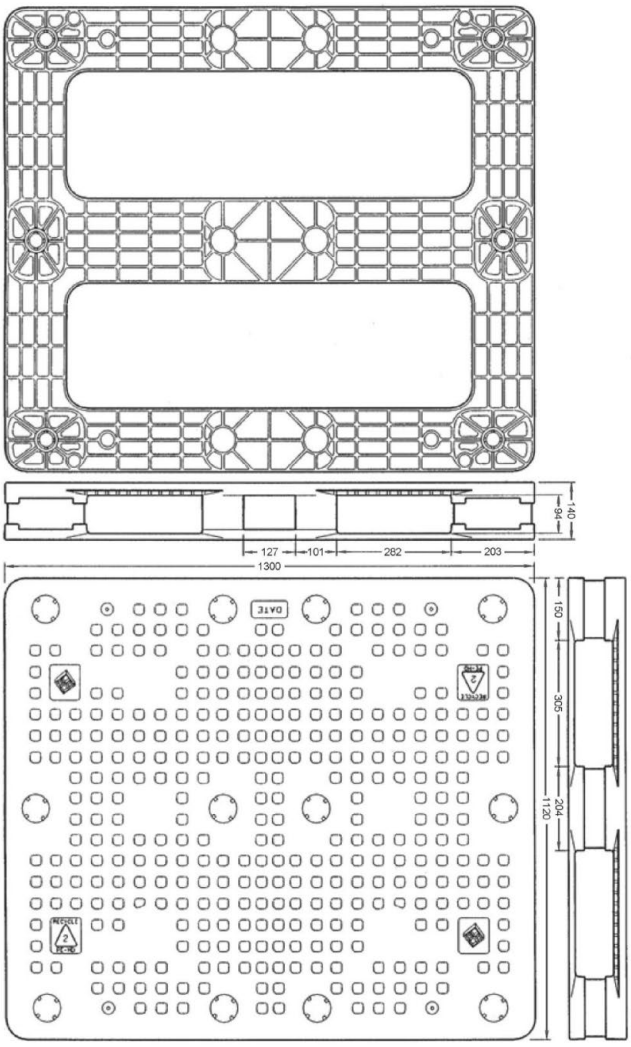


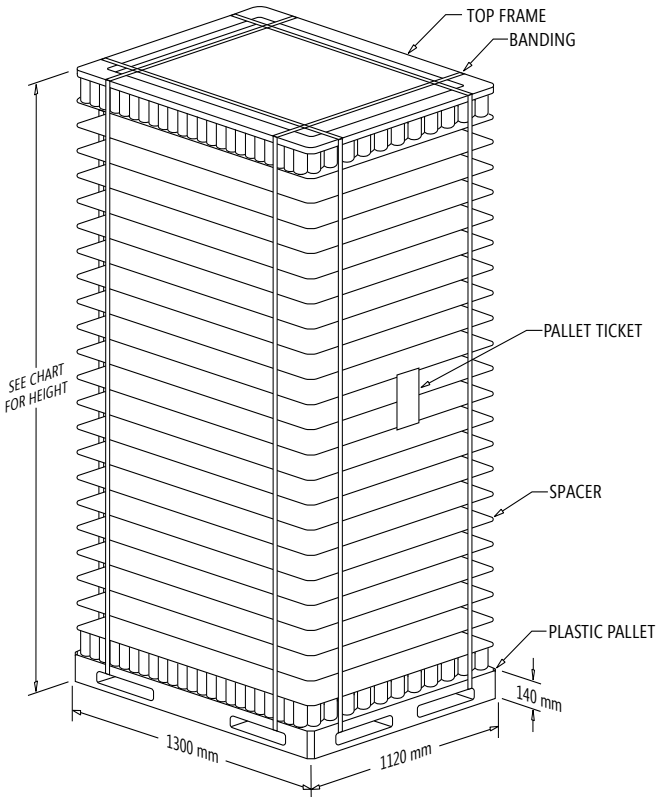
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

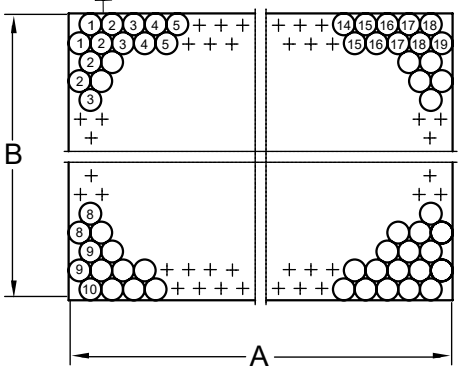
P- Plastic frame		U.K. pallet					
		1300 x 1120 x 140					
	Pallete type	Plastic					
	Frame dimensions	1300 x 1120					
	Frame type	P	P	P	P	P	P
330 ml	Cans per layer	451	451	451	451	451	451
	Number of layers	14	15	16	17	18	19
	Cans per pallet	6314	6765	7216	7667	8118	8569
	Pallet height incl. pallet	2206	2351	2497	2642	2788	2933

Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	330 ml FIT	1.2.89
	Revision: 5	Approved by:	

1.2.90 330 ML STD - U.K. PLASTIC PALLET







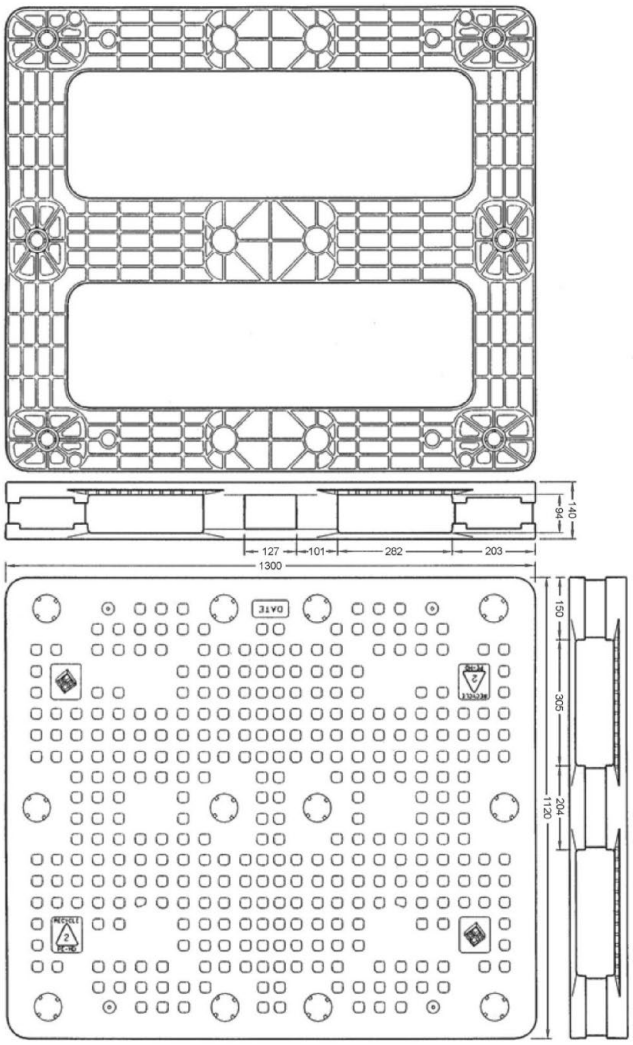
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

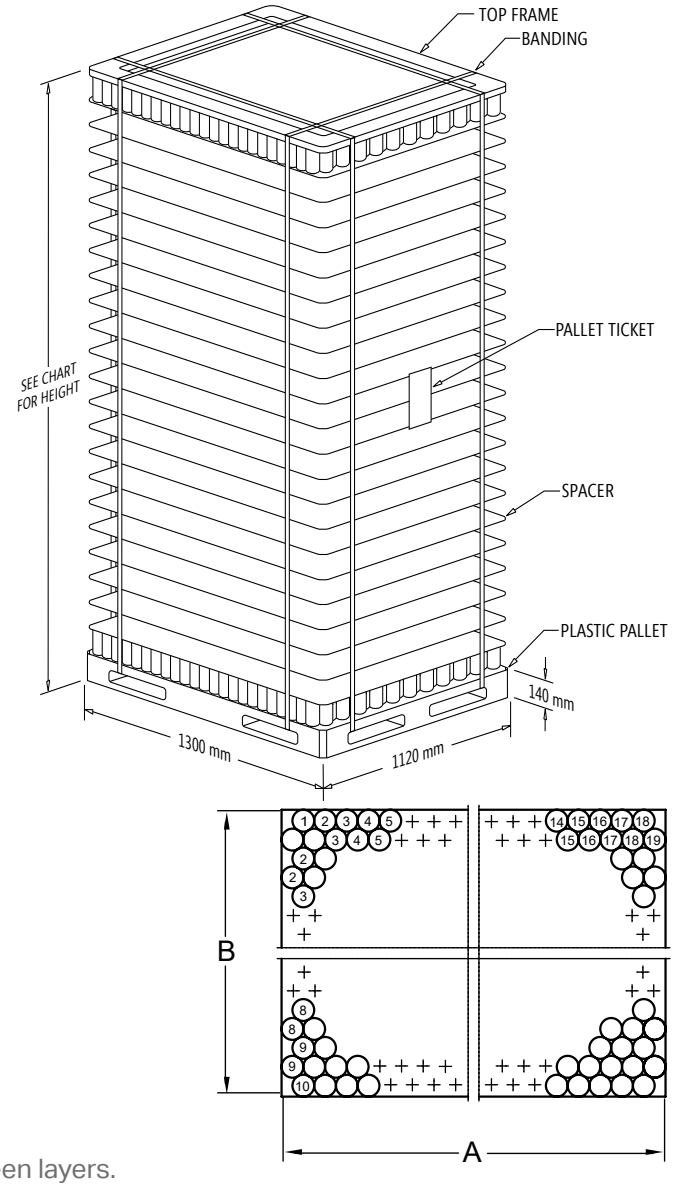
P- Plastic frame		U.K. pallet					
		1300 x 1120 x 140					
	Pallete type	Plastic					
	Frame dimensions	1300 x 1120					
	Frame type	P	P	P	P	P	P
330 ml	Cans per layer	351	351	351	351	351	351
	Number of layers	18	19	20	21	22	23
	Cans per pallet	6318	6669	7020	7371	7722	8073
	Pallet height incl. pallet	2261	2377	2494	2600	2716	2832

Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	330 ml STD	1.2.90
	Revision: 5	Approved by:	

CAN -PALLETIZATION

1.2.91 440 ML STD - U.K. PLASTIC PALLET



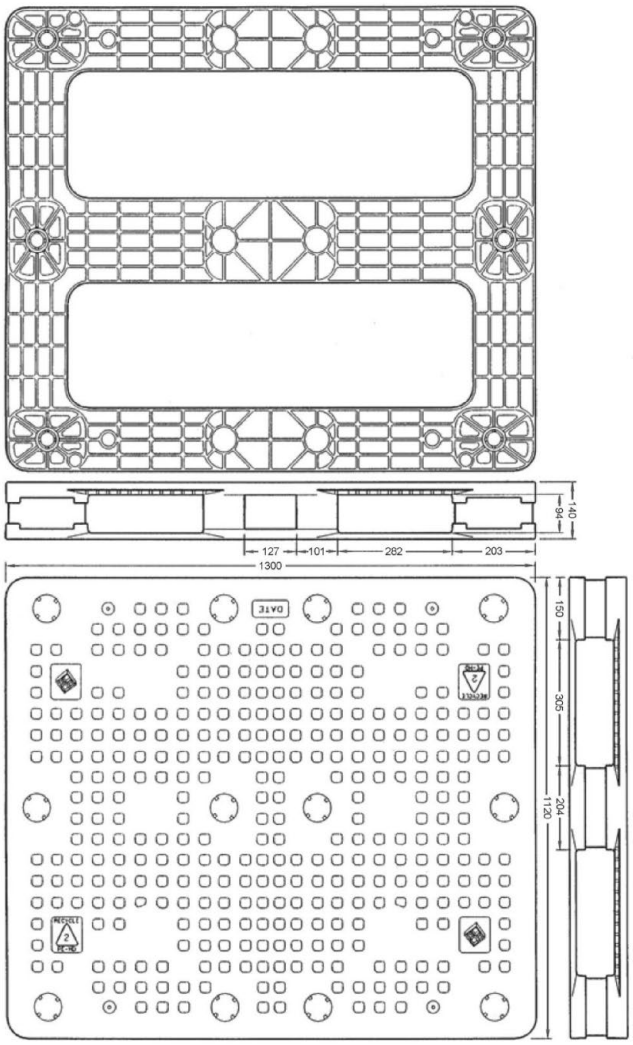


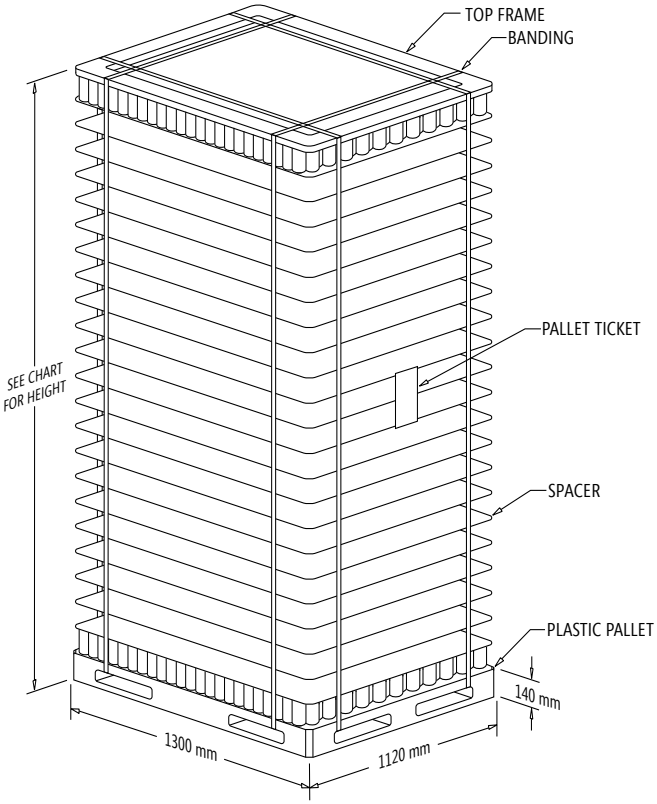
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

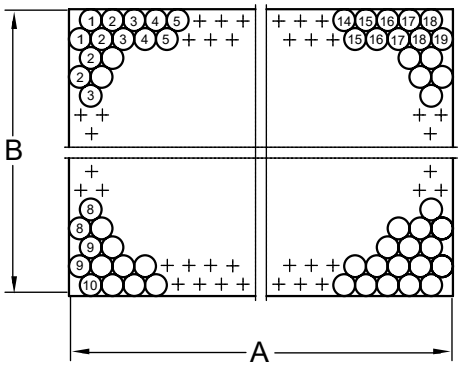
P- Plastic frame		U.K. pallet					
		1300 x 1120 x 140					
	Pallete type	Plastic					
	Frame dimensions	1300 x 1120					
	Frame type	P	P	P	P	P	P
440 ml	Cans per layer	351	351	351	351	351	351
	Number of layers	13	14	15	16	17	18
	Cans per pallet	4563	4914	5265	5616	5967	6318
	Pallet height incl. pallet	2131	2282	2433	2584	2735	2886

Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	440 ml STD	1.2.91
	Revision: 5	Approved by:	

1.2.92 500 ML STD - U.K. PLASTIC PALLET







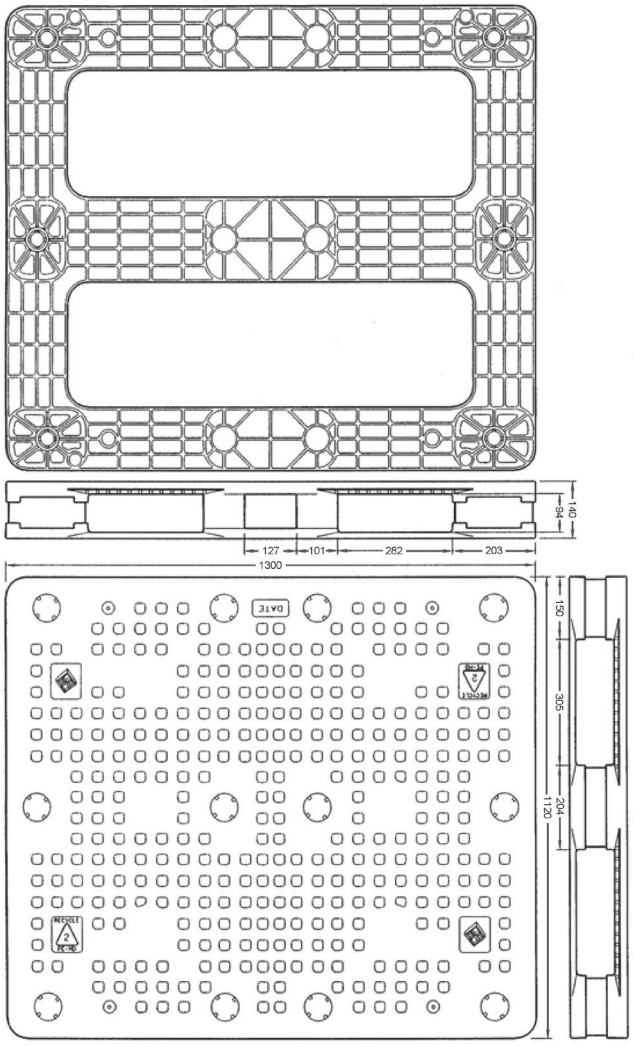
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

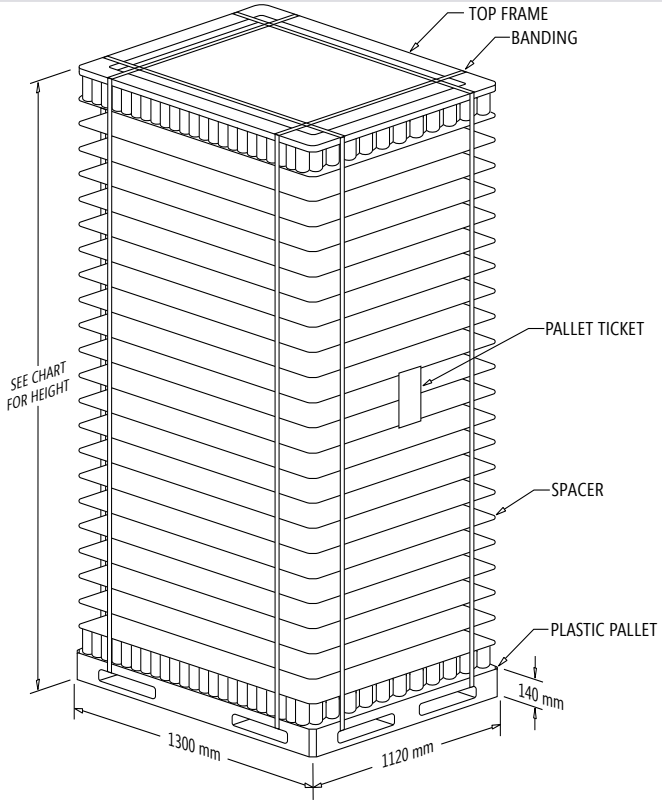
P- Plastic frame		U.K. pallet					
		1300 x 1120 x 140					
	Pallete type	Plastic					
	Frame dimensions	1300 x 1120					
	Frame type	P	P	P	P	P	P
500 ml	Cans per layer	351	351	351	351	351	351
	Number of layers	11	12	13	14	15	16
	Cans per pallet	3861	4212	4563	4914	5265	5616
	Pallet height incl. pallet	2029	2198	2367	2536	2705	2874

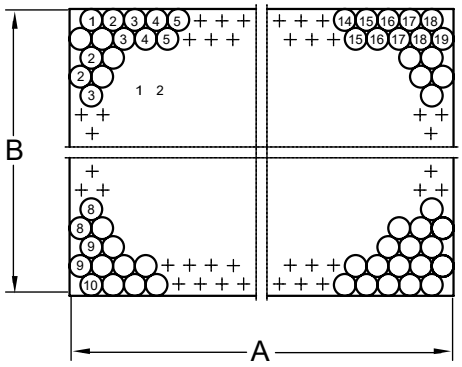
Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	500 ml STD	1.2.92
	Revision: 5	Approved by:	

CAN -PALLETIZATION

1.2.93 550 ML STD - U.K. PLASTIC PALLET







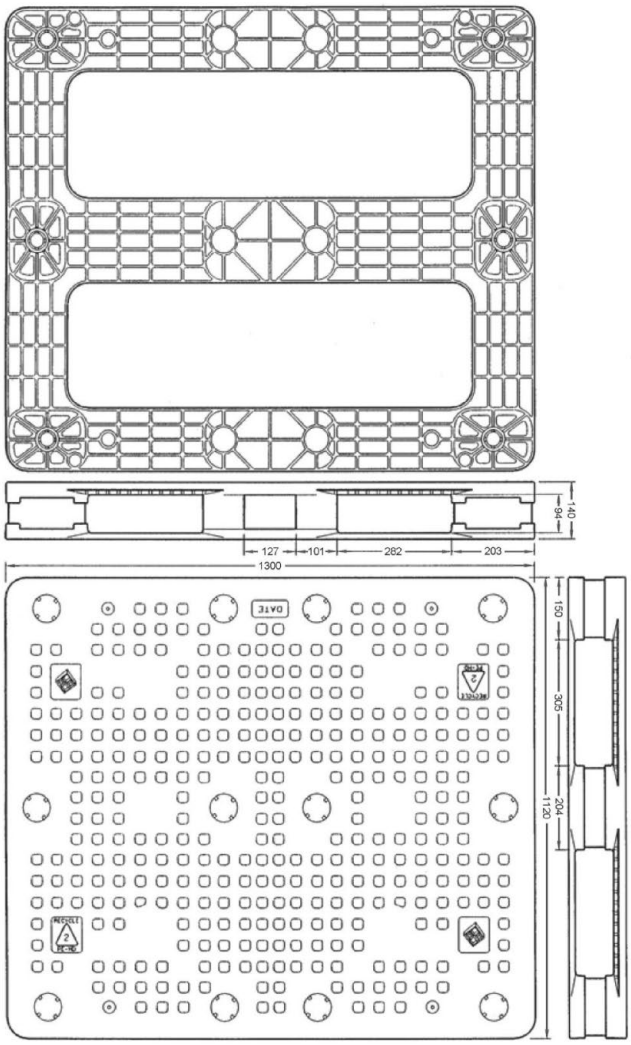
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

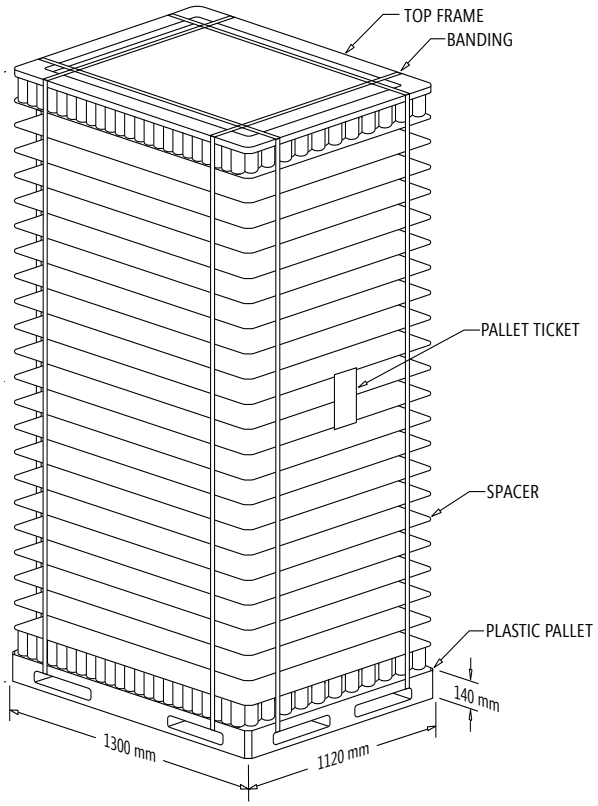
P- Plastic frame		U.K. pallet					
		1300 x 1120 x 140					
	Pallete type	Plastic					
	Frame dimensions	1300 x 1120					
	Frame type	P	P	P	P	P	P
550 ml	Cans per layer	351	351	351	351	351	351
	Number of layers	10	11	12	13	14	15
	Cans per pallet	3510	3861	4212	4563	4914	5265
	Pallet height incl. pallet	2006	2190	2373	2557	2741	2924

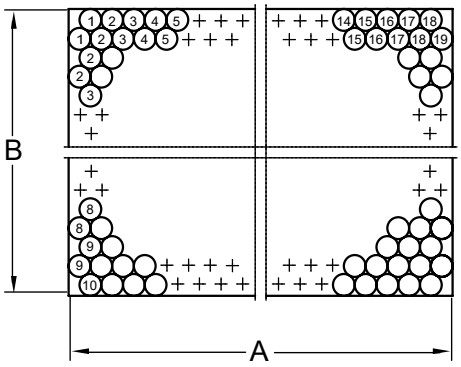
Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	550 ml STD	1.2.93
	Revision: 5	Approved by:	

CANPACK

1.2.94 568 ML STD - U.K. PLASTIC PALLET







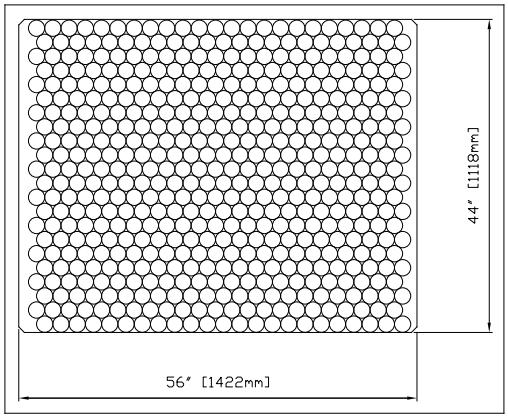
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

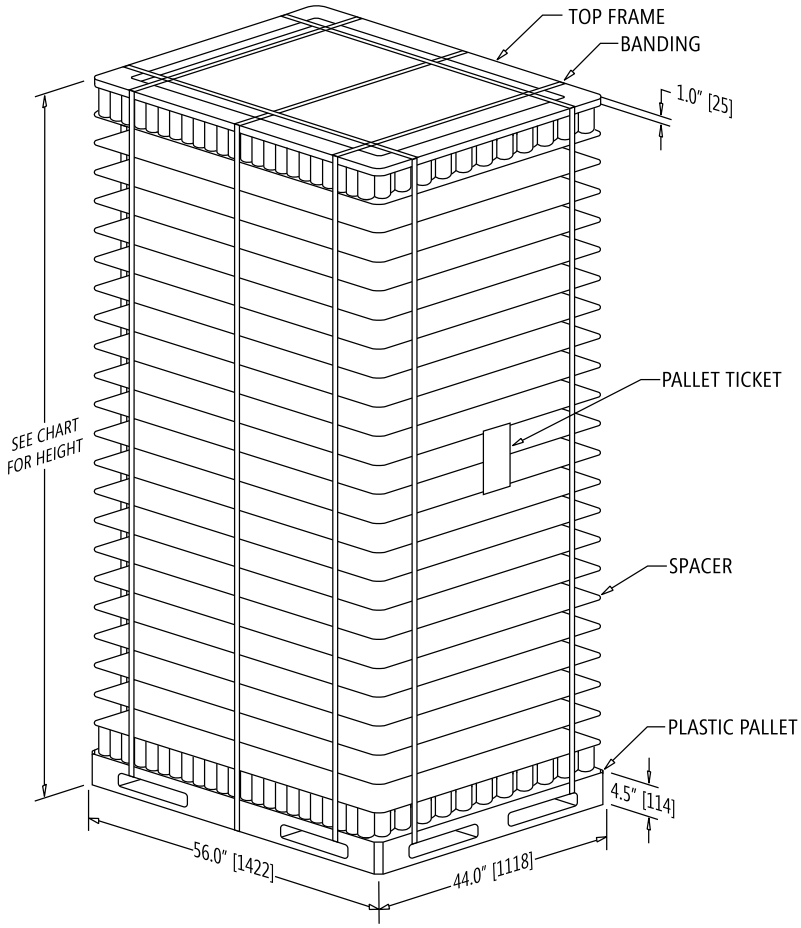
P- Plastic frame		U.K. pallet					
		1300 x 1120 x 140					
	Pallete type	Plastic					
	Frame dimensions	1300 x 1120					
	Frame type	P	P	P	P	P	P
568ml	Cans per layer	351	351	351	351	351	351
	Number of layers	10	11	12	13	14	15
	Cans per pallet	3510	3861	4212	4563	4914	5265
	Pallet height incl. pallet	2061	2250	2440	2630	2820	3007

Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER.	01.05.2020	568 ml STD	1.2.94
	Revision: 5	Approved by:	

CAN - PALETIZATION / North America

1.2.95 222 ML / 7,5 OZ FIT - AMERICAN PALLET





NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

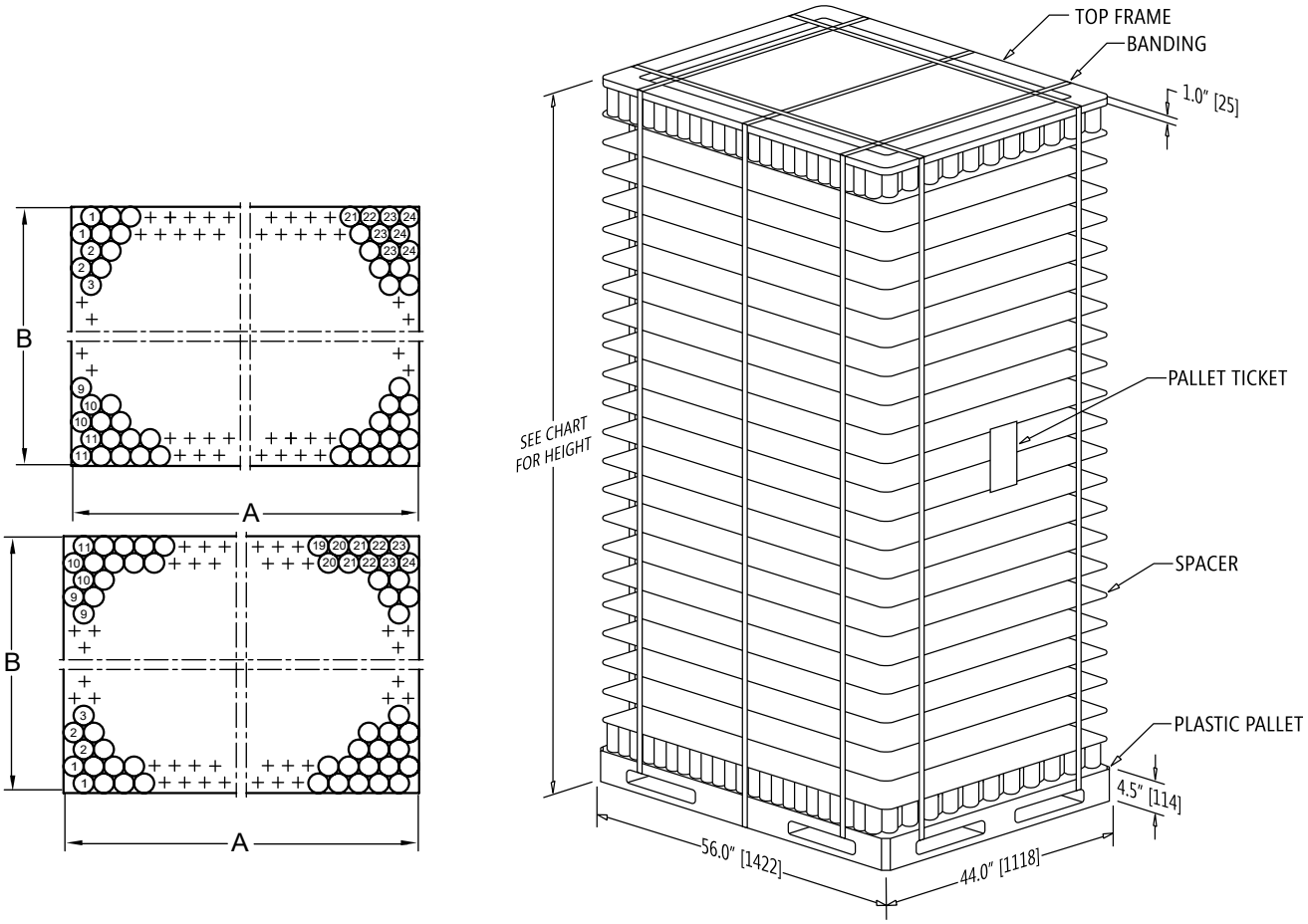
Pallet tolerance +/- 0,256" [6.5mm]

M - Steel Frame P - Plastic Frame W - Wooden Frame		American pallet			
		56" [1422mm] x 44" [1118mm] x 4,5" [114mm]			
	Pallete type	Plastic			
	Frame dimensions	56" [1422mm] x 44" [1118mm]			
	Frame type	M/P/W		M/P/W	
FIT 7,5 oz 222 ml	Cans per layer	506		506	
	Number of layers	23		24	
	Cans per pallet	11638		12144	
	Pallet height incl. pallet	mm	[inch]	mm	[inch]
		2560	100,79	2665	104,92

Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER	10.11.2022	222 ml FIT 7,5 oz	1.2.95
	Revision: 2	Approved by:	

CAN - PALETIZATION

1.2.96 269 ML / 9,1 OZ FIT - AMERICAN PALLET



NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

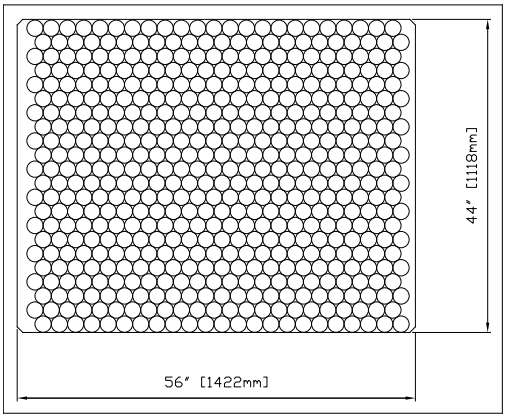
Pallet tolerance +/- 0,256" [6.5mm]

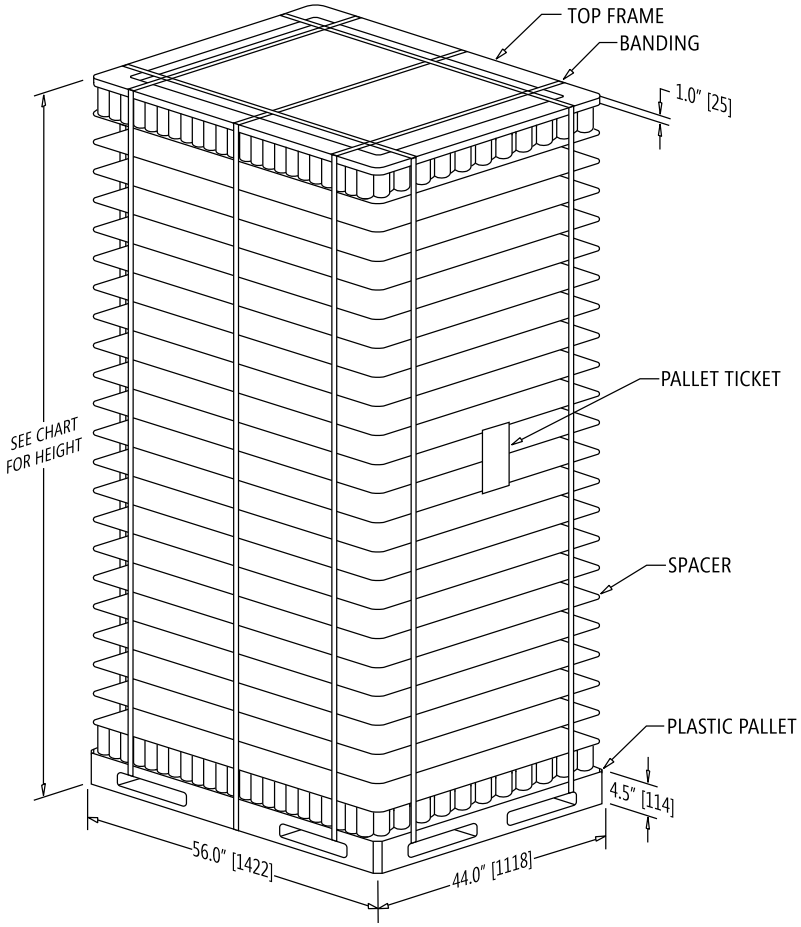
M - Steel frame P - Plastic frame W - Wooden Frame		American pallet									
		56" [1422mm] x 44" [1118mm] x 4,5" [114mm]									
	Pallete type	Plastic									
	Frame dimensions	56" [1422mm] x 44" [1118mm]									
	Frame type	M/P/W		M/P/W		M/P/W		M/P/W		M/P/W	
FIT 9,1oz 269 ml	Cans per layer	493	528	493	528	493	528	493	528	493	528
	Number of layers	17		18		19		20		21	
	Cans per pallet	8381	8976	8874	9504	9367	10032	9860	10560	10353	11088
	Pallet height incl. pallet	[mm]	[in]	[mm]	[in]	[mm]	[in]	[mm]	[in]	[mm]	[in]
		2221	87,4	2344	92,3	2467	97,1	2590	102,0	2713	106,8

Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER	28.09.2023	269 ml FIT 7,5 oz	1.2.96
	Revision: 1	Approved by:	

CAN - PALETIZATION / North America

1.2.96 355 ML / 12 OZ FIT / - AMERICAN PALLET





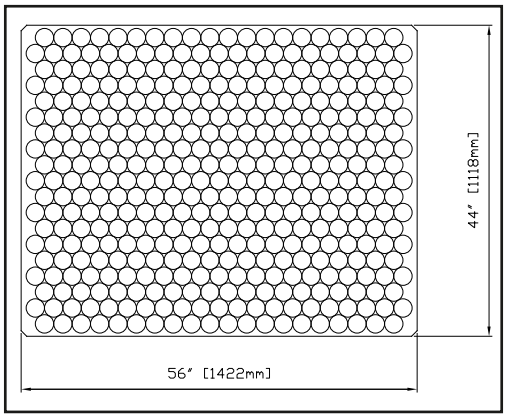
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

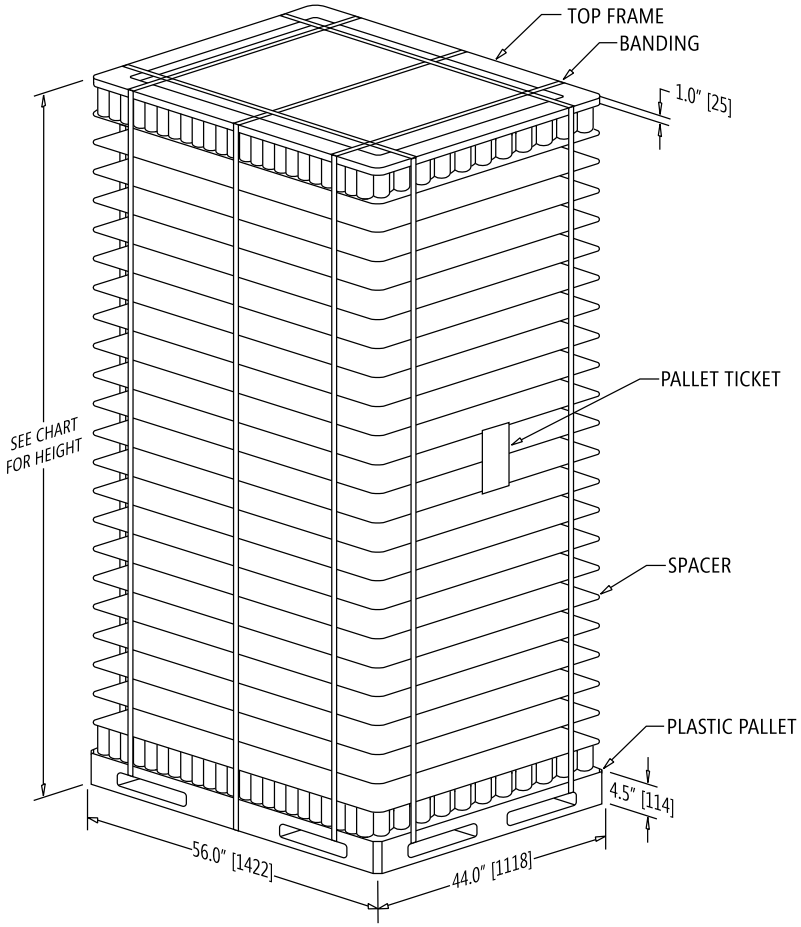
Pallet tolerance +/- 0,256" [6.5mm]

M - Steel Frame P - Plastic Frame W - Wooden Frame		American pallet			
		56" [1422mm] x 44" [1118mm] x 4,5" [114mm]			
	Pallete type	Plastic			
	Frame dimensions	56" [1422mm] x 44" [1118mm]			
	Frame type	M/P/W		M/P/W	
FIT 12 oz 355 ml	Cans per layer	506		506	
	Number of layers	15		16	
	Cans per pallet	7590		8096	
	Pallet height incl. pallet	mm	[inch]	mm	[inch]
		2495	98,23	2655	104,53

Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER	10.11.2022	355 ml FIT 12 oz	1.2.97
	Revision: 2	Approved by:	

1.2. 97 355 ML / 12 OZ STD / - AMERICAN PALLET





NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

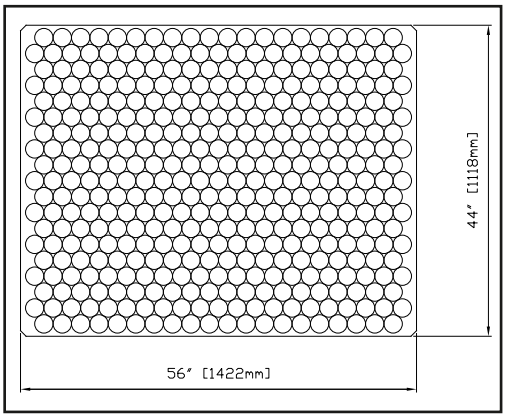
Pallet tolerance +/- 0,256" [6.5mm]

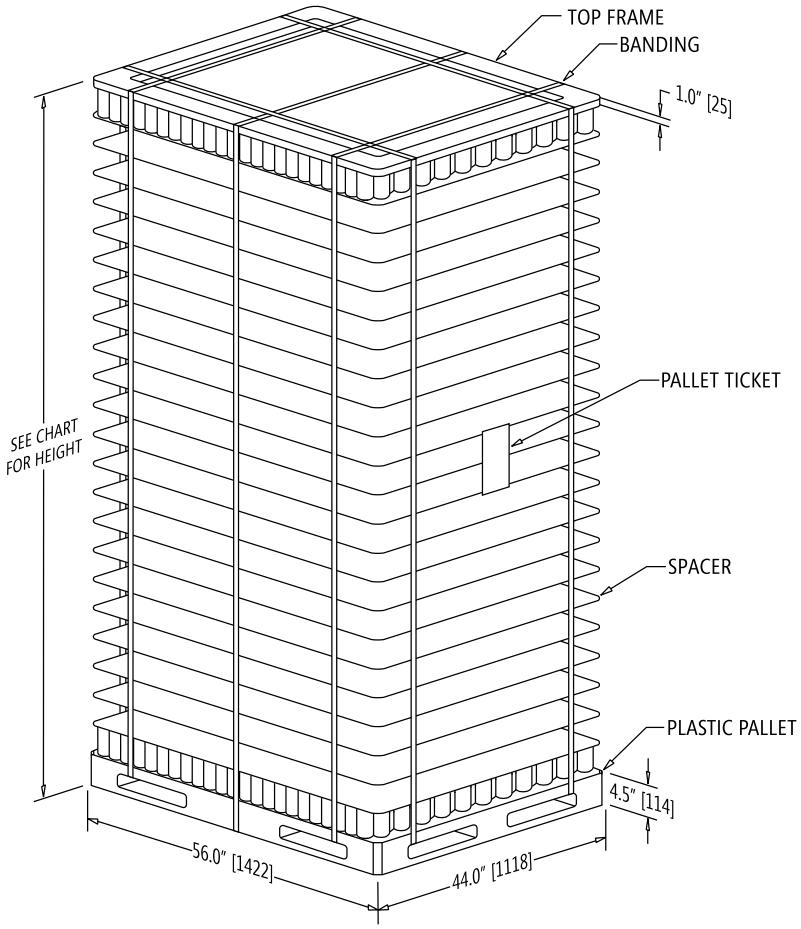
M - Steel Frame P - Plastic Frame W - Wooden Frame		American pallet					
		56" [1422mm] x 44" [1118mm] x 4,5" [114mm]					
	Pallete type	Plastic					
	Frame dimensions	56" [1422mm] x 44" [1118mm]					
	Frame type	M/P/W		M/P/W		M/P/W	
STD 12 oz 355 ml	Cans per layer	389		389		389	
	Number of layers	19		20		21	
	Cans per pallet	7391		7780		8169	
	Pallet height incl. pallet	mm	[inch]	mm	[inch]	mm	[inch]
		2485	97,83	2610	102,76	2735	107,68

Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER	10.11.2022	355 ml STD 12 oz	1.2.98
	Revision: 2	Approved by:	

CAN - PALETIZATION / North America

1.2.98 / 473 ML / 16 OZ STD / - AMERICAN PALLET





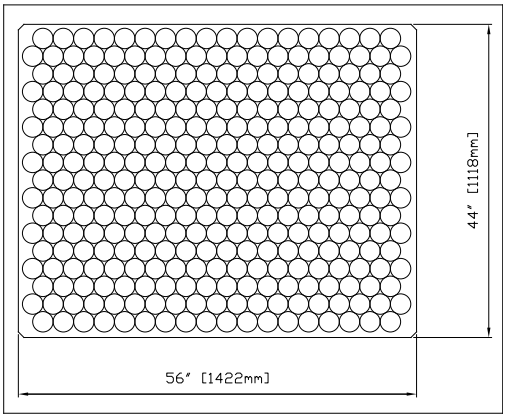
NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

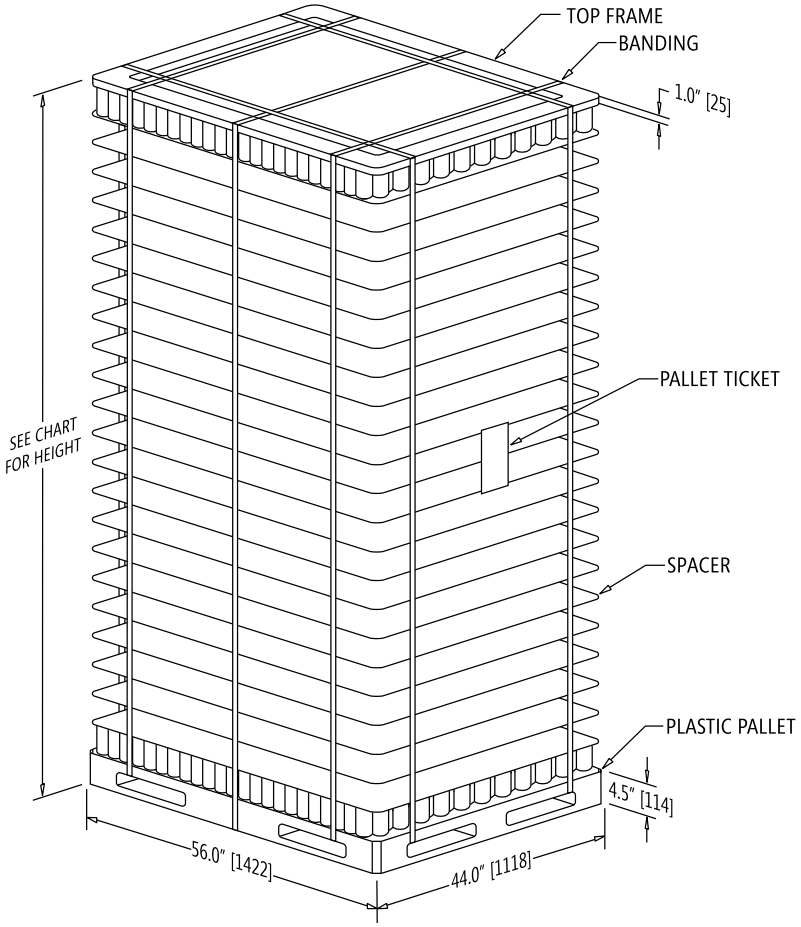
Pallet tolerance +/- 0,256" [6.5mm]

M - Steel Frame P - Plastic Frame W - Wooden Frame		American pallet			
		56" [1422mm] x 44" [1118mm] x 4,5" [114mm]			
	Pallete type	Plastic			
	Frame dimensions	56" [1422mm] x 44" [1118mm]			
	Frame type	M/P/W		M/P/W	
FIT 16 oz 473 ml	Cans per layer	389		389	
	Number of layers	15		16	
	Cans per pallet	5835		6224	
	Pallet height incl. pallet	mm	[inch]	mm	[inch]
		2520	99,21	2680	105,51

Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER	10.11.2022	473 ml STD 16 oz	1.2.99
	Revision: 2	Approved by:	

1.2.99 710 ML / 24 OZ BIGP - AMERICAN PALLET





NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

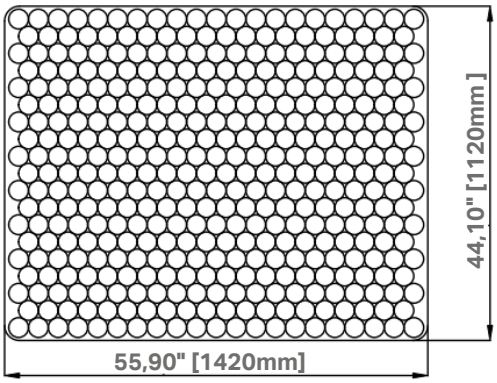
Pallet tolerance +/- 0,256" [6.5mm]

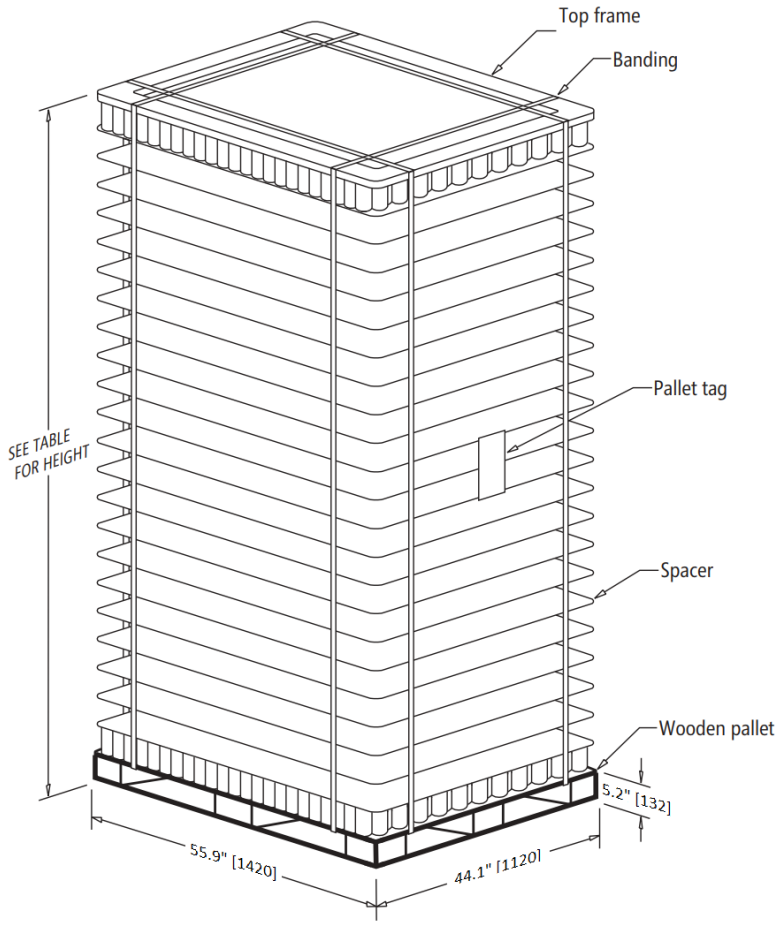
M - Steel Frame P - Plastic Frame W - Wooden Frame		American pallet			
		56" [1422mm] x 44" [1118mm] x 4,5" [114mm]			
	Pallete type	Plastic			
	Frame dimensions	56" [1422mm] x 44" [1118mm]			
	Frame type	M/P/W		M/P/W	
24 oz 710 ml	Cans per layer	314		314	
	Number of layers	12		13	
	Cans per pallet	3768		4082	
	Pallet height incl. pallet	mm	[inch]	mm	[inch]
		2480	97,64	2670	105,12

Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER	10.11.2022	710 ml 24 oz	1.2.100
	Revision: 2	Approved by:	

CAN - PALETIZATION / Import to North America

1.2.100 355 ML / 12 OZ STD - SPANISH PALLET





NOTE: The cans are placed in layers, with spacers between layers.
Pallets are strapped and can be wrapped with stretch foil on customer's demand.

Pallet tolerance +/- 0,256" [6.5mm]

M - Steel Frame P - Plastic Frame W - Wooden Frame		American pallet					
		1420mm [55,90"] x 1120mm [44,10"] x 132mm [5,20"]					
	Pallete type	Wood					
	Frame dimensions	1420mm [55,90"] x 1120mm [44,10"]					
	Frame type	M/P/W		M/P/W		M/P/W	
STD 12 oz 355 ml	Cans per layer	390		390		390	
	Number of layers	19		20		21	
	Cans per pallet	7410		7800		8190	
	Pallet height incl. pallet	mm	[inch]	mm	[inch]	mm	[inch]
		2502	98,50	2626	103,39	2749	108,23

Product:	Date:	Type:	Chapter:
PALLET DIMENSIONS AND CAN DISTRIBUTION ON LAYER	01.01.2022	355 ml STD 12 oz	1.2.101
	Revision: 1	Approved by:	

1.3 PACKAGING MATERIALS

All packaging materias used in CANPACK Group (Pallets, Frames, Interlayers, Foils, Tapes and Paper Sleeves), including their specification are included in Packaging Catalogue which is a seperate document available document on the CANPACK Sharepoint website.

https://giorgiglobal.sharepoint.com/sites/canpack-chief-technologist - PACKAGING MATERIALS

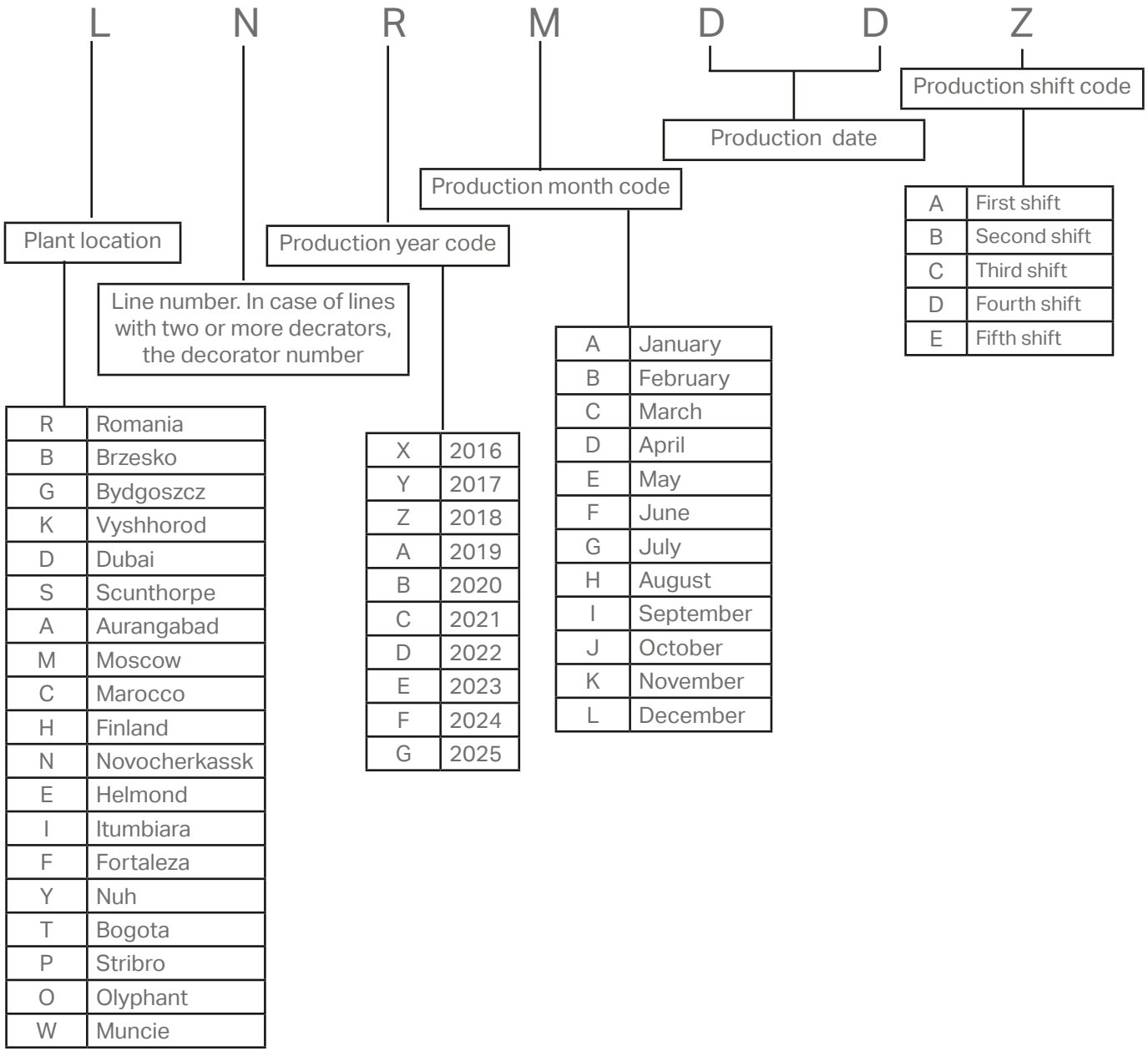
Product:	Date:	Type:	Chapter:
PACKAGING MATERIALS	12.12.2022	Aluminium cans	1.3
	Revision: 7	Approved by:	

1.4 CAN CODING

CAN CODING

CAN CODING

1.4.1 PRODUCTION DATE CODING



R	Romania
B	Brzesko
G	Bydgoszcz
K	Vyshhorod
D	Dubai
S	Scunthorpe
A	Aurangabad
M	Moscow
C	Marocco
H	Finland
N	Novocherkassk
E	Helmond
I	Itumbiara
F	Fortaleza
Y	Nuh
T	Bogota
P	Stribro
O	Olyphant
W	Muncie

X	2016
Y	2017
Z	2018
A	2019
B	2020
C	2021
D	2022
E	2023
F	2024
G	2025

A	January
B	February
C	March
D	April
E	May
F	June
G	July
H	August
I	September
J	October
K	November
L	December

A	First shift
B	Second shift
C	Third shift
D	Fourth shift
E	Fifth shift

NOTE:
Rectangle (dimensions 4 x 13mm) - need to be secure for production date code in the neighbourhood of bar code, in case of its absence- in direct neighbourhood of information inscriptions on every litography

Examples:
B2XE04A - Brzesko Plant, Line #2, 2016-05-04, A team,
O3CD15C - Olyphant Plant, Decorator #3, 2021 -04 -15, C Team

Product:	Date:	Type:	Chapter:
PRODUCTION DATE CODING	01.12.2022	Aluminium cans	1.4.1
	Revision: 4	Approved by:	

1.4.2 CAN - PRODUCT IDENTIFICATION

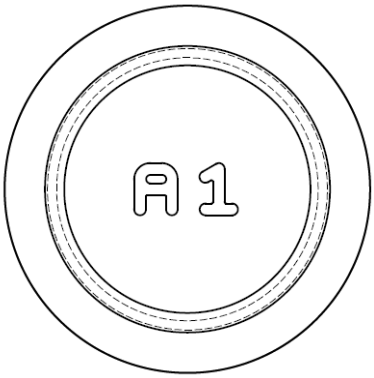
CAN - PRODUCT IDENTIFICATION

In order to supervise the production process, a marking of bodymakers is applied. The way of coding is as follows: the first letter designates the number of the production line (according to the table listed below), the second figure designates following number of the bodymaker. In case of those lines where a number of stretching presses (Bodymakers) is greater than 9, marking of Bodymaker takes place by the means of successive letters of the alphabet. See below the way of coding used in CANPACK plants:

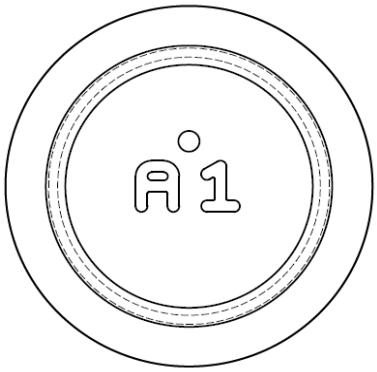
Line no.	Coding
1	A
2	B
3	C
4	D
5	E
6	F
7	G
8	H
9	I
10	J
11	K
12	L
14	M
15	N
16	O
17	P
18	R
19	S
20	T
21	U
22	V
23	W
24	X
25	Y
26	Z

Line no.	Coding
27	A°
28	B°
29	C°
30	D°
31	E°
32	F°
33	G°
34	H°
35	I°
36	J°
37	K°

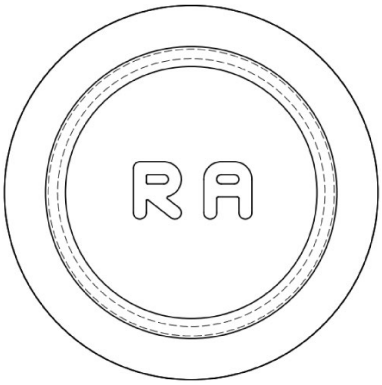
Examples



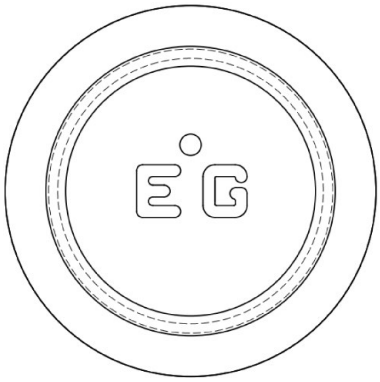
Line No. 1, Bodymaker No. 1



Line No. 27, Bodymaker No. 1



Line No. 18, Bodymaker No. 1



Line No. 31, Bodymaker No. 7

1.4.3 CAN - PRODUCT IDENTIFICATION / EMBOSS

Additionally on the line 2, the embossed cans are marked by the UV visible ink. The place of marking is located on the bottom dome of a can (showed in drawing). The code consists of letter and the number of embosser station, range from 01 to 24.

Machine	Station no.	UV coding
A	1 2 ... 24	A01 A02 ... A24
B	1 2 ... 24	B01 B02 ... B24

For each machine of the ISM system, marking code is also applied:
- on the production line no. 1, place of the marking is located on the bottom dome of a can (showed in the picture):

Examlpe of coding : spray no. 6 – line no. 6

Example of coding : spray no. 4 – line no. 6

- on the other lines, inner wall of bottom dome is marked.

Product:	Date:	Type:	Chapter:
PRODUCT IDENTIFICATION	01.05.2020	Aluminium cans	1.4.3
	Revision: 2	Approved by:	

1.4.4 CAN - PRODUCT IDENTIFICATION / ISM

The key of ISM marking applied in CANPACK plants:

ISM No.	Codes of marking				
	L#1 - Dubai	Description	L#2 - Brzesko	L#3 - Brzesko	L#4 - Bydgoszcz
1	●	one brown dot	1	1	A
2	●	one green dot	2	2	B
3	●	one orange dot	3	3	C
4	●	one yellow dot	4	4	D
5	●	one purple dot	5	5	E
6	●	one blue dot	6	6	F
7	●	one black dot	7	7	G
8	●	one jade green dot		8	H
9		no dots		9	

ISM No.	Codes of marking				
	L#5 - Vyshgorod	Description	L#6 - Bucharest (UV ink)	Description	L#7 - Bydgoszcz
1	●	one black dot	●●	two green dots	**A**
2	●	one yellow dot	●	one orange dot	**B**
3	●●	two yellow dots	●	**one blue dot**	**C**
4	●	one green dot	○ ○	two white dots	**D**
5	●●	two green dots	●	one yellow dot	**E**
6		no dots	●	one pink dot	**F**
7	●	one purple dot	○	one lavander dot	**G**
8	● ●	two purple dot	●	one aqua dot	**H**
9	●●	two black dots		no dots	I

Note:
Coding used for supervision of the production process.

Product:	Date:	Type:	Chapter:
PRODUCT IDENTIFICATION	1.12.2022	Aluminium cans	1.4.4
	Revision: 5	Approved by:	

CAN CODING

ISM No.	Codes of marking				
	L#8 - Dubai	Description	L#9 - Brzesko	L#10 - Aurangabad	Description
1	●	one brown dot	1	●	one brown dot
2	●	one green dot	2	●	one green dot
3	●	one orange dot	3	●	one orange dot
4	●	one yellow dot	4	●	one yellow dot
5	●	one purple dot	5	●	one pink dot
6	●	one blue dot	6	●	one black dot
7	●	one black dot	7	●	one blue dot
8	●	one green dot	8	●	one purple dot
9		no dots	9		no dots
10			10		
11			11		
12			12		

ISM No.	Codes of marking					
	L#11 - Scunthorpe	Description	L#12 - Volokolamsk	Description	L#14 - Casa-blanca	Description
1	●	one blue dot		no dots	●	one pink dot
2	●	one yellow dot	●	one black dot	●	one dark orange dot
3	●	one dark orange dot	●●	two black dots	○	one white dot
4	●	one green dot	●	one blue dot	●	one lavender dot
5	●●	two blue dots	●●	two blue dots	●	one light orange dot
6	●●	two yellow dots	●	one green dot	●	one green dot
7	●●	two dark orage dots	●●	two green dots	●	one blue dot
8	●●	two green dots	●	one yellow dot	●	one yellow dot
9	●	one pink dot				no dots
10		no dots				

CAN CODING

ISM no.	Codes of marking						
	L#15 - Hameenlinna	hour / minute	L#16 - Novocherkask	Description	L#17 - Scunthorpe	Description	L#20 -Itumbiara
1	A	hh:mm	●	one black dot	●	one blue dot	A
2	B	hh:mm	●	one brown dot	●	one yellow dot	B
3	C	hh:mm	●	one green dot	●	one dark orange dot	C
4	D	hh:mm	●	one purple dot	●	one green dot	D
5	E	hh:mm	●	one light blue dot	●●	two blue dots	E
6	F	hh:mm	●	one light blue dot	●●	two yellow dots	F
7	G	hh:mm	●	one yellow dot	●●	two dark orage dots	G
8	H	hh:mm	●	one orange dot	●●	two green dots	H
9	I	hh:mm		no dots	●	one pink dot	I
10						no dots	J
11							K
12							L

ISM No.	Codes of marking						
	hour / minute	L#21 - Itumbiara	hour / minute	L#22 - Maracanau	hour / minute	L#23 - Maracanau	hour / minute
1	hh:mm	A	hh:mm	A	hh:mm	A	hh:mm
2	hh:mm	B	hh:mm	B	hh:mm	B	hh:mm
3	hh:mm	C	hh:mm	C	hh:mm	C	hh:mm
4	hh:mm	D	hh:mm	D	hh:mm	D	hh:mm
5	hh:mm	E	hh:mm	E	hh:mm	E	hh:mm
6	hh:mm	F	hh:mm	F	hh:mm	F	hh:mm
7	hh:mm	G	hh:mm	G	hh:mm	G	hh:mm
8	hh:mm	H	hh:mm	H	hh:mm	H	hh:mm
9	hh:mm	I	hh:mm	I	hh:mm	I	hh:mm
10	hh:mm	J	hh:mm	J	hh:mm	J	hh:mm
11	hh:mm	K	hh:mm	K	hh:mm	K	hh:mm
12	hh:mm	L	hh:mm	L	hh:mm	L	hh:mm

CAN CODING

ISM No.	Codes of marking							
	L#24 -Bucharest (UV ink)	Description	L#25 -Nuh	L#26 -Tocancipa	hour code / minute	L#27 -Tocancipa	hour code / minute	L#29 -Stribro
1	●●	two green dots	A	1	h:mm	1	h:mm	1
2	●	one orange dot	B	2	h:mm	2	h:mm	2
3	●	one blue dot	C	3	h:mm	3	h:mm	3
4	○ ○	two white dots	D	4	h:mm	4	h:mm	4
5	●	one yellow dot	E	5	h:mm	5	h:mm	5
6	●	one pink dot	F	6	h:mm	6	h:mm	6
7		no dots	G	7	h:mm	7	h:mm	7
8	A		H	8	h:mm	8	h:mm	8
9	B		I	9	h:mm	9	h:mm	9
10	C		J	10	h:mm	10	h:mm	10

ISM No.	Codes of marking							
	L#30-Volokolamsk	L#31- Olyphant	L#32- Olyphant	L#33- Olyphant	L#34- Olyphant	L#35 - Muncie	L#36 - Muncie	L#37 - Muncie
1	A	A	A	A	A	A	A	A
2	B	B	B	B	B	B	B	B
3	C	C	C	C	C	C	C	C
4	D	D	D	D	D	D	D	D
5	E	E	E	E	E	E	E	E
6	F	F	F	F	F	F	F	F
7	G	G	G	G	G	G	G	G
8		H	H	H	H	H	H	H
9		I	I	I	I	I	I	I
10		J	J	J	J	J	J	J
11		K	K	K	K	K		
12		L	L	L	L	L		
13						M		
14						N		

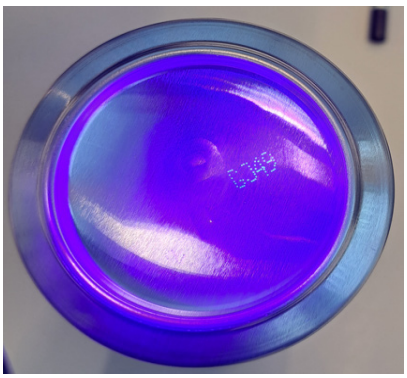
CANPACK

CAN - PRODUCT IDENTIFICATION / ISM

The coding system applied in CANPACK Netherlands:

ISM No.	Codes of marking							
	L#18 - Helmond	L#19- Helmond	L#28- Helmond	Code	Hour	Code	Hour	min
1	A	A	A	A	0	N	12	mm
2	B	B	B	B	1	P	13	mm
3	C	C	C	C	2	Q	14	mm
4	D	D	D	D	3	R	15	mm
5	E	E	E	E	4	S	16	mm
6	F	F	F	F	5	T	17	mm
7	G	G	G	G	6	U	18	mm
8	H	H	H	H	7	V	19	mm
9	I	I	I	J	8	W	20	mm
10	J	J	J	K	9	X	21	mm
11	K	K		L	10	Y	22	mm
12	L	L		M	11	Z	23	mm

Marking example for L#19:
GJ49 - LSM7,



1.4.5 BLANK CANS

In the case of special requests from the customers, usually for testing purposes (products validation) or for clients self-labeling of the cans, we can produce blank cans, i.e. cans that are passing at the decorator with no blanket wheel contact (no colors), still they are overvarnished in order to protect them for the transportation means. These cans comply with all of the traceaility requirements. In order to do so, a code is applied on the bottom using colors not detectable in the visible domain, detectable only in the UV range, i.e. with the aid of UV light. The applied code can consist in up to 6 characters, as in the example from the picture below:

6 - Machine identification
B - Hour
1234 - the last 4 numbers from the production order

Alternatively, till the moment when all facilities are equipped with UV ink printers, the coding is done in the traditional way as described in the chapter 1.4.1.

LITHOGRAPHY
BASIC INFORMATION

LITHOGRAPHY - BASIC INFORMATION

1.5.1 BASIC INFORMATION

TECHNOLOGY

The printing process for aluminum cans is different to standard “Offset” printing. CANPACK utilizes “Dry-Offset” technology where colours are applied separately without drying between application of each colour (separations between colours) and the colours cannot be mixed. The process only allows similar colours to be overprinted, in order to improve the intensity and to make colours more opaque.

COLOURS

The maximum colour print ability is up to 8 colours (including white) and key factor that must be taken into consideration by all customers is dot gain after printing (even up to 40%).

OVERVARNISH

After the process of transfering ink onto the aluminium can has been completed, the decorated can body is covered with an overvarnish (glossy, or matt lacquer). The overall aim is to protect the design and aluminium body against external conditions.

WE ARE OPEN

CANPACK has an open attitude towards all customers and graphics agencies and we are happy to offer factory tours, which give the possibility to witness, evaluate and to understand the process more thoroughly. With this knowledge, we would be able to improve communication and effectivenes of the entire process between CANPACK, customers and graphic agencies.

COMMUNICATION

Agree with your CANPACK Area Sales Manager, a line of communication. It should be the first person, who is the sole point of contact in CANPACK Graphics Department.

MORE INFO

For more information on this please contact our local CANPACK Area Sales Manager.

BASIC REQUIREMENTS

1.5.2 BASIC RQUIREMENTS

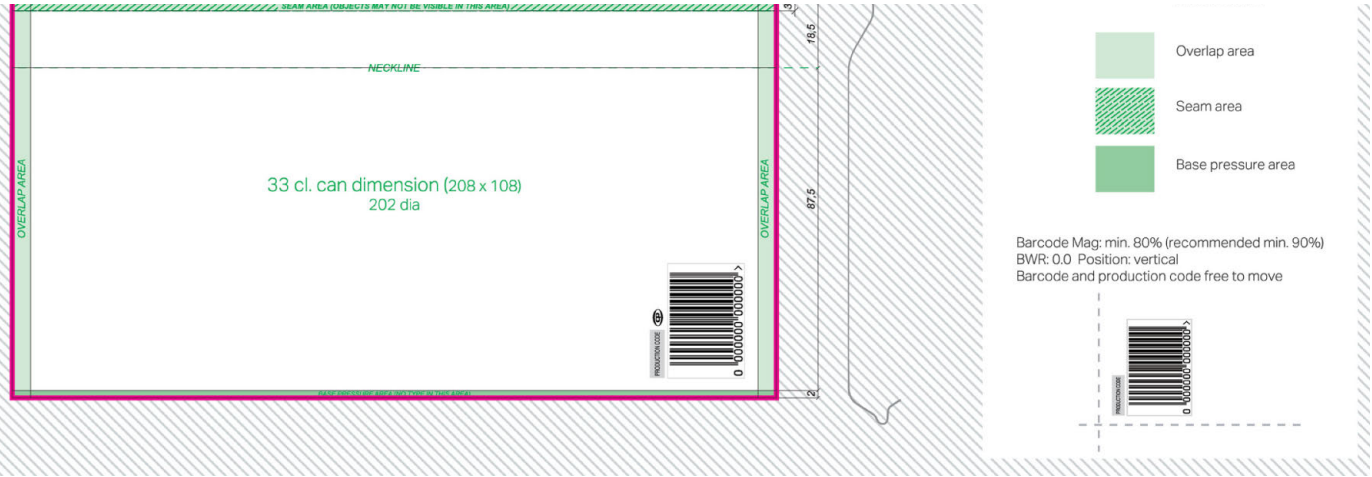
ARTWORK FILES

Issue the artwork in either Adobe Illustrator, Adobe Acrobat PDF, ArtPro, Packedge PDF or CorelDRAW file formats.

DESIGN ESSENTIALS

For each artwork preparation always utilise CANPACK's cutting guides, with attention to cans size (cutting guide example of 330ml Standard can is shown below);
Design should always be prepared to an **Artwork Cutter** area marked on each cutting guides;
CANPACK does not create designs, CANPACK will only adjust existing ideas to the printing process;
CANPACK will deal with separation, using our own knowledge and experience, with the purpose to make the separation almost not visible on one hand and applicable for printing on the other;

- **Overlap Area** - this area should not contain any legal texts, barcodes, etc.,
- **Seam Area** - objects may not be visible in this area, should not contain any legal texts,
- **Base Pressure Area** - this should not contain any legal texts, barcodes, etc.



Standard Can 330ml 202 dia Cutting Guide

The customer, whose signature appears on the approval lithography document (a test print or electronic image of lithography), is entitled to confirm it comformity with his requirements. The customer is liable for trademark infringement, copyright, patent, or other proprietary rights of any person or company comparison to previous version.

Product:	Date:	Type:	Chapter:
ALUMINIUM BEVERAGE CAN	01.05.2020	Aluminium cans	1.5.2
	Revision: 1	Approved by:	

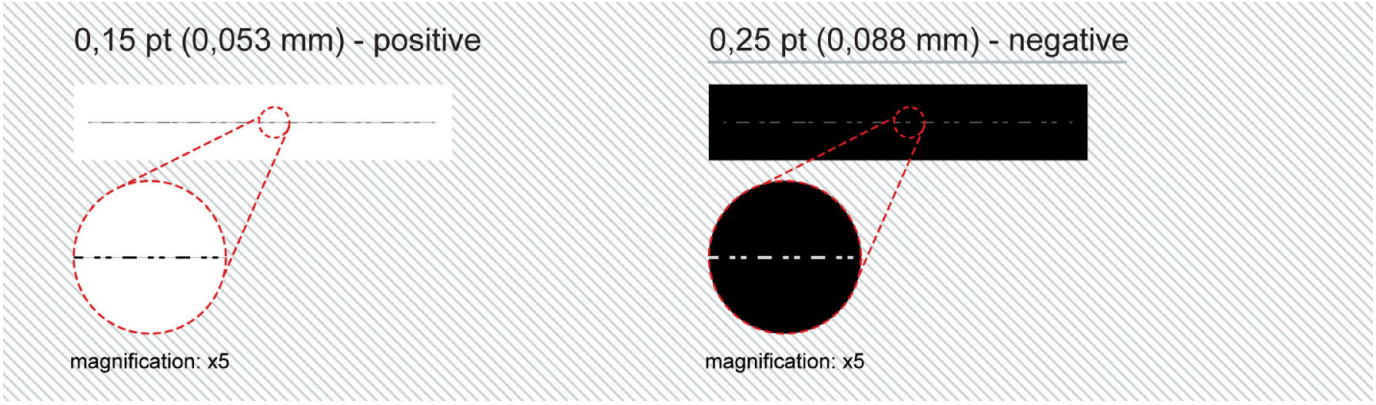
BASIC REQUIREMENTS

LINES AND SMALL ELEMENTS

The smallest element and line that can be printed on a can is:

- Positive: 0,15 pt (0,053 mm);
- Negative: 0,25pt (0,088 mm);

Ensure to keep elements simple and use bold lines.

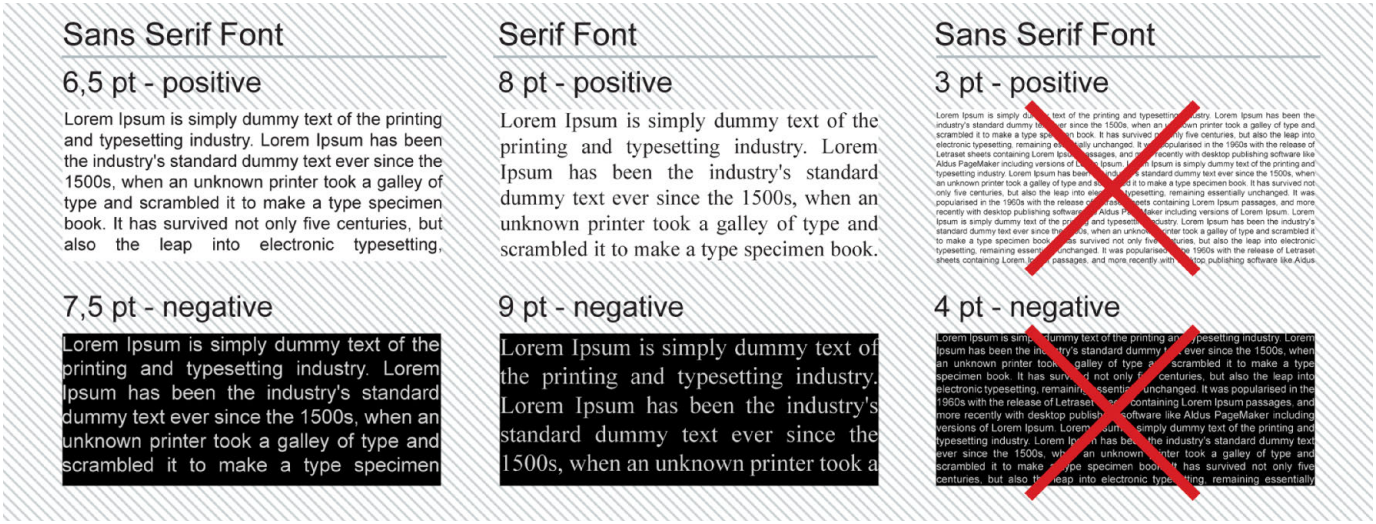


Minimum Line Size

FONTS

All fonts should be altered to curves and minimum required size should be:

- Positive: 6,5 pt (Sans Serif) / 8pt (Serif) – lower case letter based on the Regular Arial Font;
- Negative: 7,5pt (Sans Serif) / 9pt (Serif) – lower case letter based on the Regular Arial Font;
- Not condensed;
- Spacing (hinting) relative to the nominal increased by 10%.



Minimum Font Size

Product:	Date:	Type:	Chapter:
ALUMINIUM BEVERAGE CAN	01.05.2020	Aluminium cans	1.5.2
	Revision: 1	Approved by:	

BASIC REQUIREMENTS

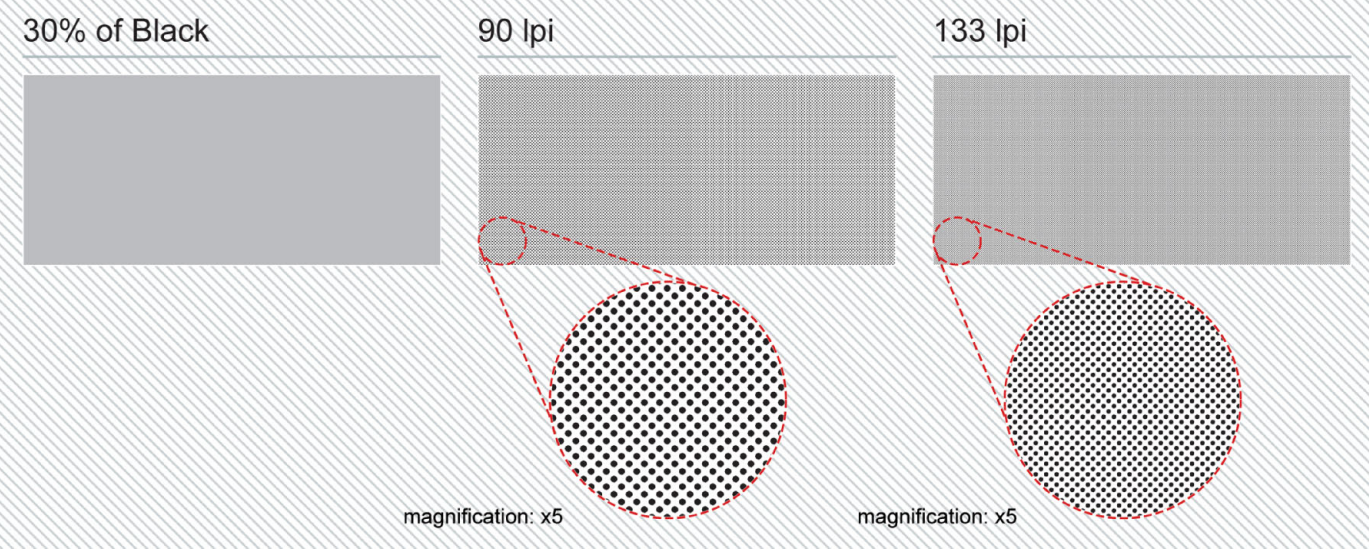
COLOURS

• Prepared artwork designs should only contain Pantone Solid Coated colours, that are required to appear on end product. With that in mind, your nominated graphic contact is able to understand the idea without additional questions (please prepare a colour legend and write for instance 70% of white etc.);
• CANPACK uses only an intensity of any particular Pantone colour (for example 30% of Pantone 226);
• Colours should be prepared in accordance with selected Pantone chart or with reference to existing colour sample (for instance: label, existing can or other packaging);
• For each design, the preparation process is for one artwork only and one colour set (Roll-outs). Thereafter for each version that is changed (new layout with different colours), this is treated as a new design and requires separate preparation and therefore it will be applied, in accordance with the Contract wording.

RASTERS

• Files (rasters, pictures to be printed on cans) should be prepared in PSD or TIFF format;
• Resolution: of at least 300 dpi with no merged layers;

CANPACK uses two technology types of printing: STD for Stadard and HR for Hi-Resolution, according to these CANPACK applies below rules:
• Screen Ruling: 85-90 lpi for STD technology and 133 lpi for HR technology;
• Minimum Dot: 6% of saturation for STD technology and 0% of saturation for HR technology.



30% of Black, Raster Simulation

Product:	Date:	Type:	Chapter:
ALUMINIUM BEVERAGE CAN	01.05.2020	Aluminium cans	1.5.2
	Revision: 1	Approved by:	

RASTERS PREPARATION PROCESS

Below there are images of three stages, showing how the preparation process works in the Dry-Offset technology:

- **Image 1**, shows original artwork file sent by client (CMYK image)
- **Image 2**, shows processed graphic by CANPACK; divided into PANTONE colours and "built-up with dots" considering ink increase during production
- **Image 3**, shows the real printed can, based on file prepared by CANPACK

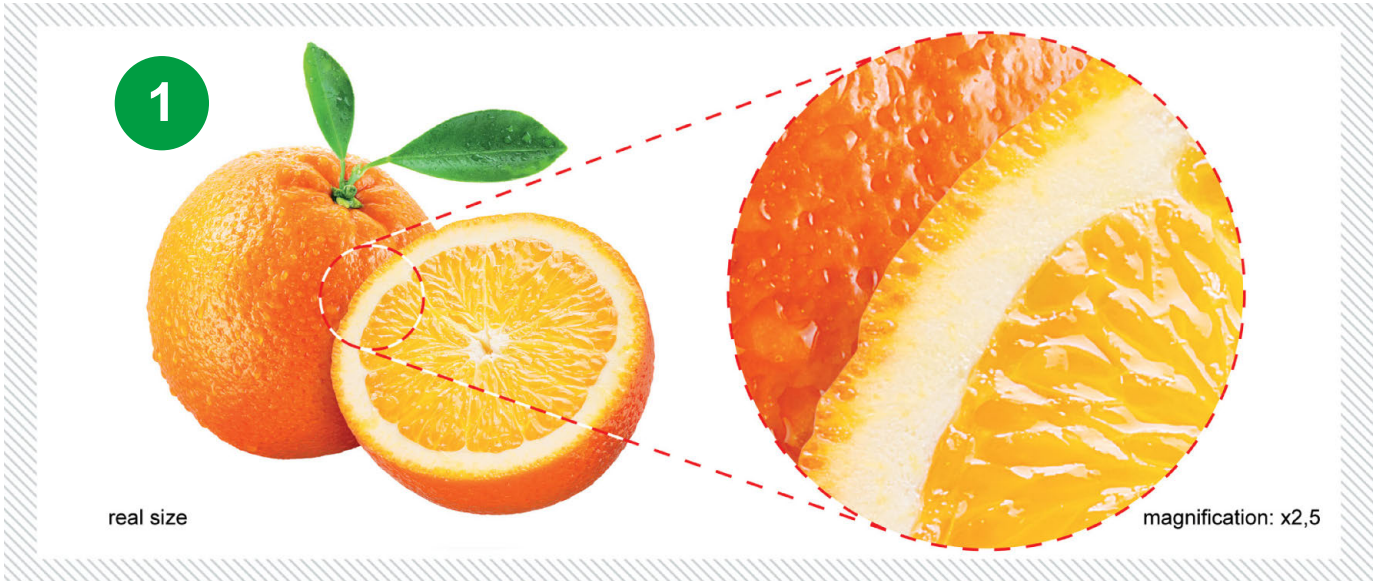


Image 1 (Original artwork file)

BASIC REQUIREMENTS

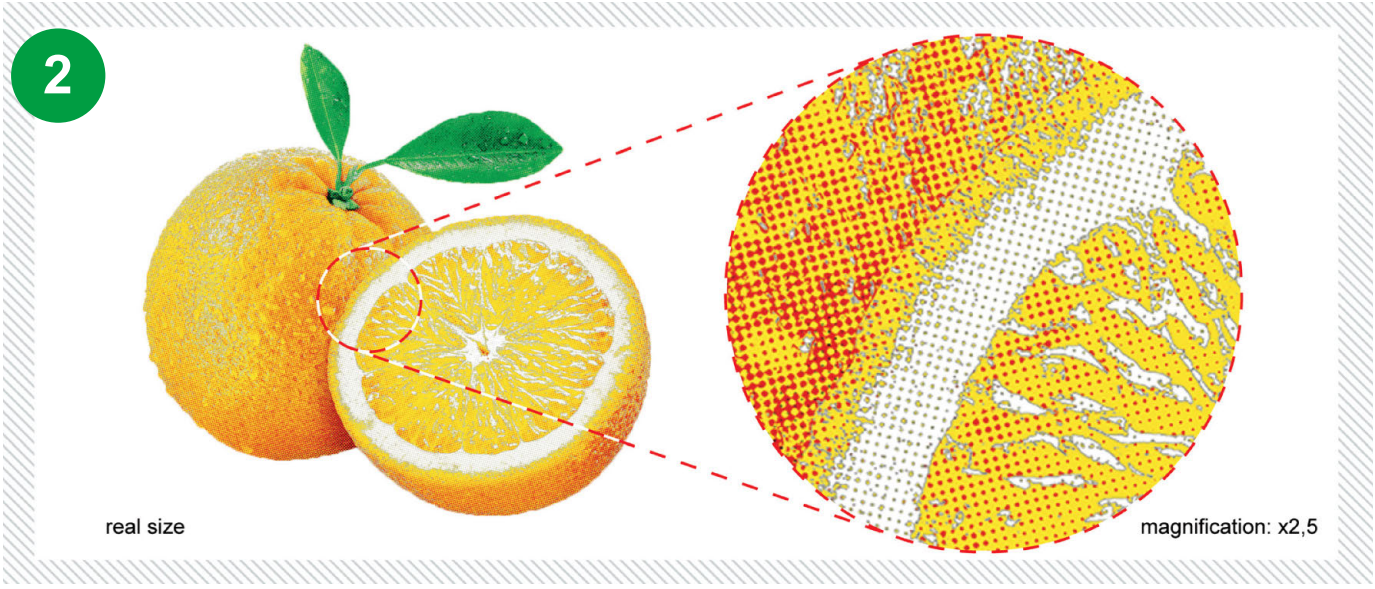


Image 2 (Processed graphic file, divided into PANTONE colours, “built-up with dots”)

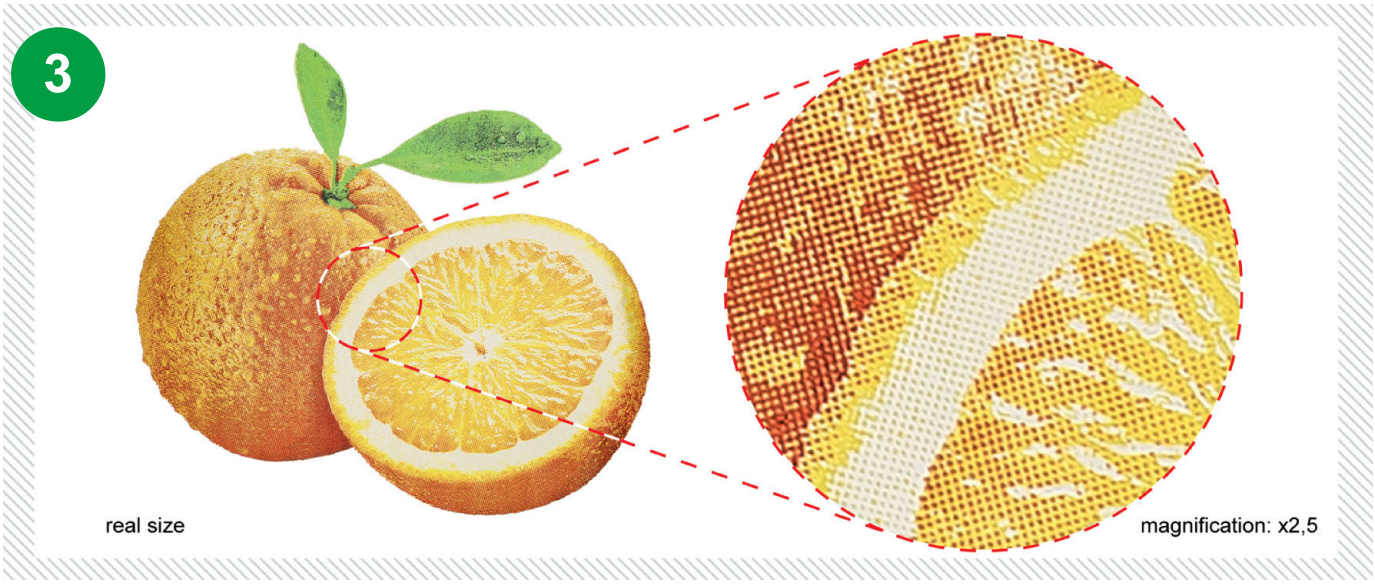


Image 3 (Real printed can)

Product:	Date:	Type:	Chapter:
ALUMINIUM BEVERAGE CAN	01.05.2020	Aluminium cans	1.5.2
	Revision: 1	Approved by:	

BASIC REQUIREMENTS

Images below present the impact of ink increase on the whole image. Both cans were printed based on the same file prepared by CANPACK. Each can has a pattern with divided colours shown as different intensity squares (10%, 50%, 100%)

- **Image 4**, shows a can printed with optimal colours intensity
- **Image 5**, shows how increase of red ink affects the whole image

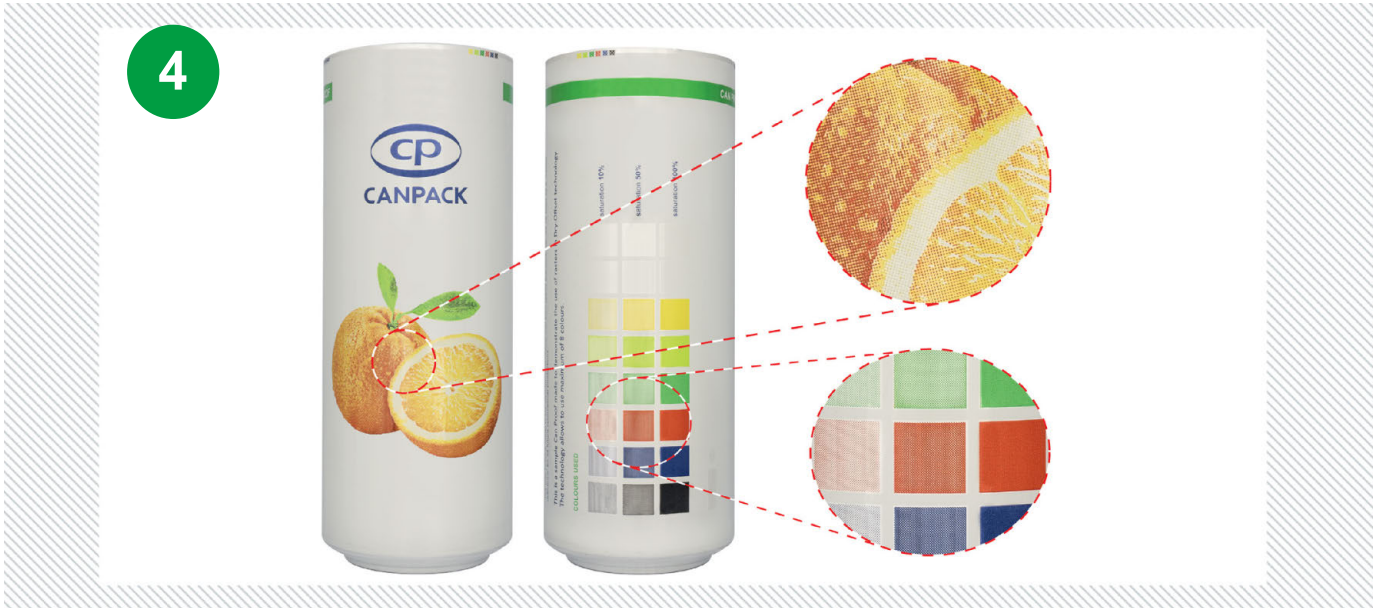


Image 4 (Can printed with optimal colours) intensity

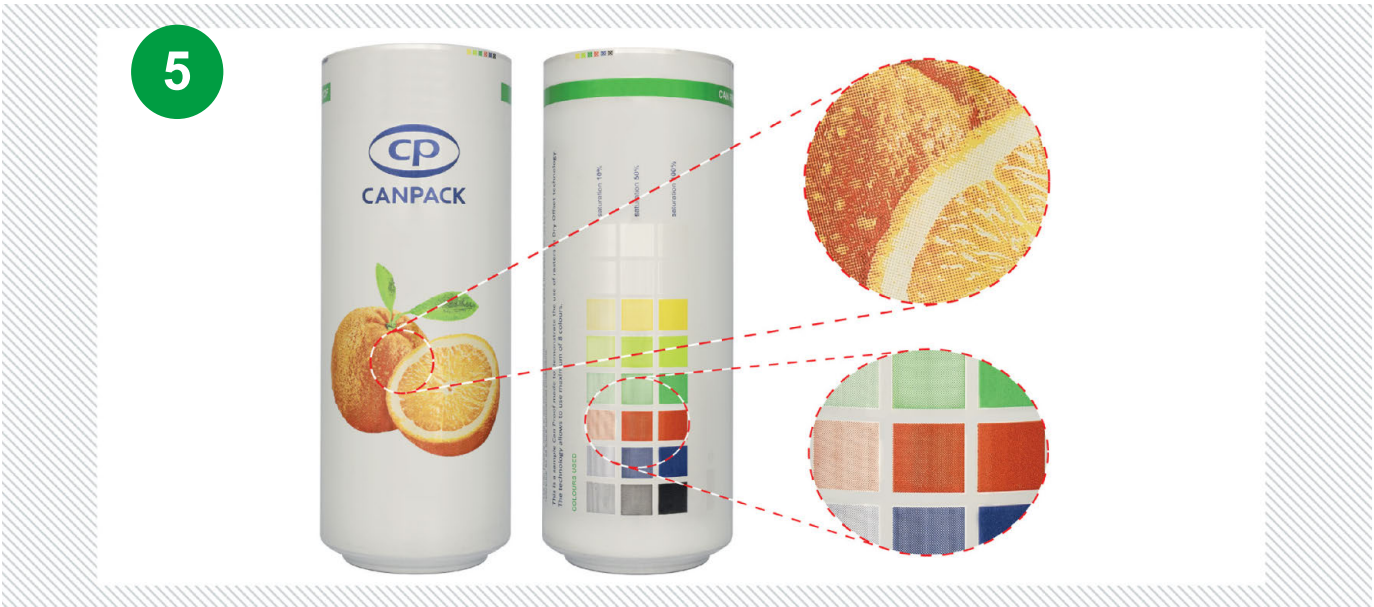


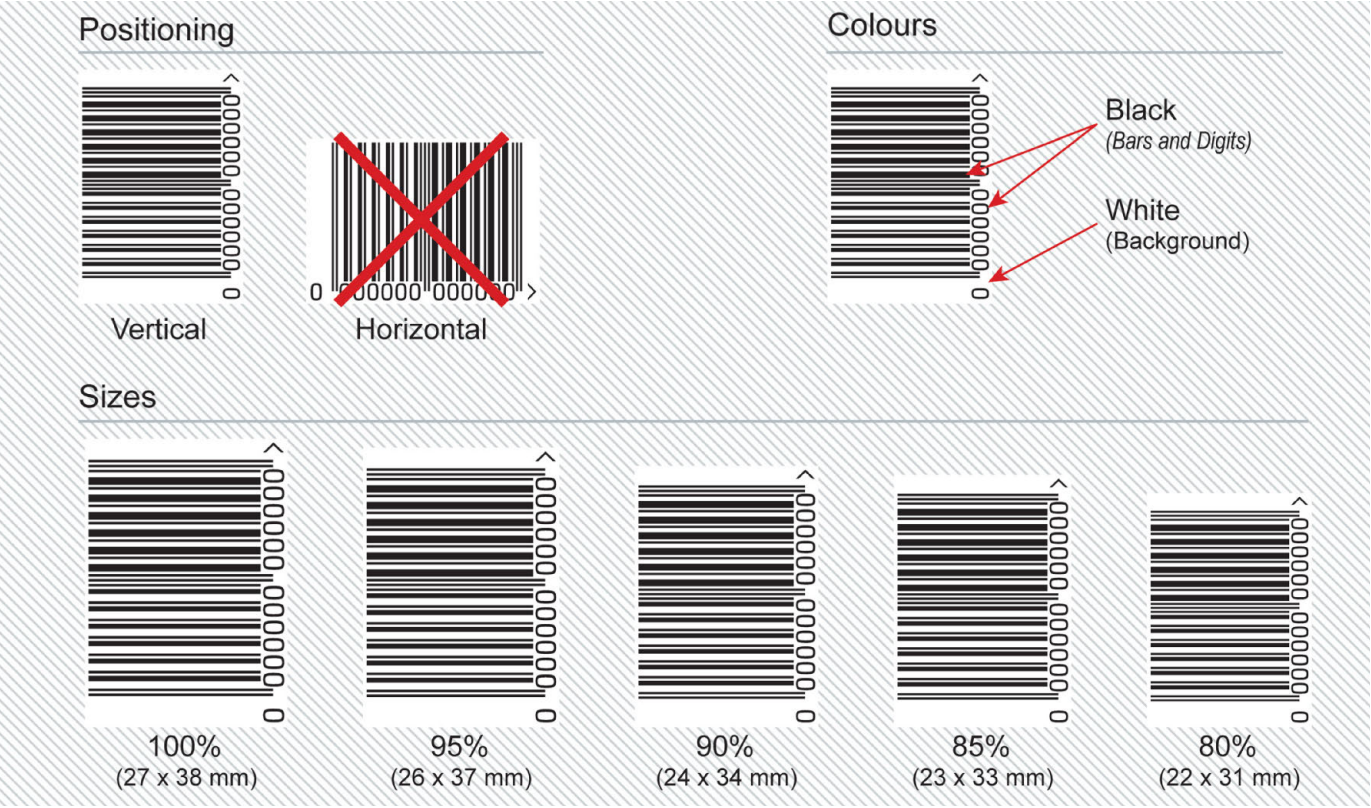
Image 5 (Can printed with red ink increased)

Product:	Date:	Type:	Chapter:
ALUMINIUM BEVERAGE CAN	01.05.2020	Aluminium cans	1.5.2
	Revision: 1	Approved by:	

BASIC REQUIREMENTS

BARCODES

- The barcode printing area principals:
- minimum size: 80%,
- suggested size: 90%;
- maximum size: 110%;
- Position of the barcode should always be veritical, not horizontal;
- Always use correct colours (white background, black bars and digits) for the barcodes to increase their legibility according to GS1 Standard;
- Barcodes outside the standard must be agreed between the customer and CANPACK.



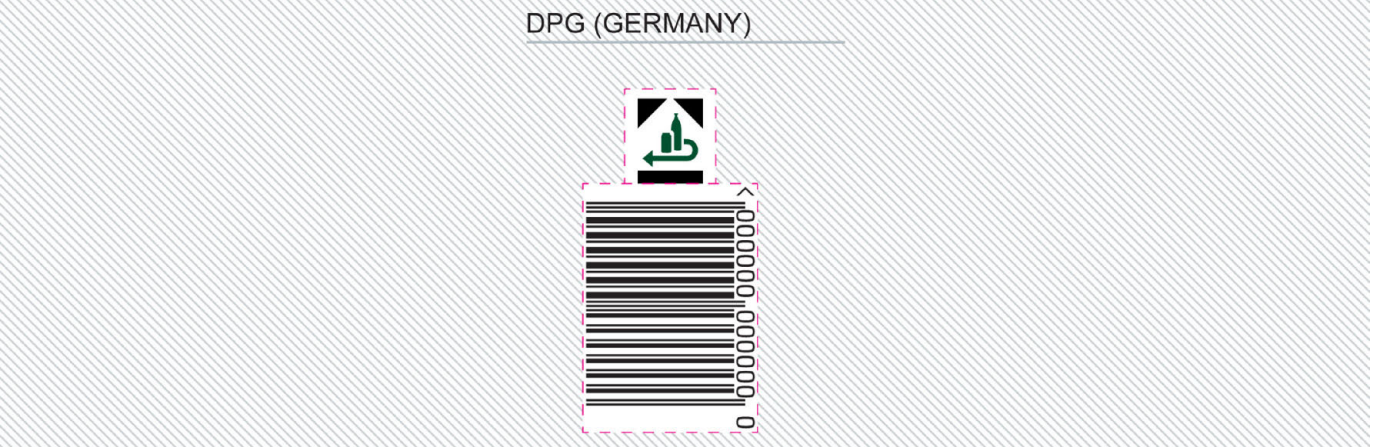
Barcode Rules

Product:	Date:	Type:	Chapter:
ALUMINIUM BEVERAGE CAN	01.05.2020	Aluminium cans	1.5.2
	Revision: 1	Approved by:	

BARCODES & DEPOSIT SCHEMES

- **DPG (Germany)**

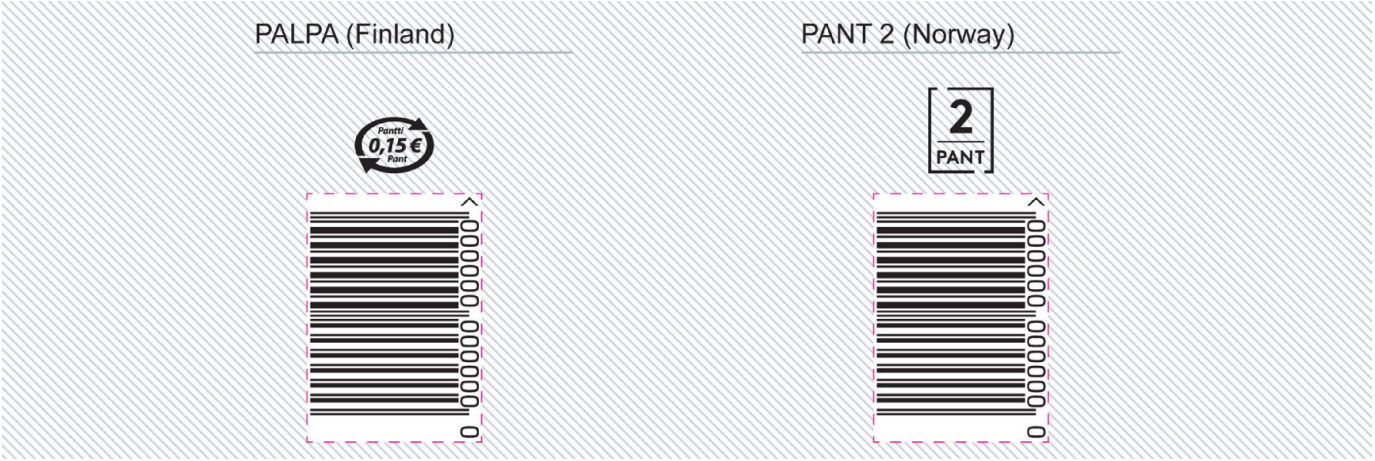
DPG deposit symbol requires using of a special ink, which is directly related to the use of a separate ink station (this should be taken into account at the initial design stage). CANPACK is a certified cans producer with a DPG deposit mark, and uses this symbol and rules associated with it, in accordance with DPG Deutsche Pfandsystem GmbH specification. Readability of this symbol is strictly controlled throughout the entire production stage.



DPG Symbol example

- **Other Deposit Schemes (Finland, Norway, etc.)**

In most cases, deposit symbols are related to EAN code size and require use of this code in accordance with GS1 specification. CANPACK does not verify used markings and rules on deposit symbols on local markets. The customer is responsible for correctness of deposit symbols placed in the project and their compliance with the applicable local markets regulations



Deposit Symbol examples

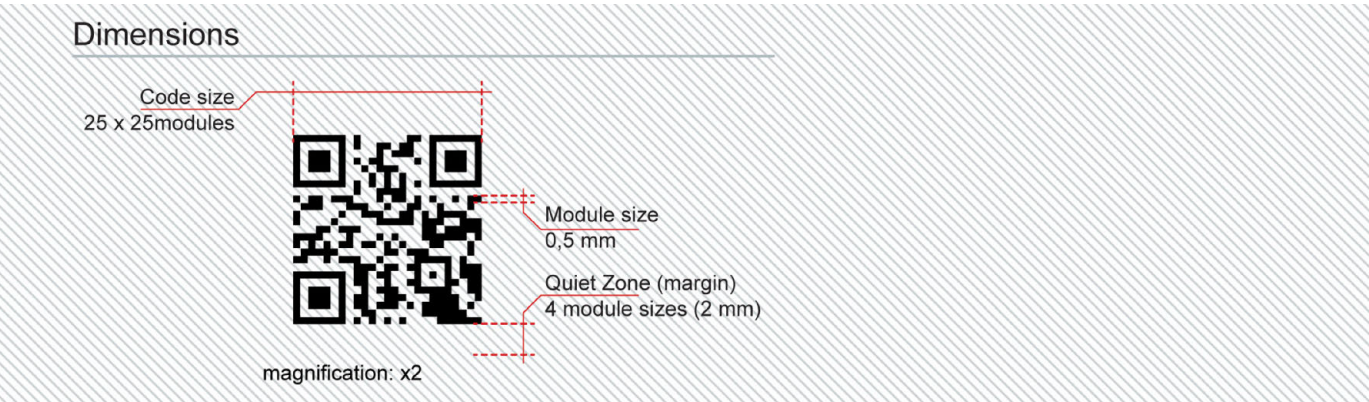
Product:	Date:	Type:	Chapter:
ALUMINIUM BEVERAGE CAN	01.05.2020	Aluminium cans	1.5.2
	Revision: 1	Approved by:	

BASIC REQUIREMENTS

2D CODES

QR code conforming to GS1 Standard:

- Minimum module size: 0,5 mm;
- Minimum code size: 21 x 21 modules;
- Maximum code size: 20% of can circumference;
- Permissible error correction: M, Q, H;
- Minimum Quiet Zone: 4 x module size;
- Reduction of print gain: 0,053 mm.



QR Code Sample Dimensions

DATAMATRIX CODE (ECC200) HAS TWO CONFIGURATIONS;

- Square with minimum size of 10 x 10 modules;
- Rectangular with minimum size of 8 x 16 modules;
- The margin around a DataMatrix code should be larger than a module.

DataMatrix Code Types

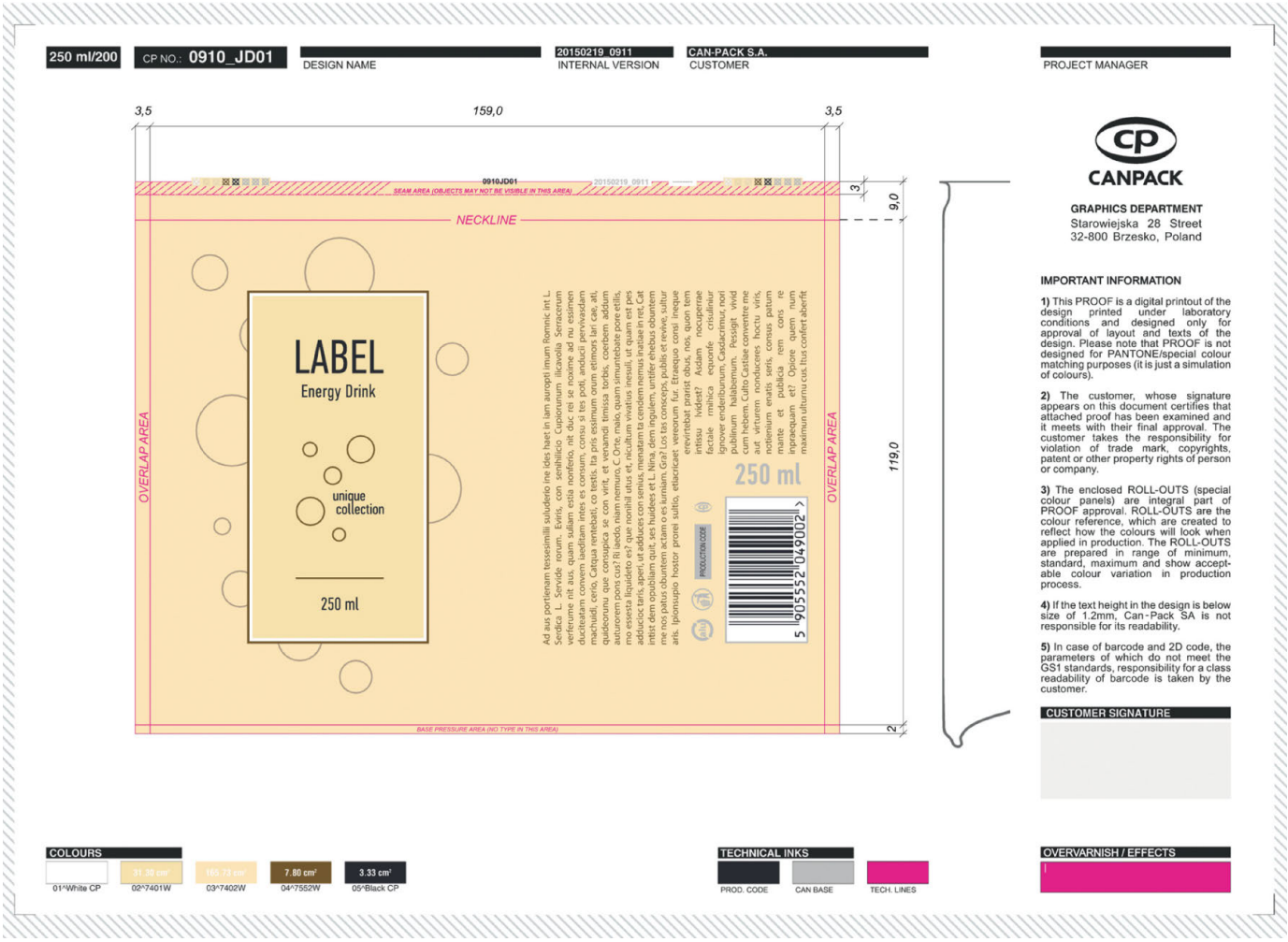
2D Codes outside the standard must be agreed between the customer and CANPACK. Any other codes such as Shazam, Instagram or Social Media codes are going to be treated as regular graphic elements and CANPACK will not take responsibility for their readability.

Product:	Date:	Type:	Chapter:
ALUMINIUM BEVERAGE CAN	01.05.2020	Aluminium cans	1.5.2
	Revision: 1	Approved by:	

1.5.3 APPROVAL PROCESS - TERMINOLOGY

PDF PROOF

PDF Proof is an electronic report generated after the design has been completed, where the separations are placed and artwork is adjusted to the printing process.
PDF Proof has been designed for layout and texts approval only.



PDF Proof example

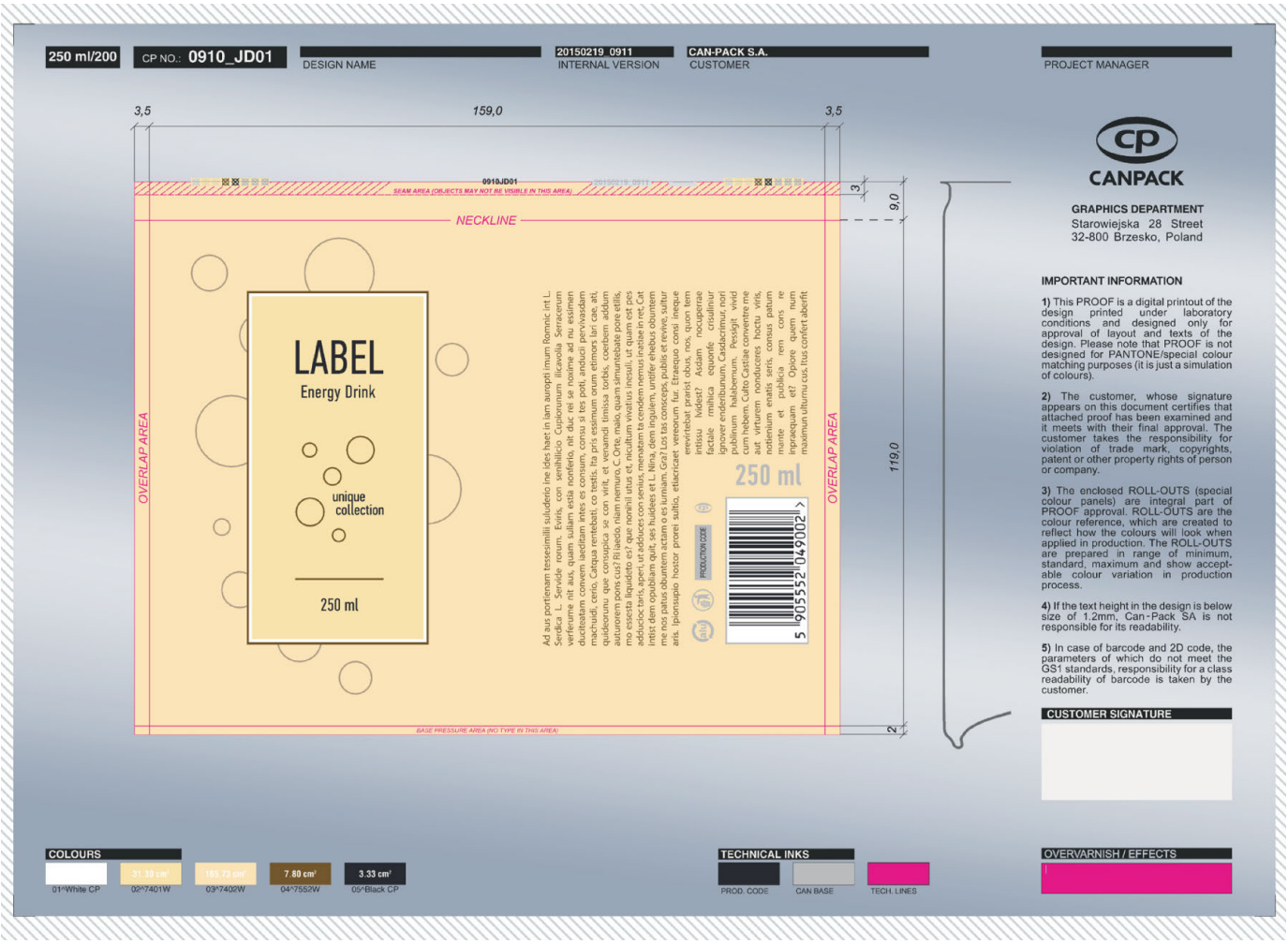
Product:	Date:	Type:	Chapter:
ALUMINIUM BEVERAGE CAN	01.05.2020	Aluminium cans	1.5.3
	Revision: 1	Approved by:	

APPROVAL PROCESS - TERMINOLOGY

PRINT PROOF

Digitally printed PDF Proof is a simulation of the design printed digitally under laboratory conditions and it is designed for layout and texts approval only.
Please note that Print Proof is not designed for colour matching purposes (it is just a simulation of colours) and due to print under laboratory conditions, dot gain phenomenon does not appear.

CANPACK prepares the Print Proof only on customer's special request.



Print Proof example

Product:	Date:	Type:	Chapter:
ALUMINIUM BEVERAGE CAN	01.05.2020	Aluminium cans	1.5.3
	Revision: 1	Approved by:	

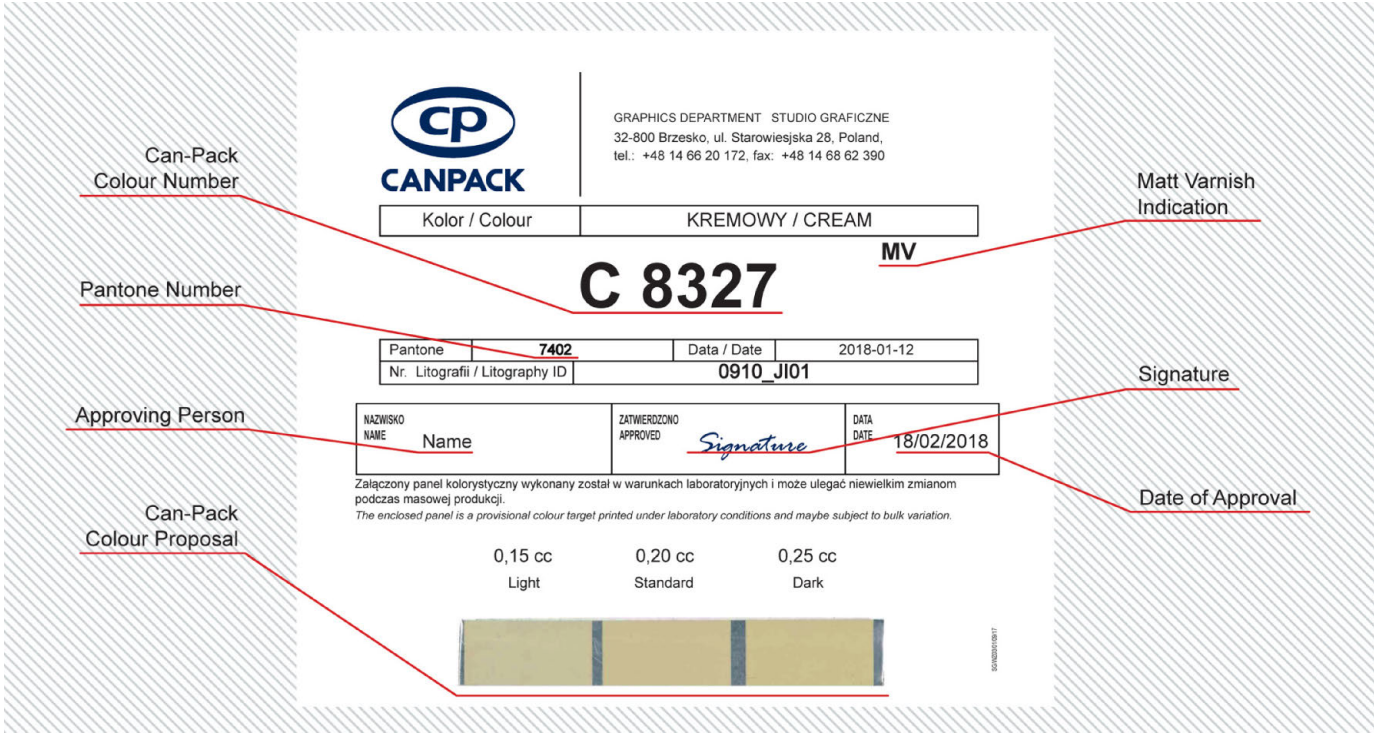
APPROVAL PROCESS - TERMINOLOGY

COLOUR ROLL-OUT

Roll-out is the colour reference which is created to reflect how the colours will look when applied in production:

- Flat aluminium plate (aluminium base)
- Colour Ink
- Overvarnish

Roll-outs are prepared, in range of minimum - standard - maximum and show colour variation. Try to choose a standard option as in commercial production the colour may vary within the minimum and maximum range.



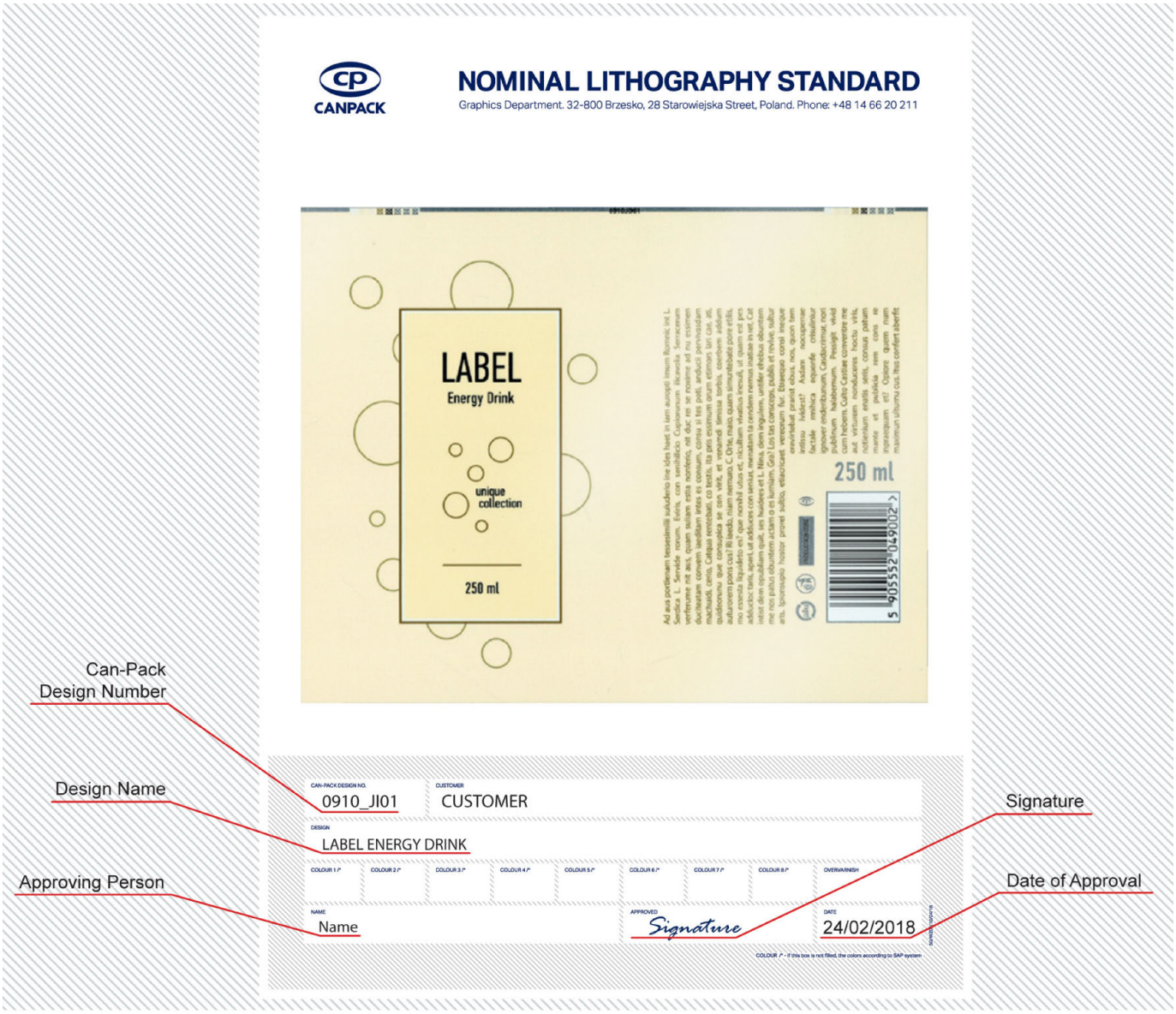
Roll-out example

APPROVAL PROCESS - TERMINOLOGY

PRODUCTION COLOUR STANDARD

Production Colour Standard is a beverage can, taken from the first commercial production run, placed onto the approval form/template.

After being signed by either CANPACK or the Customer's authorised representative, the print standard is used as reference for all future production runs of that design.



Production Colour Standard example

Please be aware that during production the colours may vary within the range of 0,05 cc (0,025 cc IGT) in comparion to approved Production Colour Standard.

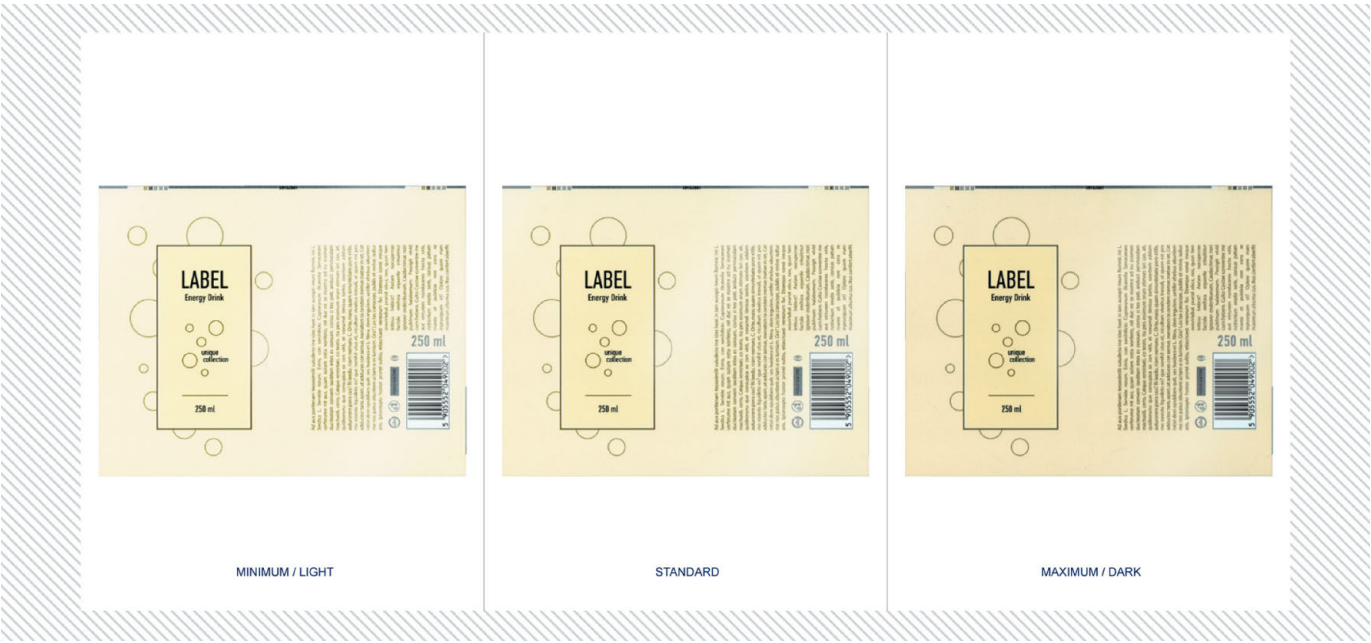
Product:	Date:	Type:	Chapter:
ALUMINIUM BEVERAGE CAN	01.05.2020	Aluminium cans	1.5.3
	Revision: 1	Approved by:	

APPROVAL PROCESS - TERMINOLOGY

PRODUCTION COLOUR STANDARD TOLERANCE

Production Colour Standard Tolerance is a set of three flat cans showing the entire design, printed in the range of **minimum - standard - maximum**.

After being signed by either CANPACK or the Customer's authorised representative, this is used as the reference for colours evaluation and for all future commercial production orders. In that case, Roll-outs are not applicable (only for first design approval before first production). Production Colour Standard Tolerance is made only after the prior agreement between CANPACK Sales Department and Customer's Purchasing Department.



Production Standard Colour Tolerance example

Product:	Date:	Type:	Chapter:
ALUMINIUM BEVERAGE CAN	01.05.2020	Aluminium cans	1.5.3
	Revision: 1	Approved by:	

APPROVAL PROCEDURE

1.5.4 APPROVAL PROCEDURE

1. PRE-APPROVAL

DURATION

5 working days

After receiving the artwork and colour reference, the CANPACK's Graphics Department will prepare a PDF Proof file for the first electronic pre-approval where the separation is placed and artwork is adjusted to the printing process. When dealing with very complicated projects the preparation process may increase in duration.

2. FINAL APPROVAL

DURATION

4 working days*

* additional 2 days for delivery

After approval of PDF version by the customer, CANPACK will then prepare the Colour Roll-outs and Print Proof*. The approval and production of cans is only possible after gaining customer's approval and return of the signed Colour Roll-outs (one copy of each) and Print Proof*.

*CANPACK prepares the Print Proof only on customer's special request.

3. CAN PROOF - TRIAL

DURATION

Timeline depends on Proof Printer availability and needs to be agreed with Coordinator

With complicated designs, which include rasters or limitations of 3-dimensional images, CANPACK would be ready to arrange a trail print in order to verify whether the concept can be applied to commercial production and if it gives the desired effect.
The Can Proof is made in the laboratory conditions with slow speed therefore can not be used as a 'master reference' for all future commercial productions.
Can Proofs are made on 500 ml cans. In exceptional cases, it is possible to print on cans of 250ml, 330ml, 550ml. Proof cans are not necked/flanged (straight wall cans).
For further details/price please discuss thus ussye with your CANPACK Area Sales Manager.

4. FIRST PRODUCTION RUN APPROVAL

When printing rasters or difficult designs CANPACK requests that customer sends a brand's representative to attend the first commercial production run for approval.
In case the Customer does not want to attend the first print run of complicated design due to any reason, CANPACK will arrange the production by themselves and with commitment to apply the best experience and practises, however, first batch produced without Customer's assistance has to be accepted and design adjustments are only possible during next order.
In case of lack of any feedback within two weeks, standards are assumed to be approved for all next productions.

5. PRODUCTION COLOUR STANDARDS

At the first print run, CANPACK will prepare the standard printing for normal approval. The printing standard is used for all future commercial production orders. Then 3 samples of the printed standards will be issued to the customer for their reference.

6. FINAL APPROVAL

With simple design changes of text only, CANPACK is willing to make an approval on an electronic basis only. The PDF Proof file, that is under change of text only is still under the control of the Customer and is carried out providing that no layout or colours are unchanged in comparison to previous version.

READY-TO-PRINT LITHOGRAPHIES

1.5.5 READY-TO-PRINT LITHOGRAPHIES

DEFINITION OF READY-TO-PRINT FILES

READY-TO-PRINT lithography means a project sent in a ready for printing form, which is entirely and at all stages prepared by the graphics agency and does not require any additional graphic interference from CANPACK Graphic Studio.
The role of CANPACK Graphic Studio in the preparation of a READY-TO-PRINT project is limited only to giving an index of material and ordering the naming of colours in the design and transferring lithographies to make printing plates.

GRAPHIC SPECIFICATION

CANPACK Graphic Studio delivers graphic specification to the graphic agency indicated by the customer.
This specification contains basic information necessary to prepare the design, such as dimensions of lithography area, barcodes and QR codes parameters, maximum number of colours, screen ruling, standard gappings between colours.

CUTTER

The design should be placed in our cutter of appropriate capacity, and should contain an index, production code, CP logo and colourboxes.

CP DESIGN ORDER FORM

Please complete and send to us CP Design Order Form. A well-completed document will allow us to eliminate possible errors at an early stage, resulting from the use of internal or external lacquer, which does not meet the client's requirements. The correct barcode number to be used in the project is also very important.

FORMAT OF GRAPHIC FILES

Graphic agency transfers to CANPACK Graphic Studio a project consisting of 1-bit TIFF files (with a resolution of 2400 ppi), separate for each colour. The name of each file should also contain a specific Pantone number. An additional file with a separation preview (gray, unprinted colour) is also required.
Raster elements must have appropriate screening and angles.
Composite and/or separation files are sent for verification/acceptance at the customer's request in the same resolution as production files.

READY-TO-PRINT LITHOGRAPHIES

IMPORTANT INFORMATION

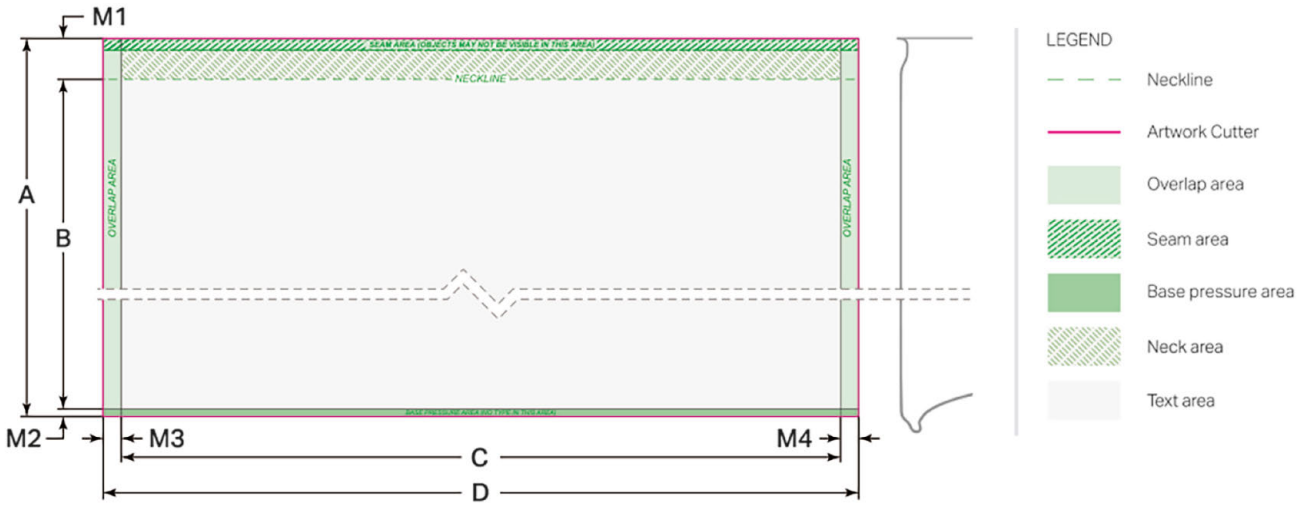
CANPACK Graphic Studio is not involved in the internal process of graphic preparation of lithography by the graphic agency, and does not provide any advice to the graphic agency. In particular, CANPACK Graphic Studio will not provide information which is an expert knowledge and which comes from the experience in designs preparation (know-how).

CANPACK Graphic Studio does not check the correctness of the project in terms of preparation and is not responsible for a final approval of the graphic design for printing. Graphic agency declaring the preparation of lithography in READY-TO-PRINT form, declares they know technological requirements of printing and accepts full responsibility for any printing errors resulting from improper preparation of the project at the stage of processing graphics and DTP.

CANPACK requests that customer sends a brand's representative to attend the first commercial production run for approval. In case the Customer does not want to attend the first print run of new design due to any reason, CANPACK will arrange the production by themselves and with commitment to apply the best experience and practises, however, first batch produced without Customer's assistance cannot be complained due to colour deviations. Design adjustments are only possible during next order.

LITHOGRAPHY DIMENSIONS - SLIM

1.5.6 LITHOGRAPHY DIMENSIONS



NOTE:

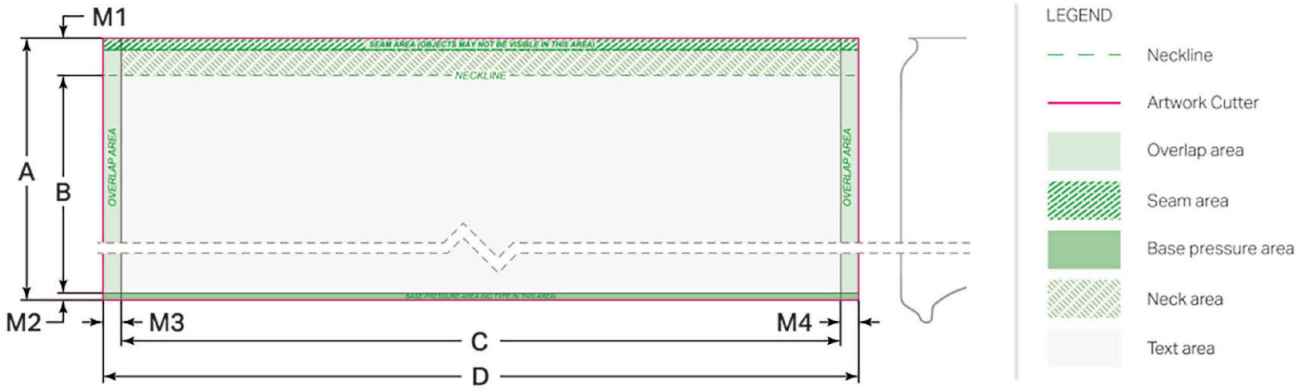
Seam area - objects may not be seen in this area,

Neck area - please note that objects will be distorted in this area,

Text area - suggested area for litography legal text, barcode, etc.,

Type of can (diameter) Body/Neck	Capacity - [ml]	Can height - [mm]	Litography area height A [mm]	Text area height B [mm]	Text area length C [mm]	Litography area length D [mm]
202/200	150	88,01	84,00	73,00	159,00	166,00
	185	103,38	101,40	90,40	159,00	166,00
	200	111,20	107,00	96,00	159,00	166,00
	240	130,00	127,00	116,00	166,00	166,00
	250	134,00	130,00	119,00	159,00	166,00
		Margins				
		M1 [mm]	M2 [mm]	M3 [mm]	M4 [mm]	
202/200	150	9,00	2,00	3,50	3,50	
	185	9,00	2,00	3,50	3,50	
	200	9,00	2,00	3,50	3,50	
	240	9,00	2,00	3,50	3,50	
	250	9,00	2,00	3,50	3,50	

LITHOGRAPHY DIMENSIONS - FIT



NOTE:

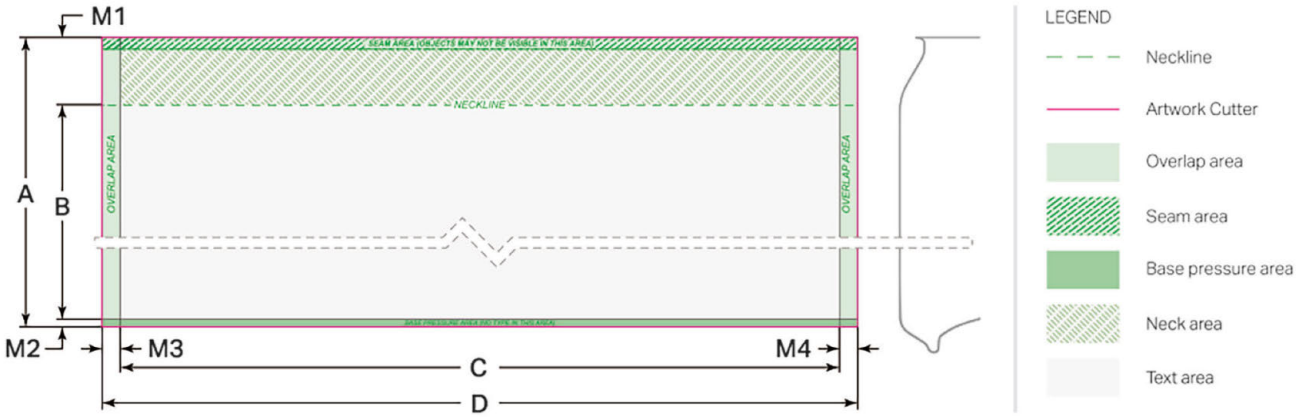
Seam area - objects may not be seen in this area,

Neck area - please note that objects will be distorted in this area,

Text area - suggested area for litography legal text, barcode, etc.,

Type of can (diameter) Body/Neck	Capacity - [ml]	Can height - [mm]	Litography area height A [mm]	Text area height B [mm]	Text area length C [mm]	Litography area length D [mm]
204/200	200 FIT	95,20	89,8	75,8	174,00	182,00
	269 FIT	122,22	119,5	105,5	174,00	182,00
	300 FIT	133,89	128,5	117,5	174,00	182,00
	330 FIT	145,40	140,0	126,0	174,00	182,00
	355 FIT	156,60	153,5	139,5	174,00	182,00
204/202	200 FIT	95,20	89,8	78,8	174,00	182,00
	269 FIT	122,22	119,5	108,5	174,00	182,00
	300 FIT	133,89	128,5	117,5	174,00	182,00
	330 FIT	145,40	140,0	129,0	174,00	182,00
	355 FIT	156,60	153,5	142,5	174,00	182,00
		Margins				
		M1 [mm]	M2 [mm]	M3 [mm]	M4 [mm]	
204/200	300	12,00	2,00	4,00	4,00	
	330	12,00	2,00	4,00	4,00	
	350	12,00	2,00	4,00	4,00	
	355	12,00	2,00	4,00	4,00	
	440	12,00	2,00	4,00	4,00	
204/202	473	9,00	2,00	4,00	4,00	
	500	9,00	2,00	4,00	4,00	
	550	9,00	2,00	4,00	4,00	
	568	9,00	2,00	4,00	4,00	
	330	9,00	2,00	4,00	4,00	

LITHOGRAPHY DIMENSIONS - STD



NOTE:

Seam area - objects may not be seen in this area,

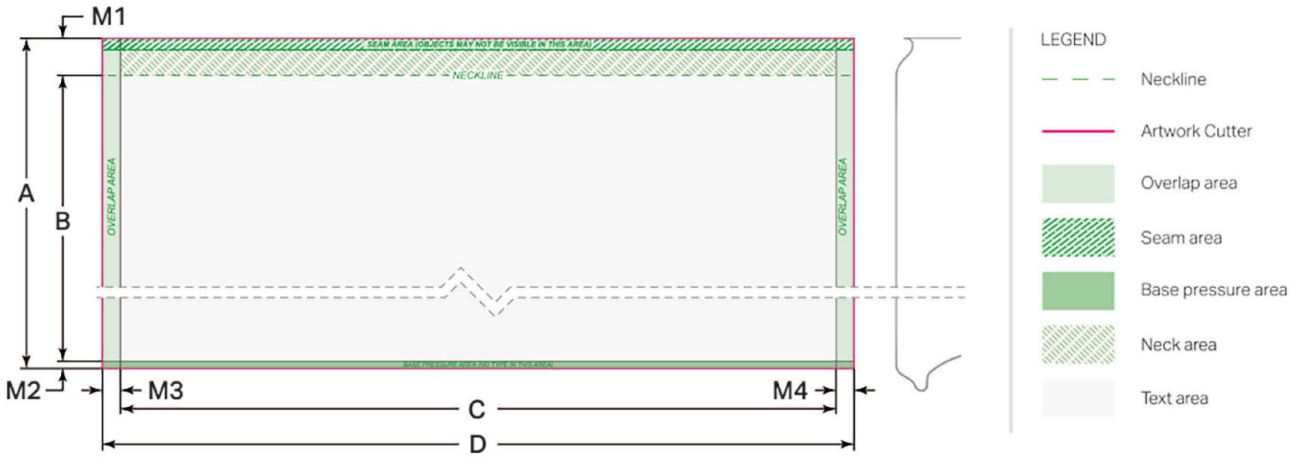
Neck area - please note that objects will be distorted in this area,

Text area - suggested area for litography legal text, barcode, etc.,

Type of can (diameter) Body/Neck	Capacity - [ml]	Can height - [mm]	Litography area height A [mm]	Text area height B [mm]	Text area length C [mm]	Litography area length D [mm]
211/202	300	106,27	99,00	78,50	198,00	208,00
	330	115,20	108,00	87,50	198,00	208,00
	350	122,22	115,00	94,50	198,00	208,00
	355	122,20	114,50	94,00	198,00	208,00
	440	149,90	142,50	122,00	198,00	208,00
	473	157,23	150,00	129,50	198,00	208,00
	500	168,00	160,50	140,00	198,00	208,00
	550	182,65	175,50	155,00	198,00	208,00
	568	188,09	181,00	160,50	198,00	208,00
211/206	330	115,20	108,00	93,00	198,00	208,00
		Margins				
		M1 [mm}	M2 [mm}	M3 [mm}	M4 [mm}	
211/202	300	18,50	2,00	5,00	5,00	
	330	18,50	2,00	5,00	5,00	
	350	18,50	2,00	5,00	5,00	
	355	18,50	2,00	5,00	5,00	
	440	18,50	2,00	5,00	5,00	
	473	18,50	2,00	5,00	5,00	
	500	18,50	2,00	5,00	5,00	
	550	18,50	2,00	5,00	5,00	
	568	18,50	2,00	5,00	5,00	
211/206	330	13,00	2,00	5,00	5,00	

Product:	Date:	Type:	Chapter:
ALUMINIUM BEVERAGE CAN	05.10.2017	Aluminium cans	1.5.6
	Revision: 1	Approved by:	

LITHOGRAPHY DIMENSIONS - LONGFIT



NOTE:

Seam area - objects may not be seen in this area,

Neck area - please note that objects will be distorted in this area,

Text area - suggested area for litography legal text, barcode, etc.,

Type of can (diameter) Body/Neck	Capacity - [ml]	Can height - [mm]	Litography area height A [mm]	Text area height B [mm]	Text area length C [mm]	Litography area length D [mm]
209/200	449	168,00	161,00	159,00	192,00	200,00
		Margins				
		M1 [mm}	M2 [mm}	M3 [mm}	M4 [mm}	
209/200	449	15,50	2,00	4,00	4,00	

Product:	Date:	Type:	Chapter:
ALUMINIUM BEVERAGE CAN	05.10.2017	Aluminium cans	1.5.6
	Revision: 1	Approved by:	

TRANSPORT, STORAGE AND WAREHOUSES SERVICES RELATED TO EMPTY BEVERAGE CANS

1.6.1 TRANSPORT, STORAGE AND WAREHOUSES SERVICES RELATED TO EMPTY BEVERAGE CANS

Transport, storage and warehouse services related to empty cans for beer and other beverages.

1. Loading

1.1. Before loading the goods, the following must be performed and checked:

- the conformity of the goods with the specification and the order number,
- the identification tags of the goods on respective pallets,
- elimination of damaged or protruding cans,
- goods must be always loaded with appropriate equipment causing no damages to both the goods and the packaging.
-

1.2. Before loading the goods, trailers / containers are verified according to below criteria:

- cargo space must be appropriate to the carriage of the goods issued,
- clean appearance and good technical condition,
- tight tarpaulin covering the whole cargo space; no holes, no cuts, no provisionary repairs,
- the floor and the sides must have a set of safety boards,
- cargo space must be free of any structural elements which would limit its stability,
- trailer must be adapted to put a seal (equipped with custom's cord in case of tarpaulins),
- trailer should be compatible for side-loading if side loading is used, as reported by Logistics Office,
- the height of the trailers must be enough to unload goods by forklift without risk of damage of top part of the pallet,
- the entire unit or vehicle is free of any foreign or foul odors,
- cargo space of the vehicle must be clean, free from sand, dust or any residue from cargo previously transported,
- the vehicle has not been used for the transport of radioactive substances,
- trailers / container must not be modified in a way enabling the carriage of goods or substances whose trade is prohibited by law (e.g. contraband or luxury goods, or any space utilized other than that of CANPACK's cargo).

1.3. Points of attention for all sea containers to be used for transport of empty cans and ends:

- if possible, use only containers solely used for transport of foodstuff.
- containers may not be delivered for shipment with the doors open.
- the container must be dry and clean inside i.e. free of dust, garbage and rust.
- water tight door seals and properly functioning door locks.
- use only containers without ventilation registers or with covered ventilation registers.
- neutral smell and not painted 30 days in advance of loading,
- not fumigated with pesticides.
- not treated/cleaned with chlorophenol-containing agents or strong-smelling agents.
- use of anti-odors agents or extra airing of the container, is not allowed.
- owing to a possible smell of paint and/or wood of new and repaired containers, these may only be o□ered after having been used several times by third parties.
- particularly free of off-flavours from previous loads, such as, but not limited to, cacao, coffee, fish products, onions, paint products, thinner, chemicals, oil products, as well as stuffy, moldy smells, may not occur in the container.

- moisture level of the floor of container must be checked in at least in 3 places, A - next to the doors, B – in the middle and C – in the rear of the container. The maximum moisture level in the wooden floor of container must not exceed 20%. Moisture measurement must be made with a wood moisture meter with that has been calibrated and certified as such within the past year

1.4 The loading operation should be performed in such a way so as to:

- avoid mechanical damages – pallets may be transported only in the vertical position,
- the pallets put on the load carrying body must strictly adjoin one another and be arranged in such a way to occupy the whole load space,
- the space unused must be secured by either nailing or stretched belts so as to eliminate the possibility of the shift of the load during the transport,
- pallets with cans must be loaded on the trailer in the way that the labels must be visible after opening trailer (sides and back) – forklift driver must see the labels before taking out the pallet,
- the ends should be loaded on the trucks so that the sleeves are placed in parallel to the driving direction; in a railway car, however, they should be arranged vertically to the driving direction.

Any discrepancies occurring between the order and the actual fact finding must be reported immediately either to the person in charge of deliveries or to the Logistics Office.

2. Unloading

2.1. It should take place by means of appropriate equipment causing no damages to both the goods and the transport packaging, in compliance with the product specification.

2.2. The manufacturer shall guarantee correct quantity and quality of the goods loaded in his factory if:

- the load-carrying body is secured with a numbered seal, which is compliant with the seal number printed on shipping document [CMR,PO],
- aluminium cans, being unloaded either manually or with a forklift, should be always transported vertically,
- the pallets without identification cards should be immediately reported to the manufacturer,
- goods are subjected to a visual examination of a pallet before and during unloading in compliance with points 1.1.1 and 1.2.2.

2.3. In case of finding and determining any differences or damages to the goods or wetting of either the goods themselves or the packing, caused by improper transportation, the following steps must be taken up:

- if a damage does not affect the quality of the filling process or there are less than 0,1% damaged pieces per pallet, it is necessary to remove all protruding or damaged cans, to record the actual difference or the range of the actual damages in a transportation document [CMR, PO] and send to the Logistics Office within seven days after the occurrence of such event.
- if the supplied goods are disqualified from being filled due to damage, it is necessary to send a transport damage protocol to the Logistics O□ce within 7 days following the day of occurrence of such event.
- please also send us a photograph in support of a damage or destruction of goods so as to determine the real cause of the damages.
- in case of having no documentation regarding transport damages (include but not limited to - lack of any annotation of damage on transportation document [CMR,PO]) , the goods sent shall be considered as accepted without reservations.

The aforesaid information will be useful to control the quality of the services rendered by the respective forwarders, and will allow to eliminate dishonest drivers.

3. Warehouse (external warehouse) and goods storage.

3.1 Upon unloading and loading of the goods, one shall apply the same procedures as in the case of direct deliveries.

3.2. A warehouse of storing empty Aluminum beer and beverage cans should comply with the following criteria:

- its surface must be clean, dry and even,
- the humidity rate must not exceed 75%,
- within a short time interval, temperature fluctuations must not exceed 10C (constant temperature),
- the stored cans should be protected from direct sunlight, precipitation and should not be stored directly either at the chemical compounds that may cause corrosion or other substances that may favor the penetration of bad odors into the product,
- pallets with ready made products should be placed in rows according to assortments, in order to secure free access to respective lithographic symbols,
- distances among the pallets should guarantee safe storage causing no mechanical damages,
- the maximum allowed storage height shall be 4 pallets of cans,
- recommended method to store easy-open lids should be storage with the use of racks/shelves racking systems,
- if no racks/shelves racking system in place – storage on the floor, maximum 2 pallets height, with plywood board separator (minimum thickens of board is 7 mm), to distribute the weight of the upper pallet evenly,
- storage of pallets one on another without plywood separator is not allowed;
- the goods should be transported vertically and using the appropriate devices or equipment,
- each warehouse must be checked once a week; in case of any damages, found defects should be removed and the Logistics O□ce should be notified about such event,
- the documents certifying both incoming and outgoing goods (especially in external warehouses) should be kept updated and archived; the reporting conditions and frequency are set forth in the co-operation agreements.

TRANSPORT DAMAGE CERTIFICATE

4. Transport complaint notification - template

Product:	Date:	Type:	Chapter:
TRANSPORT DAMAGE CERTIFICATE	15.07.2021	Aluminium cans	1.6.1
	Revision: 2	Approved by:	

END
THE BASIC INFORMATION

END - BASIC INFORMATION

END THE BASIC INFORMATION

EXPLANATION OF TERMS:

LOE – Large Opening End

SOE – Standard/ Small Opening End

SOT – Stay On Tab

OPENING TYPE

SOT
(Stay On Tab)

OPENING PANEL STYLE

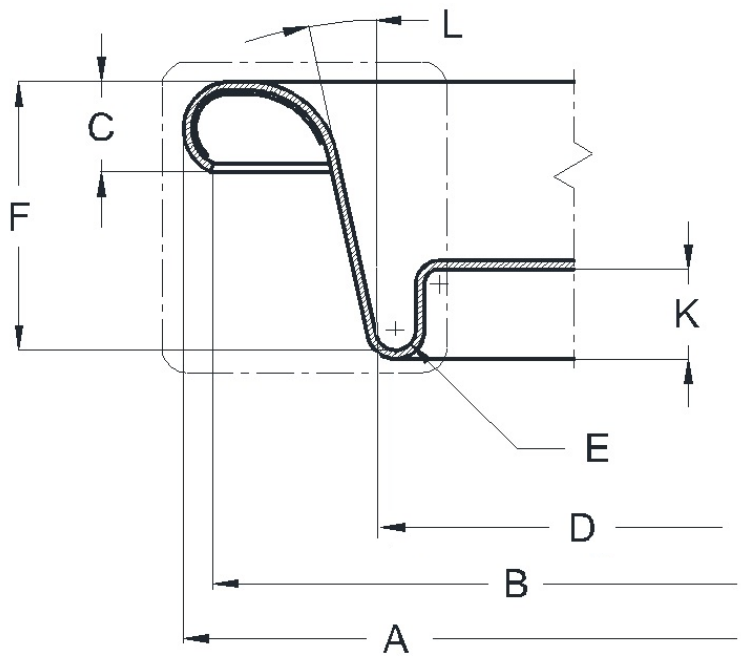
SOE
(Standard Opening Ends)

LOE
(Large Opening Ends)

Product:	Date:	Type:	Chapter:
ALUMINIUM easy open ends for beverage drinks	15.11.2023	200 B64	2.1.1
	Revision: 6	Approved by:	

END - BASIC INFORMATION

2.1.2 200 B64



Dimensions	200 B64 dia					
-	Unit	Value	Tolerance +/-	Unit	Value	Tolerance +/-
A - Curl diameter	[mm]	57,00	0,25	[inch]	2,244	0,0098
B - Inner curl diameter	[mm]	55,20	min	[inch]	2,173	min
C - Curl height	[mm]	2,05	0,15	[inch]	0,081	0,0059
D - Counter sink diameter	[mm]	47,42	Ref	[inch]	1,866	Ref
E - Counter sink radius	[mm]	0,43	Ref	[inch]	0,170	Ref
F - Counter sink depth	[mm]	6,60	0,15	[inch]	0,260	0,0059
K - Panel depth	[mm]	2,34	0,20	[inch]	0,092	0,0079
L - Chuck wall angle	[deg]	12^0	-	[deg]	12^0	-
Basic information	Nominal Value					
Base material thicknes	[mm]	0,220	0,005	[inch]	0,0086	0,0002
Material	typ	Aluminium alloy				
Inside coating type	typ	PVC Free				
Pop Force	[N]	27	max	[lbs]	6,1	max
Push Force	[N]	36	max	[lbs]	8,1	max
Buckle pressure	[kPA]	620	min	[PSI]	90	min
Compound type	Water Base Compound /WBC/					
Compound placement	High On Shoulder					
Enamel rater	[mA]	ind. 15				max
		avg. 2				

Product:	Date:	Type:	Chapter:
ALUMINIUM easy open ends for beverage drinks	10.03.2022	200 B64	2.1.2
	Revision: 6	Approved by:	

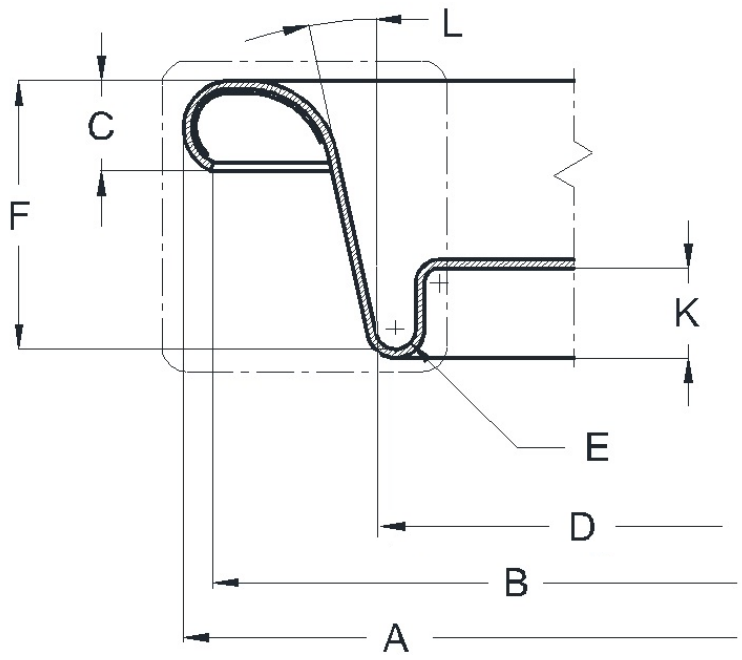
END - BASIC INFORMATION

2.1.3 200 B64

Opening type	Dia	Tab Type
End mark: B64/SOT/LOE	200	JCAT-91R
	Produced by:	CANPACK Middle East
End mark: B64/SOT/SOE	200	JCAT-91R
	Produced by:	CANPACK Middle East
End mark: B64/SOT/SOE	200	JCAT-91R
	Produced by:	CANPACK Middle East

END - BASIC INFORMATION

2.1.4 202 B64

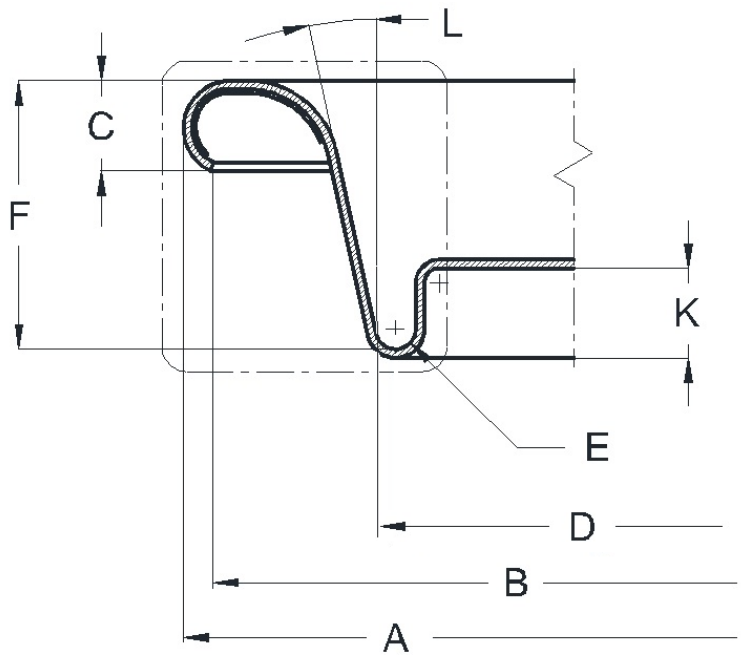


Dimensions	202 B64 dia					
-	Unit	Value	Tolerance +/-	Unit	Value	Tolerance +/-
A - Curl diameter	[mm]	59,44	0,25	[inch]	2,340	0.0098
B - Inner curl diameter	[mm]	57,60	min	[inch]	2,268	min
C - Curl height	[mm]	2,08	0,15	[inch]	0,082	0,0059
D - Counter sink diameter	[mm]	49,61	Ref	[inch]	1,953	Ref
E - Counter sink radius	[mm]	0,51	Ref	[inch]	0,020	Ref
F - Counter sink depth	[mm]	6,86	0,15	[inch]	0,270	0,0059
K - Panel depth	[mm]	2,34	0,15	[inch]	0,092	0,0059
L - Chuck wall angle	[deg]	12° 25'	-	[deg]	12° 25''	-
Basic information	Nominal Value					
Base material thicknes	[mm]	0,224	0,005	[inch]	0,0088	0,0002
Material	typ	Aluminium alloy				
Inside coating type	typ	PVC Free				
Pop Force	[N]	27	max	[lbs]	6,1	max
Push Force	[N]	36	max	[lbs]	8,1	max
Buckle pressure	[kPA]	620	min	[PSI]	90	min
Compound type	Water Base Compound /WBC/					
Compound placement	High On Shoulder					
Enamel rater	[mA]	ind. 15				max
		avg. 2				

Product:	Date:	Type:	Chapter:
ALUMINIUM easy open ends for beverage drinks	17.11.2022	202 dia / B64	2.1.4
	Revision: 7	Approved by:	

END - BASIC INFORMATION / MEA

2.1.5 202 B64

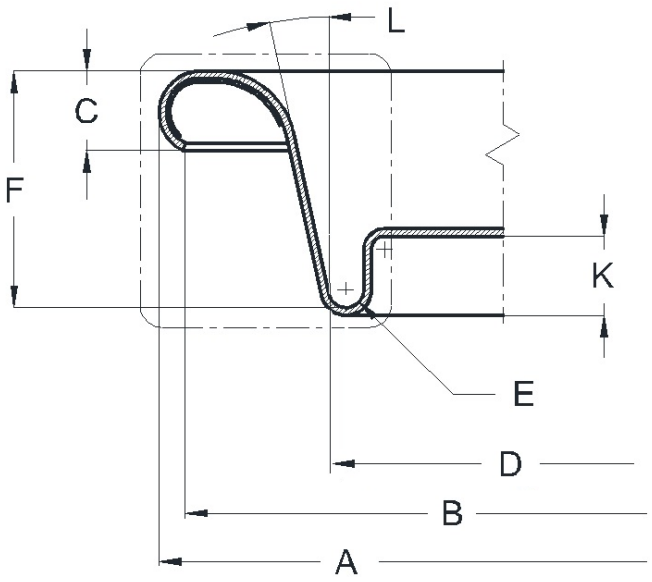


Dimensions	202 B64 dia					
-	Unit	Value	Tolerance +/-	Unit	Value	Tolerance +/-
A - Curl diameter	[mm]	59,44	0,25	[inch]	2,340	0.0098
B - Inner curl diameter	[mm]	57,60	min	[inch]	2,268	min
C - Curl height	[mm]	2,08	0,15	[inch]	0,082	0,0059
D - Counter sink diameter	[mm]	49,61	Ref	[inch]	1,953	Ref
E - Counter sink radius	[mm]	0,51	Ref	[inch]	0,020	Ref
F - Counter sink depth	[mm]	6,86	0,15	[inch]	0,270	0,0059
K - Panel depth	[mm]	2,60	0,08	[inch]	0,092	0,0031
L - Chuck wall angle	[deg]	12° 25"	-	[deg]	12° 25"	-
Basic information	Nominal Value					
Base material thicknes	[mm]	0,224	0,005	[inch]	0,0088	0,0002
Material	typ	Aluminium alloy				
Inside coating type	typ	PVC Free				
Pop Force	[N]	27	max	[lbs]	6,1	max
Push Force	[N]	36	max	[lbs]	8,1	max
Buckle pressure	[kPA]	620	min	[PSI]	90	min
Compound type	Water Base Compound /WBC/					
Compound placement	High On Shoulder					
Enamel rater	[mA]	ind. 10				max
		avg. 2				

Product:	Date:	Type:	Chapter:
ALUMINIUM easy open ends for beverage drinks	08.12.2022	202 dia / B64	2.1.5
	Revision: 1	Approved by:	

END - BASIC INFORMATION / North America

2.1.6 202 B64



Dimensions	202 B64 dia					
-	Unit	Value	Tolerance +/-	Unit	Value	Tolerance +/-
A - Curl diameter	[mm]	59,44	0,25	[inch]	2,340	0.0098
B - Inner curl diameter	[mm]	57,60	min	[inch]	2,268	min
C - Curl height	[mm]	2,08	0,15	[inch]	0,082	0,0059
D - Counter sink diameter	[mm]	49,61	Ref	[inch]	1,953	Ref
E - Counter sink radius	[mm]	0,508	Ref	[inch]	0,020	Ref
F - Counter sink depth	[mm]	6,86	0,15	[inch]	0,270	0,0059
I – Outer panel diameter	[mm]	-	-	[inch]	-	-
K - Panel depth	[mm]	2,38	0,15	[inch]	0,093	0,0059
L - Chuck wall angle	[deg]	12° 25"	-	[deg]	12° 25"	-
Basic information	Nominal Value					
Base material thicknes	[mm]	0,224	0,005	[inch]	0,0088	0,0002
Material	typ	Aluminium alloy				
Inside coating type	typ	PVC Free				
Pop Force	[N]	23	max	[lbs]	5,2	max
Push Force	[N]	27	max	[lbs]	6,1	max
Buckle pressure	[kPA]	620	min	[PSI]	90	min
Compound type	Water Base Compound /WBC/					
Compound placement	High On Shoulder					
Enamel rater	[mA]	ind. 15				max
		avg. 2				

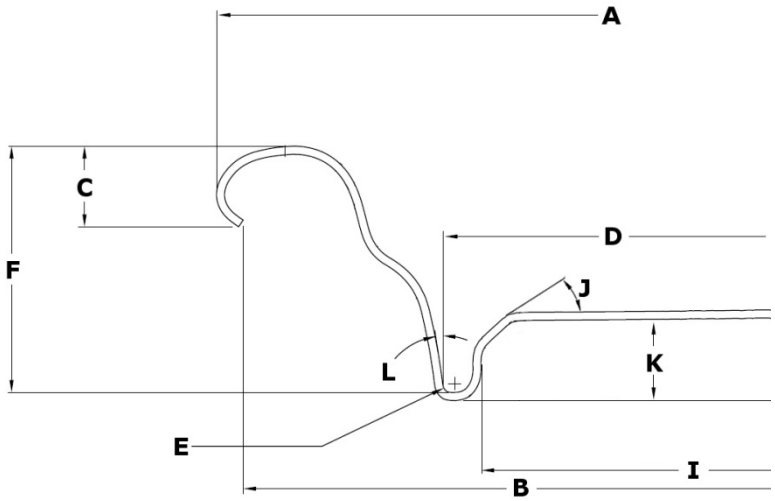
END - BASIC INFORMATION

2.1.7 202 B64

Opening type	Dia	Tab Type
End mark: B64/SOT/LOE	202	STOLLE-X
	Produced by:	CANPACK US (Olyphant)
End mark: B64/SOT/LOE	202	JCAT-91R
	Produced by:	CANPACK Middle East
End mark: B64/SOT/SOE	202	JCAT-91R
	Produced by:	CANPACK Middle East
End mark: B64/SOT/LOE	202	JCAT-91R
	Produced by:	CANPACK Middle East

END - BASIC INFORMATION

2.1.8 200 CDL



Dimensions	200 CDL dia					
-	Unit	Value	Tolerance +/-	Unit	Value	Tolerance +/-
A - Curl diameter	[mm]	56,90	0,25	[inch]	2,240	0.0098
B - Inner curl diameter	[mm]	55,20	min	[inch]	2,173	min
C - Curl height	[mm]	2,08	0,15	[inch]	0,082	0,0059
D - Counter sink diameter	[mm]	45,51	Ref	[inch]	1,792	Ref
E - Counter sink radius	[mm]	0,48	Ref	[inch]	0,019	Ref
F - Counter sink depth	[mm]	6,35	0,15	[inch]	0,250	0,0059
I – Outer panel diameter	[mm]	43,20	Ref	[inch]	1,700	Ref
J – Panel angle	[deg]	45^0	-	[deg]	45^0	
K - Panel depth	[mm]	2,03	0,15	[inch]	0,082	0,0059
L - Chuck wall angle	[deg]	8^0-$11,5^0$	-	[deg]	8^0-$11,5^0$	-
Basic information	Nominal Value					
Base material thicknes	[mm]	0,203	0,005	[inch]	0,0080	0,0002
Material	typ	Aluminium alloy				
Inside coating type	typ	PVC Free				
Pop Force	[N]	27	max	[lbs]	6,1	max
Push Force	[N]	36	max	[lbs]	8,1	max
Buckle pressure	[kPA]	620	min	[PSI]	90	min
Compound type	Water Base Compound /WBC/					
Compound placement	High On Shoulder					
Enamel rater	[mA]	ind. 15				max
		avg. 2				

Product:	Date:	Type:	Chapter:
ALUMINIUM easy open ends for beverage drinks	10.03.2022	200 CDL	2.1.8
	Revision: 7	Approved by:	

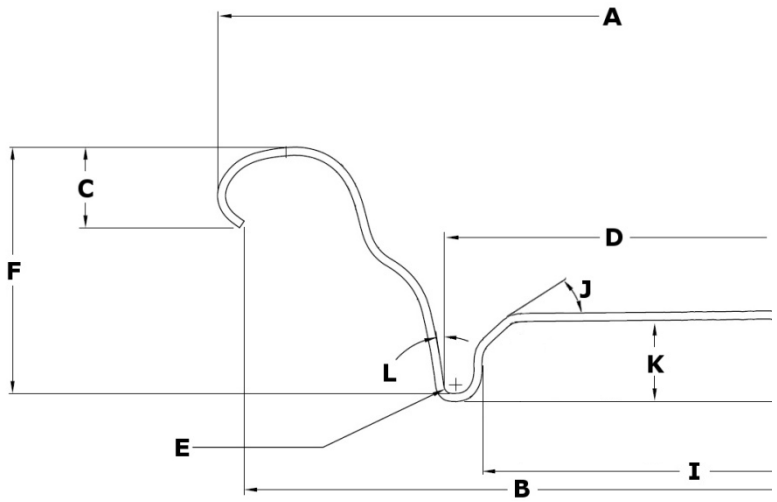
END - BASIC INFORMATION

2.1.9 200 CDL

Opening type	Dia	Tab Type
End mark: CDL/SOT/LOE	200	CAT-99
	Produced by:	CANPACK Poland (Brzesko)
End mark: CDL/SOT/STD	200	CAT-99
	Produced by:	CANPACK Poland (Brzesko)
End mark: CDL/SOT/STD	200	JCAT-91R
	Produced by:	CANPACK Poland (Brzesko) CANPACK Middle East
End mark: CDL/SOT/LOE	200	JCAT-91R
	Produced by:	CANPACK Middle East CANPACK Poland (Brzesko)

END - BASIC INFORMATION

2.1.10 202 CDL

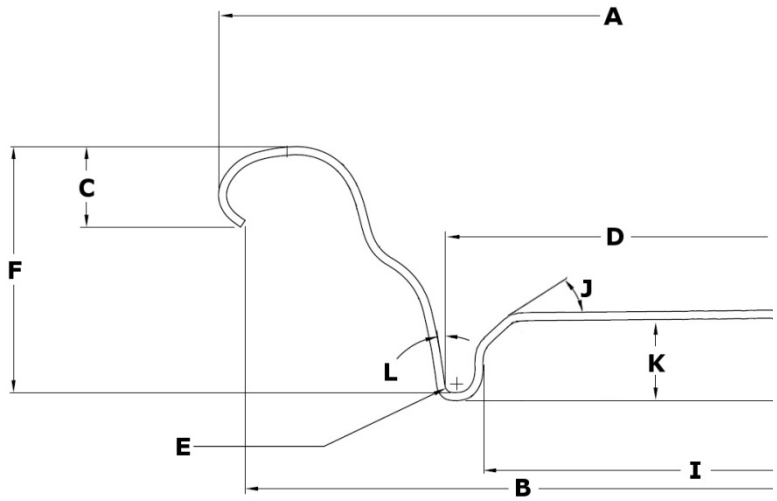


Dimensions	202 CDL dia					
-	Unit	Value	Tolerance +/-	Unit	Value	Tolerance +/-
A - Curl diameter	[mm]	59,31	0,25	[inch]	2,335	0.0098
B - Inner curl diameter	[mm]	57,60	min	[inch]	2,268	min
C - Curl height	[mm]	2,06	0,15	[inch]	0,081	0,0059
D - Counter sink diameter	[mm]	47,42	Ref	[inch]	1,867	Ref
E - Counter sink radius	[mm]	0,23	Ref	[inch]	0,009	Ref
F - Counter sink depth	[mm]	6,35	0,15	[inch]	0,250	0,0059
I – Outer panel diameter	[mm]	45,56	Ref	[inch]	1,793	Ref
J – Panel angle	[deg]	45^0	-	[deg]	45^0	
K - Panel depth	[mm]	2,04	0,15	[inch]	0,080	0,0059
L - Chuck wall angle	[deg]	8º35"	-	[deg]	8º35"	-
Basic information	Nominal Value					
Base material thicknes	[mm]	0,208	0,005	[inch]	0,0082	0,0002
Material	typ	Aluminium alloy				
Inside coating type	typ	PVC Free				
Pop Force	[N]	27	max	[lbs]	6,1	max
Push Force	[N]	36	max	[lbs]	8,1	max
Buckle pressure	[kPA]	620	min	[PSI]	90	min
Compound type	Water Base Compound /WBC/					
Compound placement	High On Shoulder					
Enamel rater	[mA]	ind. 15				max
		avg. 2				

Product:	Date:	Type:	Chapter:
ALUMINIUM easy open ends for beverage drinks	23.12.2022	202 CDL	2.1.10
	Revision: 8	Approved by:	

END - BASIC INFORMATION/ South America

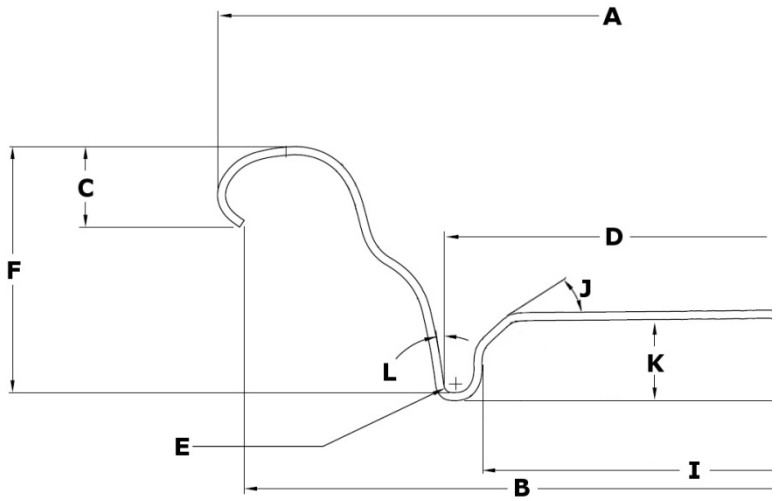
2.1.11 202 CDL



Dimensions	202 CDL dia					
-	Unit	Value	Tolerance +/-	Unit	Value	Tolerance +/-
A - Curl diameter	[mm]	59,31	0,25	[inch]	2,335	0.0098
B - Inner curl diameter	[mm]	57,60	min	[inch]	2,268	min
C - Curl height	[mm]	2,06	0,15	[inch]	0,081	0,0059
D - Counter sink diameter	[mm]	47,42	Ref	[inch]	1,867	Ref
E - Counter sink radius	[mm]	0,23	Ref	[inch]	0,009	Ref
F - Counter sink depth	[mm]	6,35	0,15	[inch]	0,250	0,0059
I – Outer panel diameter	[mm]	45,56	Ref	[inch]	1,761	Ref
J – Panel angle	[deg]	45^0	-	[deg]	45^0	
K - Panel depth	[mm]	2,04	0,15	[inch]	0,080	0,0059
L - Chuck wall angle	[deg]	8º35’	-	[deg]	8º35’	-
Basic information	Nominal Value					
Base material thicknes	[mm]	0,208	0,005	[inch]	0,0082	0,0002
Material	typ	Aluminium alloy				
Inside coating type	typ	PVC Free				
Pop Force	[N]	22,26	max	[lbs]	5,0	max
Push Force	[N]	36	max	[lbs]	8,1	max
Buckle pressure	[kPA]	620	min	[PSI]	90	min
Compound type	Water Base Compound /WBC/					
Compound placement	Low On Shoulder					
Enamel rater	[mA]	Max 25				max
		Max 5				

END - BASIC INFORMATION/ Custom Printed End

2.1.12 202 CDL



Dimensions	202 CDL dia					
-	Unit	Value	Tolerance +/-	Unit	Value	Tolerance +/-
A - Curl diameter	[mm]	59,31	0,25	[inch]	2,335	0.0098
B - Inner curl diameter	[mm]	57,46	min	[inch]	2,262	min
C - Curl height	[mm]	2,02	0,15	[inch]	0,079	0,0059
D - Counter sink diameter	[mm]	47,42	Ref	[inch]	1,867	Ref
E - Counter sink radius	[mm]	0,23	Ref	[inch]	0,009	Ref
F - Counter sink depth	[mm]	6,35	0,15	[inch]	0,250	0,0059
I – Outer panel diameter	[mm]	45,56	Ref	[inch]	1,793	Ref
J – Panel angle	[deg]	45^0	-	[deg]	45^0	
K - Panel depth	[mm]	2,04	0,15	[inch]	0,080	0,0059
L - Chuck wall angle	[deg]	8º35''	-	[deg]	8º35''	-
Basic information	Nominal Value					
Base material thicknes	[mm]	0,208	0,005	[inch]	0,0082	0,0002
Material	typ	Aluminium alloy				
Inside coating type	typ	PVC Free				
Pop Force	[N]	27	max	[lbs]	6,1	max
Push Force	[N]	36	max	[lbs]	8,1	max
Buckle pressure	[kPA]	620	min	[PSI]	90	min
Compound type	Water Base Compound /WBC/					
Compound placement	High On Shoulder					
Enamel rater	[mA]	Max 25 Max 5				max

Product:	Date:	Type:	Chapter:
ALUMINIUM easy open ends for beverage drinks	23.12.2022	202 CDL	2.1.12
	Revision: 7	Approved by:	

END - BASIC INFORMATION

2.1.13 202 CDL

Opening type	Dia	Tab Type
End mark: CDL/SOT/LOE	202	CAT-91CP
	Produced by:	CANPACK Poland (Brzesko)
End mark: CDL/SOT/LOE	202	JCAT-91R
	Produced by:	CANPACK Middle East (Dubai) CANPACK Poland (Bydgoszcz) CANPACK Poland (Brzesko)
End mark: CDL/SOT/LOE	202	CAT-99
	Produced by:	CANPACK Poland (Brzesko)
End mark: CDL/SOT/LOE	202	STOLLE-X
	Produced by:	CANPACK Poland (Bydgoszcz) CANPACK Brasil (Fortaleza)

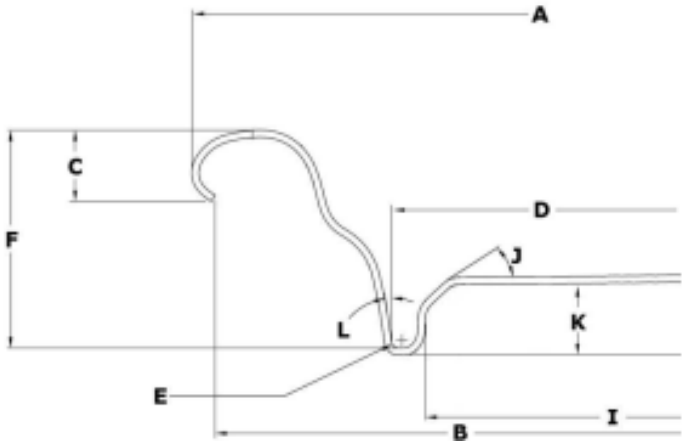
END - BASIC INFORMATION

2.1.14 202 CDL

Opening type	Dia	Tab Type
End mark: CDL/SOT/LOE	202	JCAT-91R
	Produced by:	CANPACK Poland (Brzesko)

END - BASIC INFORMATION / North America

2.1.15 202 CDL+



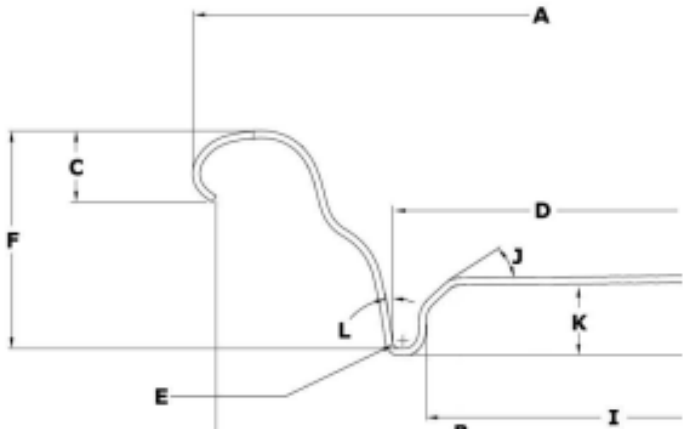
Dimensions	202 CDL+ dia					
-	Unit	Value	Tolerance +/-	Unit	Value	Tolerance +/-
A - Curl diameter	[mm]	59,31	0,25	[inch]	2.335	0.0098
B - Inner curl diameter	[mm]	57,60	min	[inch]	2,268	min
C - Curl height	[mm]	2,06	0,15	[inch]	0,081	0,0059
D - Counter sink diameter	[mm]	47,42	Ref	[inch]	1,867	Ref
E - Counter sink radius	[mm]	0,23	Ref	[inch]	0,0091	Ref
F - Counter sink depth	[mm]	5,97	0,15	[inch]	0,235	0,0059
I – Outer panel diameter	[mm]	45,56	Ref	[inch]	1,794	Ref
J – Panel angle	[deg]	45^0	-	[deg]	45^0	-
K - Panel depth	[mm]	2,08	0,15	[inch]	0,082	0,0059
L - Chuck wall angle	[deg]	-	-	[deg]	-	-
Basic information	Nominal Value					
Base material thicknes	[mm]	0,208	0,005	[inch]	0,0082	0,0002
Material	typ	Aluminium alloy				
Inside coating type	typ	PVC Free				
Pop Force	[N]	23	max	[lbs]	5,2	max
Push Force	[N]	27	max	[lbs]	6,1	max
Buckle pressure	[kPA]	620	min	[PSI]	90	min
Compound type	Water Base Compound /WBC/					
Compound placement	High On Shoulder					
Enamel rater	[mA]	ind. 15				max
		avg. 2				

2.1.16 202 CDL+

Opening type	Dia	Tab Type
End mark: CDL/SOT/LOE	202	STOLLE-X
	Produced by:	CANPACK US (Olyphant)
End mark: CDL/SOT/LOE	202	JCAT-91R
	Produced by:	CANPACK Middle East (Dubai)

END - BASIC INFORMATION

2.1.17 206 CDL



Dimensions	206 CDL dia					
-	Unit	Value	Tolerance +/-	Unit	Value	Tolerance +/-
A - Curl diameter	[mm]	64,52	0,25	[inch]	2.540	0.0098
B - Inner curl diameter	[mm]	62,61	min	[inch]	2,465	min
C - Curl height	[mm]	2,08	0,15	[inch]	0,082	0,0059
D - Counter sink diameter	[mm]	52,39	Ref	[inch]	2,062	Ref
E - Counter sink radius	[mm]	-	-	[inch]	-	-
F - Counter sink depth	[mm]	6,81	0,15	[inch]	0,268	0,0059
I – Outer panel diameter	[mm]	50,32	Ref	[inch]	1.981	Ref
J – Panel angle	[deg]	45^0	-	[deg]	45^0	-
K - Panel depth	[mm]	2,11	0,13	[inch]	0,083	0,0051
L - Chuck wall angle	[deg]	-	-	[deg]	-	-
Basic information	Nominal Value					
Base material thicknes	[mm]	0,239	0,005	[inch]	0,0094	0,0002
Material	typ	Aluminium alloy				
Inside coating type	typ	PVC Free				
Pop Force	[N]	23	max	[lbs]	5,2	max
Push Force	[N]	27	max	[lbs]	6,1	max
Buckle pressure	[kPA]	620	min	[PSI]	90	min
Compound type	Water Base Compound /WBC/					
Compound placement	High On Shoulder					
Enamel rater	[mA]	ind. 15				max
		avg. 2				

END - BASIC INFORMATION

2.1.18 206 CDL

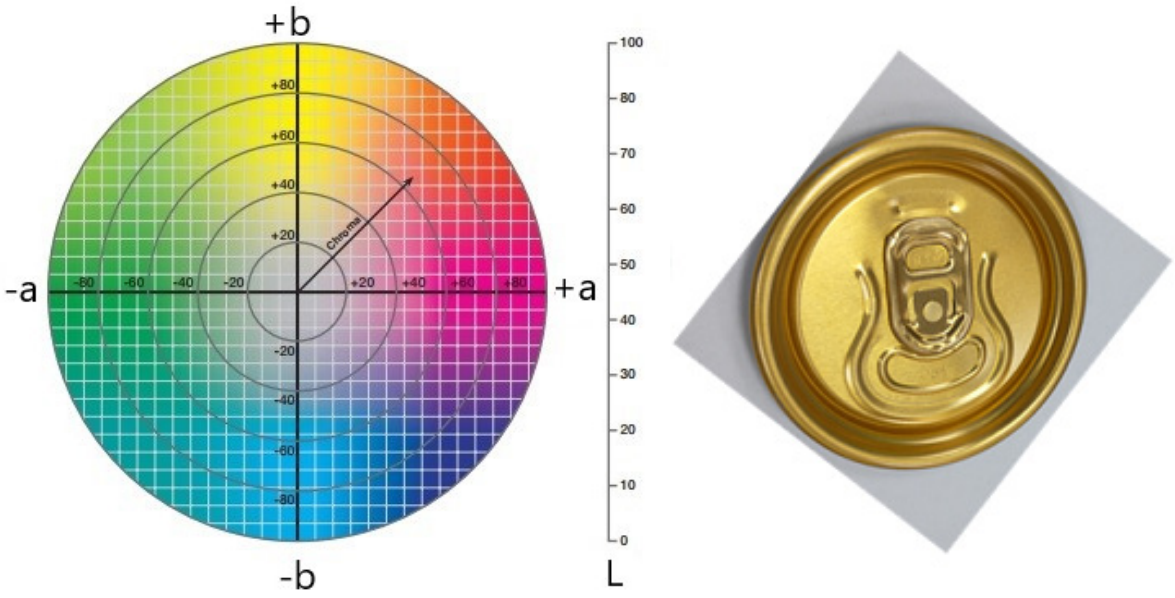
Opening type	Dia	Tab Type
End mark: CDL/SOT/LOE	206	JCAT-91R
	Produced by:	CANPACK Middle East

END - BASIC INFORMATION

2.1.19 GOLD STANDARD

CAN Pack Gold Standard

Our lacquer standard is Akzo Nobel Vitalac 820-310.483.



We can only move between the Lab parameters shown for each shade below:

Parameters of XRite	Values	
	Min	Max
L	76,67	77,79
a	8,00	10,57
b	34,31	41,77

DeltaE2000 should be less than <2.5

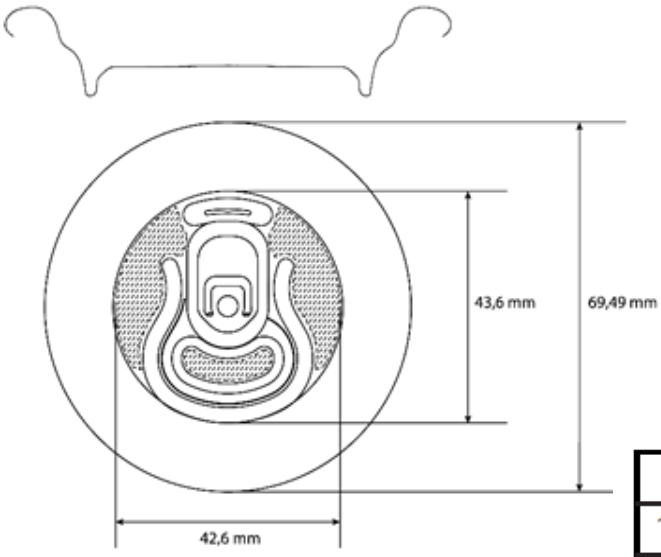
Product:	Date:	Type:	Chapter:
ALUMINIUM easy open ends for beverage drinks	24.09.2021	Aluminum end	2.1.19
	Revision: 1	Approved by:	

2.1.20 INCISING END

INCISING END – CHARACTERISTIC

Example with incising

INCISING AREA



Incising Area

Example:
End size: 202
End type: CDL
Opening type: SOT
Aperture version: LOE

	Characters sizes for Incising
1	0.188
2	0.125
2	0.100

2.1.21 PLANTS PRODUCTION

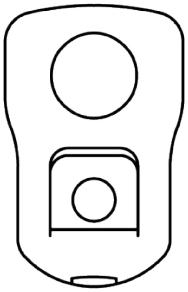
Ends and Tabs Production in our Plants				
End Size	End Type	Opening Type	Tab Type	Produced by (location)
200	B64	SOE/LOE	JCAT-91R	CANPACK Middle East
200	CDL	SOE/LOE	CAT-99	CANPACK Poland (BRZESKO)
200	CDL	SOE	JCAT-91R	CANPACK Poland (BRZESKO)
202	B64	SOE	JCAT-91R	CANPACK Middle East
202	B64	LOE	JCAT-91R	CANPACK Middle East
202	CDL	LOE	CAT-99	CANPACK Poland (BRZESKO)
202	CDL	LOE	CAT91CP	CANPACK Poland (BRZESKO)
202	CDL	LOE	JCAT-91R	CANPACK Poland (BRZESKO, Bydgoszcz) CANPACK Middle East
206	CDL	LOE	JCAT-91R	CANPACK Middle East
202	CDL+	LOE	JCAT-91R	CANPACK Middle East
202	B64	SOE/LOE	Stolle X Gen 3	CANPACK US (Olyphant)
202	CDL	LOE	Stolle X Gen 3	CANPACK Poland (Bydgoszcz) CANPACK Brazil (Fortaleza)
202	CDL+	SOE/LOE	Stolle X Gen 3	CANPACK US (Olyphant)

2.1.22 TAB TYPES

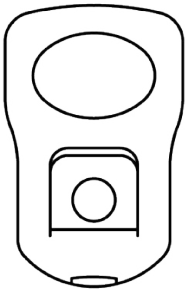
CAT-91CP

JCAT-91R

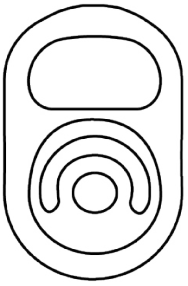
JCAT-91R PROMO



CAT-99



CAT-99 PROMO



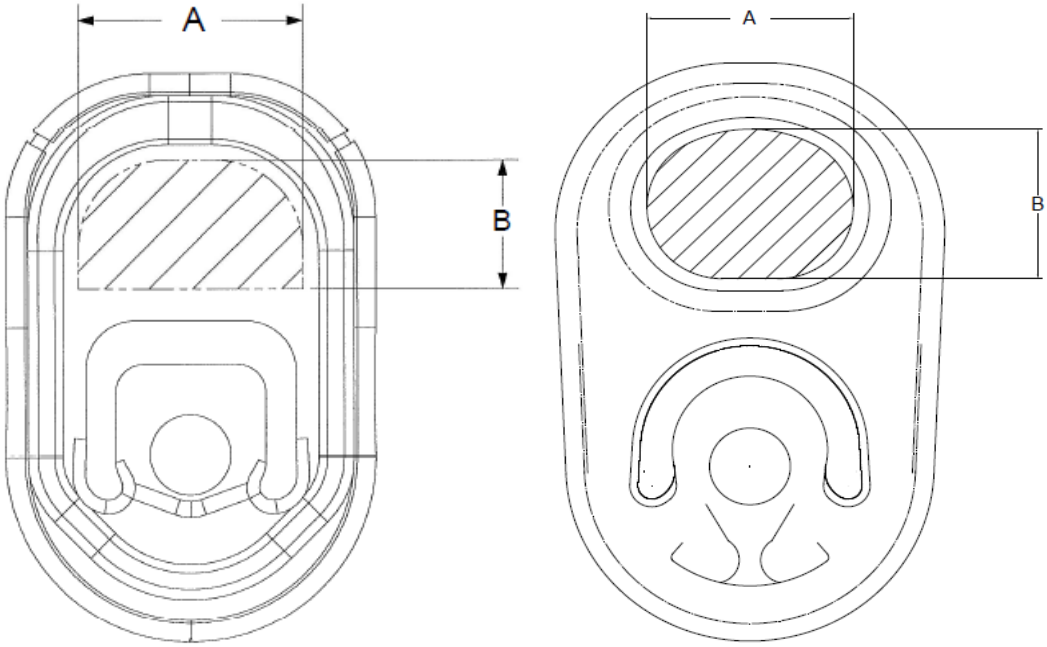
STOLLE-X

Products with unlacquered tabs shall not be used in the process of tunnel pasteurization or other high temperature treatments due to darkening effect on the metal; in any such case darkening of metal shall not be deemed as a defect of the Products.

Product:	Date:	Type:	Chapter:
ALUMINIUM easy open ends for beverage drinks	15.11.2023	TAB TYPES	2.1.22
	Revision: 7	Approved by:	

END - BASIC INFORMATION

2.1.25 TABS MARKING SYSTEM



Area of Tab printing		
Typ of Tab	A	B
Stolle X Gen3	0.329	0.251
JCAT91-R	0.359	0.206

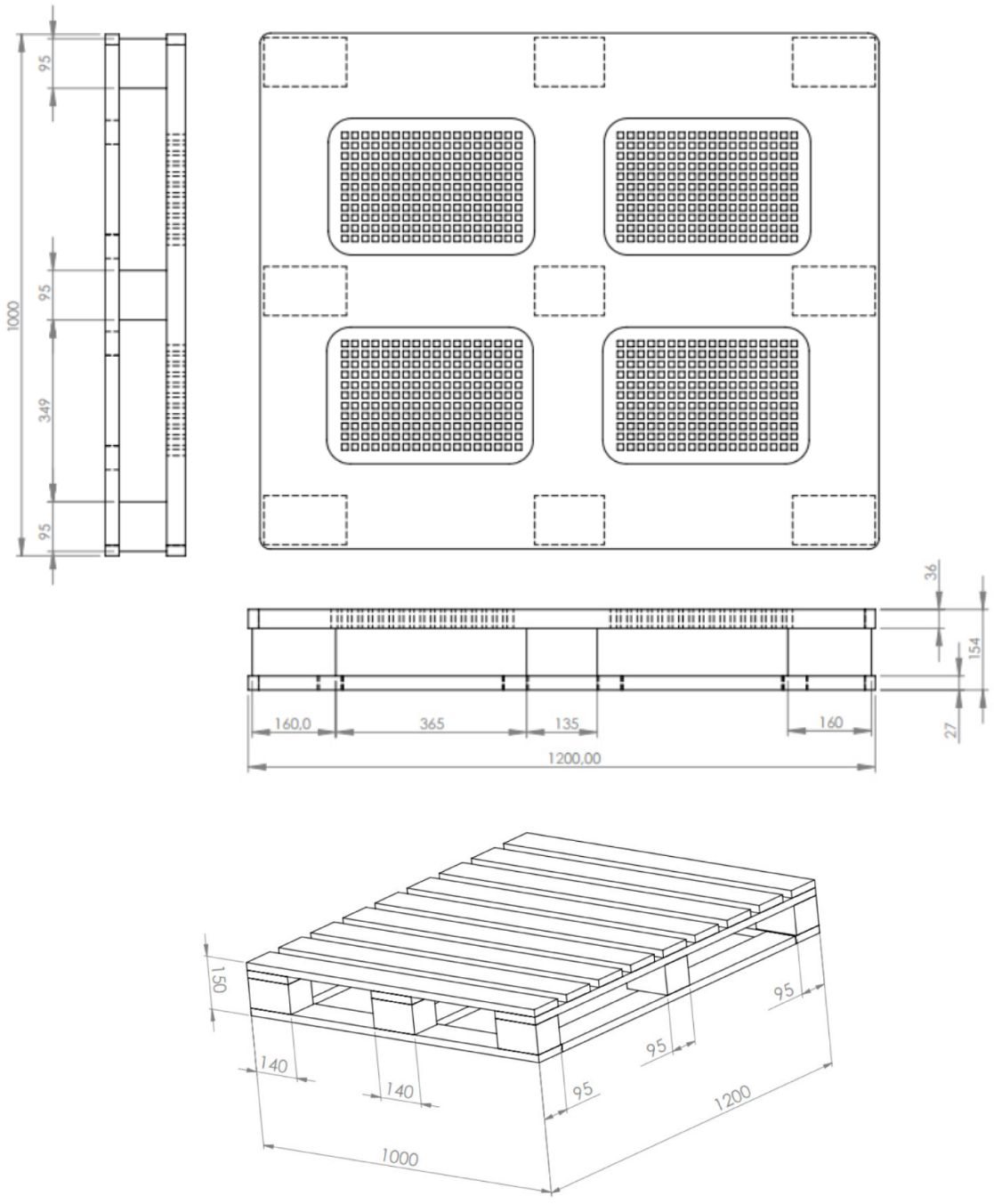
2.2 END - PALLETIZATION

END - PALLETIZATION

END - PALLETIZATION

2.2.1 END - PALET SPECIFICATION

Packags are on a plastic or wooden pallet, closed or open on a shorter side, for customers using hand pallet trucks.



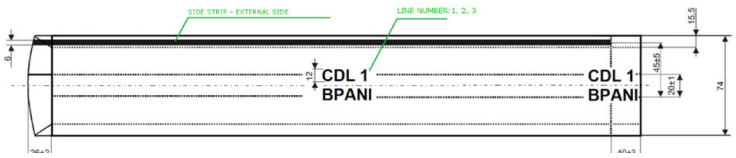
Product:	Date:	Type:	Chapter:
ALUMINIUM easy open ends for beverage drinks	01.05.2020	Aluminium end	2.2.1
	Revision: 4	Approved by:	

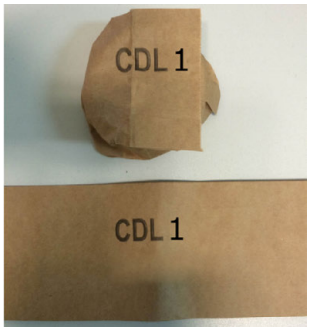
2.2.2 SLEEVES - PALLETIZATION

Types of sleeve gluing:

Manually glued:	
Machine glued:	
Unglued:	

Paper sleeves have a belt for automatic depalletization. Additional information may be printed on the sleeves, eg no. Press no., Line no., type of ends (CDL, BPANI) etc





Product:	Date:	Type:	Chapter:
ALUMINIUM easy open ends for beverage drinks	01.05.2020	Aluminium end	2.2.2
	Revision: 4	Approved by:	

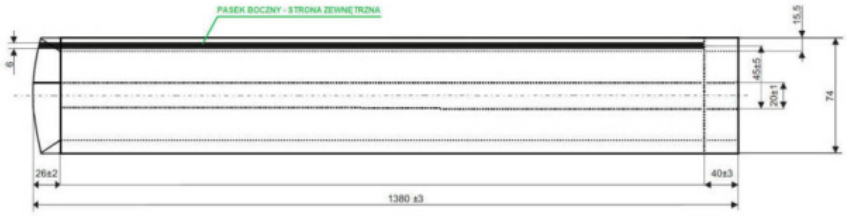
END - PALLETIZATION

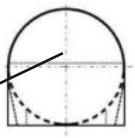
2.2.3 SLEEVES - PALLETIZATION

Types of sleeve gluing:

Manually glued:	
Machine glued:	
Unglued:	

Paper sleeves have a belt for automatic depalletization. Additional information may be printed on the sleeves, eg no. Press no., Line no., type of ends (CDL, BPANI) etc

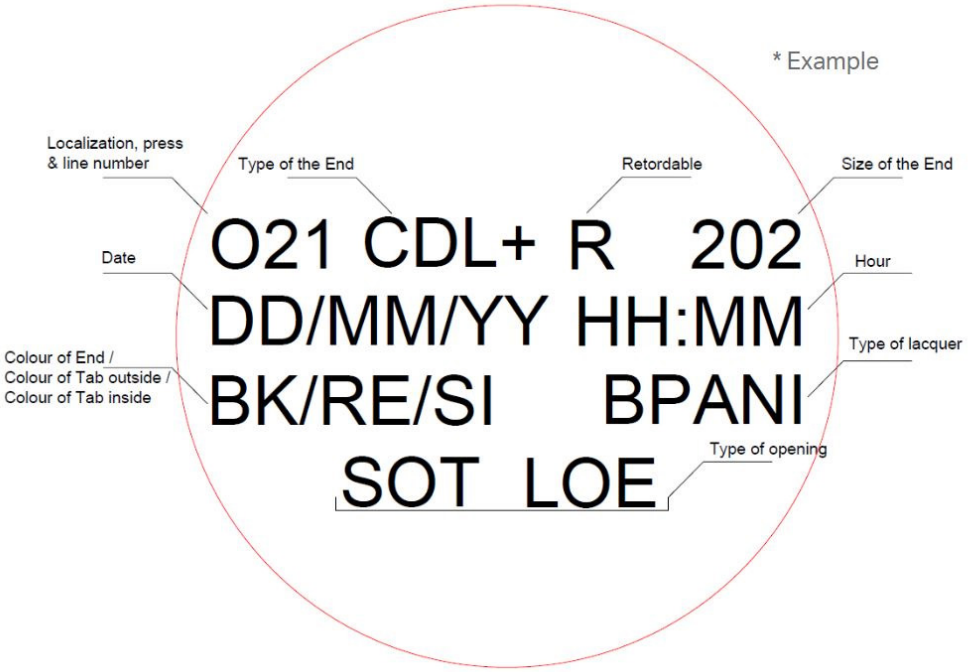




Area of sleeve marking
Legend of marking on page 2.2.4

Product:	Date:	Type:	Chapter:
ALUMINIUM easy open ends for beverage drinks	11.09.2023	Aluminium end	2.2.3
	Revision: 1	Approved by:	

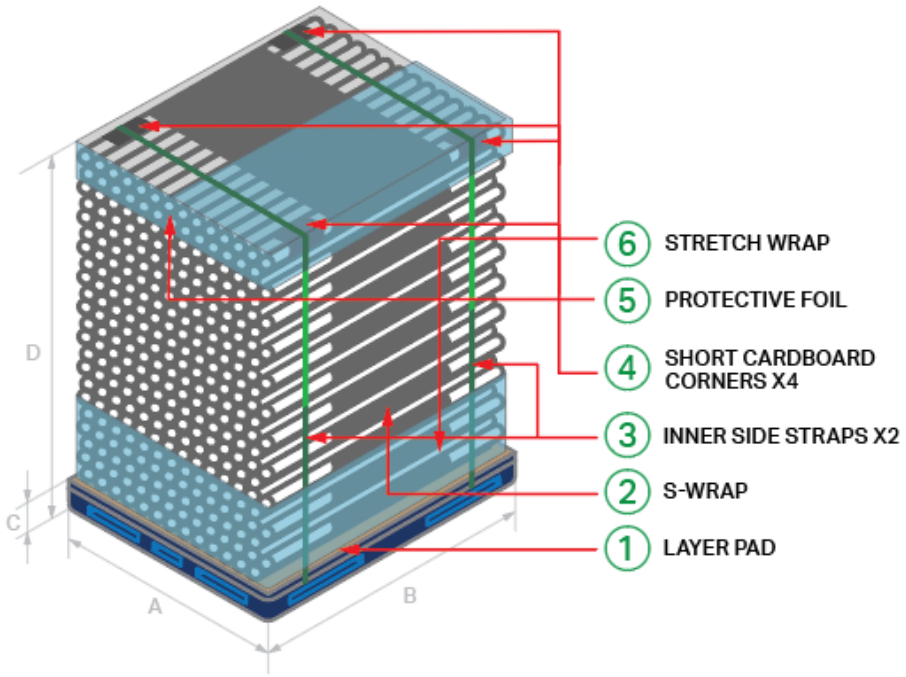
2.2.4 SLEEVES - MARKING SYSTEM



Sleeves marking system in Plants	
PLANT	**LINES**
Brzesko	**E#21 E#24**
Bydgoszcz	**E#13 E#16**
Dubaj	**E#18 E#19**
Fortaleza	**On going**
Olyphant	**E#20**

END - PALLETIZATION

2.2.5 200 B64

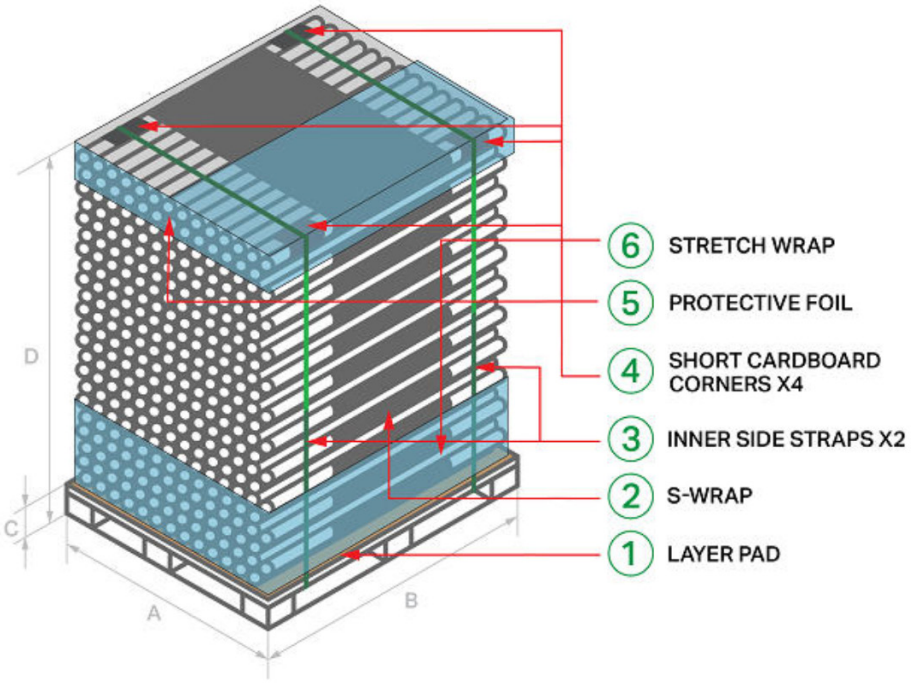


NOTE:
The ends are packed into paper bags and then placed in the layers. There is the paper between layers. The entire package is strapped and wrapped with stretch foil. Number of ends on a pallet are agreed between customer and supplier. The tolerance on quantity lids sleeve + - 3 pcs. ends / sleeve.

Type of pallets	**-**	**Standard plastic pallet**
Number of bags in layer	**pcs**	**16**
Number of ends in bag	**pcs**	**600**
Number of layers	**pcs**	**32**
Number of ends per pallet	**pcs**	**307 200**
A - Pallet width	**mm**	**1000**
B - Palet length	**mm**	**1200**
C - Pallet heigth	**mm**	**154**
D - Pallet height incl. Pallet	**mm/inch**	**~1889/~69,51**
Pallet weight incl. Pallet	**kg/lb**	**~890/~1962**

END - PALLETIZATION / CP ME

2.2.6 200 B64

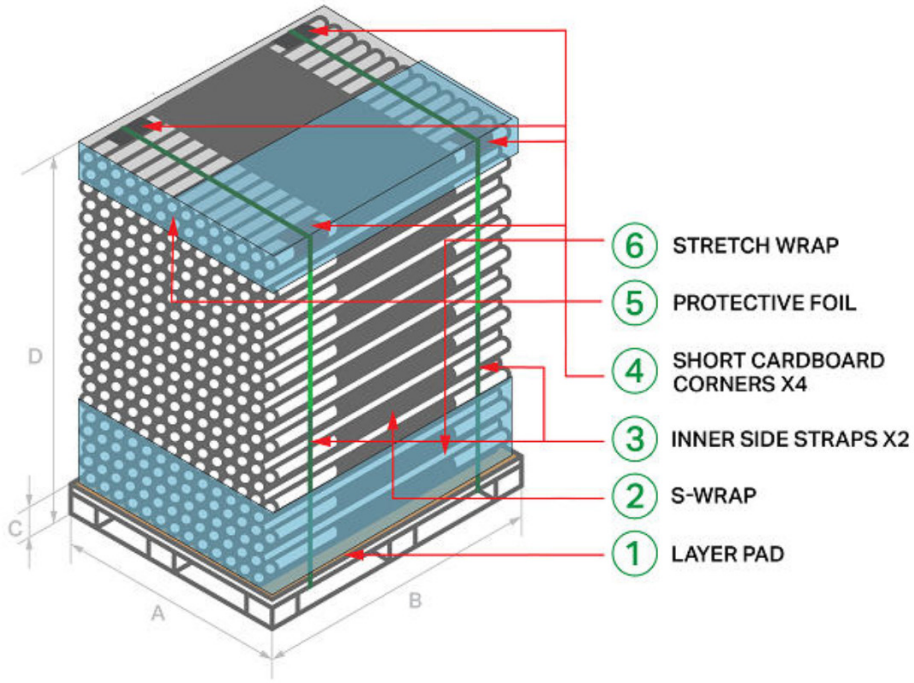


NOTE:
The ends are packed into paper bags and then placed in the layers. There is the paper between layers. The entire package is strapped and wrapped with stretch foil. Number of ends on a pallet are agreed between customer and supplier. The tolerance on quantity lids sleeve + - 3 pcs. ends / sleeve.

Type of pallets	**-**	**Standard wooden pallet**
Number of bags in layer	**pcs**	**16**
Number of ends in bag	**pcs**	**625**
Number of layers	**pcs**	**21**
Number of ends per pallet	**pcs**	**210 000**
A - Pallet width	**mm**	**1000**
B - Palet length	**mm**	**1200**
C - Pallet heigth	**mm**	**130**
D - Pallet height incl. Pallet	**mm/inch**	**~1170/~46,06**
Pallet weight incl. Pallet	**kg/lb**	**~595,7/~1313**

END - PALLETIZATION / CP ME

2.2.7 200 B64

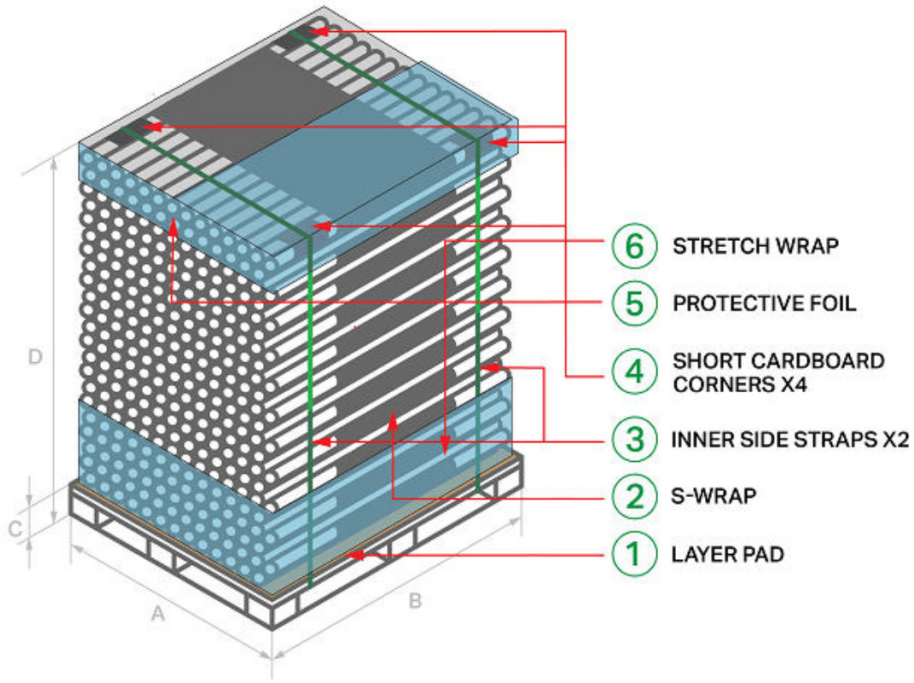


NOTE:
The ends are packed into paper bags and then placed in the layers. There is the paper between layers. The entire package is strapped and wrapped with stretch foil. Number of ends on a pallet are agreed between customer and supplier. The tolerance on quantity lids sleeve + - 3 pcs. ends / sleeve.

Type of pallets	**-**	**Standard wooden pallet**
Number of bags in layer	**pcs**	**16**
Number of ends in bag	**pcs**	**600**
Number of layers	**pcs**	**33**
Number of ends per pallet	**pcs**	**316 800**
A - Pallet width	**mm**	**1000**
B - Palet length	**mm**	**1200**
C - Pallet heigth	**mm**	**130**
D - Pallet height incl. Pallet	**mm/inch**	**~1765/~69,48**
Pallet weight incl. Pallet	**kg/lb**	**~883,5/~1948**

END - PALLETIZATION / CP ME

2.2.8 202 B64

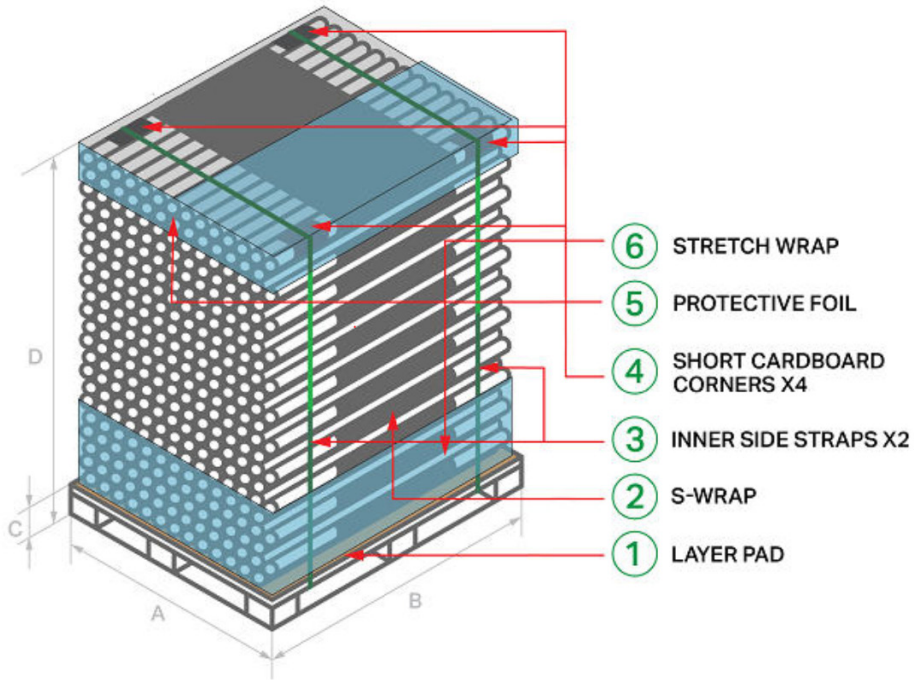


NOTE:
The ends are packed into paper bags and then placed in the layers. There is the paper between layers. The entire package is strapped and wrapped with stretch foil. Number of ends on a pallet are agreed between customer and supplier. The tolerance on quantity lids sleeve + - 3 pcs. ends / sleeve.

Type of pallet	**-**	**Standard wooden pallet**
Number of bags in layer	**pcs**	**16**
Number of ends in bag	**pcs**	**600**
Number of layers	**pcs**	**32**
Number of ends per pallet	**pcs**	**307 200**
A - Pallet width	**mm**	**1000**
B - Pallet length	**mm**	**1200**
C - Pallet height	**mm**	**130**
D - Pallet height incl. Pallet	**mm/inch**	**~1784,2/~70,24**
Pallet weight incl. Pallet	**kg/lb**	**~892,53/~1967**

END - PALLETIZATION / CP ME

2.2.9 202 B64

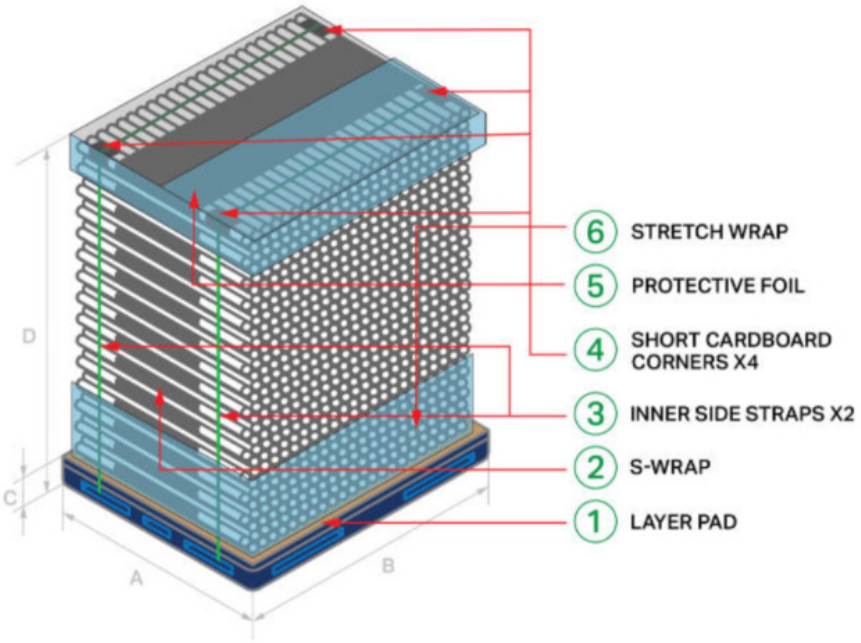


NOTE:
The ends are packed into paper bags and then placed in the layers. There is the paper between layers. The entire package is strapped and wrapped with stretch foil. Number of ends on a pallet are agreed between customer and supplier. The tolerance on quantity lids sleeve + - 3 pcs. ends / sleeve.

Type of pallet	**-**	**Standard wooden pallet**
Number of bags in layer	**pcs**	**15**
Number of ends in bag	**pcs**	**600**
Number of layers	**pcs**	**21**
Number of ends per pallet	**pcs**	**189 000**
A - Pallet width	**mm**	**1000**
B - Pallet length	**mm**	**1200**
C - Pallet height	**mm**	**130**
D - Pallet height incl. Pallet	**mm/inch**	**~1215/~47,83**
Pallet weight incl. Pallet	**kg/lb**	**~561/~1237**

END - PALLETIZATION / NORTH AMERICA

2.2.10 202 B64

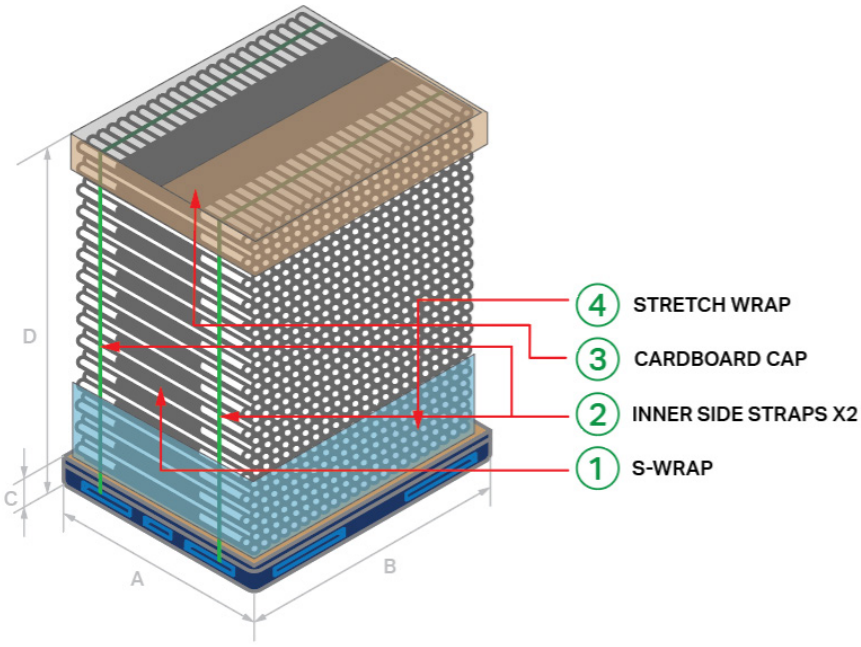


NOTE:
The ends are packed into paper bags and then placed in the layers. There is the paper between layers. All strappedand wrapped with stretch foil. Number of ends on a pallet are agreed between customer and supplier. The toleranceon quantity lids sleeve + - 3 pcs. ends / sleeve. This method of palletization is for distance above 1000 miles from the plant.
Pallet tolerance: +/- 0,256" [6,5mm]

Type of pallet	-	Standard plastic pallet
Number of bags in layer	pcs	22
Number of ends in bag	pcs	552
Number of layers	pcs	29
Number of ends per pallet	pcs	352 176
A - Pallet width	Inch	44
B - Pallet length	Inch	56
C - Pallet height	Inch	5,5
D - Pallet height incl. Pallet	mm/Inch	1636,6/~64,43
Pallet weight incl. Pallet	kg/lb	~1081,68/~2383

END - PALLETIZATION / NORTH AMERICA

2.2.11 202 B64

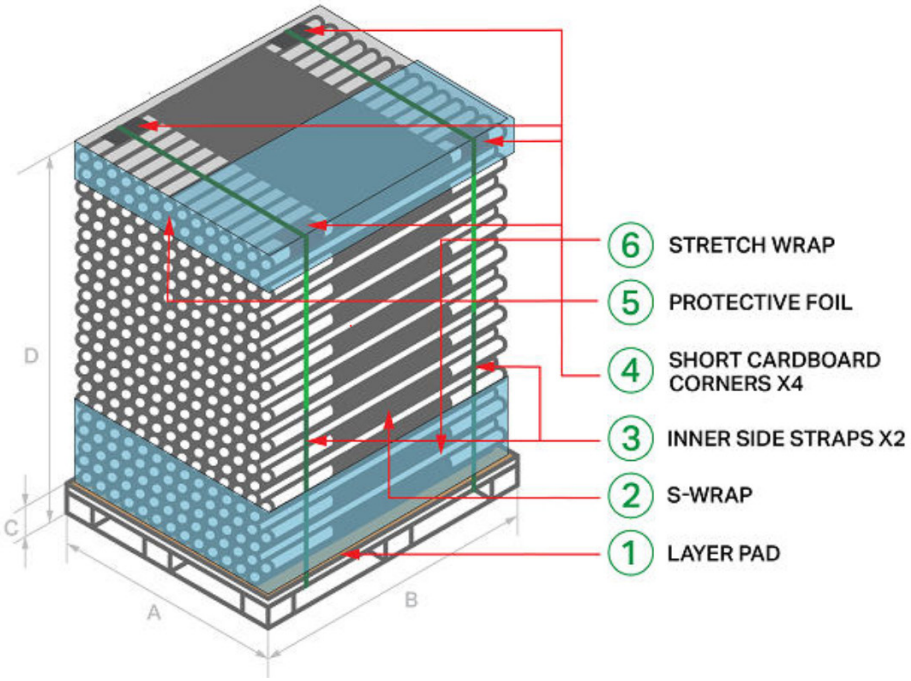


NOTE:
The ends are packed into paper bags and then placed in the layers. There is the paper between layers. Pallet iswrapped.Number of ends on a pallet are agreed between customer and supplier. The tolerance on quantity lids sleeve + - 3pcs. ends /sleeve. This method of palletization is for distance under 1000 miles from the plant.

Type of pallet	-	Standard plastic pallet
Number of bags in layer	pcs	22
Number of ends in bag	pcs	552
Number of layers	pcs	29
Number of ends per pallet	pcs	352 176
A - Pallet width	Inch	44
B - Pallet length	Inch	56
C - Pallet height	Inch	5,5
D - Pallet height incl. Pallet	mm/Inch	1636,6/~64,43
Pallet weight incl. Pallet	kg/lb	~1081,7/~2383

END - PALLETIZATION / NORTH AMERICA

2.2.12 202 B64



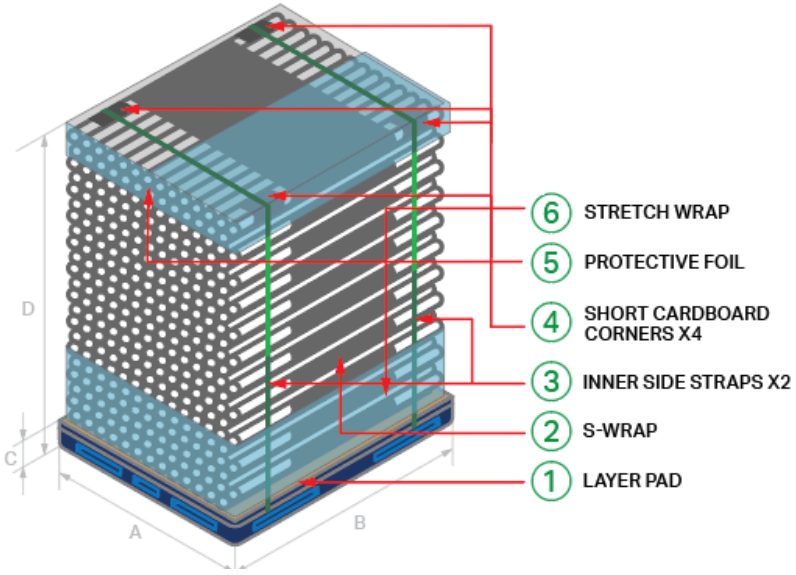
NOTE:
The ends are packed into paper bags and then placed in the layers. There is the paper between layers. All strappedand wrapped with stretch foil. Number of ends on a pallet are agreed between customer and supplier. The tolerance on quantity lids sleeve + - 3 pcs. ends / sleeve.
Pallet tolerance: +/- 0,256" [6,5mm]

Type of pallet	-	Standard wooden pallet
Number of bags in layer	pcs	16
Number of ends in bag	pcs	580
Number of layers	pcs	32
Number of ends per pallet	pcs	296 960
A - Pallet width	mm	1000
B - Pallet length	mm	1200
C - Pallet height	mm	130
D - Pallet height incl. Pallet	mm/inch	~1782,5/~70,17
Pallet weight incl. Pallet	kg/lb	~916/~2019,43

Product:	Date:	Type:	Chapter:
ALUMINIUM easy open ends for beverage drinks	03.11.2022	202 B64	2.2.12
	Revision: 1	Approved by:	

END - PALLETIZATION

2.2.13 200 CDL

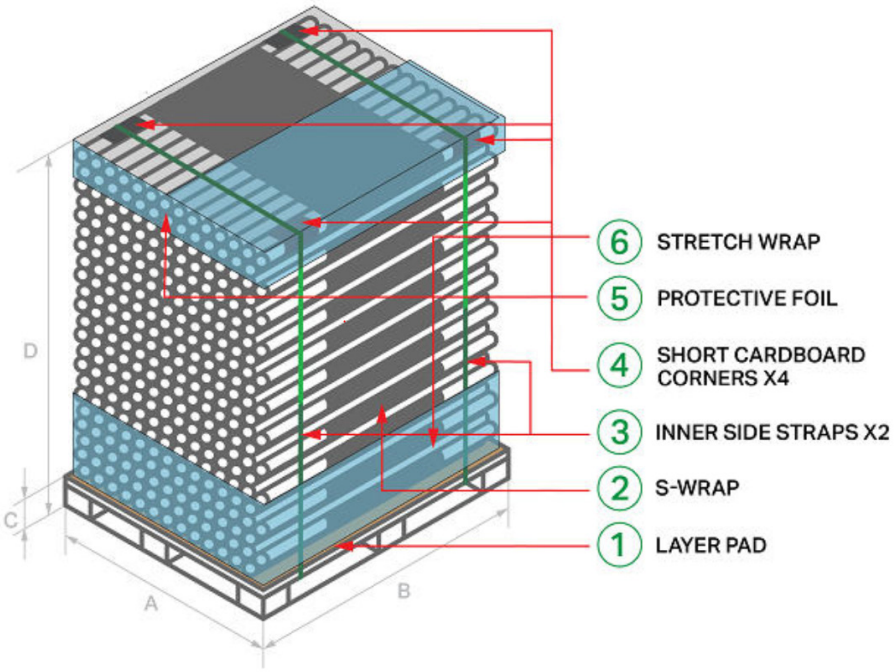


NOTE:
The ends are packed into paper bags and then placed in the layers. There is the paper between layers. The entire package is strapped and wrapped with stretch foil. Number of ends on a pallet are agreed between customer and supplier. The tolerance on quantity lids sleeve + - 3 pcs. ends / sleeve.

Type of pallet	-	Standard pallet
Number of bags in layer	pcs	16
Number of ends in bag	pcs	630
Number of layers	pcs	33
Number of ends per pallet	pcs	332 640
A - Pallet width	mm	1000
B - Pallet length	mm	1200
C - Pallet heigth	mm	154
D - Pallet height incl. Pallet	mm/inch	~1834/~72,04
Pallet weight incl. Pallet	kg/lb	~816,3/~1799

END - PALLETIZATION

2.2.14 200 CDL



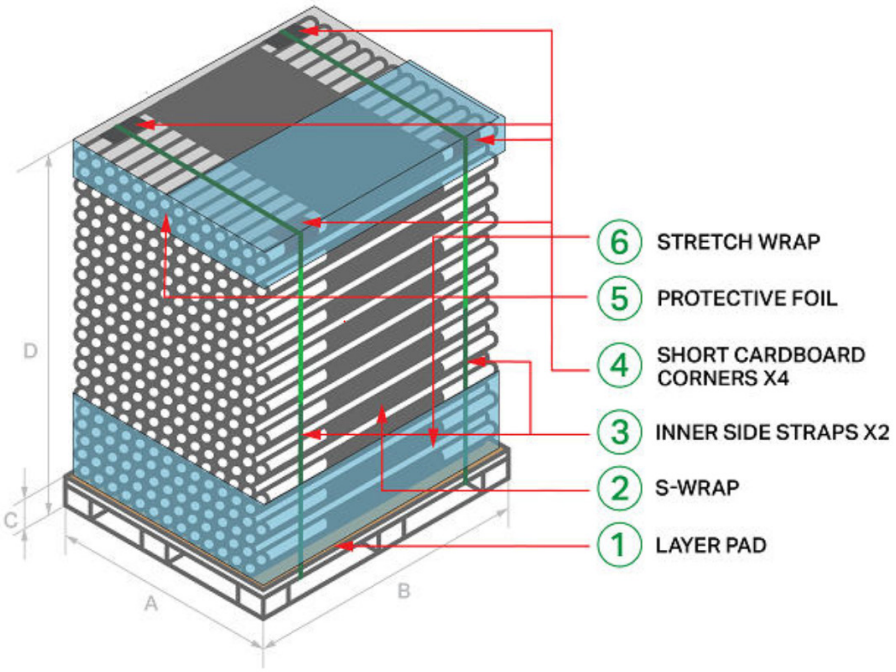
NOTE:
The ends are packed into paper bags and then placed in the layers. There is the paper between layers. The entire package is strapped and wrapped with stretch foil. Number of ends on a pallet are agreed between customer and supplier. The tolerance on quantity lids sleeve + - 3 pcs. ends / sleeve.

Type of pallet	**-**	**Standard wooden pallet**
Number of bags in layer	**pcs**	**16**
Number of ends in bag	**pcs**	**630**
Number of layers	**pcs**	**33**
Number of ends per pallet	**pcs**	**332 640**
A - Pallet width	**mm**	**1000**
B - Pallet length	**mm**	**1200**
C - Pallet heigth	**mm**	**150**
D - Pallet height incl. Pallet	**mm/inch**	**~1830/~72,04**
Pallet weight incl. Pallet	**kg/lb**	**~816,3/~1799**

Product:	Date:	Type:	Chapter:
ALUMINIUM easy open ends for beverage drinks	23.12.2022	200 CDL	2.2.14
	Revision: 1	Approved by:	

END - PALLETIZATION / CP ME

2.2.15 200 CDL

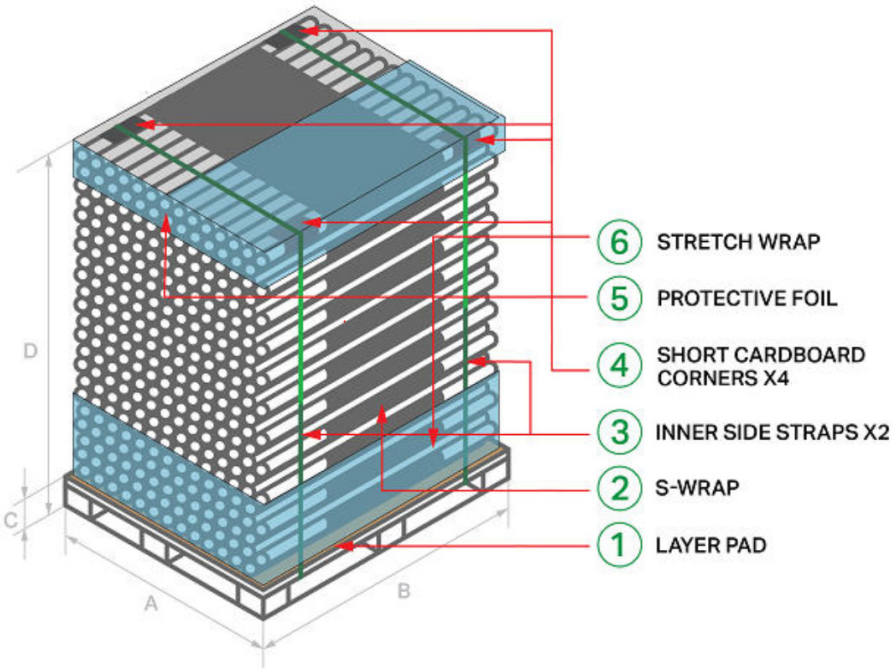


NOTE:
The ends are packed into paper bags and then placed in the layers. There is the paper between layers. The entire package is strapped and wrapped with stretch foil. Number of ends on a pallet are agreed between customer and supplier. The tolerance on quantity lids sleeve + - 3 pcs. ends / sleeve.

Type of pallet	**-**	**Standard wooden pallet**
Number of bags in layer	**pcs**	**16**
Number of ends in bag	**pcs**	**600**
Number of layers	**pcs**	**33**
Number of ends per pallet	**pcs**	**316 800**
A - Pallet width	**mm**	**1000**
B - Pallet length	**mm**	**1200**
C - Pallet heigth	**mm**	**130**
D - Pallet height incl. Pallet	**mm/inch**	**~1810/~71,25**
Pallet weight incl. Pallet	**kg/lb**	**~781/~1721**

END - PALLETIZATION / CP ME

2.2.16 200 CDL



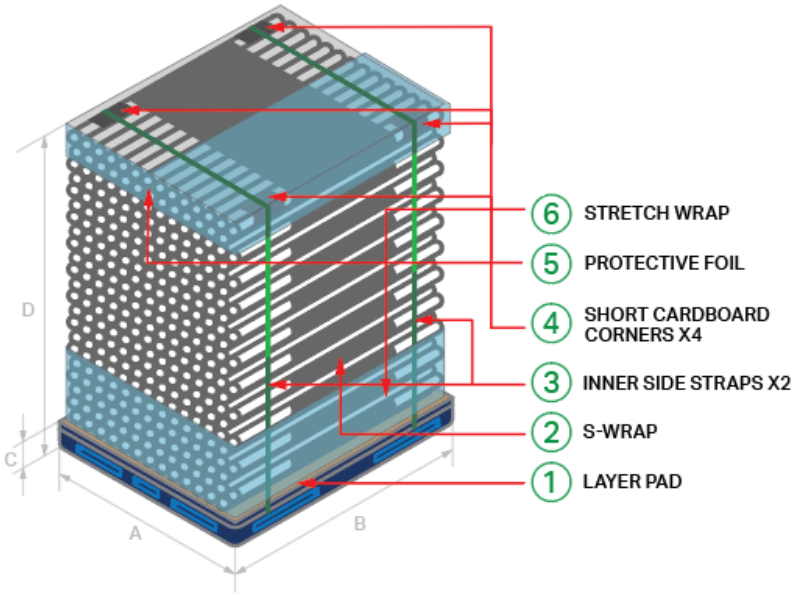
NOTE:
The ends are packed into paper bags and then placed in the layers. There is the paper between layers. The entire package is strapped and wrapped with stretch foil. Number of ends on a pallet are agreed between customer and supplier. The tolerance on quantity lids sleeve + - 3 pcs. ends / sleeve.

Type of pallet	**-**	**Standard wooden pallet**
Number of bags in layer	**pcs**	**16**
Number of ends in bag	**pcs**	**600**
Number of layers	**pcs**	**21**
Number of ends per pallet	**pcs**	**201 600**
A - Pallet width	**mm**	**1000**
B - Pallet length	**mm**	**1200**
C - Pallet heigth	**mm**	**130**
D - Pallet height incl. Pallet	**mm/inch**	**~1167/~45,94**
Pallet weight incl. Pallet	**kg/lb**	**~503,3/~1109,6**

Product:	Date:	Type:	Chapter:
ALUMINIUM easy open ends for beverage drinks	23.12.2022	200 CDL	2.2.16
	Revision: 1	Approved by:	

END - PALLETIZATION

2.2.17 202 CDL

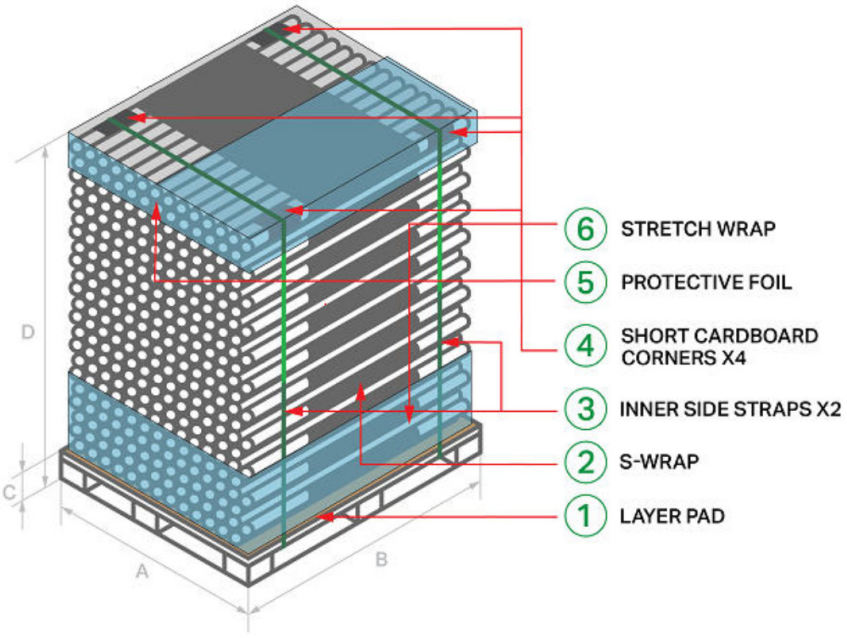


NOTE:
The ends are packed into paper bags and then placed in the layers. There is the paper between layers. The entire package is strapped and wrapped with stretch foil. Number of ends on a pallet are agreed between customer and supplier. The tolerance on quantity lids sleeve + - 3 pcs. ends / sleeve.

Type of pallet	-	Standard plastic pallet
Number of bags in layer	pcs	16
Number of ends in bag	pcs	650
Number of layers	pcs	32
Number of ends per pallet	pcs	332 800
A - Pallet width	mm	1000
B - Pallet length	mm	1200
C - Pallet height	mm	150
D - Pallet height incl. Pallet	mm/inch	~1894/~74,56
Pallet weight incl. Pallet	kg/lb	~877,7/ ~1935
Sleeve length	mm	1120-1150

END - PALLETIZATION

2.2.18 202 CDL

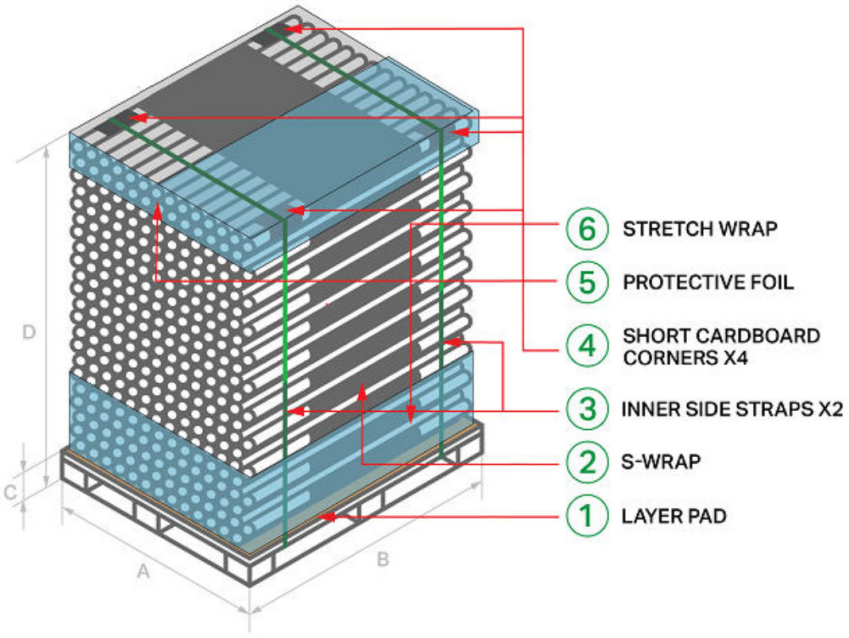


NOTE:
The ends are packed into paper bags and then placed in the layers. There is the paper between layers. The entire package is strapped and wrapped with stretch foil. Number of ends on a pallet are agreed between customer and supplier. The tolerance on quantity lids sleeve + - 3 pcs. ends / sleeve.

Type of pallet	**-**	**Standard wooden pallet**
Number of bags in layer	**pcs**	**16**
Number of ends in bag	**pcs**	**650**
Number of layers	**pcs**	**32**
Number of ends per pallet	**pcs**	**332 800**
A - Pallet width	**mm**	**1000**
B - Pallet length	**mm**	**1200**
C - Pallet height	**mm**	**150**
D - Pallet height incl. Pallet	**mm/inch**	**~1894/~74,56**
Pallet weight incl. Pallet	**kg/lb**	**~877,7/ ~1935**
Sleeve length	**mm**	**1120-1150**

END - PALLETIZATION / CP ME

2.2.19 202 CDL

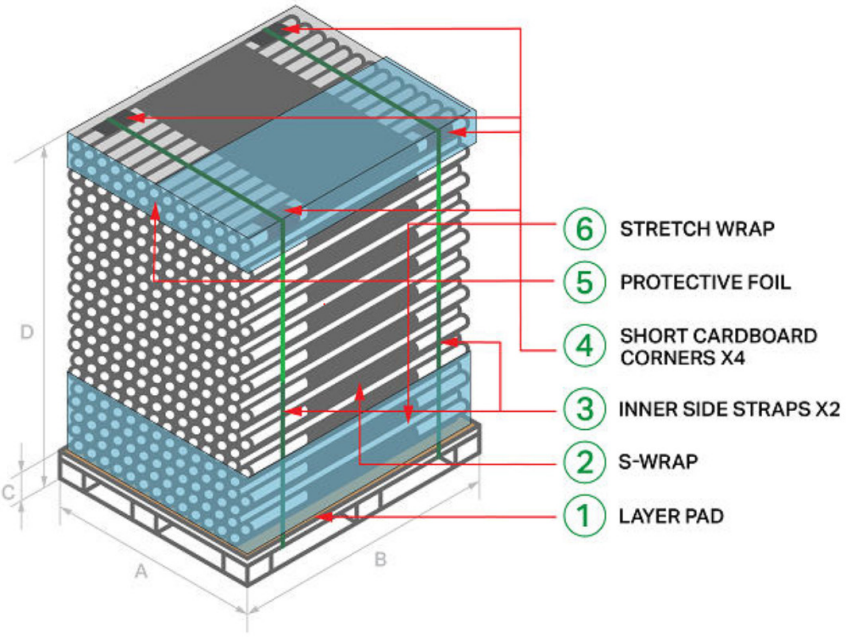


NOTE:
The ends are packed into paper bags and then placed in the layers. There is the paper between layers. The entire package is strapped and wrapped with stretch foil. Number of ends on a pallet are agreed between customer and supplier. The tolerance on quantity lids sleeve + - 3 pcs. ends / sleeve.

Type of pallet	**-**	**Standard wooden pallet**
Number of bags in layer	**pcs**	**16**
Number of ends in bag	**pcs**	**650**
Number of layers	**pcs**	**32**
Number of ends per pallet	**pcs**	**332 800**
A - Pallet width	**mm**	**1000**
B - Pallet length	**mm**	**1200**
C - Pallet height	**mm**	**130**
D - Pallet height incl. Pallet	**mm/inch**	**~1874/ ~73,77**
Pallet weight incl. Pallet	**kg/lb**	**~877,7/ ~1935**
Sleeve length	**mm**	**1120-1150**

END - PALLETIZATION / CP ME

2.2.20 202 CDL



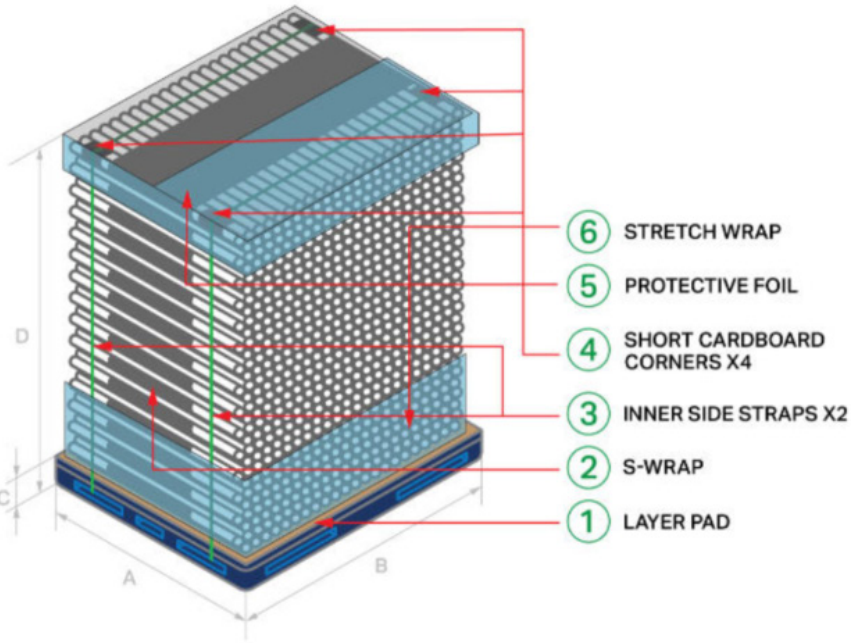
NOTE:
The ends are packed into paper bags and then placed in the layers. There is the paper between layers. The entire package is strapped and wrapped with stretch foil. Number of ends on a pallet are agreed between customer and supplier. The tolerance on quantity lids sleeve + - 3 pcs. ends / sleeve.

Type of pallet	-	Standard wooden pallet
Number of bags in layer	pcs	16
Number of ends in bag	pcs	650
Number of layers	pcs	21
Number of ends per pallet	pcs	218 400
A - Pallet width	mm	1000
B - Pallet length	mm	1200
C - Pallet height	mm	130
D - Pallet height incl. Pallet	mm/inch	~1233/ ~48,54
Pallet weight incl. Pallet	kg/lb	~582,8/ ~1284,8
Sleeve length	mm	1120-1150

Product:	Date:	Type:	Chapter:
ALUMINIUM easy open ends for beverage drinks	23.12.2022	202 CDL	2.2.20
	Revision: 1	Approved by:	

END - PALLETIZATION / NORTH AMERICA

2.2.21 202 CDL PLUS

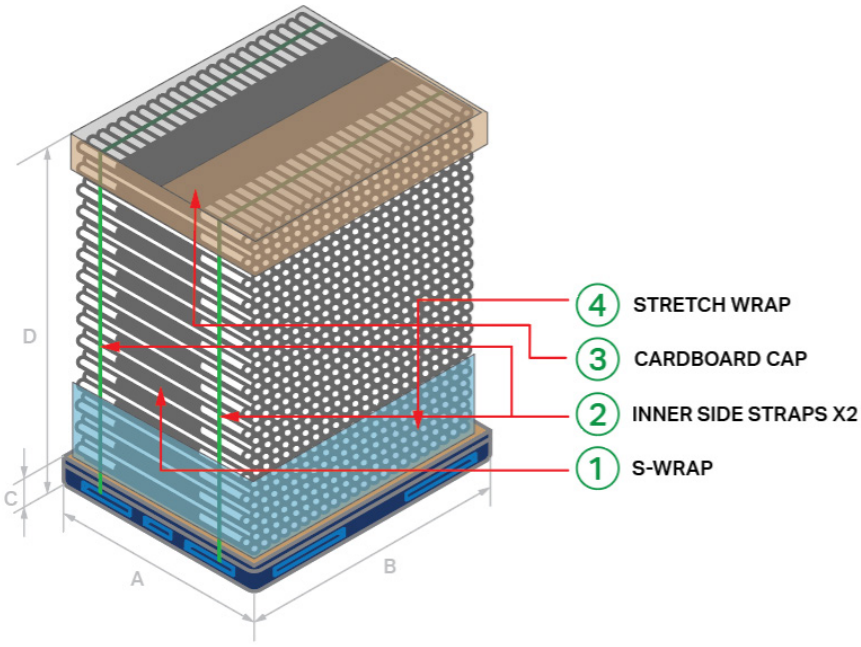


NOTE:
The ends are packed into paper bags and then placed in the layers. There is the paper between layers. All strappe-dand wrapped with stretch foil. Number of ends on a pallet are agreed between customer and supplier. The tole-ranceon quantity lids sleeve + - 3 pcs. ends / sleeve. This method of palletization is for distance above 1000 miles from the plant.
Pallet tolerance: +/- 0,256" [6,5mm]

Type of pallet	**-**	**Standard plastic pallet**
Number of bags in layer	**pcs**	**22**
Number of ends in bag	**pcs**	**600**
Number of layers	**pcs**	**29**
Number of ends per pallet	**pcs**	**382 800**
A - Pallet width	**Inch**	**44**
B - Pallet length	**Inch**	**56**
C - Pallet height	**Inch**	**5,5**
D - Pallet height incl. Pallet	**mm/Inch**	**~1632,9/~64,29**
Pallet weight incl. Pallet	**kg/lb**	**~1037,8/~2284,9**

END - PALLETIZATION / NORTH AMERICA

2.2.22 202 CDL PLUS



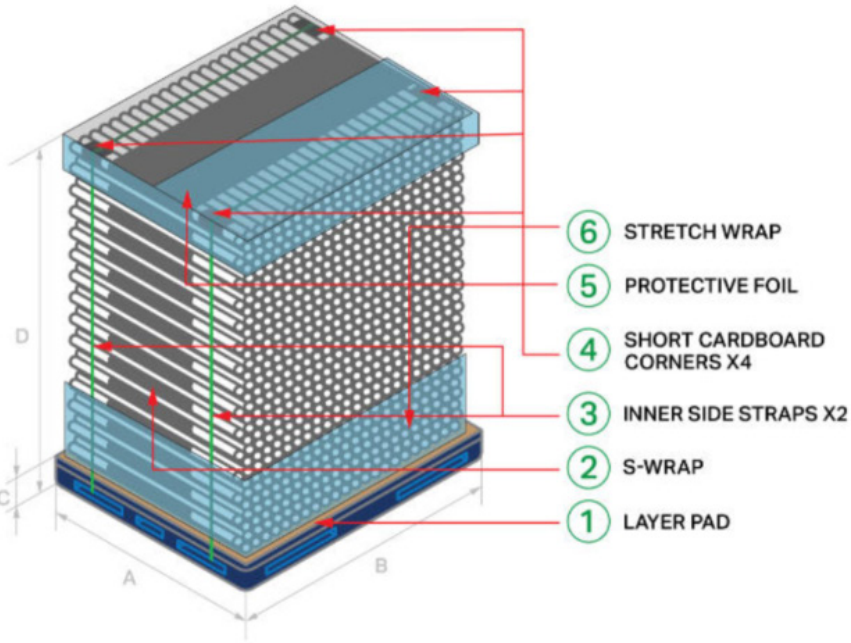
NOTE:
The ends are packed into paper bags and then placed in the layers. There is the paper between layers. Pallet iswrapped.Number of ends on a pallet are agreed between customer and supplier. The tolerance on quantity lids sleeve + - 3pcs. ends /sleeve. This method of palletization is for distance under 1000 miles from the plant.

Type of pallet	**-**	**Standard plastic pallet**
Number of bags in layer	**pcs**	**22**
Number of ends in bag	**pcs**	**600**
Number of layers	**pcs**	**29**
Number of ends per pallet	**pcs**	**382 800**
A - Pallet width	**Inch**	**44**
B - Pallet length	**Inch**	**56**
C - Pallet height	**Inch**	**5,5**
D - Pallet height incl. Pallet	**mm/Inch**	**~1632,9/~64,29**
Pallet weight incl. Pallet	**kg/lb**	**~1037,8/~2284,9**

Product:	Date:	Type:	Chapter:
ALUMINIUM easy open ends for beverage drinks	31.08.2023	202 CDL +	2.2.22
	Revision: 3	Approved by:	

END - PALLETIZATION / NORTH AMERICA

2.2.23 202 CDL PLUS

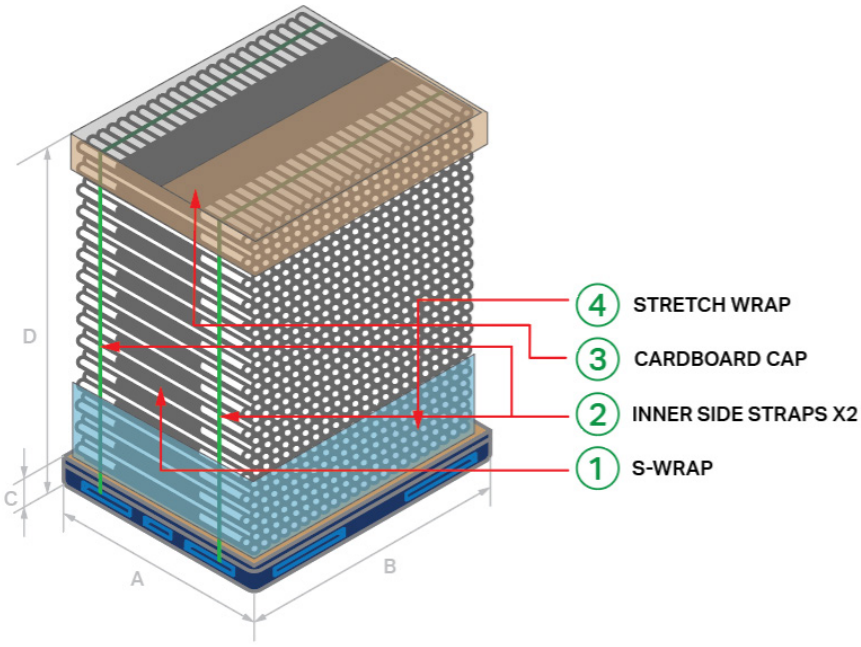


NOTE:
The ends are packed into paper bags and then placed in the layers. There is the paper between layers. Pallet iswrapped.Number of ends on a pallet are agreed between customer and supplier. The tolerance on quantity lids sleeve + - 3pcs. ends /sleeve. This method of palletization is for distance under 1000 miles from the plant.

Type of pallet	**-**	**Standard plastic pallet**
Number of bags in layer	**pcs**	**21**
Number of ends in bag	**pcs**	**600**
Number of layers	**pcs**	**29**
Number of ends per pallet	**pcs**	**365 400**
A - Pallet width	**Inch**	**44**
B - Pallet length	**Inch**	**56**
C - Pallet height	**Inch**	**5,5**
D - Pallet height incl. Pallet	**mm/Inch**	**~1632,9/~64,29**
Pallet weight incl. Pallet	**kg/lb**	**~992,6/~2188,1**

END - PALLETIZATION / NORTH AMERICA

2.2.24 202 CDL PLUS



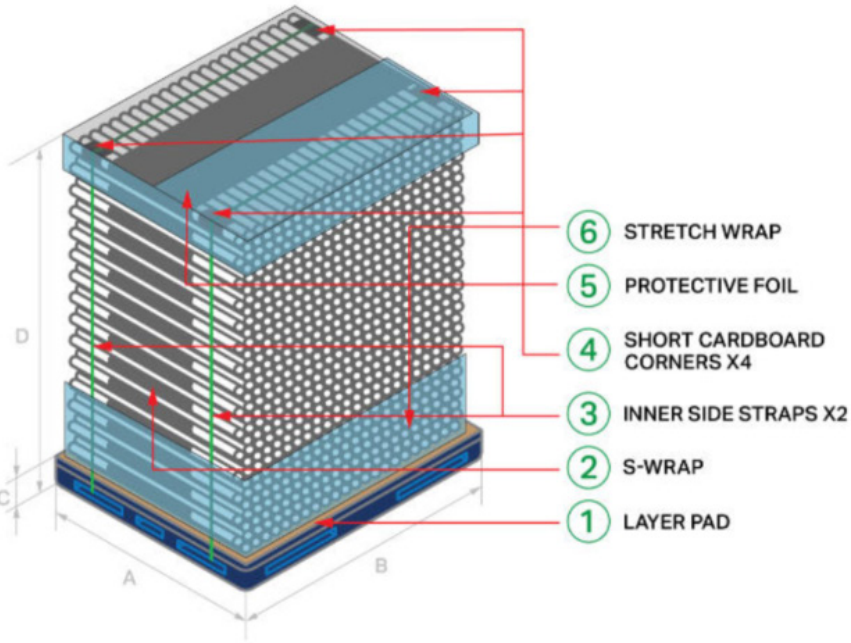
NOTE:
The ends are packed into paper bags and then placed in the layers. There is the paper between layers. Pallet iswrapped.Number of ends on a pallet are agreed between customer and supplier. The tolerance on quantity lids sleeve + - 3pcs. ends /sleeve. This method of palletization is for distance under 1000 miles from the plant.

Type of pallet	**-**	**Standard plastic pallet**
Number of bags in layer	**pcs**	**21**
Number of ends in bag	**pcs**	**600**
Number of layers	**pcs**	**29**
Number of ends per pallet	**pcs**	**365 400**
A - Pallet width	**Inch**	**44**
B - Pallet length	**Inch**	**56**
C - Pallet height	**Inch**	**5,5**
D - Pallet height incl. Pallet	**mm/Inch**	**~1632,9/~64,29**
Pallet weight incl. Pallet	**kg/lb**	**~992,6/~2188,1**

Product:	Date:	Type:	Chapter:
ALUMINIUM easy open ends for beverage drinks	31.08.2023	202 CDL +	2.2.24
	Revision: 3	Approved by:	

END - PALLETIZATION / NORTH AMERICA

2.2.25 206 CDL

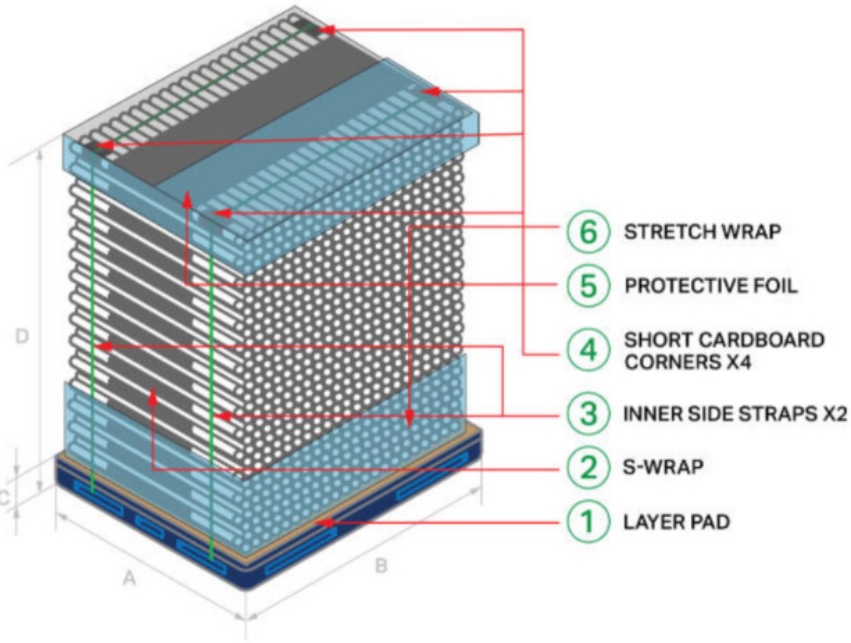


NOTE:
The ends are packed into paper bags and then placed in the layers. There is the paper between layers. All strappedand wrapped with stretch foil. Number of ends on a pallet are agreed between customer and supplier. The tolerance on quantity lids sleeve + - 3 pcs. ends / sleeve.
Pallet tolerance: +/- 0,256" [6,5mm]

Type of pallet	-	Standard plastic pallet
Number of bags in layer	pcs	21
Number of ends in bag	pcs	600
Number of layers	pcs	24
Number of ends per pallet	pcs	302 400
A - Pallet width	Inch	44
B - Pallet length	Inch	56
C - Pallet height	Inch	5,5
D - Pallet height incl. Pallet	mm/Inch	~1483/~58,35
Pallet weight incl. Pallet	kg/lb	~1054/~2323,67

END - PALLETIZATION / NORTH AMERICA

2.2.26 206 CDL



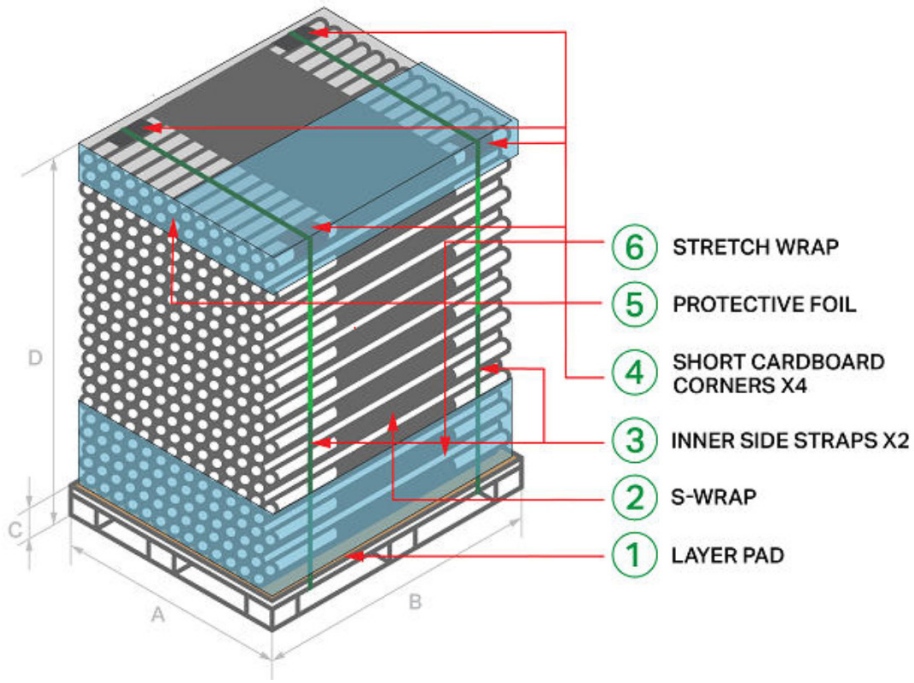
NOTE:
The ends are packed into paper bags and then placed in the layers. There is the paper between layers. All strappedand wrapped with stretch foil. Number of ends on a pallet are agreed between customer and supplier. The tolerance on quantity lids sleeve + - 3 pcs. ends / sleeve.
Pallet tolerance: +/- 0,256" [6,5mm]

Type of pallet	**-**	**Standard plastic pallet**
Number of bags in layer	**pcs**	**21**
Number of ends in bag	**pcs**	**580**
Number of layers	**pcs**	**24**
Number of ends per pallet	**pcs**	**292 320**
A - Pallet width	**Inch**	**44**
B - Pallet length	**Inch**	**56**
C - Pallet height	**Inch**	**5,5**
D - Pallet height incl. Pallet	**mm/Inch**	**~1483/~58,35**
Pallet weight incl. Pallet	**kg/lb**	**~1013,6/~2234,6**

Product:	Date:	Type:	Chapter:
ALUMINIUM easy open ends for beverage drinks	02.11.2022	206 CDL	2.2.26
	Revision: 2	Approved by:	

END - PALLETIZATION / NORTH AMERICA

2.2.27 206 CDL



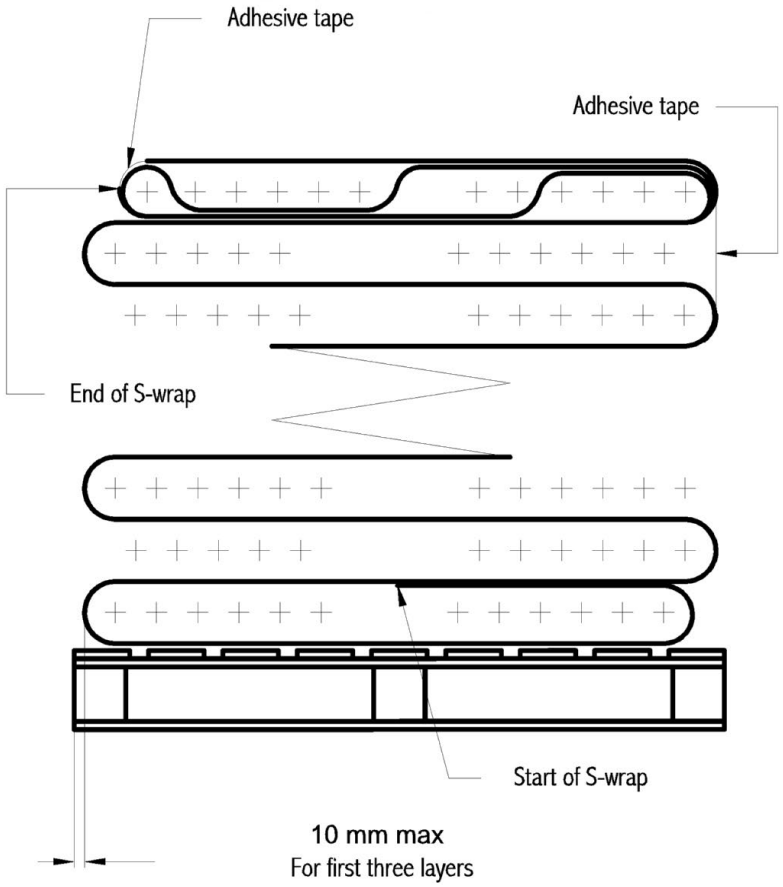
NOTE:
The ends are packed into paper bags and then placed in the layers. There is the paper between layers. All strappedand wrapped with stretch foil. Number of ends on a pallet are agreed between customer and supplier. The tolerance on quantity lids sleeve + - 3 pcs. ends / sleeve.
Pallet tolerance: +/- 0,256" [6,5mm]

Type of pallet	-	Standard wooden pallet
Number of bags in layer	pcs	14
Number of ends in bag	pcs	580
Number of layers	pcs	29
Number of ends per pallet	pcs	235 480
A - Pallet width	mm	1000
B - Pallet length	mm	1200
C - Pallet height	mm	130
D - Pallet height incl. Pallet	mm/inch	~1753/~69,01
Pallet weight incl. Pallet	kg/lb	~820/~1807,7

END - PALLETIZATION

2.2.28 END

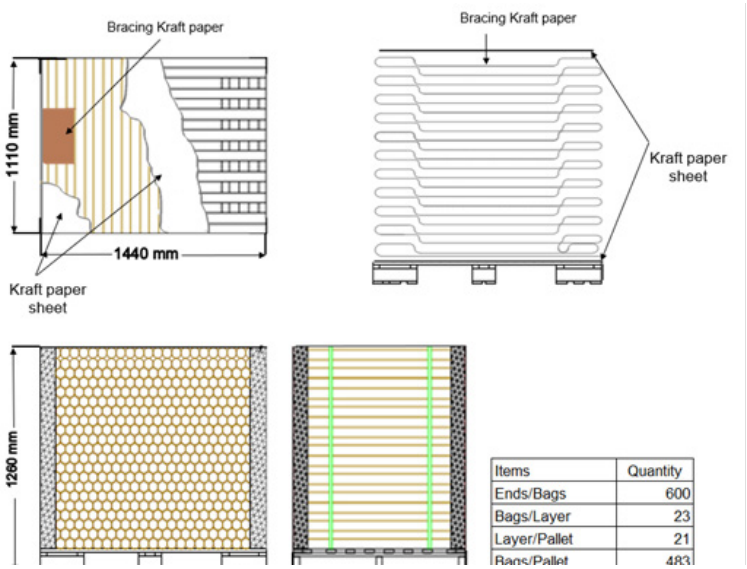
Standard plasti pallet with S-Wrap stacking system



Product:	Date:	Type:	Chapter:
ALUMINIUM easy open ends for beverage drinks	01.05.2020	END	2.2.28
	Revision: 4	Approved by:	

END - PALLETIZATION / South America

2.2.29 202 CDL

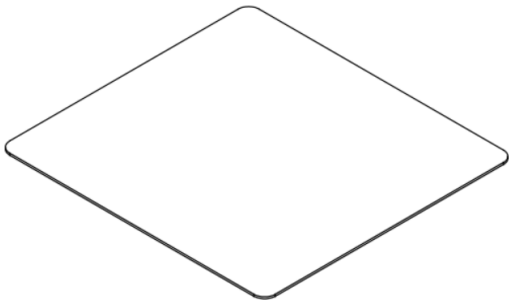


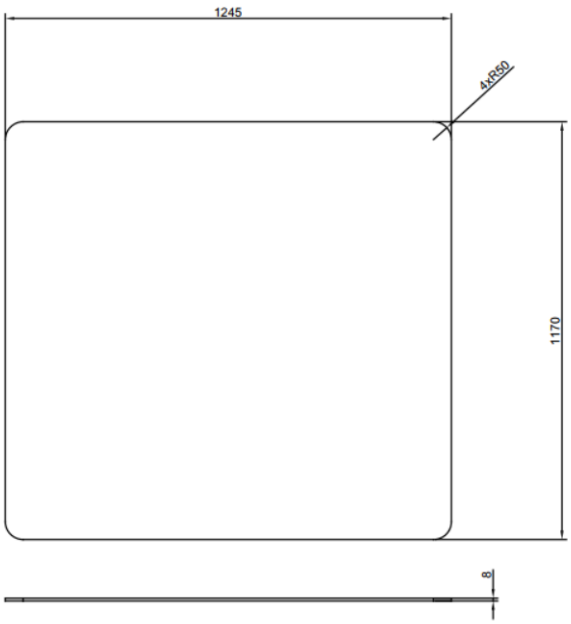
Pallet description	pcs	Standard wooden fumigated pallet
Pallet dimensions	mm	1110 (length)
		1440 (width)
		125 (height)
Full Pallet height	mm	1250
Full Pallet weight	kg	744
Number of ends in bag	pcs	600
Number of bags in layer	pcs	23
Number of layers	pcs	21
Number of bags per pallet	pcs	483
Number of ends per pallet	pcs	289,800
Stretched	-	yes
Bag material	-	Kraft paper
Bag paper grammage	g/m2	60 - 98
Bag Length	mm	965 - 1090
Length of fold	mm	89 - 140
Bag circunference plus	mm	10 - 15
Side stripe	mm	15
Side stripe color	-	Black
Side stripe position	-	opposite side of folding
Closure	-	One sigle adhesive tape

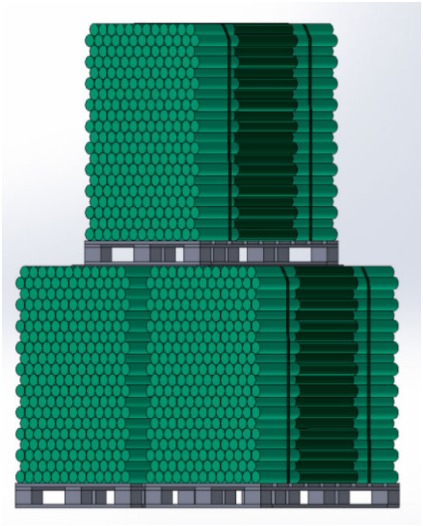
2.2.30 END - PALLETIZATION - PREREQUISITES

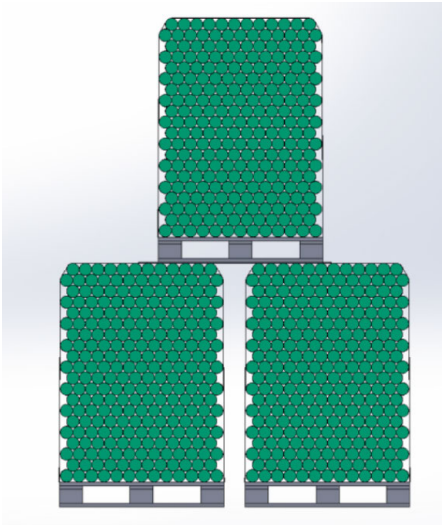
The ends pallets are separated in between by a separating slab that has the following properties:

- it is made of chipboard or MDF
- it has a density: 500 - 750 Kg / m3
- it has a bending strength higher than 10 N / mm2
- it has a weight between 6.0 - 9.0 Kg
- according to the dimensions below









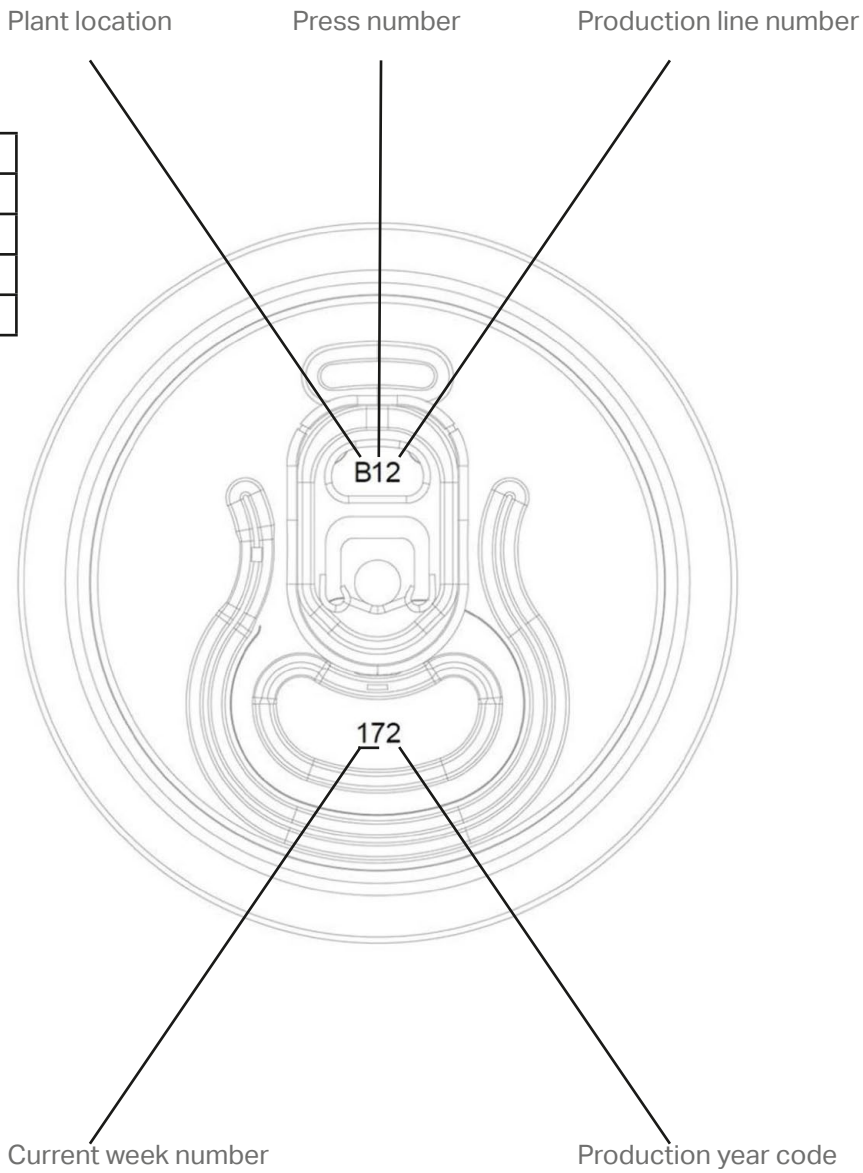
Product:	Date:	Type:	Chapter:
ALUMINIUM easy open ends for beverage drinks	28.06.2021	Aluminium Ends	2.2.30
	Revision: 1	Approved by:	

END CODING SYSTEM

END CODING

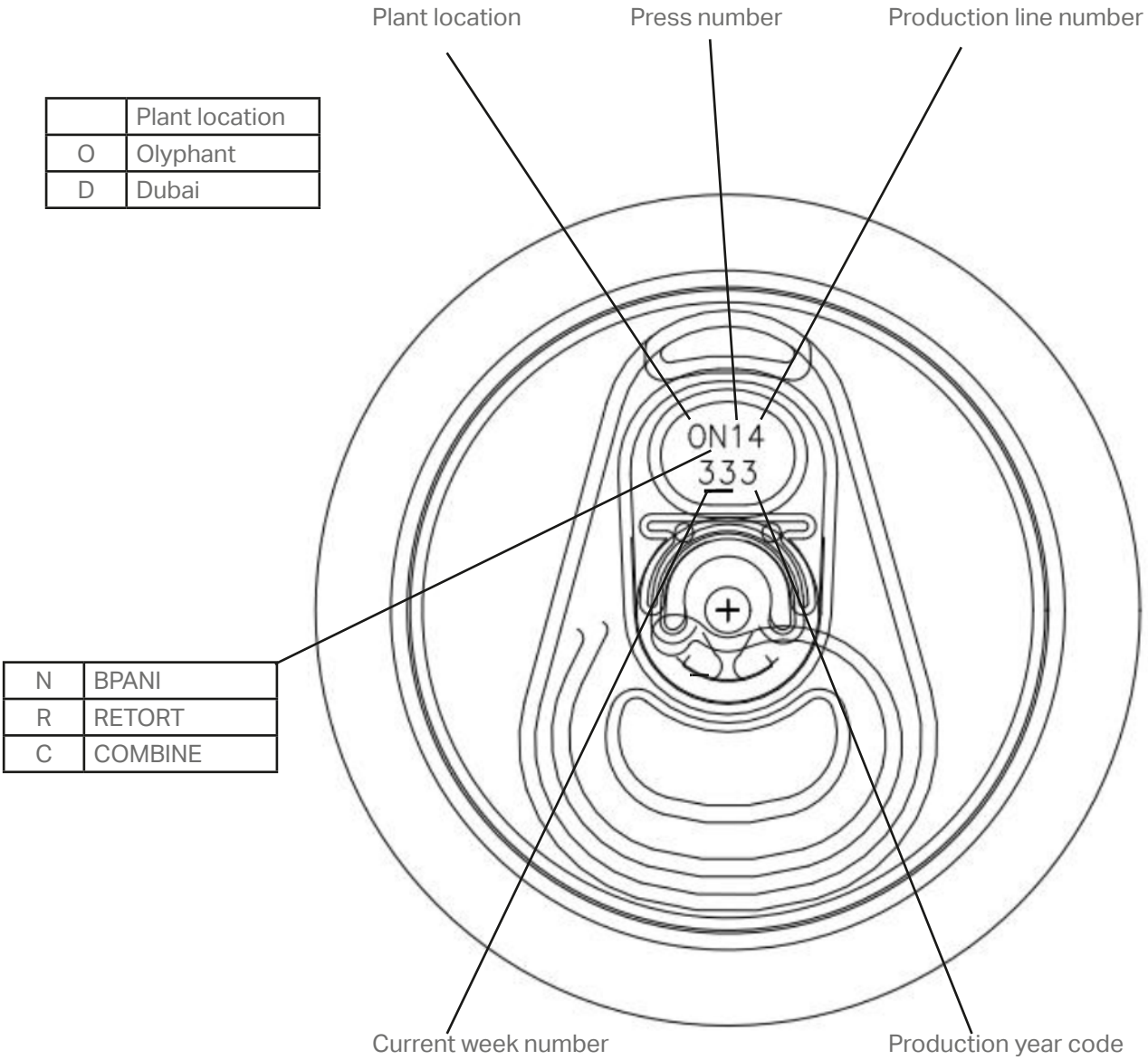
2.3.1 PRODUCTION DATE CODING

	Plant location
B	Brzesko
G	Bydgoszcz
D	Dubai
F	Fortaleza



Product:	Date:	Type:	Chapter:
ALUMINIUM easy open ends for beverage drinks	01.05.2020	200 dia, 202 dia	2.3.1
	Revision: 4	Approved by:	

2.3.2 PRODUCTION DATE CODING



	Plant location
O	Olyphant
D	Dubai

N	BPANI
R	RETORT
C	COMBINE

Product:	Date:	Type:	Chapter:
ALUMINIUM easy open ends for beverage drinks	21.12.2021	202 dia, 206 dia	2.3.2
	Revision: 1	Approved by:	

2.4 END - PROMOTION TAB

2.4.1 202 DIA

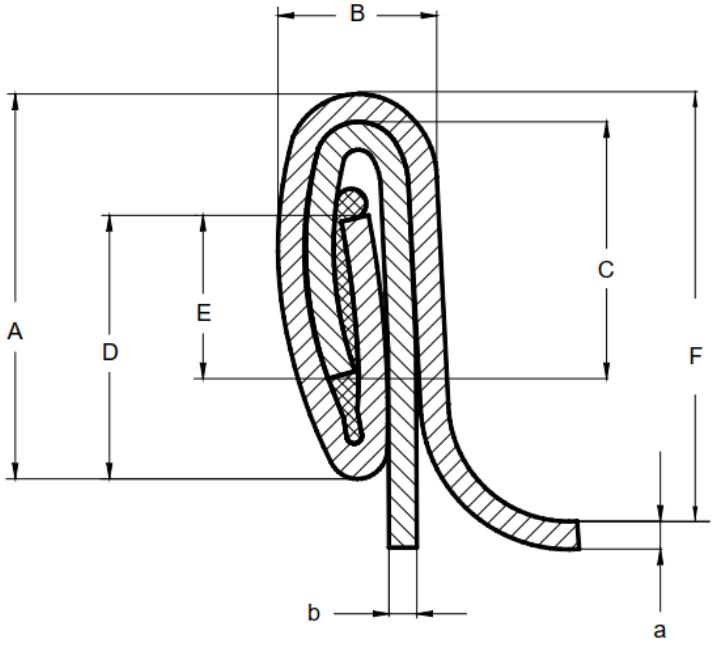
Promotion End with CAT-91 Tab

There is possibility to make promotional and decorative ends at CANPACK, all information on this subject can be obtained in the marketing department. Whole promotion parts can be made by incising or laser printing. To see examples of special promotion Ends with Tabs refer to catalog.

SEAM
THE BASIC INFORMATION

SEAM - BASIC INFORMATION

3.1.1 END 200 B64, END 200 CDL - CAN 202/200

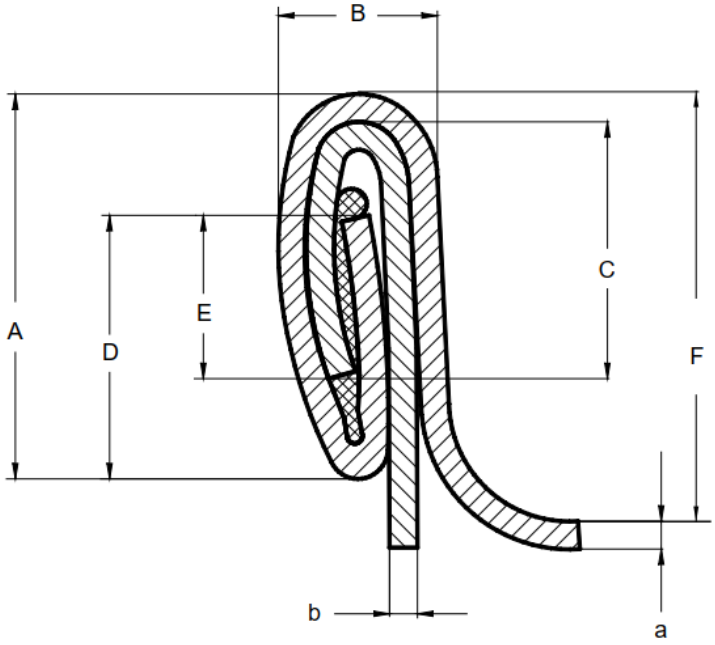


		Value [mm]		Production toller. [mm]	Seamer setting toller. [mm]
		B64	CDL		
A	Seam length	2,55	2,50	±0,15	±0,15
B	1st OP Seam thickness	2,00		±0,10	±0,05
B	2nd OP Seam thickness	1,14	1,09	±0,05	±0,03
C	Body hook length	1,60		±0,20	±0,10
D	End hook length	1,60		±0,20	±0,15
E	Overlap	min 0,75		-	-
F	Countersink depth	6,60	6,35	±0,15	
a	End component thickness	0,230	0,213	-	-
b	Body wall thickness	0,160		-	-
	BHB [%]	72% - 97%		-	-
	Tightness raiting [%]	min 99%		-	-
	Free space	0,13		±0,05	-
	Seam gap	max 0,07		-	-

Product:	Date:	Type:	Chapter:
SEAM - BASIC INFORMATION	11.09.2023	End 200 B64 End 200 CDL CAN 202/200	3.1.1
	Revision: 7	Approved by:	

SEAM - BASIC INFORMATION

3.1.2 END 200 B64, END 200 CDL - CAN 204/200 FIT

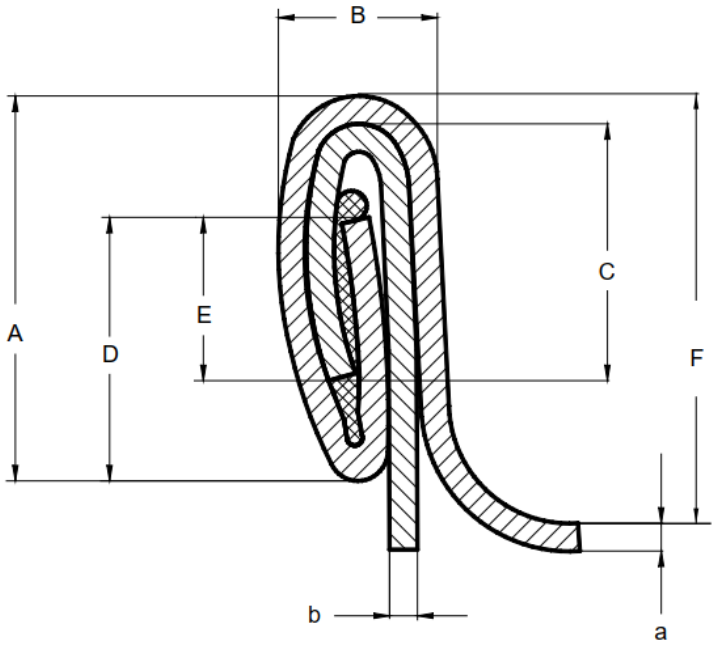


		Value [mm]		Production toller. [mm]	Seamer setting toller. [mm]
		B64	CDL		
A	Seam length	2,55	2,50	±0,15	±0,15
B	1st OP Seam thickness	2,00		±0,10	±0,05
B	2nd OP Seam thickness	1,15	1,10	±0,05	±0,03
C	Body hook length	1,60		±0,20	±0,10
D	End hook length	1,60		±0,20	±0,15
E	Overlap	min 0,75		-	-
F	Countersink depth	6,60	6,35	±0,15	-
a	End component thickness	0,230	0,213	-	-
b	Body wall thickness	0,165		-	-
	BHB [%]	72% - 97%		-	-
	Tightness raiting [%]	min 99%		-	-
	Free space	0,13		±0,05	-
	Seam gap	max 0,07		-	-

Product:	Date:	Type:	Chapter:
SEAM - BASIC INFORMATION	11.09.2023	End 200 B64 End 200 CDL Can 204/200 FIT	3.1.2
	Revision: 6	Approved by:	

SEAM - BASIC INFORMATION

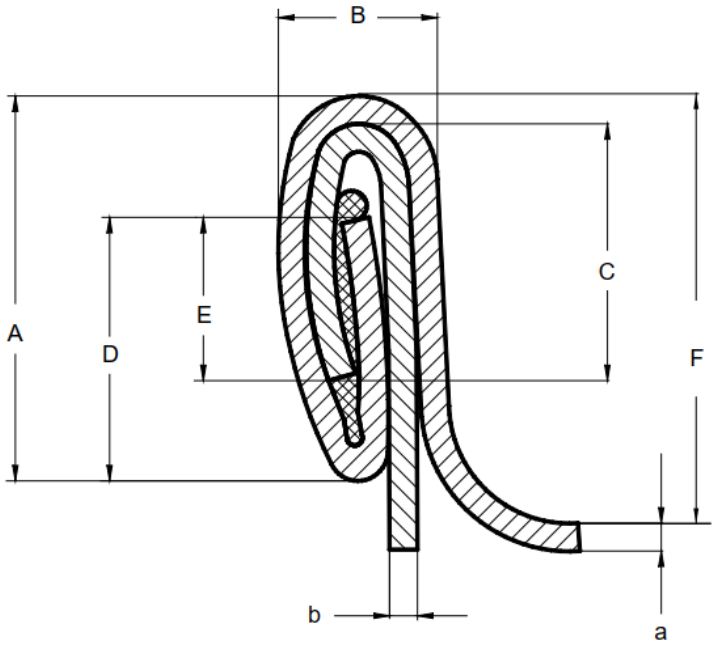
3.1.3 END 202 B64, END 202 CDL, END 202 CDL+ - CAN 204/202 FIT



		Value [mm]			Production toller. [mm]	Seamer setting toller. [mm]
		B64	CDL	CDL +		
A	Seam length	2,55	2,50		±0,15	±0,15
B	1st OP Seam thickness	2,00			±0,10	±0,05
B	2nd OP seam thickness	1,15	1,11		±0,05	±0,03
C	Body hook length	1,60			±0,20	±0,10
D	End hook length	1,60			±0,20	±0,15
E	Actual Overlap	min 0,75			-	-
F	Countersink depth	6,60	6,35	5,97	±0,15	-0
a	End component thickness	0,230	0,218		-	-
b	Body wall thickness	0,165			-	-
	BHB [%]	72% - 97%			-	-
	Tightness rating [%]	min 99%			-	-
	Free space	0,13			±0,05	-
	Seam gap	max 0,07			-	-

SEAM - BASIC INFORMATION

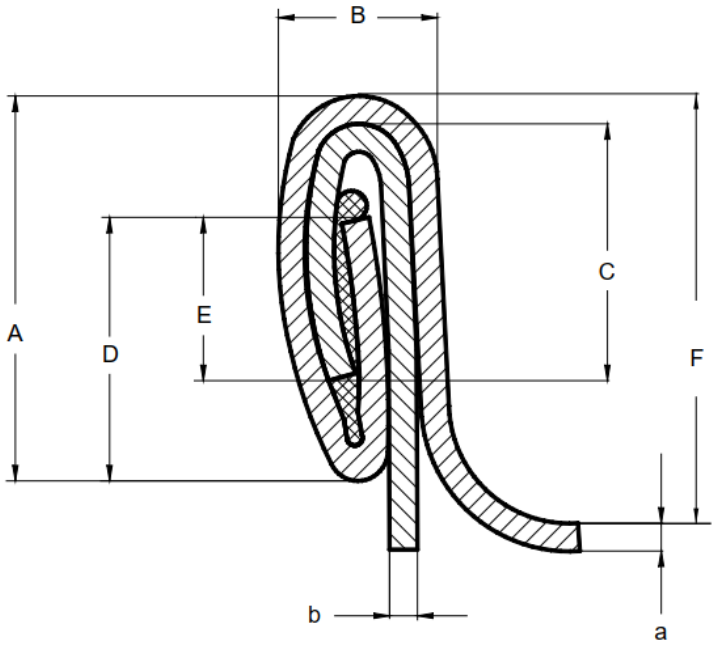
3.1.4 END 202 B64 - CAN 211/202



		Value [mm]	Production toller. [mm]	Seamer setting toller. [mm]
		B64		
A	Seam length	2,55	±0,15	±0,15
B	1st OP Seam thickness	2,00	±0,10	±0,05
B	2nd OP seam thickness	1,16	±0,05	±0,03
C	Body hook length	1,60	±0,20	±0,10
D	End hook length	1,60	±0,20	±0,15
E	Overlap	min 0,75	-	-
F	Countersink depth	6,86	±0,15	
a	End component thickness	0,23	-	-
b	Body wall thickness	0,170	-	-
	BHB [%]	72% - 97%	-	-
	Tightness rating [%]	min 99%	-	-
	Free space	0,13	±0,05	-
	Seam gap	max 0,07	-	-

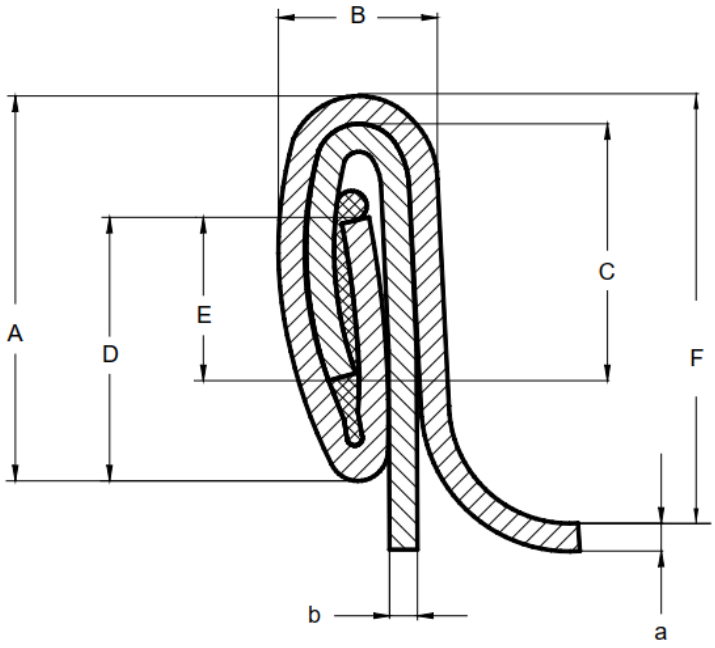
SEAM - BASIC INFORMATION

3.1.5 END 202 CDL, END 202 CDL+ - CAN 211/202



		Value [mm]		Production toller. [mm]	Seamer setting toller. [mm]
		CDL	CDL +		
A	Seam length	2,50		±0,15	±0,15
B	1st OP Seam thickness	2,00		±0,10	±0,05
B	2nd OP seam thickness	1,12		±0,05	±0,03
C	Body hook length	1,60		±0,20	±0,10
D	End hook length	1,60		±0,20	±0,15
E	Actual Overlap	min 0,75		-	-
F	Countersink depth	6,35	5,97	±0,15	-
a	End component thickness	0,218		-	-
b	Body wall thickness	0,170		-	-
	BHB [%]	72% - 97%		-	-
	Tightness rating [%]	min 99%		-	-
	Free space	0,13		±0,05	-
	Seam gap	max 0,07		-	-

3.1.6 END 206 CDL - CAN 300/206/206



		Value [mm] CDL	Production toller. [mm]	Seamer setting toller. [mm]
A	Seam length	2,50	±0,15	±0,15
B	1st OP Seam thickness	2,05	±0,10	±0,05
B	2nd OP seam thickness	1,23	±0,05	±0,03
C	Body hook length	1,60	±0,20	±0,10
D	End hook length	1,60	±0,20	±0,10
E	Actual Overlap	min 0,75	-	-
F	Countersink depth	6,81	±0,15	-
a	End component thickness	0,249	-	-
b	Body wall thickness	0,180	-	-
	BHB [%]	72% - 97%	-	-
	Tightness rating [%]	min 90%	-	-
	Free space	0,13	±0,05	-
	Seam gap	max 0,07	-	-

SEAM
INSPECTION PROTOCOLS

3.2.1 END 202 B64 - CAN 211/202

CANPACK

SEAM INSPECTION 202/200

CAN Al	Date:	Time:	Quality inspector:
	Litography:	END 200/200 CDL	Litography:
	Producer:		Producer:
	Code:		Code:

Head No		1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	
Visual																				
Can heigth	+0,60																			+0,60
	+0,40																			+0,40
	+0,20																			+0,20
	-0,20																			-0,20
	-0,40																			-0,40
	-0,60																			-0,60
Countersink depth CD 6,60±0,15 6,35±0,15	6,90																			6,90
	6,75																			6,75
	6,60																			6,60
	6,45																			6,45
	6,30																			6,30
Seam thickness ST Al-1,14 ± 0,05 Al-1,09 ± 0,05	+0,08																			+0,08
	+0,06																			+0,06
	+0,04																			+0,04
	+0,02																			+0,02
	-0,02																			-0,02
	-0,04																			-0,04
	-0,06																			-0,06
	-0,08																			-0,08
Seam length SL 2,55±0,15 2,50±0,15	2,75																			2,75
	2,65																			2,65
	2,55																			2,55
	2,45																			2,45
	2,35																			2,35
Body hook length BH 1,60±0,20	1,90																			1,90
	1,80																			1,80
	1,70																			1,70
	1,60																			1,60
	1,50																			1,50
	1,40																			1,40
	1,30																			1,30
End hook length EH 1,60±0,20	1,90																			1,90
	1,80																			1,80
	1,70																			1,70
	1,60																			1,60
	1,50																			1,50
	1,40																			1,40
	1,30																			1,30
Seam gap max. 0,07 mm	1.																			1.
	2.																			2.
	3.																			3.
Overlap O min. 0,75 mm	1,30																			1,30
	1,20																			1,20
	1,10																			1,10
	1,00																			1,00
	0,90																			0,90
	0,80																			0,80
	0,75																			0,75
	0,70																			0,70
Wrinkle/Tightnes rating % min. 99%	100																			100
	90																			90
	80																			80
	70																			70
Body hook butting (%) Al-can 72...97% Fe-can 72...92%																				
Free space 0,13±0,05	0,18																			0,18
	0,13																			0,13
	0,08																			0,08

Notes:

3.2.2 END 202 CDL - CAN 211/202

CANPACK

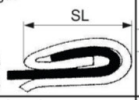
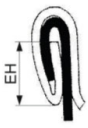
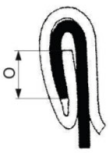
SEAM INSPECTION
202

CAN Al	Date:								Time:					Quality inspector:					
	Litography:								END 202 CDL					Litography:					
	Producer:													Producer:					
	Code:													Code:					
Head No		1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	
Visual																				
Can heigth	+0,60																			+0,60
	+0,40																			+0,40
	+0,20																			+0,20
	-0,20																			-0,20
	-0,40																			-0,40
	-0,60																			-0,60
Countersink depth CD	6,90																			6,90
	6,75																			6,75
	6,60																			6,60
	6,45																			6,45
6,35±0,15	6,30																			6,30
Seam thickness ST	+0,08																			+0,08
	+0,06																			+0,06
	+0,04																			+0,04
	+0,02																			+0,02
	-0,02																			-0,02
	-0,04																			-0,04
Al-1,14 ± 0,05	-0,06																			-0,06
Al-1,12 ± 0,05	-0,08																			-0,08
Seam length SL	2,75																			2,75
	2,65																			2,65
	2,55																			2,55
	2,45																			2,45
2,50± 0,15	2,35																			2,35
Body hook length BH	1,90																			1,90
	1,80																			1,80
	1,70																			1,70
	1,60																			1,60
	1,50																			1,50
	1,40																			1,40
1,60±0,20	1,30																			1,30
End hook length EH	1,90																			1,90
	1,80																			1,80
	1,70																			1,70
	1,60																			1,60
	1,50																			1,50
	1,40																			1,40
1,60±0,20	1,30																			1,30
Seam gap	1.																			1.
	2.																			2.
max. 0,07 mm	3.																			3.
Overlap O	1,30																			1,30
	1,20																			1,20
	1,10																			1,10
	1,00																			1,00
	0,90																			0,90
	0,80																			0,80
	0,75																			0,75
min. 0,75 mm	0,70																			0,70
Wrinkle/Tightnes rating %	100																			100
	90																			90
	80																			80
min. 99%	70																			70
Body hook butting (%)																				
Al-can 72...97%																				
Fe-can 72...92%																				
Free space	0,18																			0,18
	0,13																			0,13
0,13±0,05	0,08																			0,08
Notes:																				

3.2.3 END B64, END 200 CDL - CAN 202/200 SLIM

CANPACK

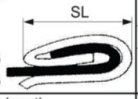
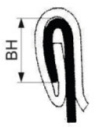
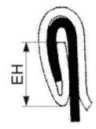
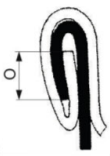
SEAM INSPECTION
202/200

	Date:								**Time:**					**Quality inspector:**					
CAN Al	**Litography:**								**END 200/200 CDL**					**Litography:**					
	Producer:													**Producer:**					
	Code:													**Code:**					
Head No		1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	
Visual																				
Can heigth	+0,60																			+0,60
	+0,40																			+0,40
	+0,20																			+0,20
	-0,20																			-0,20
	-0,40																			-0,40
	-0,60																			-0,60
Countersink depth  6,60±0,15 6,35±0,15	6,90																			6,90
	6,75																			6,75
	6,60																			6,60
	6,45																			6,45
	6,30																			6,30
Seam thickness  Al-1,14 ± 0,05 Al-1,09 ± 0,05	+0,08																			+0,08
	+0,06																			+0,06
	+0,04																			+0,04
	+0,02																			+0,02
	-0,02																			-0,02
	-0,04																			-0,04
	-0,06																			-0,06
	-0,08																			-0,08
Seam length  2,55± 0,15 2,50± 0,15	2,75																			2,75
	2,65																			2,65
	2,55																			2,55
	2,45																			2,45
	2,35																			2,35
Body hook length  1,60±0,20	1,90																			1,90
	1,80																			1,80
	1,70																			1,70
	1,60																			1,60
	1,50																			1,50
	1,40																			1,40
	1,30																			1,30
End hook length  1,60±0,20	1,90																			1,90
	1,80																			1,80
	1,70																			1,70
	1,60																			1,60
	1,50																			1,50
	1,40																			1,40
	1,30																			1,30
Seam gap	1.																			1.
	2.																			2.
max. 0,07 mm	3.																			3.
Overlap  min. 0,75 mm	1,30																			1,30
	1,20																			1,20
	1,10																			1,10
	1,00																			1,00
	0,90																			0,90
	0,80																			0,80
	0,75																			0,75
	0,70																			0,70
Wrinkle/Tightnes rating %	100																			100
	90																			90
	80																			80
min. 99%	70																			70
Body hook butting (%) Al-can 72...97% Fe-can 72...92%																				
Free space	0,18																			0,18
	0,13																			0,13
0,13±0,05	0,08																			0,08
Notes:																				

3.2.4 END 202 B64, END 202 CDL - CAN 204/202 FIT

CANPACK

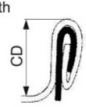
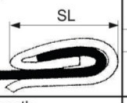
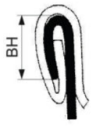
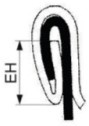
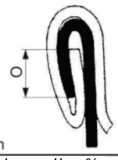
SEAM INSPECTION
204/202 FIT

	Date:								Time:					Quality inspector:						
CAN Al	Litography:								END 202/202 CDL					Litography:						
	Producer:													Producer:						
	Code:													Code:						
Head No		1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	
Visual																				
Can heigth	+0,60																			+0,60
	+0,40																			+0,40
	+0,20																			+0,20
	-0,20																			-0,20
	-0,40																			-0,40
	-0,60																			-0,60
Countersink depth  6,60±0,15 6,35±0,15	7,16																			7,16
	7,01																			7,01
	6,86																			6,86
	6,71																			6,71
	6,56																			6,56
Seam thickness  Al-1,15 ± 0,05 Al-1,11 ± 0,05	+0,08																			+0,08
	+0,06																			+0,06
	+0,04																			+0,04
	+0,02																			+0,02
	-0,02																			-0,02
	-0,04																			-0,04
	-0,06																			-0,06
	-0,08																			-0,08
Seam length  2,55±0,15 2,50±0,15	2,75																			2,75
	2,65																			2,65
	2,55																			2,55
	2,45																			2,45
	2,35																			2,35
Body hook length  1,60±0,20	1,90																			1,90
	1,80																			1,80
	1,70																			1,70
	1,60																			1,60
	1,50																			1,50
	1,40																			1,40
	1,30																			1,30
End hook length  1,60±0,20	1,90																			1,90
	1,80																			1,80
	1,70																			1,70
	1,60																			1,60
	1,50																			1,50
	1,40																			1,40
	1,30																			1,30
Seam gap max. 0,07 mm	1.																			1.
	2.																			2.
	3.																			3.
Overlap  min. 0,75 mm	1,30																			1,30
	1,20																			1,20
	1,10																			1,10
	1,00																			1,00
	0,90																			0,90
	0,80																			0,80
	0,75																			0,75
	0,70																			0,70
Wrinkle/Tightnes rating % min. 99%	100																			100
	90																			90
	80																			80
	70																			70
Body hook butting (%) Al-can 72...97% Fe-can 72...92%																				
Free space 0,13±0,05	0,18																			0,18
	0,13																			0,13
	0,08																			0,08
Notes:																				

3.2.5 END 200 B64, END 200 CDL - CAN 204/200 FIT

CANPACK

SEAM INSPECTION
204/200 dia FIT

	Date:								**Time:**					**Quality inspector:**						
CAN Al	**Litography:**								**END 200/200 CDL**					**Litography:**						
	Producer:													**Producer:**						
	Code:													**Code:**						
Head No		1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	
Visual																				
Can heigth	+0,60																			+0,60
	+0,40																			+0,40
	+0,20																			+0,20
	-0,20																			-0,20
	-0,40																			-0,40
	-0,60																			-0,60
Countersink depth  6,60±0,15 6,35±0,15	7,16																			7,16
	7,01																			7,01
	6,86																			6,86
	6,71																			6,71
	6,56																			6,56
Seam thickness  Al-1,15 ± 0,05 Al-1,10 ± 0,05	+0,08																			+0,08
	+0,06																			+0,06
	+0,04																			+0,04
	+0,02																			+0,02
	-0,02																			-0,02
	-0,04																			-0,04
	-0,06																			-0,06
	-0,08																			-0,08
Seam length  2,55±0,15 2,50±0,15	2,75																			2,75
	2,65																			2,65
	2,55																			2,55
	2,45																			2,45
	2,35																			2,35
Body hook length  1,60±0,20	1,90																			1,90
	1,80																			1,80
	1,70																			1,70
	1,60																			1,60
	1,50																			1,50
	1,40																			1,40
	1,30																			1,30
End hook length  1,60±0,20	1,90																			1,90
	1,80																			1,80
	1,70																			1,70
	1,60																			1,60
	1,50																			1,50
	1,40																			1,40
	1,30																			1,30
Seam gap max. 0,07 mm	1.																			1.
	2.																			2.
	3.																			3.
Overlap  min. 0,75 mm	1,30																			1,30
	1,20																			1,20
	1,10																			1,10
	1,00																			1,00
	0,90																			0,90
	0,80																			0,80
	0,75																			0,75
	0,70																			0,70
Wrinkle/Tightnes rating % min. 99%	100																			100
	90																			90
	80																			80
	70																			70
Body hook butting (%) Al-can 72...97% Fe-can 72...92%																				
Free space 0,13±0,05	0,18																			0,18
	0,13																			0,13
	0,08																			0,08
Notes:																				

3.2.6 END 202 CDL+ - CAN 211/202

CANPACK

SEAM INSPECTION
211/202

CAN Al	Date:	Time:	Quality inspector:
	Litography:	END 202 CDL+	Litography:
	Producer:		Producer:
	Code:		Code:

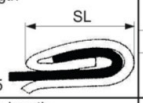
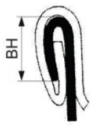
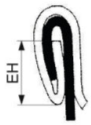
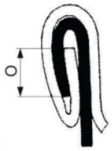
Head No		1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	
Visual																				
Can heigth	+0,60																			+0,60
	+0,40																			+0,40
	+0,20																			+0,20
	-0,20																			-0,20
	-0,40																			-0,40
	-0,60																			-0,60
Countersink depth (CD) 5,97±0,15	6,27																			6,27
	6,12																			6,12
	5,97																			5,97
	5,82																			5,82
	5,67																			5,67
Seam thickness (ST) Al-1,12 ± 0,05	+0,08																			+0,08
	+0,06																			+0,06
	+0,04																			+0,04
	+0,02																			+0,02
	-0,02																			-0,02
	-0,04																			-0,04
	-0,06																			-0,06
	-0,08																			-0,08
Seam length (SL) 2,50±0,15	2,75																			2,75
	2,65																			2,65
	2,55																			2,55
	2,45																			2,45
	2,35																			2,35
Body hook length (BH) 1,60±0,20	1,90																			1,90
	1,80																			1,80
	1,70																			1,70
	1,60																			1,60
	1,50																			1,50
	1,40																			1,40
	1,30																			1,30
End hook length (EH) 1,60±0,20	1,90																			1,90
	1,80																			1,80
	1,70																			1,70
	1,60																			1,60
	1,50																			1,50
	1,40																			1,40
	1,30																			1,30
Seam gap max. 0,07 mm	1.																			1.
	2.																			2.
	3.																			3.
Overlap (O) min. 0,75 mm	1,30																			1,30
	1,20																			1,20
	1,10																			1,10
	1,00																			1,00
	0,90																			0,90
	0,80																			0,80
	0,75																			0,75
	0,70																			0,70
Wrinkle/Tightnes rating % min. 99%	100																			100
	90																			90
	80																			80
	70																			70
Body hook butting (%) Al-can 72...97% Fe-can 72...92%																				
Free space 0,13±0,05	0,18																			0,18
	0,13																			0,13
	0,08																			0,08

Notes:

3.2.7 END 202 CDL+ - CAN 204/202 FIT

CANPACK

SEAM INSPECTION
204/202 FIT

	Date:								**Time:**					**Quality inspector:**						
CAN **Al**	**Litography:**								**END** **202 CDL+**					**Litography:**						
	Producer:													**Producer:**						
	Code:													**Code:**						
Head No		1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	
Visual																				
Can heigth	+0,60																			+0,60
	+0,40																			+0,40
	+0,20																			+0,20
	-0,20																			-0,20
	-0,40																			-0,40
	-0,60																			-0,60
Countersink depth  5,97±0,15	6,27																			6,27
	6,12																			6,12
	5,97																			5,97
	5,82																			5,82
	5,67																			5,67
Seam thickness  Al-1,11 ± 0,05	+0,08																			+0,08
	+0,06																			+0,06
	+0,04																			+0,04
	+0,02																			+0,02
	-0,02																			-0,02
	-0,04																			-0,04
	-0,06																			-0,06
	-0,08																			-0,08
Seam length  2,50±0,15	2,75																			2,75
	2,65																			2,65
	2,55																			2,55
	2,45																			2,45
	2,35																			2,35
Body hook length  1,60±0,20	1,90																			1,90
	1,80																			1,80
	1,70																			1,70
	1,60																			1,60
	1,50																			1,50
	1,40																			1,40
	1,30																			1,30
End hook length  1,60±0,20	1,90																			1,90
	1,80																			1,80
	1,70																			1,70
	1,60																			1,60
	1,50																			1,50
	1,40																			1,40
	1,30																			1,30
Seam gap max. 0,07 mm	1.																			1.
	2.																			2.
	3.																			3.
Overlap  min. 0,75 mm	1,30																			1,30
	1,20																			1,20
	1,10																			1,10
	1,00																			1,00
	0,90																			0,90
	0,80																			0,80
	0,75																			0,75
	0,70																			0,70
Wrinkle/Tightnes rating % min. 99%	100																			100
	90																			90
	80																			80
	70																			70
Body hook butting (%) Al-can 72...97% Fe-can 72...92%																				
Free space 0,13±0,05	0,18																			0,18
	0,13																			0,13
	0,08																			0,08
Notes:																				

3.2.8 END 206 CDL - CAN 300/206

CANPACK

SEAM INSPECTION
300/206

CAN Al	Date:	Time:	Quality inspector:
	Litography:	END 206 CDL	Litography:
	Producer:		Producer:
	Code:		Code:

Head No		1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	
Visual																				
Can heigth	+0,60																			+0,60
	+0,40																			+0,40
	+0,20																			+0,20
	-0,20																			-0,20
	-0,40																			-0,40
	-0,60																			-0,60
Countersink depth (CD) 6,81±0,15	7,11																			7,11
	6,96																			6,96
	6,81																			6,81
	6,66																			6,66
	6,51																			6,51
Seam thickness (ST) Al-1,23±0,05	+0,08																			+0,08
	+0,06																			+0,06
	+0,04																			+0,04
	+0,02																			+0,02
	-0,02																			-0,02
	-0,04																			-0,04
	-0,06																			-0,06
	-0,08																			-0,08
Seam length (SL) 2,50±0,15	2,75																			2,75
	2,65																			2,65
	2,55																			2,55
	2,45																			2,45
	2,35																			2,35
Body hook length (BH) 1,60±0,20	1,90																			1,90
	1,80																			1,80
	1,70																			1,70
	1,60																			1,60
	1,50																			1,50
	1,40																			1,40
	1,30																			1,30
End hook length (EH) 1,60±0,20	1,90																			1,90
	1,80																			1,80
	1,70																			1,70
	1,60																			1,60
	1,50																			1,50
	1,40																			1,40
	1,30																			1,30
Seam gap max. 0,07 mm	1.																			1.
	2.																			2.
	3.																			3.
Overlap (O) min. 0,75 mm	1,30																			1,30
	1,20																			1,20
	1,10																			1,10
	1,00																			1,00
	0,90																			0,90
	0,80																			0,80
	0,75																			0,75
	0,70																			0,70
Wrinkle/Tightnes rating % min. 90%	100																			100
	90																			90
	80																			80
	70																			70
Body hook butting (%) Al-can 72...97% Fe-can 72...92%																				
Free space 0,13±0,05	0,18																			0,18
	0,13																			0,13
	0,08																			0,08
Notes:																				

4.1 CAN-INITIAL ACCEPTANCE OF CAN BATCH

INITAL ACCEPTANCE OF CAN BATCH

INITAL ACCEPTANCE OF CAN BATCH

4.1.1 INTIAL ACCEPTANCE OF CAN BATCH

A. VISUAL ASSESSMENT OF A PALLET DURING UNLOADING

1. Visual assesment of a pallet

Inital acceptance of a pallet should be performed from 1 meter distance with use of a naked eye during unloading or immediately after unloading is finished.

Check information included on the tag and compare them to the order. Pay special attention to:

- type and symbol of lithography,
- can dimensions,
- quantity of cans.

Perform visual assessment of external elements of a pallet. Check, if there aren't any:

- mechanical damage of cans,
- damage of a pallet making depalletization impossible.

All damaged cans must be removed with no exceptions. Allowable quantity of cans with transportation defects in external layers of a pallet must not exceed 0.1% of cans in the delivered batch.

The pallet damaged to such extent that it is impossible to be used in the production process should be left to producer's disposal and complaint form shall be filled out about. Such a pallet is not considered in further proceedings.

To fill a complaint about a pallet, draw up the complaint protocol (see point C).

Provide the vehicle number and enclose photographs of the damaged pallet.

B. EXAMINATION OF CANS

Rules of collecting cans to be examination: Randomly collect can sample of specified quantity from the batch (depending on the type of examination). Before that, specify the method of can collection (e.g. the fifth layer from the bottom, the fifth can from the left along the longer side). Cans having more than one incompatibility shall be assigned to only one type of incompatibilities.

1. Visual assessment

a. Put cans next to each other in a well-lit room in such a way that it is no shading effect. Day light is recommended. Classify defects regarding the categories enclosed to this instruction. Compare examination results to the qualification number.

b. Using light D65 assess from the distance of 1 m, whether there are any perceptible differences in lithography among cans and incompatibilities of significant marketing importance. "Lithography pattern" approved by producer shall be treated as reference. In case of arguments, use lighting with temperature of 5000 K. Defects not perceptible with a naked eye from the distance no lesser than 1 m shall not be treated as incompatibilities or defects.

c. The method of results usage is specified in point C.

2. Geometric dimensions.

Check, if cans are not mechanically damaged as they must not be a subject of geometric examination. Perform measurements by means of tests or measuring devices of accuracy appropriate for dimensions and dimension deviations.

Measure:

- can height,
- flange width,
- inside neck diameter.

Can height and neck width shall be measured in four locations. Measurement of a can inside neck diameter shall be performed only once. A can shall considered as not meeting requirements, if the measurement result exceeds the specified tolerance. Can measurements should comply with producer's technical conditions.

3. Impermeability of internal lacquer coating.

In order to assure measurement correctness, it is recommended to collect a new batch of samples, not damaged by previous measurements. Perform examination exclusively on not derformed cans.

The results of the measurement should be compared to the specifications for a given type of beverage. Assessment of internal varnish coating integrity is determined by metal exposure test (enamel rater test). Enamel rater is an electrochemical method, using sodium chloride solution and under test voltage set at 6.3 VDC. A batch does not meet requirements if the allowable integral current factor for the internal liner coating has been exceeded in more than one can or if the average for the sample set is higher in the table (see page 48).

4. Bar code.

Use laser scanner. Examine sufficient number of cans.

C. THE ANALYSIS OF THE VISUAL ASSESSMENT AND EXAMINATION OF CANS

1. If the number of cans not meeting requirements is equal to, or less than the qualification number, the batch should be considered as meeting requirements and assigned to the production process.
2. In situations, when the number of cans not meeting requirements exceeds the qualification number, hold the batch being examined and perform the examination once again on the new batch of cans. If the repeated examination shows that the number of cans not meeting requirements does not exceed the qualification number, the batch should be considered as meeting requirements and assigned to the production process. If the number of cans not meeting requirements exceeds the qualification number, hold the batch permanently and leave it to the producer's disposal and draw up a complaint protocol.

It is possible:

- To accept cans from this batch in the production process, if:

a. there is no risk of decreased product quality,
b. production line output is not decreased,
c. apperance of can is not changed.

- To select pallets with cans meeting requirements and to accept these cans in the production process; in such a situation a batch should be understood to be a pallet or a group of pallets accepted in the production process.

3. Draw up a complaint protocol.

D. FILLING A COMPLAINT

Complaints related to the delivered products should be submitted to the Trade and Marketing Office by means of forms, in accordance with the enclosed template. If complaints are related with quality defects of cans, examples of such defected products should be delivered to the producer. Separate the batch that was complained about and leave it to disposal of the CANPACK company. Do not make any interferences to the actual state of this batch.

CANPACK reserves the right to have access to the documentation being the basis for the filed complaint and to the records of processing parameters having impact on the packaging.

CANPACK	

CAN body defects	
Critical AQL=0,01	
Application of legally forbidden materials	0,01
Application of non-approved materials	0,01
Illegible inscription required by law	0,01
Metal slivers	0,01
Serious health and life threatening dirt or foreign materials related to the technological process	0,01
Foreign smell or defect causing taste change	0,01
Foreign can	0,01
Invalid bar code	0,01
No adhesion of internal lacquer	0,01
Partially or totally missing of Internal lacquer	0,01
Major AQL=0,4	
Damaged part of the flange causing leaking	0,4
Cracked or cut dome causing leaking	0,4
Perforation	0,4
Peeling at the neck (no adhesion)	0,4
Missing part of the lithography	0,4
High metal exposure/internal coating defects	0,4
Resistance parameters out of specification (Dome reversal pressure, Axial Load)	0,4
Illegible bar code	0,4
Lack of overvarnish at the dome ring or flange	0,4
Large mechanical defects like wrinkles, dents, pin holes and creases	0,4
Geometric dimensions out of specification	0,4

INITIAL ACCEPTANCE OF CAN BATCH

CAN body defects	
Minor AQL=1,5	
Damaged (waved or deformed) part of the flange not causing leakage	1,5
Improper color of lithography	1,5
Improper lithography offset / Position of multiprint elements out of specification	1,5
Scratching and abrasion of lithography	1,5
Improper embossing registration to lithography	1,5
Poor printing, missing color	1,5
Incorrect labeling	1,5
Wet pallets	1,5
Minor Secondary AQL=4	
Double neck (hump at the neck)	4
Minor colour deviations (not visible from 1m)	4
Low effect of special overvarnish	4
Lithography printed inside can (offset)	4
Foreign material on the side wall externally (dirt)	4
Aluminum dots (splashes)	4
Small mechanical defects like wrinkles, dents, pin holes and creases	4
Bad mobility of cans	4
Packaging inconsistent with production order	4
Transport damages	4
Incomplete/delayed delivery	4

Initial acceptance at customer's premises should be performed in accordance with the ISO 2859-1 and ISO 3951 standards. Samples should be collected randomly, taking into account whole delivered batch. The recommended check level is S3. In case of arguments, level S2 is allowable, too.
Allowable level of transportation defects is 0.1%

Product:	Date:	Type:	Chapter:
Initial acceptance of can batch	01.05.2020	Aluminium cans	4.1.1
	Revision: 1	Approved by:	

CLAIM PROTOCOL			
Complaint ID:			
Customer name:			
Customer address:			
Claim reason:			
Date of the claim:		Claimed goods (cans/ends)	
Production number (CP pallet):		Production code (CP can/end):	
Bodymaker numbers on defective cans			
Labels numbers defining pallets with defective goods:			
Amount of complained/blocked goods:		Complaint from the market (yes/no)	
Amount of defective goods found in the batch		Product filled (yes/no)	

Complaint description :

Measurements/tests done by the Customer

Customer identification		**Information sent to CANPACK**		
Contact person:			Yes	No
Position/dep. :		Copy of invoice	☐	☐
Phone:		Photos of defect	☐	☐
e-mail:		Defective samples	☐	☐

Date: Signature:

Place: .....

The document can be filled once nonconforming product occurs.
The document should be sent to the Sales Department or the Sales contact.

END
THE INITIAL ACCEPTANCE OF
END BATCH

INITIAL ACCEPTANCE OF END BATCH

A. VISUAL ASSESSMENT OF A PALLET DURING UNLOADING

1. Visual assessment of a pallet.

Inital acceptance of a pallet should be performed with use of a naked eye during unloading or immediately after unloading is finished.

Check information included on the tag and compare it to the order. Pay special attention to:

- end is type,
- end dimensions,
- quantity of ends.

Perform visual assessment of external elements of a pallet. Check, if there is any:

- mechanical damage of sleeves,
- damage of a pallet making depalletization impossible.

The pallet damaged to such extent that it is impossible to be used in the productions process should be left to producer's disposal and a complaint form shall be filled out. Such a pallet is not considered in further proceedings.

Filing a complaint about a pallet, draw up the complaint protocol (see point C). It is recommended to provide the vehicle number and enclose photographs of the damaged pallet.

B. EXAMINATION OF ENDS.

Rules of collecting ends for examination: Randomly collect end sample of specified quantity from the batch (depending on the type of examination). Before that it is recommended to specify the method of end collection (e.g. one end from each sleeve protruding from the right).

Ends having more than one incompatibility shall be assigned to only one type of incompatibilities.

1. Visual assessment.

Check, if there are any:

- mechanical decfects,
- lacquering defects,
- sealing compound defects.
- and other defects specified in the "End defects" list and compare examination results to the qualification number.

INITIAL ACCEPTANCE OF END BATCH

2. Geometric dimensions.

Check if ends are not mechanically damaged as they must not be a subject of geometric examination.
Perform measurements by means of tests or measuring devices of accuracy appropriate for dimensions and dimension deviations.
Measure:

- external diameter,
- curl height,
- counter sink depth.

Curl height and counter sink depth shall be measured in four locations.
Measurement of the external diameter of an end shall be performed only once.
An end shall be considered as not meeting requirements, if the measurement result exceeds specified tolerance.
End measurements should comply with producer's technical conditions.

3. Impermeability of internal lacquer coating.

In order to assure measurement correctness, it is recommended to collect a new batch of samples, not damaged by previous measurements. Perform examination exclusively on not deformed ends.
A batch should be considered as not meeting requirements, if the number of individual exceeding is greater than allowable quantity or if the average value is exceeded.

4. End opening examination

Collect ends and perform opening.

C. THE ANALYSIS OF THE VISUAL ASSESSMENT AND EXAMINATION OF ENDS

1. If the number of ends not meeting requirements is equal or less than the qualification number, the batch should be considered as meeting requirements and assigned to the production process.

2. In situations, when the number of ends not meeting requirements exceeds the qualification number, hold the batch being examined and perform the examination once again on the new batch of ends. If the repeated examination shows that the number of ends not meeting requirements does not exceed the qualification number, the batch should be considered as meeting requirements and assigned to the production process.

If the number of ends not meeting requirements exceeds the qualification number, hold the batch permanently leave it to the producer's disposal and draw up a complaint protocol.

It is possible:

- to accept ends from this batch in the production process, if:
  a) there is no risk of decreased product quality,
  b) production line output is not decreased,
  c) appearance of end is not changed,
- to select sleeves with ends meeting requirements and to accept these ends in the production process; in such a situation a batch should be understood as a sleeve or a group of sleeves accepted in the production process.

3. Draw up a complaint protocol.

D. FILING A COMPLAINT

Complaints related to the delivered products should be submitted to the Trade and Marketing Office by means of forms in accordance with the enclosed template. If complaints are related with quality defects of ends, examples of such defected products should be delivered to the producer. Separate the batch that was complained about and leave it to disposal of the CANPACK company. Do not make any interferences to the actual state of this batch.

CANPACK reserves the right to have access to the documentation being the basis for the filed complaint and to the records of processing parameters having impact on the packaging.

INITIAL ACCEPTANCE OF END BATCH

CANPACK

End defects	
Critical AQL=0,01	
Application of legally forbidden materials	0,01
Application of non-approved materials	0,01
Foreign smell or defect causing taste change	0,01
Partially or totally missing of Internal lacquer	0,01
Serious health and life threatening dirt or foreign materials related to the technological process	0,01
Partially or totally missing of Internal lacquer	0,01
Internal coating defects causing metal exposure excess	0,01
Metal slivers	0,01
Major AQL=0,4	
Missing compound or incomplete compound	0,4
Tab burr or sharp edge	0,4
Mixed assortment	0,4
Missing tab or unconverted end	0,4
Lack of opening or opening which makes impossible the normal use of the package	0,4
Resistance parameters out of specification (pressures)	0,4
Perforation, leakages	0,4
Large mechanical defects	0,4
Peeling at the tab or external surface (no adhesion)	0,4

CANPACK	
End defects	
Minor AQL=1,5	
Contamination with compound	1,5
External surface scratches	1,5
External surface contamination	1,5
Turned tab	1,5
Missing or defective printing	1,5
Colour shade out of standard	1,5
Geometric dimensions out of specification	1,5
Minor Secondary AQL=4	
Small mechanical defects	4
Clenched ends	4
Reversed ends in the sleeve	4
Bubbles in sealing compound or filmweight out of specification	4
Sponginess	4
Transportation damages	4
Packaging inconsistent with production order	4
Incomplete/delayed delivery	4

Initial acceptance at customer's premises should be performed in accordance with the ISO 2859-1 and ISO 3951 standards. Samples should be collected randomly taking into account the whole delivered batch. The recommended check level is S3. In case of arguments, level S2 is allowable, too. Allowable level of transportation defects is 4 ends in the sleeve.

4.3 MEASUREMENT OF WATER RESIDUE ON THE END AFTER CANNING PROCES

MEASUREMENT OF WATER RESIDUE ON THE END AFTER CANNING PROCESS

4.3.1 END

MEASUREMENT OF WATER RESIDUE ON THE END AFTER CANNING PROCESS

Target: Assurance of proper condition for cans during product store and stress corrosion prevention.

Required equipment:
Analytical balance.
Sterile container or leakproof polyethylene bag.
Pincette.
Cotton wool or filter paper, called cotton wool.

Procedure:
Place cotton wools in 4 leakproof containers and weigh whole with measuring accuracy 0,001 g. Results should be noted.

Fot. 1. Container with the cotton wool to accumulate the moisture.

Product:	Date:	Type:	Chapter:
INITIAL ACCEPTANCE OF END BATCH	01.05.2020	Aluminium cans	4.3.1
	Revision: 1	Approved by:	

MEASUREMENT OF WATER RESIDUE ON THE END AFTER CANNING PROCESS

MEASUREMENT OF WATER RESIDUE ON THE END AFTER CANNING PROCESS

Take 4 cans from each conveyor after coding or drying process.

Fot. 2. Measure of the weight of container with the cotton wool.

Product:	Date:	Type:	Chapter:
INITIAL ACCEPTANCE OF END BATCH	01.05.2020	Aluminium cans	4.3.1
	Revision: 1	Approved by:	

MEASUREMENT OF WATER RESIDUE ON THE END AFTER CANNING PROCESS

Please collect the moisture with the end of filled can, together with area under the tab and incisions, using the cotton wool taken out from container. Do not allow to contaminate the cotton wool.

Fot. 3. Collecting the moisture from the end.

Put the cotton wools in leakproof containers and immediately weigh them again (please ensure the shortest time between sampling and weighing). Results should be noted.

Calculate the difference between weight of dry cotton wools and weight of damp cotton wools (after taking water from the end). That difference is the measure of water residue on the end. Maximal admitted amount of water residue is shown in the table no. 1.

MEASUREMENT OF WATER RESIDUE ON THE END AFTER CANNING PROCESS

MEASUREMENT OF WATER RESIDUE ON THE END AFTER CANNING PROCESS

Parameter	Maximal admitted amount of water in sample
Avarage value from the test	3 mg
Individual value	9 mg

The measurements should be performed everyday or permanently – depending on work of the line. (It is CP recommendation only.)

CAN LEAKAGE AND CORROSION. GENERAL PRINCIPLES FOR STORING

LEAKAGE AND CORROSION - LEAKAGE PROTECTION

4.4.1 ALUMINUM CAN PRIMARY LEAKAGE PROTECTION

Basic sources of leakage are the following:
- improper operation of filling line resulting in mechanical damages,
- improper storage handling.

CANPACK indicates the need to observe instructions regarding transport, unloading, storage of empty cans, storage of finished product.
In order to avoid leakage the following measures should be taken:

1. Inspect the filling line paying special attention to:
- correct synchronization of can conveyors especially in filling / seaming machine section,
- check the double tab quality,
- check correct operation of filling level detectors,
- check the technical condition of filling and seaming machine lifting devices,
- check the quality of coil surfaces and lateral surfaces of conveyors - adjust and polish, if necessary,
- check surface quality and synchronization of feeding screws,
- check correct operation of filling level check machine,
- examine cans visually, paying attention to the possibility of the seaming machine leaving possible damage during the seaming process,
- check if depalletizer spacer and guide holders do not cause mechanical damage to cans,
- check if the packaging system does not cause any mechanical damages to cans,

2. During depalletization, reject and elimination of damaged cans from external pallets walls.
3. Control the quality of operation of conveying systems, in the event of uncontrolled standstills inspect the line in order to reject damaged or jammed cans.
4. Disengage conveyors during line standstill.
5. Shut down the process line in the event of detection of mechanical damages which may result in leakage.
6. In the event of detection of can technological defects, which would result in a leakage the batch should be stopped and left to the manufacturer's disposition.

During periodical visits CANPACK service personnel checks process line operation taking into account the aforementioned aspects and provides assistance in operating the filling line on appropriate technical level.

LEAKAGE AND CORROSION - SECONDARY CORROSION

CANPACK indicates that a leakage from one damaged can in the pallet is a source of secondary corrosion and perforation, which can damage neighboring cans and those stacked in the lower layers of the pallet. If secondary corrosion is not identified and completely ignored, in short time the corrosion can spread out to the entire storage room and eventually lead to high material and financial loss.

Secondary corrosion can be limited to the minimum by observing the following instructions specified by CANPACK:

- check storage rooms with finished product,
- observe the following rule: do not transfer wet or insufficiently dried up cans to storage room,
- identify and reject wet trays,
- reject heat sealed packs containing cans with secondary leakage,
- do not dispatch pallets with leakage symptoms,
- should technological defects be detected contact the supplier's agent,
- train storage and distribution personnel on how to deal with secondary corrosion,

And regarding:

- transport, unloading, storage of empty cans, storage of finished product,
- primary corrosion prevention.

When a complaint regarding secondary corrosion and its effects has been lodged, the claimed batch should be isolated and left to the manufacturer's disposition without changing the existing state. Then promptly notify the supplier.

Product:	Date:	Type:	Chapter:
Leakage and corrosion - secondary corrosion.	01.05.2020	Aluminium cans	4.4.1
	Revision: 1	Approved by:	

LEAKAGE AND CORROSION - STRESS CORROSION

Stress corrosion arises in the score line of end, causing leakage.

1. **The following conditions are conducive to formation of stress corrosion:**

- high humidity, insufficient drying up of sealed cans,
- foiling wet cans,
- temperature changes causing change in pressure,
- presence of salt remained after rinsing,
- high storage temperature.

2. **Prevention:**

- control water residues on cans prior to packaging,
- keep the following parameters of water for pasteurization:
    a. pH from 6,5 to 7,5;
    b. the frequency of measurements of physicochemical parameters of water for pasteurisation is defined by separate instructions from breweries or beverage manufacturers including service cans.
- do not wrap cold cans with foil below the dew point,
- do not pack and wrap wet cans,
- observe CP requirements regarding transport, unloading and storage of empty cans,
- observe CP requirements regarding storage of finished product,
- check storage rooms with finished product,
- observe the rule not to transfer wet or insuffciently dried up cans to a storage room,
- identify and reject wet trays,
- reject heat sealed packs containing cans with secondary leakage,
- do not dispatch pallets with leakage symptoms,
- train storage and distribution personnel on how to deal with stress corrosion.

Complying with the pasteurization water requirments will prevent from dark stain effect on the can dome area which is not coated by the overvarnish or on the bottom rim coat.

The receiver shall be held liable for the occurrence of any case of stress corrosion, being a result of having failed to comply with the mentioned conditions.

4.4.2 GENERAL PRINCIPLES FOR STORING AND WAREHOUSING FINISHED PRODUCTS

1. **Observe rules regarding primary, secondary and stress corrosion prevention.**
2. **Tray requirements:**

- tray material must be free of substances aggressive to Aluminum or those, which could cause corrosion (chlorides, sulfates, etc.),
- trays and tray design should be such, as to prevent cans from moving while being packed and during shipment, which otherwise could damage the cans,
- tray material should not damage the lithography,
- formed trays should be glued,
- trays should be made of corrugated board to assure good shock absorption during can storage and shipment.

3. **Pallets requirements:**

- only undamaged pallets should be used,
- pallets dimensions should be such to ensure that trays will not project outside the pallet outline,
- prevent the products from being stored on the pallets with protruding nails,
- pallet surface should be flat.

4. **Storage room and storing requirements:**

- the storage area should be free from substances reacting with can surface,
- do not store cans in areas exposed to direct sunlight and adverse weather conditions (rain, snow),
- storing conditions must comply with storage conditions for the packed product,
- the store room should be dry, with a humidity of less than 75%, the fluctuation of temperature must not exceed 10°C within 2 hours, while constant temperature must not be below 0°C and cannot exceed 35°C,
- storing surface must be clean and should prevent dirt and impurities (rocks, structural elements) from adhering to pallets.

5. **Fork lift requirements:**

- fork lift forks must be clean, even and allow the whole pallet to be lifted,
- battery-electric truck parameters should assure safe loading,
- extension arm area should prevent the cans from being damaged on the pallet.

CANPACK recommends strict control of the storage area and periodical control of finished product condition as well as storage conditions. Inspection results and comments should be recorded.

The recommendations presented above do not cover other activities regarding the scope of the subject resulting both from practice and widely understood requirements or law regulations and manufacturer's internal regulations.

5.1 RETURN TRANSPORT

THE PACKAGING - THE RETURN TRANSPORT

5.1.1 RETURN TRANSPORT

RETURN TRANSPORT

Because of the multiple usage and in order to avoid damages or destruction of the packaging i.e. pallets, frames and cardboard layers, please find below our instructions and preferences as far as packing, loading and transport of the packaging is concerned.

Wood and plastic pallets with steel frames and plastic shall be pilled in a set (photo no. 1) i.e. pallete - steel frame - pallete - steel frame - and so on.
Each properly packed pile shall contain 15 sets of adequately prepared frames and steel pallets.

During transportation of the pallets and wooden frames, the preferable way of packing is to divide them into seperate piles, assuming that the properly packed set of frames on the pallet contains 50 pieces in the pile additionally straped with tape, what eliminates possibility of shifting of the load during transportation - photo no. 2. It is also acceptable to pack frames and pallets in the way steel pallets are packed, in this case strapping with tape it is recommended.

Cardboard and plastic layers as the packaging, especially exposed to damages during storage and transport, shall be placed on the pallet in the amount of 500 pieces. From the top they shall be secured with steel or wooden frame. Each pallet with layers shall be additinally straped with tapes, in order to avoid the damage of the load during transportation - photo no. 3.

Each packaging returned to our plant shall have marks allowing identification of its owner. In case of pallets and frames, there are permanent marks on all packaging.
The layers have overprint with name of the owner of the packaging. The return without any marks identifying the owner (for instance overprint) is allowed.

During loading, each transport unit, regardless its type, shall be filled on the whole surface with the packaging. Leaving free surface causes shifting of the load during transport and its damages and leads to its damages, what does not allow for its further usage - photo no. 4.

We hope that the above indications and their implementation will allow to avoid damages or destruction of transport packaging.

THE PACKAGING - THE RETURN TRANSPORT

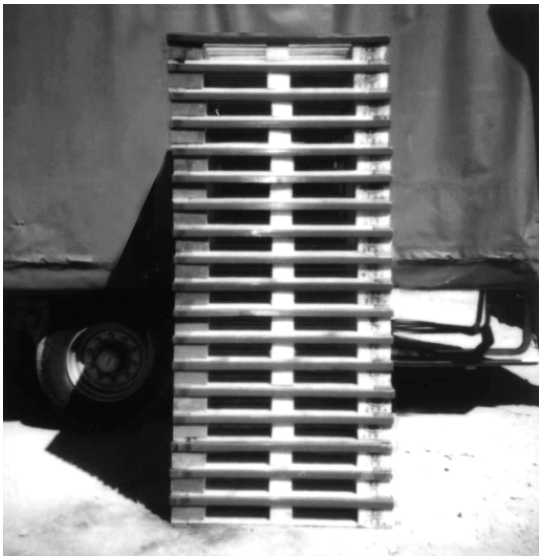


Photo. No. 1

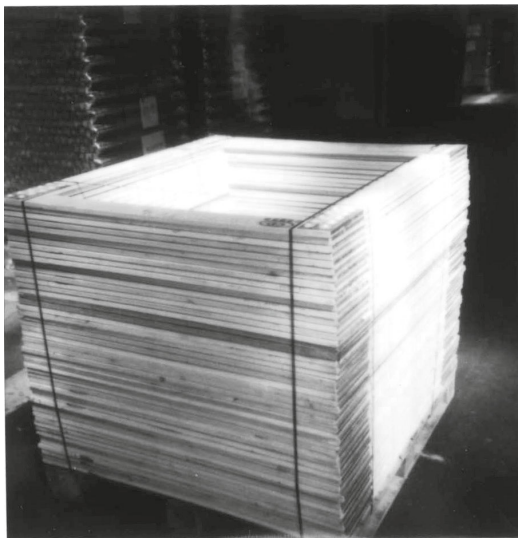


Photo. No. 2

Photo. No. 3

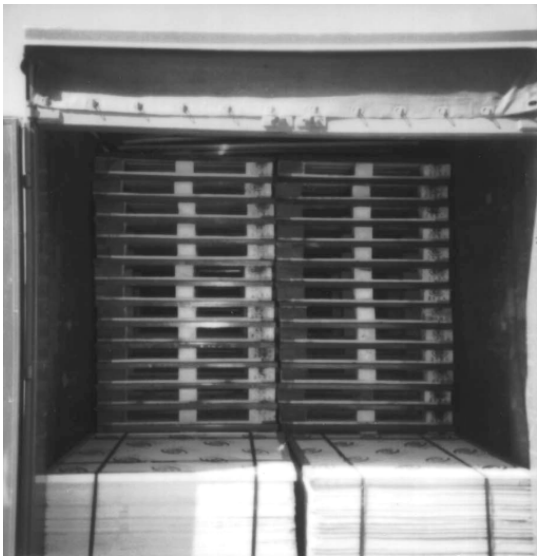


Photo. No. 4

Product:	Date:	Type:	Chapter:
INITIAL ACCEPTANCE OF END BATCH.	01.05.2020	Aluminium cans	5.1.1
	Revision: 1	Approved by:	

COATINGS COMBINATIONS FOR CANS AND ENDS

6.1.1 BPA NI COATINGS / PFAS NI COATINGS

A) BPA AND BPA NI COATINGS

The chemical known as Bisphenol A (BPA) is used in combination with other chemicals to manufacture epoxy resins found in protective coatings for beverage cans and it can migrate in very small amounts to the drinks, so EFSA's scientists regularly review its safety. In April 2023, EFSA published a re-evaluation of BPA's safety, significantly reducing the tolerable daily intake (TDI) to 0.2 nanograms (0.2 billionths of a gram) per kilogram of body weight per day, replacing the previous temporary level of 4 micrograms (4 millionths of a gram) per kilogram of body weight per day. This will represent a basis of setting up new legislation acts. These coatings are generally called BPANI (bisphenol A non-intended), meaning that bisphenol A has not been intentionally used within their production.

The application purpose of these coatings is the same, though. The coatings have been subjected to tests in independent laboratories and have been accredited with all health-related documents confirming their utilization possibility in contact with food. All documents related are available and updated.

To answer any unclarity in the producer – filler relationship, the next conditions are compulsory to attain:

- Any time new materials are sent to the CANPACK Graphic Studio, a clear indication that a certain lithography ought to be prepared for the BPA NI coatings, PFAS NI cotings or their combinations, to assure a correct continuity of the process preparation and subsequent identification
- The full traceability of the product must be assured

Picture 1 - Example of coding

Product:	Date:	Type:	Chapter:
COATINGS COMBINATIONS FOR CANS AND ENDS	31.07.2023	Aluminium cans and ends	6.1.1
	Revision: 3	Approved by:	

B) PFAS AND PFAS NI COATINGS

PFAS - basic information

Per- and polyfluoroalkyl substances (PFASs) also known as „Forever Chemicals" as they never degrade, are synthetic organofluorine chemical compounds that have multiple fluorine atoms attached to an alkyl chain, defined as fluorinated substances that contain at least one fully fluorinated methyl or methylene carbon atom, persisting in the environment as organic pollutants. Their residues have been detected in humans and wildlife, prompting concern for causing various cancers.

PFAS-NI

Our lacquers (Inside / outside) for cans and ends can have the composition not to contain these chemicals, being per- and polyfluoroalkyl substances non intended type of lacquers.

Should the CANS and ENDS contain a combination of lacquers with or without BPA or PFAS, the following coding combinations will be followed:

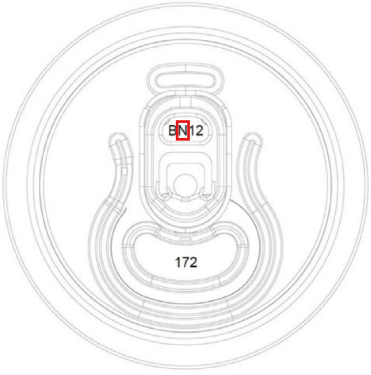
CANS and ENDS Marking Example as in Table 1:

No.	Coding	CANs		ENDs	
		Type varnish description		Type varnish description	
		Inside Varnish	Outside Varnish	Inside Varnish	Outside Varnish
1	A	BPANI/PFASNI	BPANI/PFASNI	BPANI/PFASNI	BPANI/PFASNI
2	E	BPANI/PFASNI	BPA/PFASNI	BPANI/PFASNI	BPA/PFASNI
3	D	BPANI/PFASNI	BPANI/PFAS	BPANI/PFASNI	BPANI/PFAS
4	N	BPANI/PFASNI	BPA/PFAS	BPANI/PFAS	BPA/PFAS
5	S	BPA/PFASNI	BPA/PFAS	BPA/PFASNI	BPA/PFAS
6	F	BPA/PFASNI	BPA/PFASNI	BPA/PFASNI	BPA/PFASNI
7	C	BPANI/PFASNI/RETORT	BPANI/PFASNI/RETORT	BPANI/PFASNI/RETORT	BPANI/PFASNI/RETORT
8	G	BPANI/PFASNI/RETORT	BPA/PFASNI/RETORT	BPANI/PFASNI/RETORT	BPA/PFASNI/RETORT
9	P	BPANI/PFASNI/RETORT	BPA/PFAS/RETORT	BPANI/PFASNI/RETORT	BPA/PFAS/RETORT
10	R	BPA/PFASNI/RETORT	BPA / PFAS/RETORT	BPA/PFASNI/RETORT	BPA/PFAS/RETORT
11	H	BPA/PFASNI/RETORT	BPA/PFASNI/RETORT	BPA/PFASNI/RETORT	BPA/PFASNI/RETORT
12	J	N/A	N/A	BPA/PFAS	BPA/PFAS
13	K	N/A	N/A	BPANI/PFASNI	BPA/PFAS
14	L	N/A	N/A	BPANI/PFAS	BPANI/PFAS
15	Y	N/A	N/A	BPA/PFAS/RETORT	BPA/PFAS/RETORT

Table 1

Picture 2 - Example of coding according to Table 1

Each easy-open end is additionally labelled with the letter as in the table above, located on the panel like in the example below from Picture 3.



Picture 3 - Example of Ends marking

Product:	Date:	Type:	Chapter:
COATINGS COMBINATIONS FOR CANS AND ENDS	16.08.2023	Aluminium cans and ends	6.1.1
	Revision: 3	Approved by:	

BPA NI COATINGS / PFAS NI COATINGS

Cans are labelled when pallets are formed, using the following templates from the Picture 4 and Picture 5. The templates are plant specific, depending on equipment layout.

Picture 4 - Pallet label example for ECC systems: each pallet loaded with cans is separately labelled with a bright orange tag containing the information of the BPA NI coating used.

Picure 5 - Pallet label example for SAP4Hanna systems: each pallet load with cans is separately labelled with a white tag containing the information of the BPA NI / PFAS NI / Combination coating used.

Product:	Date:	Type:	Chapter:
COATINGS COMBINATIONS FOR CANS AND ENDS	31.07.2023	Aluminium cans and ends	6.1.1
	Revision: 2	Approved by:	

BPA NI COATINGS / PFAS NI COATINGS

Ends are labelled when pallets are formed, using the following templates from the Picture 6 and Picture 7. The templates are plant specific, depending on equipment layout.

Picture 6 - Pallet label example for ECC systems: each pallet loaded with ends is separately labelled with a bright orange tag containing the information of the BPA NI coating used.

Picture 7 - Pallet label fo SAP4Hanna systems: each pallet load with ends is separately labelled with a white tag containing the information of the BPA NI / PFAS NI / Combination coating used.

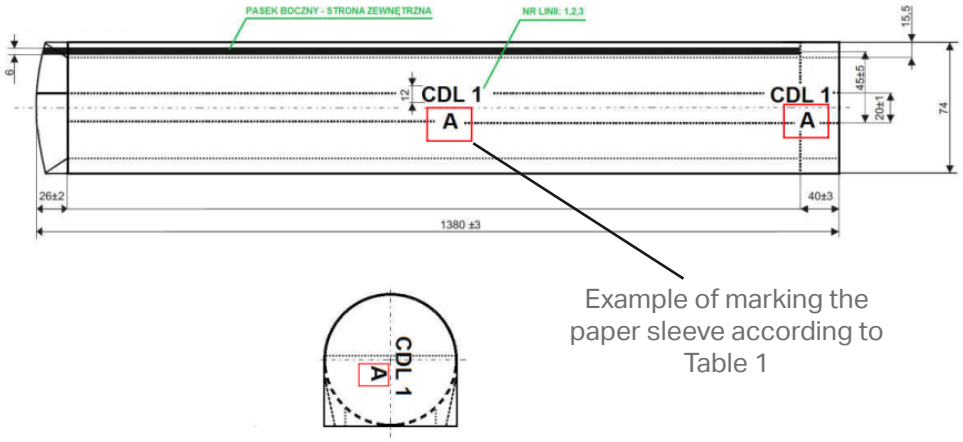
Product:	Date:	Type:	Chapter:
COATINGS COMBINATIONS FOR CANS AND ENDS	31.07.2023	Aluminium cans and ends	6.1.1
	Revision: 2	Approved by:	

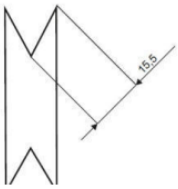
Each paper sleeve for ends packing is additionally labeld with a LASER printing with all information for the contained ends as in te example below from Picture 8:

Picture 8 - LASER marking example

Still in use, are the analogue labels, as in the examples below: paper sleeves for Aluminum SOT 202 ends with dimensions of 31 x 74 x 1380 with a side strip side strip – external side; line number: 1, 2, 3

Picture 9 - analogous way to label paper sleeves of ends with example of marking according to Table 1

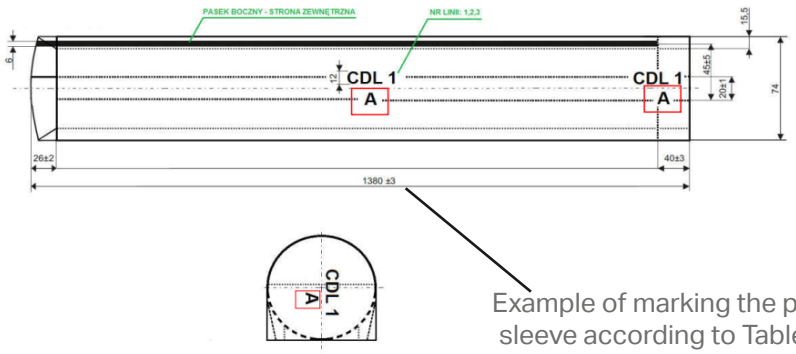




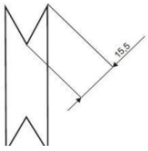
Paper sleeve for aluminium SOT 202 ends with dimensions of 31 x 74 x 1380 with a side strip	
Dimensions:	31 x 74 x 1380
Paper:	70 g/m2
Editing of technical sheet no: 1	
Approved: P. TRUNÓW	Date: 26.11.2014

Or, paper sleeve for Aluminum SOT 202 ends with dimensions of 31 x 74 x 1380 with a side strip

Picture 10 - analogous way to label paper sleeves of ends with example of marking according to Table 1



Example of marking the paper sleeve according to Table 1



Paper sleeve for aluminium SOT 202 ends with dimensions of 31 x 74 x 1380 with a side strip		
Dimensions:	31 x 74 x 1380	
Paper:	70 g/m2	
Editing of technical sheet no: 1		
Approved:	P. TRUNÓW	Date: 26.11.2014

This method of products labelling prevents accidental mixing of products.

In the case of the use of cans and ends for classic beers without any additives and admixtures as juices, alcohol or other substances that do not occur usually in beer, conducting the storage of the test is not necessary and production takes place in a standard manner. Use of cans and ends for different types of drinks than a classic beer, especially in case when the recipe or composition of the beverages is changed, from those that have passed the procedure described below, it must first be sent to CANPACK SA. Drink Identification Cards (attached). On the basis of the information contained in the Charter Identification Drink, CANPACK decides to carry out the storage test.

In the case of lack of confirmation by CANPACK regarding internal resistance lacquer coating to the BPA NI / PFAS NI drink (drink identification card and / or storage test), the decision to manufacture cans and ends for each of the beverage shall be determined with the client. If the criteria mentioned above are not matched especially:

a. no Drink Identification Cards were filled and sent to CANPACK .
b. no storage test performed if required
c. usage of cans and ends for beverages which did not receive a positive result of storage test

The only responsibility for any possible interactions that may occur as a result of contact of a drink with the internal coating (in particular the influence on taste and smell, migration, leaks)shall be borne by the customer.

Table 2: QUALIFICATION FORM OF A NEW BEVERAGE

Quality Assurance Department (*address*)

qualification form of a new beverage

Dear Customer!

We kindly ask you to fill in this form each time you plan to launch a new beverage into the market. This will help us assign this new beverage into the correct corrosivity category and subsequently to produce a safe can of good quality.

General information	
Date	
Customer contact: name/surname/email/phone	
Customer name	
Number of contract	
New Product name	
Beverage formula number/code	
Type of the beverage (beer,soft drink, energetic drink, etc.)	
Alcoholic beverage produced in natural fermentation process, chemically preserved, not pasteurized (please mention alcohol content % and used preservative)	
Shelf life	
Ingredients	
% juice in finished product	
Gas used for the beverage saturation (CO2, N2)	
Saturation level (volumes) MIN-MAX	
Internal coating type (Standard Epoxy/BPANI/both types)	
Can size(s) in cl	
Physical & chemical properties:	
pH:	
Brix	
Titratable acidity (% w/v)	
TPO - Total Package Oxygen (ppb)	
DO - Dissolved Oxygen (ppb)	
Red #40, yes/no, if yes (ppm)	
Yellow #5, yes/no, if yes (ppm)	
Chlorides (ppm)	
Sulphates (ppm)	
Copper (ppm)	
Acids Type (eg. citric acid)	
Contains Phosphoric acid (YES/NO)?	
Sulphites (only for wine)	
Sulphur dioxide SO2 (only for wine)	

Thermal treatment	
1. Pasteurization (tunel/flash)	
- Temperature/time	
2. Hot filling	
- Heated beverage temperature - Cooling time - Filling temperature	
3. Sterilization (autoclave, continuous sterilizer)	
- Temperature/time	

Samples available	in CP cans from first filling
	only in other container glass/plastic/not CP cans

The storage period of filled packagings („shelf life") is limited to 1 year because of no experience related to results of longer storage.
CANPACK recommends to keep records enabling easy identification of cans and ends implemented into the production processes.

This information is an integral part of the CP Product Specification.

CANPACK .	**Customer**
Signature	**Signature**
Date	**Date**

6.2.1 RETORT

1. What is retort
2. Requiremetns for Cans
3. Requiremetns for Ends
4. Cans marking
5. Ends marking

1. Retort or sterillization

The sterilization refers to any process that eliminates, removes, kills, or deactivates all forms of life and other biological agents (such as fungi, bacteria, viruses, spore forms, prions, unicellular eukaryotic organisms such as Plasmodium, etc.). At the customers facility, after filling, the cans are subjected to sterilization. The sterilization occurs in one of the 3 types of retort sterilizers: Rotary (cans are placed in baskets and secured by rubber pins - top/bottom - to prevent from movement during basket rotation), Stationary (cans placed in the basket – no basket rotation), Pockets (cans pushed into rotary pockets). Due to the fact of subjecting of the cans to such stress, the need for testing prior to finite product is obvious. It is also important to know how the retort sterilizer looks like / what type it is at the customer line.

2. Requirements for cans

Inside Spray

All Inside Sprays used for the retort products are sterilization resistant: both the types without intentionally adding BPA and the standard Epoxy ones. Regularly, there are conducted migration tests in this regard.

Overvarnish and Inks

The overvarnishes used for the retort products are more resistant than the standard ones. They resist up to 125oC, 30 min and they protect the specially retortable inks applied onto the cans. The distribution of the retort varnishes is higher than compared to the standard one, hence a bigger gravure roller might be used.

Bottom Rim coat

On the rim of the cans, just the layer of the UV Rim Coat is present. The UV filmweight is retort resistant, hence it is not covered by the second layer of overvarnish.

3. Requirements for ends

Product side lacquer

Similarly to the Inside Sprays in the case of the cans, the coil for the shells, the endstock is bought with retort resistant lacquer applied in a sufficient amount to protect the product. There are regular migration tests conducted to ensure the product safety.

Public side lacquer

The purchased endstock and tabstock are covered with lacquers that resist to the sterilization process.

Sealing compound

The sealing compound is resistant to 125C, 30 min and there are regular migration tests that prove that the overall migration limit is below the specification within the regular requirements (Regulation (EU) No 10/2011 and FDA 21 CFR 175.300).

4. Cans Marking

Marking on cans – production code

Retort – The letter "R" is placed in the production code area according to the below combination within the production code:

:

Picture 11 - An example of retort cans codification

BPANI and RETORT - The letters "R" and "N" are placed in the production code area according to the combination below:

Picture 12 - An example of retort cans codification

5. Ends marking

Picture 13 - An example of retort Ends codification

7.1 CANPACK WARRANTY TERMS

CANPACK WARRANTY TERMS

7.1.1 WARRANTY PERIODS AND OBLIGATIONS

As used herein, CANPACK includes CANPACK S.A., CANPACK US LLC and their subsidiary and affiliated companies.

1. Subject to these CANPACK Warranty Terms and the CANPACK Technical Specifications, the warranty period ("Warranty Period") for aluminum beverage cans and aluminum beverage ends (collectively, "Goods") supplied to the customer ("Customer") is as follows:

- Warranty period for aluminum beverage cans is 12 months from the date of filling, however not longer than 24 months from the date of production, whichever period is shorter.
- Notwithstanding the above, the warranty period for aluminum beverage cans intended to be filled with Hard Seltzers (as defined in Section 3 – Categories of Products) is 6 months from the date of filling, however not longer than 18 months from the date of production, whichever period is shorter. In the case of certain BPANI lacquers, upon notice from CANPACK (communicated prior to production), no warranty for Goods is granted by CANPACK.
- Extended Warranty Period for aluminum beverage cans intended to be filled with Hard Seltzers (as defined in Section 3 – Categories of Products) ("Extended HS Warranty") is 12 months from the date of filling, however not longer than 24 months from the date of production, whichever period is shorter, subject to the following conditions:
    - 4-month pack test or EIS electrochemical test was passed successfully;
    - Controlled and recorded total package oxygen ("TPO") level in Customer's liquid product (the "Product") does not exceed 1.00 ppm;
    - Dissolved oxygen ("DO") level in the Product does not exceed 0.6 ppm;
    - In the case of BPANI lacquers, unless agreed otherwise by CANPACK and Customer, only SW BPANI V70 series shall be used and specifically V70Q11.
- Warranty period for aluminum ends is 12 months from date of filling, however not longer than 36 months from the date of production, whichever period is shorter

Empty aluminum beverage cans must be filled within 12 months from the date of production. If empty aluminum beverage cans are filled after 12 months from the date of production, no warranty for Goods is granted by CANPACK.

All time periods will be based upon written or electronic records of filling and/or production which, in the case of production records, shall be made available for review as requested by CANPACK for any warranty claim.

7.1.2 WARRANTY CONDITIONS

1. CANPACK provides the above warranty (in Section 1 – Warranty Period and Obligations) provided that the Compatibility Tests or Rapid Test was performed and yielded a "PASSED" result as set forth in Section 5 or 6 of these CANPACK Warranty Terms (or testing was exempted as set forth in Section 4 – Warranty Without Testing) and, provided further that Customer:

- provided CANPACK with a completed New Beverage Form in the form provided by CANPACK, which can change from time to time;
- stores, handles, fills, retorts or sterilizes (if applicable), pasteurizes (if applicable) Goods properly (as per industry and product safety standards);
- fulfills all conditions stipulated in these CANPACK Warranty Terms; and
- fulfills all conditions stipulated in the CANPACK Technical Specifications.

2.. The conditions of proper filling, handling, storage, sterilization, and pasteurization (including those listed below) shall be fulfilled by Customer in respect of the Product and Goods for the entire Warranty Period:

a. There are no changes in the Product formulation vs. the tested one;

b. There are no changes in the Product formulation pH (+/-5%) vs the tested one;

c. Copper content does not exceed 0.2 ppm;

d. Dyes do not exceed 80 ppm;

e. Carbonation level is not more than 4 volumes of CO2;

f. DO in the Product does not exceed 1.2 ppm (0.6 ppm in case of Extended HS Warranty);

g. TPO does not exceed 2 ppm (1 ppm in case of Extended HS Warranty);

h. Internal pressure is in the range between 10 to 60 psi at 70 F (21.11 °C);

i. Temperature of the beverages during hot filling shall not exceed 195°F (90.55°C);

j. The combination of pasteurizer (process) temperature, carbonation volume and storage or transportation conditions does not produce an internal pressure of more than 90 psi;

k. If the Product is pasteurized or retorted, the pH of the process water remains between 6.5 and 7.5;

l. Temperature during storage does not exceed 95° F (35 °C) or go below 32° F (0 °C);

m. Fluctuation of temperature during storage does not exceed 50° F (10 °C) within 2 hours;

n. Filled cans are warmed above the dew point (unless the Product is to be distributed and stored under refrigeration) and lids are blown dry prior to packaging;

o. The fill volume shall not exceed the nominal container contents volume by more than 2ml;

p. The Goods are stored before filling in a manner which protects them from solid, airborne and flavor contamination and moisture; and

q. The Goods were shipped, transported, handled, and stored in a manner protecting them from damage or contamination.

3. If the Goods are released by Customer after the Warranty Period or if any warranty condition stipulated in Section 2 – Warranty Conditions are breached or violated by Customer, then the following conditions apply:

a. Customer hereby releases and forever discharges CANPACK and its predecessors, successors, direct and indirect parent companies, direct and indirect subsidiary companies, directly and indirectly owned or controlled operating companies, agents, assigns, affiliates, attorneys, representatives, and past, present, and future directors, officers, shareholders, members, partners, representatives, trustees, and employees (collectively, "CANPACK Released Parties") from any and all losses, damages, liabilities, deficiencies, claims, actions, judgments, settlements, interest, awards, penalties, fines, costs, expenses, and attorneys' fees, including for or in connection with product recall, property damage, or personal injury or death (collectively, "Claims"), based on, related to, arising out of, or in connection with the Goods, Customer's Product, or filled Goods;

b. Customer waives any and all of Customer's rights, pursuant to any and all agreements with CANPACK and applicable law, to claim any damages in connection with the Goods, Customer's Product, and/or filled Goods; and

c. Customer shall indemnify, defend and hold harmless the CANPACK Released Parties from any and all Claims based on, related to, arising out of, or in connection with the Goods, Customer's Product, or filled Goods.

7.1.3 CATEGORIES OF PRODUCTS

CATEGORY I STANDARD BEERS	CATEGORY II MEDIUM AGGRESSIVE DRINKS	CATEGORY III AGGRESSIVE DRINKS
• Standard Beer with alcohol content ≤ 6% vol. • standard non-alcoholic beer	• soft drinks (excluding tonic) • soft drinks with juices • strong beer with alcohol content > 6% vol. • iced tea drinks	• juices, coffee • juices, soft drinks with alcohol addition • beers with juices • energetic drinks • energetic drinks with alcohol, whey • beverages with milk products • isotonic drinks • carbonated and non-carbonated mineral water • tonics • bread drink • low alcoholic carbonated drinks: ciders, wines, aromatized wine-based drinks, aromatized wine-product cocktails including not pasteurized, chemically preserved beverages. • Hard Seltzers

"**Standard Beer**" shall mean a beverage obtained exclusively from the fermentation of a wort of a malted barley or wheat, water, yeast, hops and rice containing an alcohol content meeting the volume range stated in Section 4 – Warranty Without Testing, subsection 1 below. For the avoidance of doubt, any such beverage containing added juice, flavoring or any ingredients other than the ones mentioned in the preceding sentence, or any beer not meeting the below stated alcohol volume range shall not be considered as a Standard Beer.
"**Hard Seltzer**" (also known as spiked seltzer, alcoholic seltzer, or hard sparkling water) shall mean a drink consisting of carbonated water, alcohol, and often flavoring (coming from either real fruit juice or artificial flavoring), typically produced from either a brewed sugar base or a brewed clear malt base.

7.1.4 WARRANTY WITHOUT TESTING

Based on the categorization of the Product and/or risk assessment, CANPACK may give the warranty described in Section 1 – Warranty Period and Obligations without conducting prior testing in the following cases, subject to CANPACK's sole discretion:

1. Goods intended to be filled with a Category I Product: Customer fulfills the conditions stipulated in Section 2 – Warranty Conditions and the Product in the Goods meets the following specifications:

CONDITION	RANGE
pH range of product	From 2.4 to 4.8
Chloride content	**not more than 250 ppm**
Maximum alcohol level per volume	6% ABV

2. Goods intended to be filled with a Category II Product: Based on the information provided by Customer in the New Beverage Form, followed by a risk assessment and provided Customer fulfills the conditions stipulated in Section 2 – Warranty Conditions.

3. Goods intended to be filled with a Category III Product: All Category III Products require testing prior to any warranty being applicable.

4. The foregoing "Warranty without Testing" terms are subject to CANPACK's written acceptance prior to Customer's use of the Goods.

7.1.5 WARRANTY FOR CORROSION IN CASE OF RAPID TESTS

1. CANPACK and Customer may agree that instead of performing full Compatibility Tests as set forth in Section 6 – Compatibility Tests, CANPACK may evaluate the degree of corrosivity of the Product towards aluminum by conducting a "Rapid Test." The Rapid Test measures aluminum concentrations over a certain period of time of the Product placed in an uncoated aluminum can and monitors any perforation of the Product through the uncoated aluminum can, color change or other changes of such Product. These results combined with formulation information provided by Customer in the New Beverage Form allows the parties to determine how corrosive the Product is to the Goods and to decide on a warranty, if any.

2. If the results of the Rapid Test are:

- "PASSED": CANPACK may, with Customer's agreement, provide a 3-, 6- or 12-month warranty for perforation only (for avoidance of doubt, odor, color, and taste performances are excluded from the warranty); or
- "FAILED": no warranty is given by CANPACK.

3. Rapid Test procedures and testing result parameters shall be agreed to by the parties in writing prior to the testing occurring. Where such Rapid Test is to be performed by a laboratory other than a CANPACK laboratory, such laboratory shall be approved in writing by CANPACK in advance and shall agree to enter into a non-disclosure agreement covering its receipt of information from CANPACK (including, but not limited to, Product information and any specification documents) and CANPACK shall have access to all laboratory testing results.

7.1.6 COMPATIBILITY TESTS

1. CANPACK sells to Customer the Goods based on the specific intended use of the Goods (as noted in the CANPACK Technical Specifications or in the parties' contract, herein "Product Use") which use includes the Product or other liquids to be filled into the Goods and the manner of intended handling, transportation, storage, and use of the Goods. To best satisfy this, CANPACK and Customer will engage in mutually acceptable testing (including compatibility testing and testing the retention of the external lacquer in case the Goods are subject to a sterilization process) of the Goods to ensure that the Goods can perform as required for Product Use ("Compatibility Test"). Compatibility Test procedures and testing result parameters shall be agreed to by the parties in writing prior to the start of testing. Where such Compatibility Tests are to be performed by a laboratory other than a CANPACK laboratory, such laboratory shall be approved in writing by CANPACK in advance and agree to enter into a non-disclosure agreement covering its receipt of information from CANPACK (including, but not limited to, Product specifications and Goods information and specifications) and CANPACK shall have access to all testing results.

2. There may be times, however, when Customer requires CANPACK to manufacture Goods or release Goods for use prior to such Compatibility Tests being performed or completed. In such cases, and as a material condition of sale, the following terms shall apply (subject to Section 5 – Warranty for Corrosion in Case of Rapid Tests):

a. The warranty (as set forth in Section 1 – Warranty Period and Obligations) by CANPACK for defects or failures that may result from the interaction of Goods and the Product or other liquid filled in the Goods (including, but not limited to, leakage, corrosion, odor, taste, or color issues) or resulting from the sterilization of Goods is explicitly excluded and rendered null and void.

b. Customer hereby releases and forever discharges the CANPACK Released Parties from any and all Claims based on, related to, arising out of, or in connection with: (i) the interaction between the beverage or other liquid and the Goods (including, but not limited to, leakage, corrosion, odor, taste, or color issues) or resulting from sterilization of the Goods, unless all mutually agreed upon testing (including Compatibility Testing and sterilization testing) is first performed with mutually satisfactory results; (ii) the interaction between the Product or other liquid and the Goods if the specification of the Product or other liquid filled into the Goods is different than the specification of the Product or other liquid tested (i.e., any changes in the specifications of the Product or other liquid should be tested to the mutual satisfaction of CANPACK and Customer before such Product or other liquid is filled into the Goods and subsequently held for storage or placed for sale); (iii) the sterilization of the Goods by Customer if the specification of the sterilization process agreed for the testing is different than the specification of the sterilization process performed by Customer (i.e., any changes in the specifications of the sterilization process shall be tested to the mutual satisfaction of CANPACK and Customer before the sterilization of the Goods is made).

c. Customer shall, without limitation on time or amount, indemnify, defend, and hold harmless the CANPACK Released Parties from any and all Claims based on, related to, arising out of, or in connection with this Section 6 subsections 2(a), 2(b), and 2(c) immediately above of these CANPACK Warranty Terms.

7.1.7 WARRANTY FOR ALUMINIUM ENDS WITH UNLACQUERED TABS IN CASE OF TUNNEL PASTEURIZATION

1. Aluminum ends with unlacquered tabs shall not be used in the process of tunnel pasteurization or other high temperature treatments due to the darkening effect on the aluminum.
2. If Customer uses aluminum ends with unlacquered tabs in the tunnel pasteurization or other high temperature treatments, CANPACK provides no warranty for tab darkening.

CANPACK WARRANTY TERMS

7.1.8 OTHER PROVISIONS

These CANPACK Warranty Terms constitute an integral part of the sale agreement or order placed by Customer. If there are any contradictions or inconsistencies between these CANPACK Warranty Terms and any other sales agreement between CANPACK and Customer or the order placed by Customer with CANPACK, these CANPACK Warranty Terms prevail.

Except as provided herein or otherwise required under applicable law, no other warranties or guarantees are expressed or implied by CANPACK, by operation of law or otherwise, including any warranty of fitness for particular purpose or use, regarding the Goods provided. The Goods are being provided solely for the benefit of Customer and, hence, these CANPACK Warranty Terms are limited solely to the claims of Customer and shall not apply to any third party or other entity claiming under or through Customer and no third party is intended as a beneficiary of these CANPACK Warranty Terms; provided, however, that all such indemnification obligations of Customer as set forth in these CANPACK Warranty Terms shall apply to any and all claims by Customer or by any third-party with respect to the Goods.

Time is of the essence with any warranty claim. It is the responsibility of Customer to promptly notify CANPACK of any warranty claim as soon as possible after Customer knew, or should have known, of such claim. These CANPACK Warranty Terms shall be void at any time Customer's delay in providing prompt notice prejudices CANPACK, including CANPACK's ability to verify the claim or perform adequate testing to confirm the same.

CANPACK and CUSTOMER have executed these CANPACK Warranty Terms as of the Effective Date set forth above.

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CANPACK	CUSTOMER
_____	_____
By:	By:
Name:	Name:
Title:	Title:
Date:	Date:

Product:	Date:	Type:	Chapter:
CANPACK WARRANTY TERMS	23.03.2023	Aluminium cans and ends	7.1.8
	Revision: 4	Approved by:	