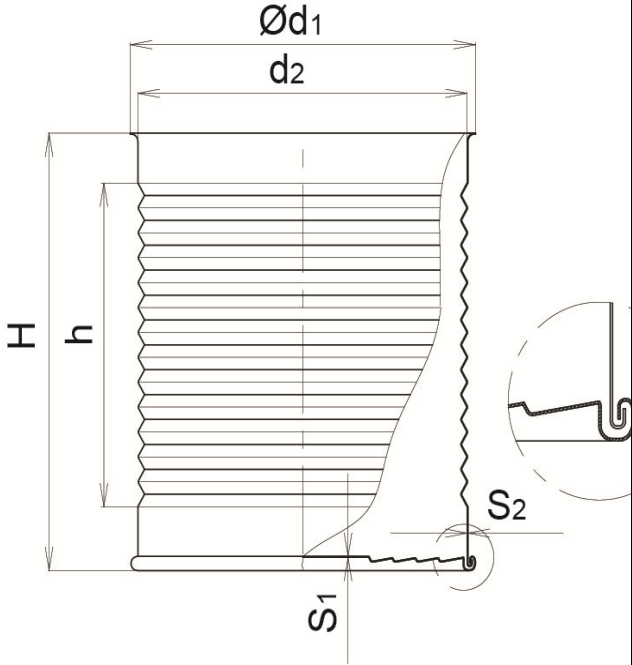
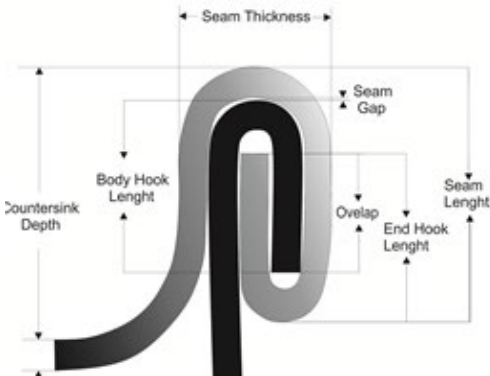


QUALITY REQUIREMENTS FOR PACKAGING		Date of issue: 14.10.2020
No.: 09-099-CF	Internal index: 0.85/099/119	Internal name: 3 p food can
Packaging application	Foods	
Quality parameters	Unit	Range or specification description
a) Dimensions - d2 - internal - d1 - outside - H - body - h - beads (numbers) Useful volume b) Material thickness - s2 - body - s1 - bottom and end c) External and internal protection - External surface - Internal surface - Visible defects d) Joints and sealing - body-bottom - protection of the weld	mm mm mm mm ml mm mm	99 104.0 ±0.25; flange width – 2.5 ±0.25 119 ±0.5 75 (13) 850 Tinplate, Standard EN 10202 0.16 ETP 0.21 TFS or ETP Body: Gold or Transparent Lacquer or Lithography Bottom&End: Gold or Transparent Lacquer Gold, Aluminized or White Lacquer – BPA NI Body: Gold or Transparent Lacquer or Lithography Bottom&End: Gold or Transparent Lacquer Without any visible defects Double seaming, sealed WAKOL Clear lacquer BPA NI
		The batches correspond to internal company Technical Specification. The cans are in accordance with Regulation (EO) 1935:2004&10:2011 and EN ISO 15593:2008. Seam height – 3.17 -0.17 mm; Seam thickness – (3×S1+2×S2+0.1)+0.13 mm; Countersink depth – 3.15 +0.23 mm; Body hook – 2.0 ±0.2 mm; End hook – 1.7 mm min; Overlap – 1.1 mm min; Wrinkle free – min 75% 
		Delivery packaging for auto transport: On pallets 1200x800 mm, max height 1450 mm, 990 pcs on pallet, wrapped with foil.



TECHNICAL SPECIFICATION

Easy Open Ends 99 mm

ITEM	401 DIA EOE (99 mm)
➤ END MATERIAL	TFS
THICKNESS	0.22 MM
TEMP	T4 CA
OUTSIDE LACQUER	GOLD $\geq 6 \text{ g/m}^2$
INSIDE LACQUER	POLYESTER GOLD(BPA-NI) $\geq 14 \text{ g/m}^2$
➤ TAB MATERIAL	GALVANIZED
THICKNESS	0.30 MM
OUTSIDE & INSIDE LACQUER	ALUMINIZED
➤ PARAMETER	
OUTSIDE DIAMETER	108.50 $\pm$ 0.15MM
CURL HEIGHT	2,00 $\pm$ 0.15 MM
COUNTER - SINK DEPTH	4,75 $\pm$ 0.12 MM
PLANE DEPTH	$\geq 3.10 \text{ MM}$
COMPRESSIVE STRENGTH	$\geq 170 \text{ kPa}$
POP	15 N – 35 N
TEAR	40 N – 80 N
SEAMING COMPOUND WEIGHT	83 $\pm$ 10mg
PACKING:	PER PALLET: 43 700 PCS