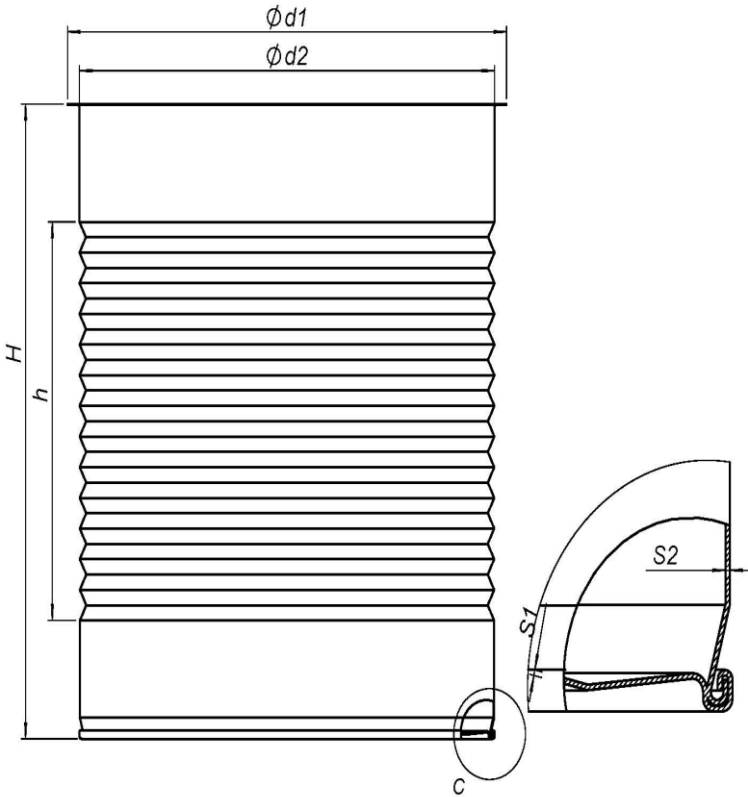


QUALITY REQUIREMENTS FOR PACKAGING		Date of issue: 09.04.2015
No.: 09-099-CF-Neck		Internal name: 3 p food can
Packaging application	Foods	
Quality parameters	Unit	Range or specification description
a) Dimensions		
- d2	mm	99
- d1	mm	104.7 ±0.25
- H	mm	175 ±0.8
- h	mm	75
Useful volume	cm ³	1300
b) Material thickness		Tinplate, Standard EN 10202
- s2 - body	mm	0.16 ±0.01 ETP
- s1 - bottom	mm	0.21 ±0.02 ETP or TFS
c) External and internal protection		
- External surface		Gold lacquered or Lithography
- Internal surface		Body: Alu-pigment lacquered Bottom: Gold- or Alu- pigment lacquered
- Corrosion		No corrosion present
- Visible defects		Without any visible defects
d) Joints and sealing		
- body-bottom		Double seaming, sealed Wakol
- protection of the weld		Powder Holak
		Special requirements: The batches correspond to internal company Technical Specification. The cans are in accordance with Regulation (EO) 1935:2004 and EN ISO 15593:2008. Delivery packaging: For auto transport: On pallets 800x1200 mm, max height 1450 mm, 693 pcs on pallet, wrapped with foil. SEAM DIMENSIONS: -`b` seam thickness = $(3s1+2s2+0.16) \pm 0.15$ mm -`s1` end thickness -`s2` body thickness -Seam length 3.0 ± 0.2 mm -`BL` Body Hook 2.0 ± 0.2 mm -`EHL` End Hook 2.0 ± 0.2 mm -`x` overlap 50% min - X= BL/SL; EHL/SL -Countersink Deep 3.15 ± 0.15 mm



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