




12oz (US) 355ml 202/204x602
August 31st 2020

2-PIECE DWI ALUMINIUM CAN & END

- Slick Can 202/204 x 602 355ml
- 202 Diameter LOE



	RP & Associates:	Customer:
Approved By		
Name	Eric Loke	
Title	QA / CTS Manager	
Date	18-Aug-2020	



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1. Raw material

Item	Alloy & temper	Stock gauge
Can stock	3004-H19 or 3104-H19	0.275 mm +/- 0.005
End stock	5182-H48	0.224 mm
Tab stock	5182-H48	0.280 mm

2. Interior coating

Item	Coating material	Remark
Can	BPANi Lacquer	Water based
End	BPANi Lacquer	Water based

3. Exterior coating

Item	Coating material	Remark
Can	Polyester / Acrylic	Water based
End	Modified epoxy	Solvent based

4. Sealing compound

Item	Rubber type	Remark
Rubber	Styrene / Butadiene	Water based



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CAN MANUFACTURING PRODUCT CODING

The date code is printed on the can.

Example: 2JAA8.....Plate 2, 1st of January 2018

1 or 2 = Printing Plate number 1 or 2
JA = Cans produced on this date, 01
A = Cans produced in January
8 = Cans produced in 2018

Date Code:

A	B	C	D	E	F	G	H	I	J
1	2	3	4	5	6	7	8	9	0

Month Code:

A	B	C	D	E	F	G	H	I	J	K	L
Jan	Feb	Mar	Apr	May	Jun	Jul	Aug	Sep	Oct	Nov	Dec

Year Code:

8	9	0	1	2	3	4	5	6	7
2018	2019	2020	2021	2022	2023	2024	2025	2026	2027

END MANUFACTURING PRODUCT CODING

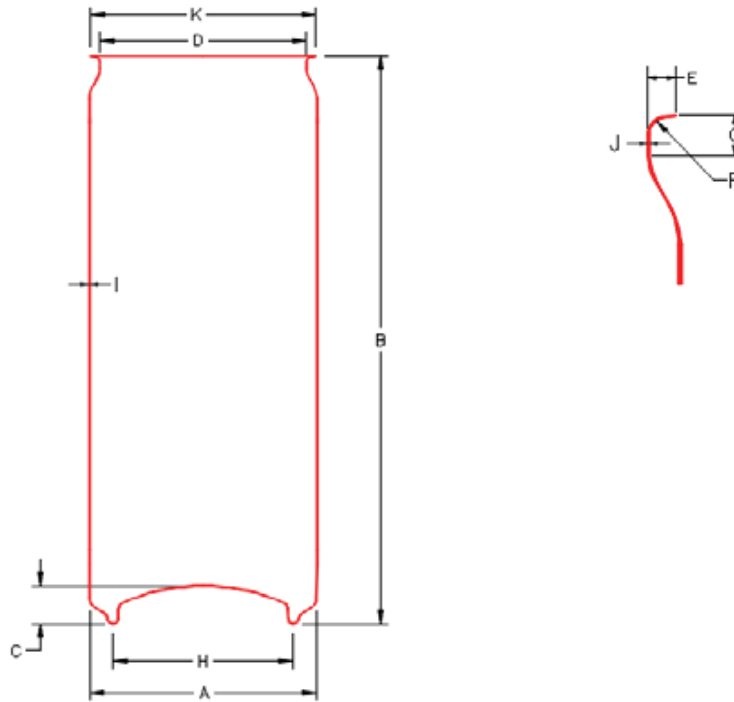
The production identification is found on the public side of the end.

Example: A-1..... Produced in January at Lane 1

A-M = Month code
1, 2, 3... = Lane code

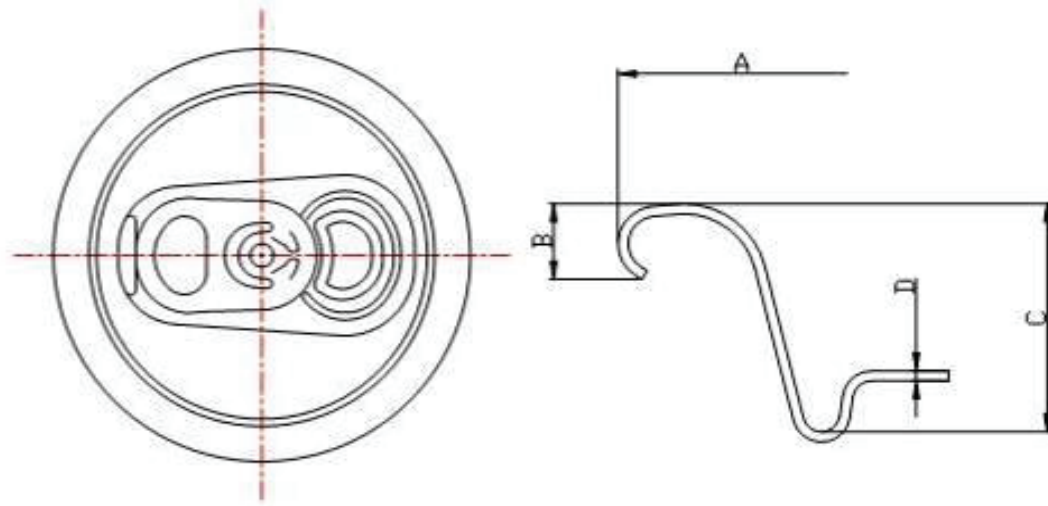
Month Code:

A	B	C	D	E	F	G	H	J	K	L	M
Jan	Feb	Mar	Apr	May	Jun	Jul	Aug	Sep	Oct	Nov	Dec



Can Specifications

Item	Ref.	Unit	Specification	Tolerance
Outside body diameter	A	mm	57.80	Reference
Finished can height	B	mm	155.23	+/- 0.25
Dome depth	C	mm	9.65	+/- 0.35
Neck plug diameter	D	mm	52.40	+/- 0.25
Flange width	E	mm	2.08	+/- 0.25
Flange radius	F	mm	1.52	+/- 0.25
Neck seaming clearance	G	mm	3.50	Reference
Base diameter	H	mm	45.72	Reference
Wall thickness	I	mm	0.105	+/- 0.025
Flange thickness	J	mm	0.155	+/- 0.025
Flange diameter	K	mm	56.6	Reference
Flange angle		degree	0 – 7	Reference
Column strength		kgf	80	Minimum
Dome reversal		psi	90	Minimum
Brimful capacity		ml	385	+/-2
Head space		mm	12.20	Reference
Average enamel rating value		mA	5	Maximum
Individual enamel rating value		mA	25	Maximum

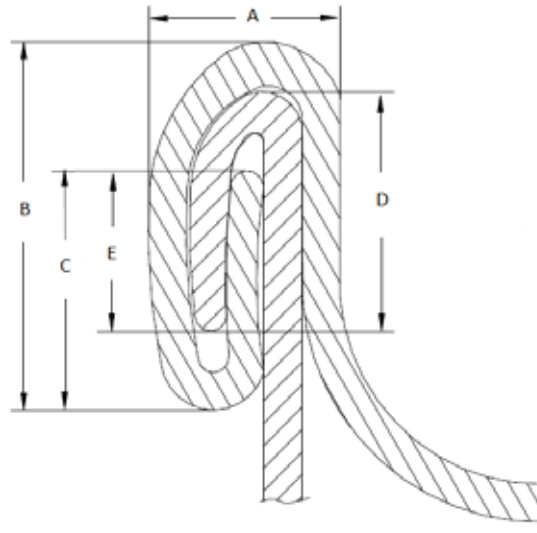


End Specifications

Item	Ref.	Unit	Specification	Tolerance
Curl diameter	A	mm	59.44	+/- 0.25
Curl height	B	mm	2.03	+/- 0.15
Countersink depth	C	mm	6.86	+/- 0.15
Coated metal thickness	D	mm	0.234	+/- 0.020
Compound weight		mg	26	+/- 6
Pop strength		N	23	Maximum
Tear strength		N	27	Maximum
Buckle strength		psi	90	Minimum
Average enamel rating value		mA	5	Maximum
Individual enamel rating value		mA	25	Maximum

Disclaimer:

1. Ends must be dried completely after filling to avoid stress corrosion of the scores. They must be stored in conditions that are free from high humidity.
2. It is the filler's responsibility to conduct seaming and opening tests to ensure the ends are compatible with the can, and functional, prior to full production

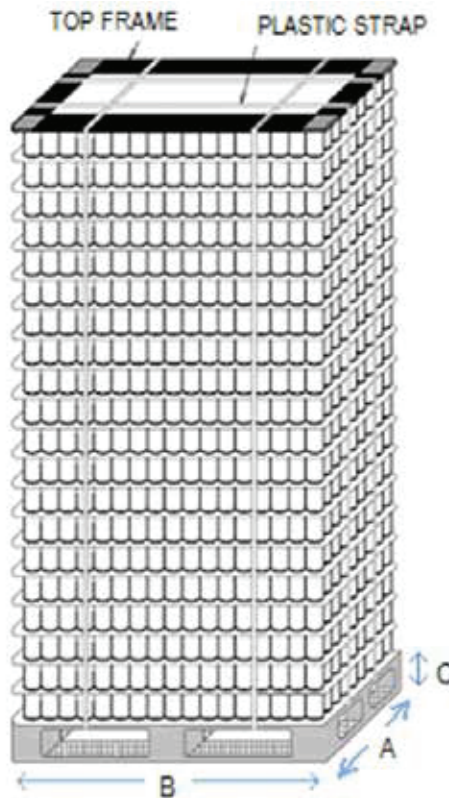


Recommended Seaming Specification

Item	Ref.	Unit	Specification	Tolerance
Pin gauge height		mm	148.74	Reference
Seamed can height		mm	155.23	+/- 0.50
1 st operation seam thickness		mm	2.10	+/- 0.10
2 nd operation seam thickness	A	mm	1.15	+/- 0.05
Seam length	B	mm	2.60	+/- 0.15
Countersink depth		mm	6.86	+/- 0.20
End hook	C	mm	1.60	+/- 0.20
Body hook	D	mm	1.60	+/- 0.20
Overlap	E	mm	0.76	Minimum
Seam gap		mm	0.10	Maximum
Free space		mm	0.14	+/- 0.05
Body hook butting		%	72 – 97	Reference
Can holding chuck pressure		Kgf	40 ~ 60	Reference
Filing level at filling temperature at 30°C		ml	345 – 355 (Carbonated)	Reference
			325 – 335 (Retort)	

Note:

RPA reserves the rights for periodic revisions of above specifications as part of continuous improvements.

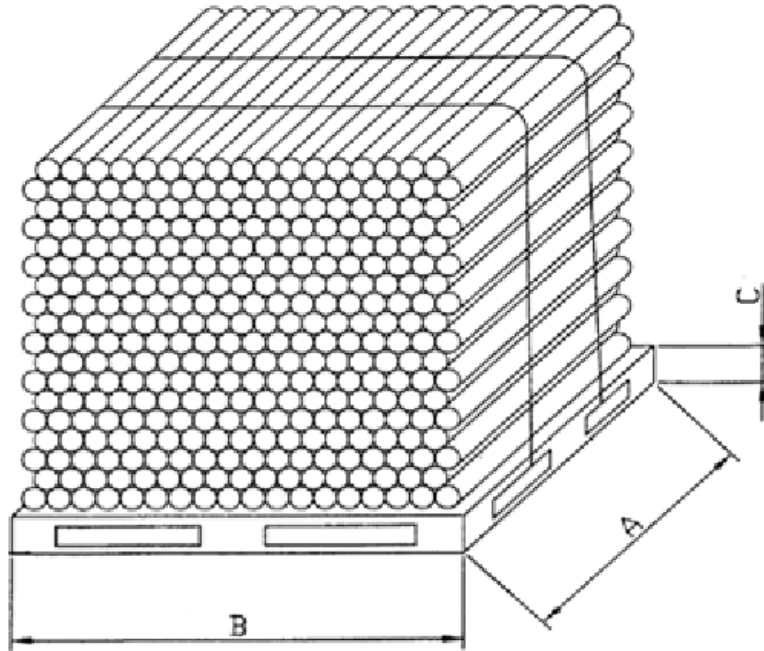


Packaging Specification for Cans

Parameter	Ref.	Unit	
No. of layers / pallet		N/A	14
Pallet size	A X B	Inch (mm)	44 x 56 1120x1422
Pallet type		N/A	Plastic
Base pallet height	C	mm	120
Pallet height (approximately)		mm	2308
No. of cans / layer		N/A	506
No. of straps / pallet (Band straps)		N/A	2 x 2
No. of cans / pallet		pcs	7,084
Wrap around		N/A	1 round full



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Packaging Specification for Ends

Item	Parameter	Unit	Standard
A X B X C	Pallet size	Inch (mm)	40 x 48 (1016 x 1220 x 120)
	Pallet type	N/A	Plastic
	Ends / sleeve	pcs	500
	Sleeves / layer	N/A	19
	Layers / pallet	N/A	12
	Sleeves / pallet	N/A	220 Full sleeve + 1 loose sleeve (308 pcs)
	Total ends / pallet	N/A	110,308