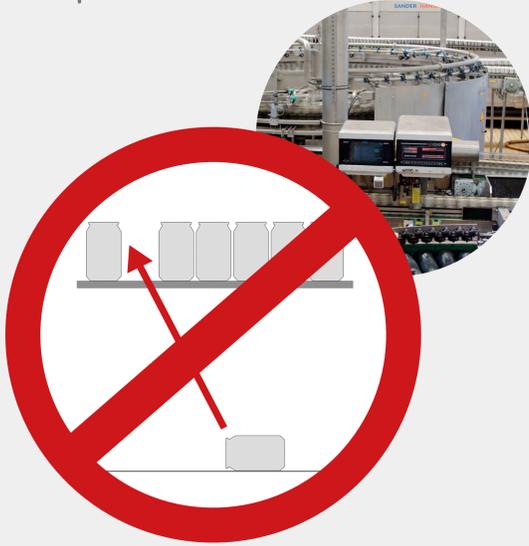


Filling

- Segregate fallen cans and dispose of them



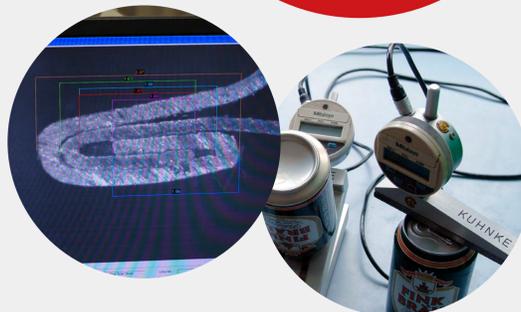
Check

- Total air content per can <2ml for carbonated beverages
- TPO per can <0.6mg directly after filling
- Headspace oxygen per can <2% for non-carbonated beverages (determination directly after filling)
- CO2 level according to your specifications
- LN2 pressure according to Metal Packaging Europe - Beverage recommendations: 1.5 bar at 20 degrees

Seaming



- Record date and pallet label
- Segregate damaged ends and dispose of them



- Perform regular seam checks

Packaging



- Segregate damaged cans and dispose of them
- Remove wet cans

Drying and Coding

- Ensure that there is no moisture on the dome
- Ardagh guideline: max. 6mg per dome

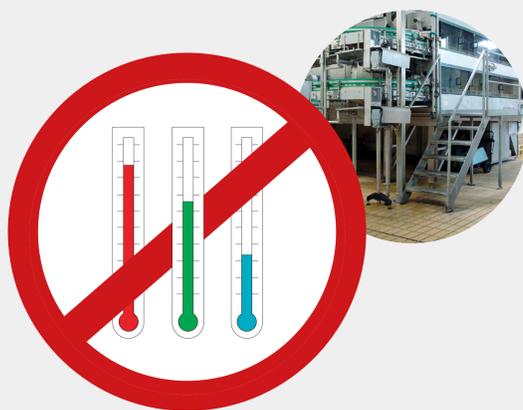


- Regularly check coding



- Ensure that there is no moisture on the end
- Metal Packaging Europe - Beverage recommendations: max. 3mg per end. Ardagh guideline: max. 20mg per body

Pasteurising unit and can warmer



- Regularly inspect pasteurisation temperature

Check water quality

- pH value >6.5 and <7.5

For further recommendations on pasteuriser operations see Metal Packaging Europe - Beverage recommendations

Fill level inspection

- Check the correct fill level

