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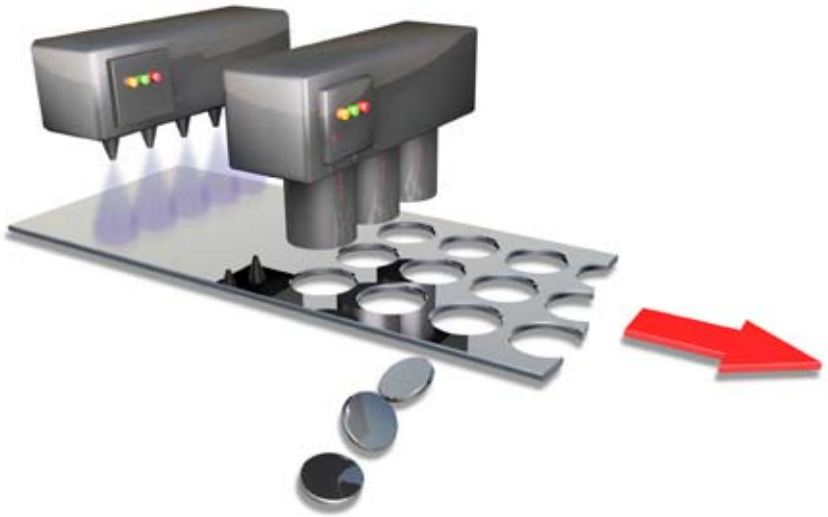
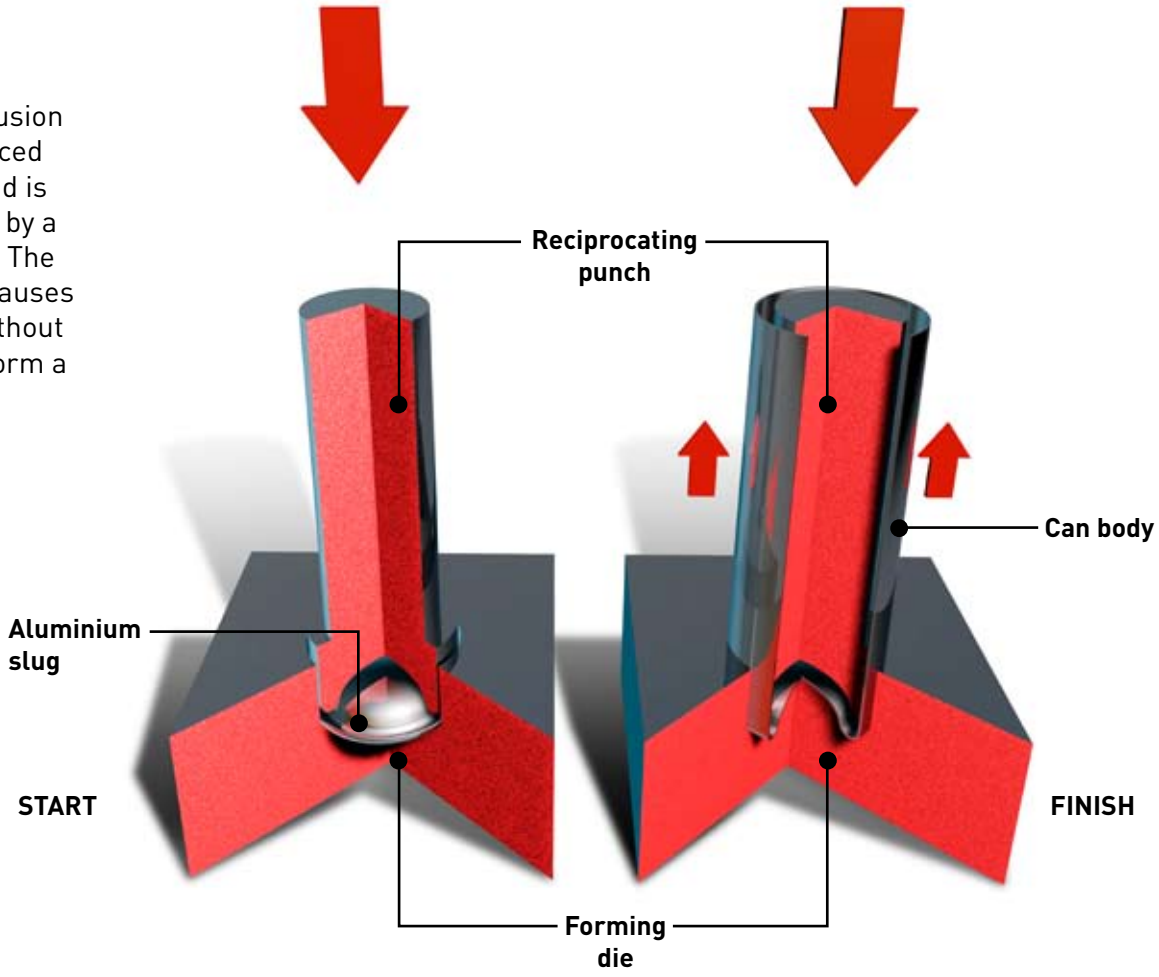
How aluminium Aerosol cans are made

1. Discs (slugs), the same diameter as the finished aerosol can, are punched out from thick aluminium sheet



2. In the impact extrusion process a slug is placed in the forming die and is struck at high speed by a reciprocating punch. The force of the impact causes the metal to flow, without addition of heat, to form a closed end can.



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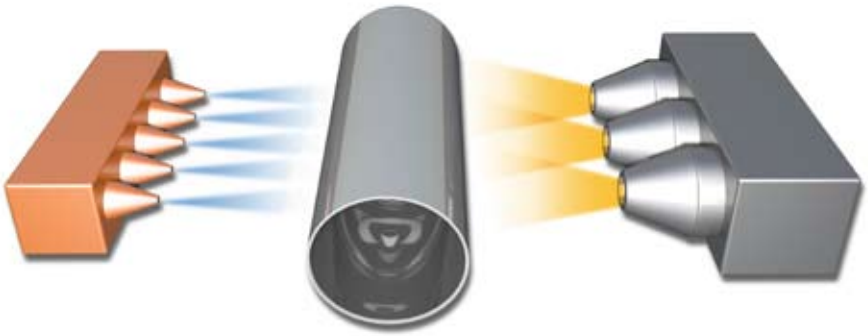
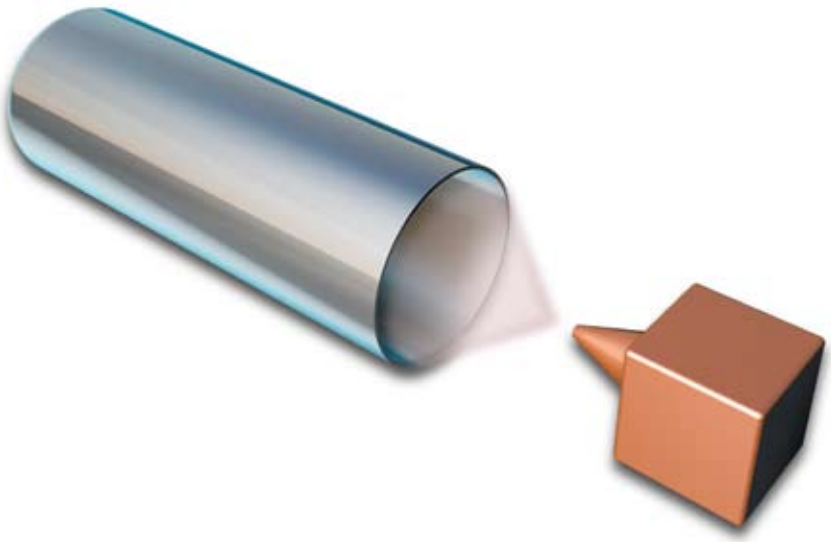
3. Trimmers remove the surplus irregular edge and cut each can to a precise specified height. The surplus material is recycled.

4. The trimmed can bodies are passed through highly efficient washers and then dried. This prepares the internal and external surfaces for coating and printing.



5. The inside of each can is sprayed with lacquer. This special lacquer is to protect the can itself from corrosion and its contents from any possibility of interaction with the metal.



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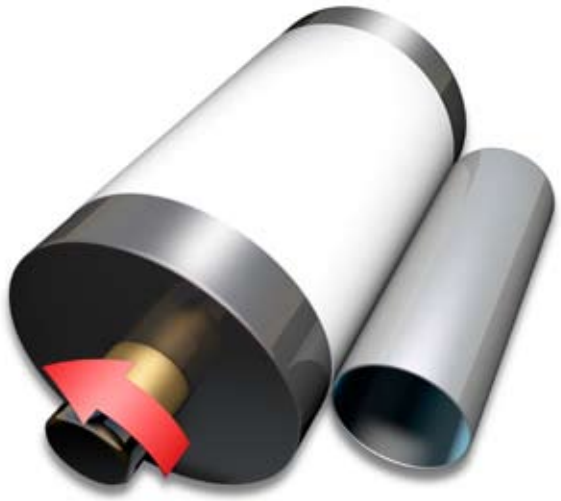
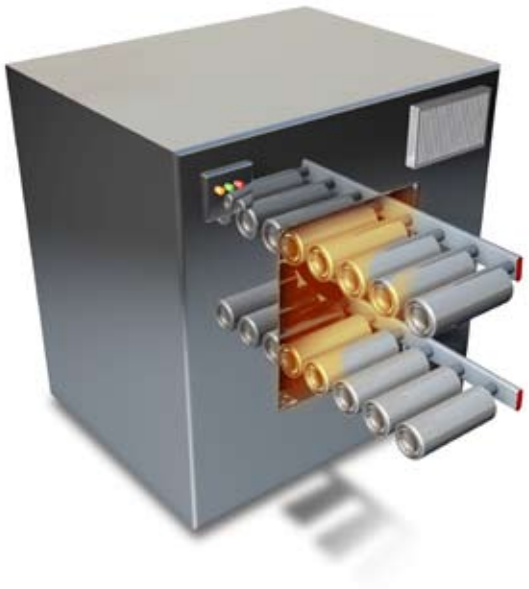
6. After heat curing the cans are coated externally with a clear or pigmented base coat which forms a good surface for the printing inks.



7. The cans pass through a hot air oven to dry the lacquer while being conveyed on a pin-chain.



8. In the next step a decorator applies the printed design in up to eight colours, plus an overvarnish.

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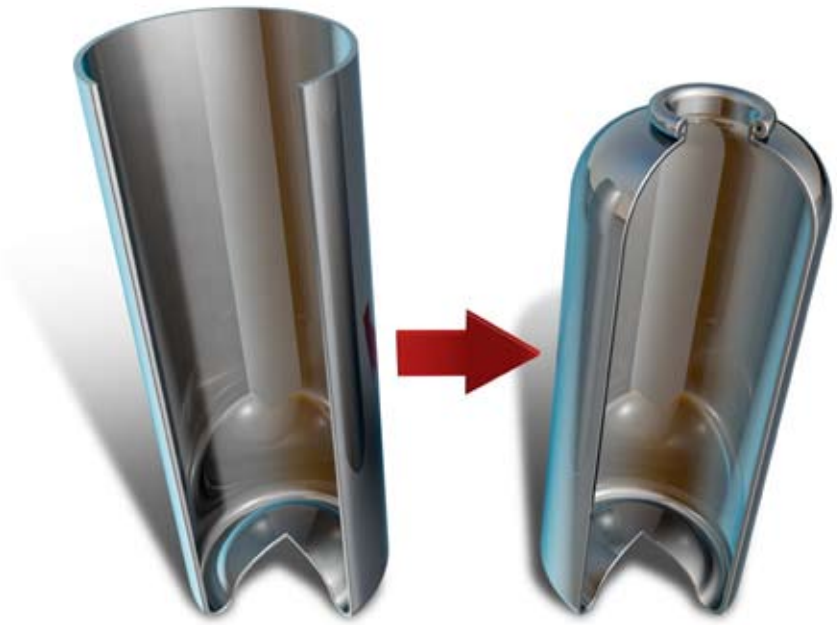
9. The cans are conveyed through a second pin-chain oven which dries the ink and varnish

10. The last forming process is to swage the top edge of the can in approximately 15 steps to form a smooth top and roll flange to accept the aerosol valve/spray mechanism.



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11. Every can is tested at each stage of manufacture. At the final stage it passes through a pressure tester, which automatically rejects any cans with pinholes or fractures.

12. The finished can bodies are then transferred to the warehouse to be automatically palletised before despatch to the filling plant.

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