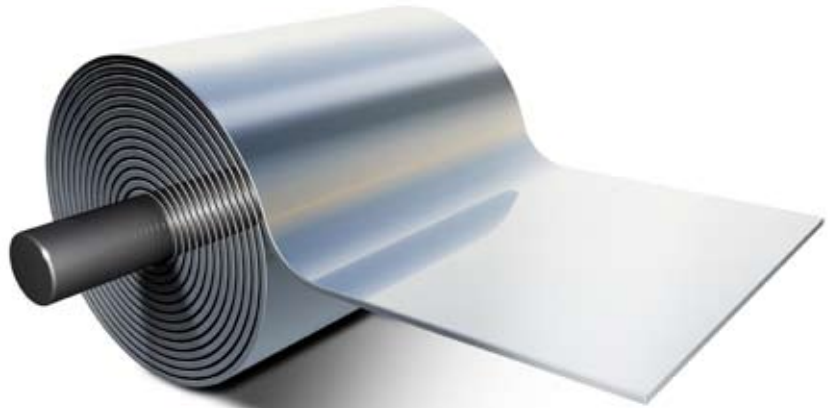
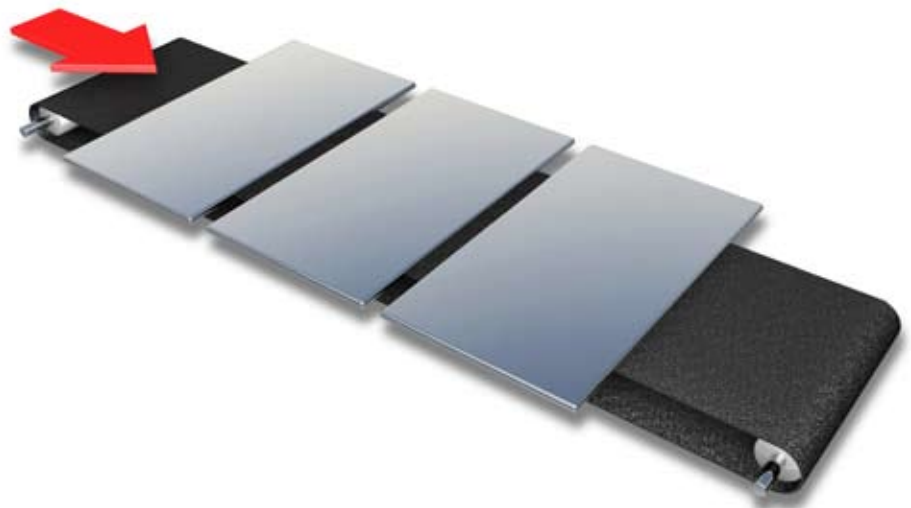




1. Aluminium strip arrives at the closure manufacturing plant in large coils.



2. Aluminium strip is cut into large sheets.

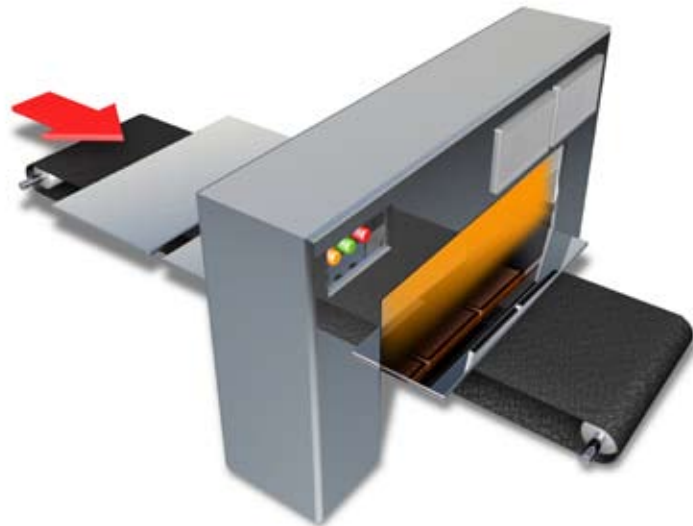


3. Lacquer is applied to the side of the sheet that will become the internal surfaces of the finished closure and print is applied to the external surface.

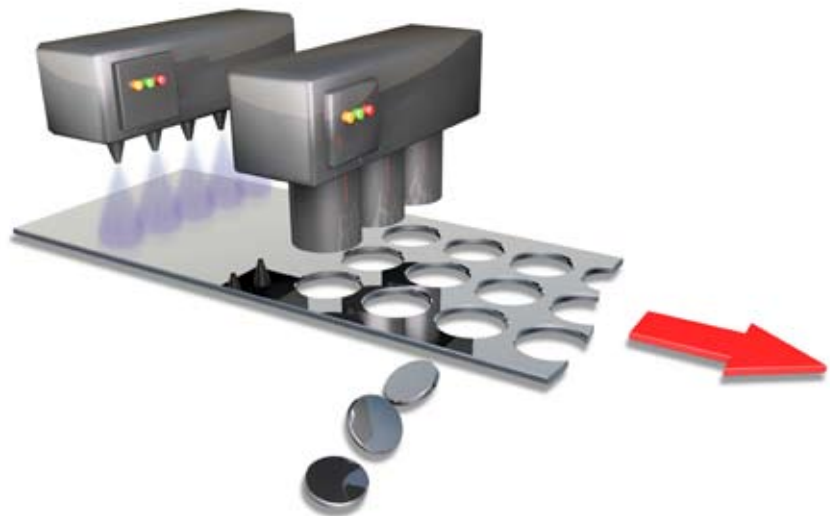




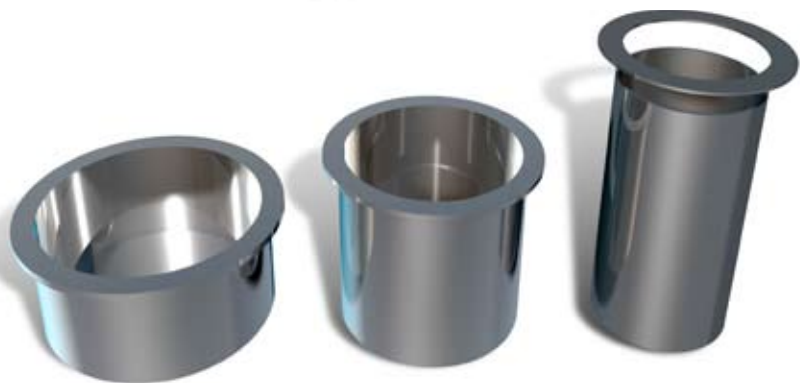
4. The lacquered and printed sheets are dried in an oven



5. The sheet is fed through a cupping press, which blanks and draws the metal into shallow cups.



6. In sequential press operations the Blank and first draw produced in the cupping press is converted into 1st and 2nd redraws to achieve the finished depth of the closure.



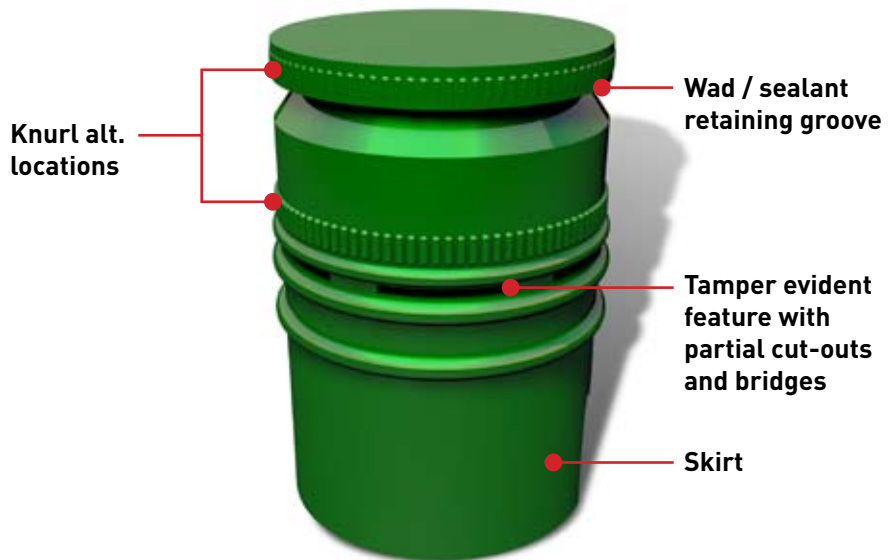
**Blank &
first draw**

**1st
redraw**

**2nd redraw &
clip trim flange**



7. The 2nd redraw has knurling and a tamper evident feature added as required. The skirt may be long (as shown) or short, to suit the design requirements



8. A wad or liquid sealant is applied inside the top of the closure to aid sealing to the top of the container and, where necessary, to protect the metal from the product held in the container.

**Wad pressed
in liner**

**“Annular” flowed
in sealant**

**“All-over” flowed
in sealant**





9. After the smooth sided closure is fitted over the top of the filled container, a rubber roller presses around the outside of the closure to force the soft metal to take up the thread form in the neck of the container.

