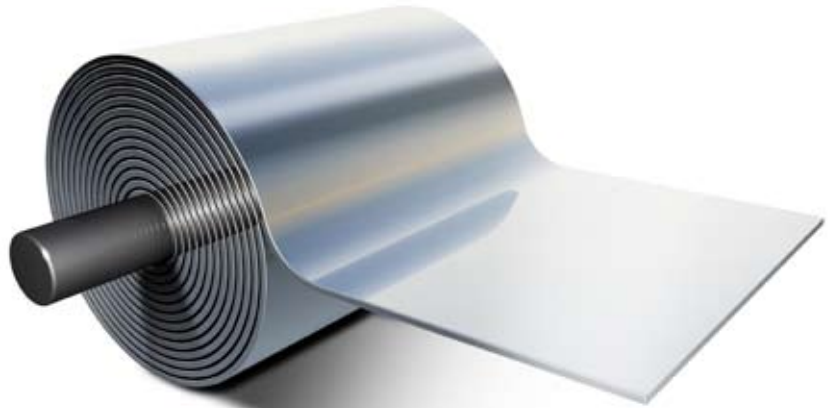
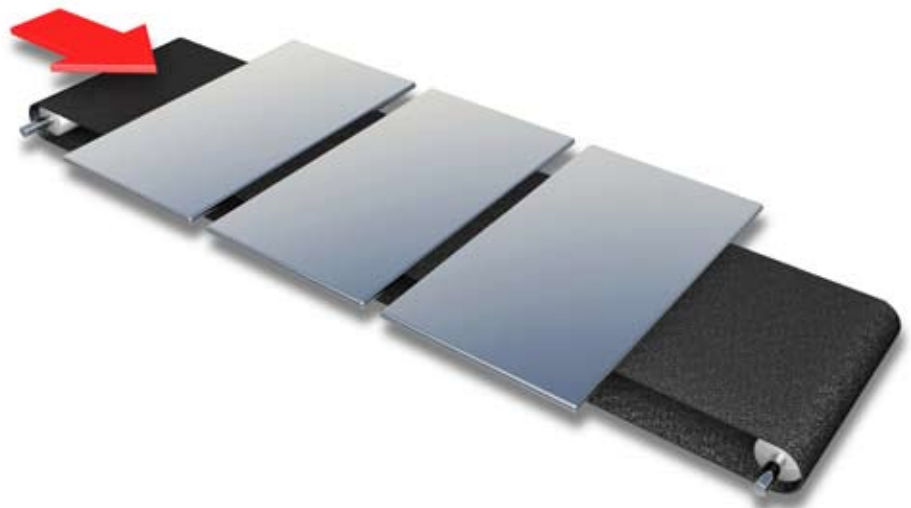




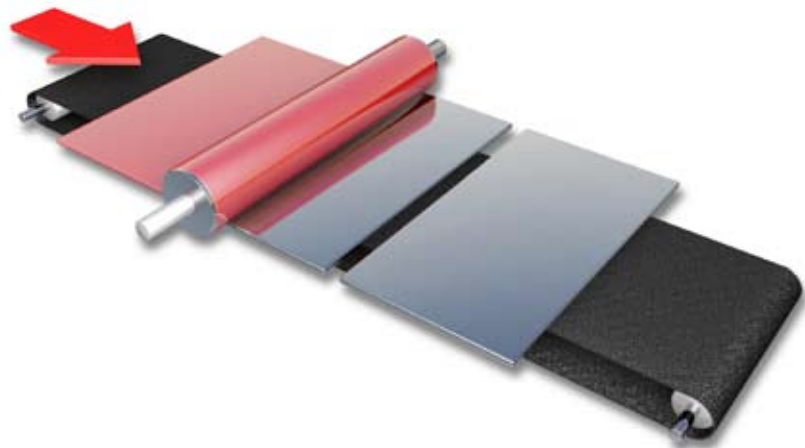
1. Steel strip arrives at the can manufacturing plant in large coils.



2. Steel strip is cut into large sheets.

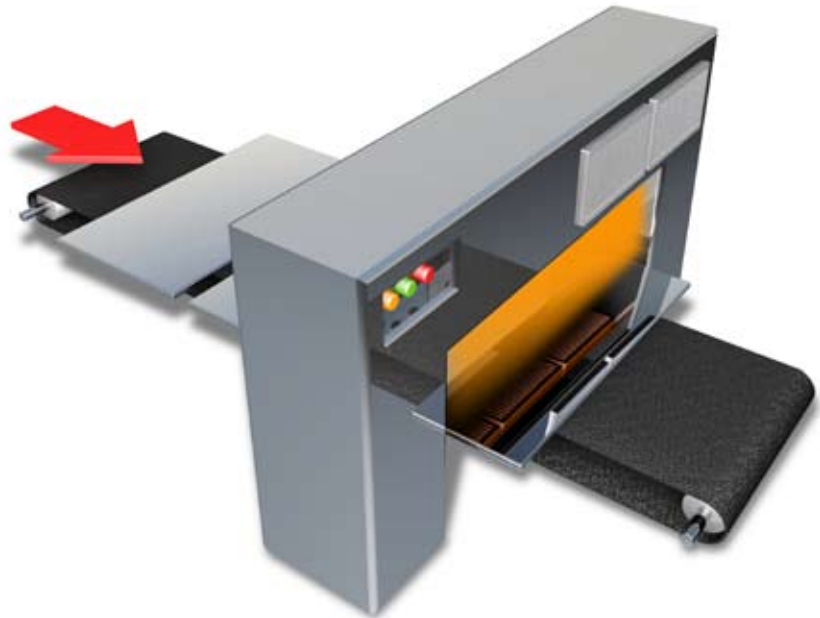


3. Lacquer is applied to the side of the sheet that will become the internal surfaces of the finished closure and if necessary print is applied to the external surface.

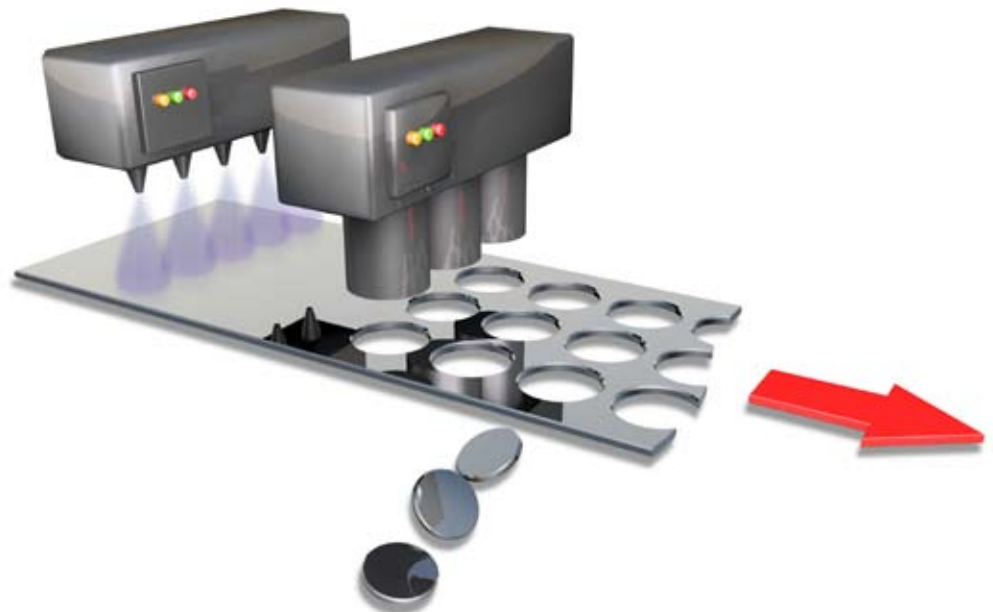




4. The lacquered and printed sheets are dried in an oven



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

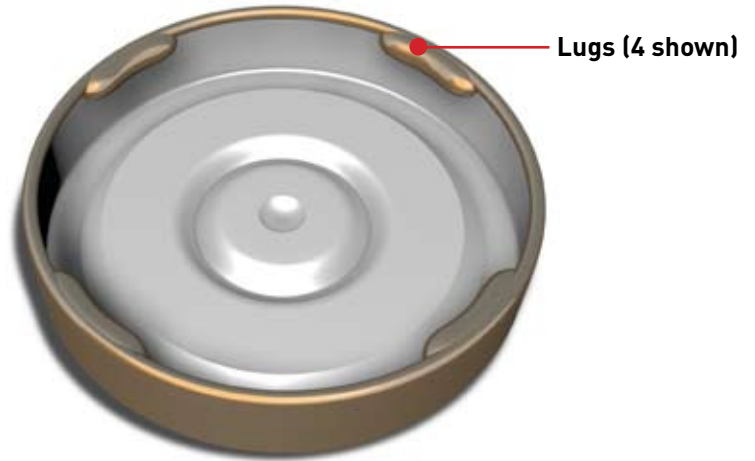




Drawn cup → Edges hemmed → Edges curled and lugs formed



6. After the cup is drawn the edges are hemmed and curled. The lugs which fit into the threads of the container are then formed in the curled edges



7. Sealing compound is applied around the closure and then dried

