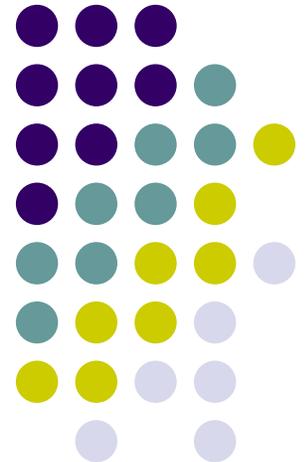
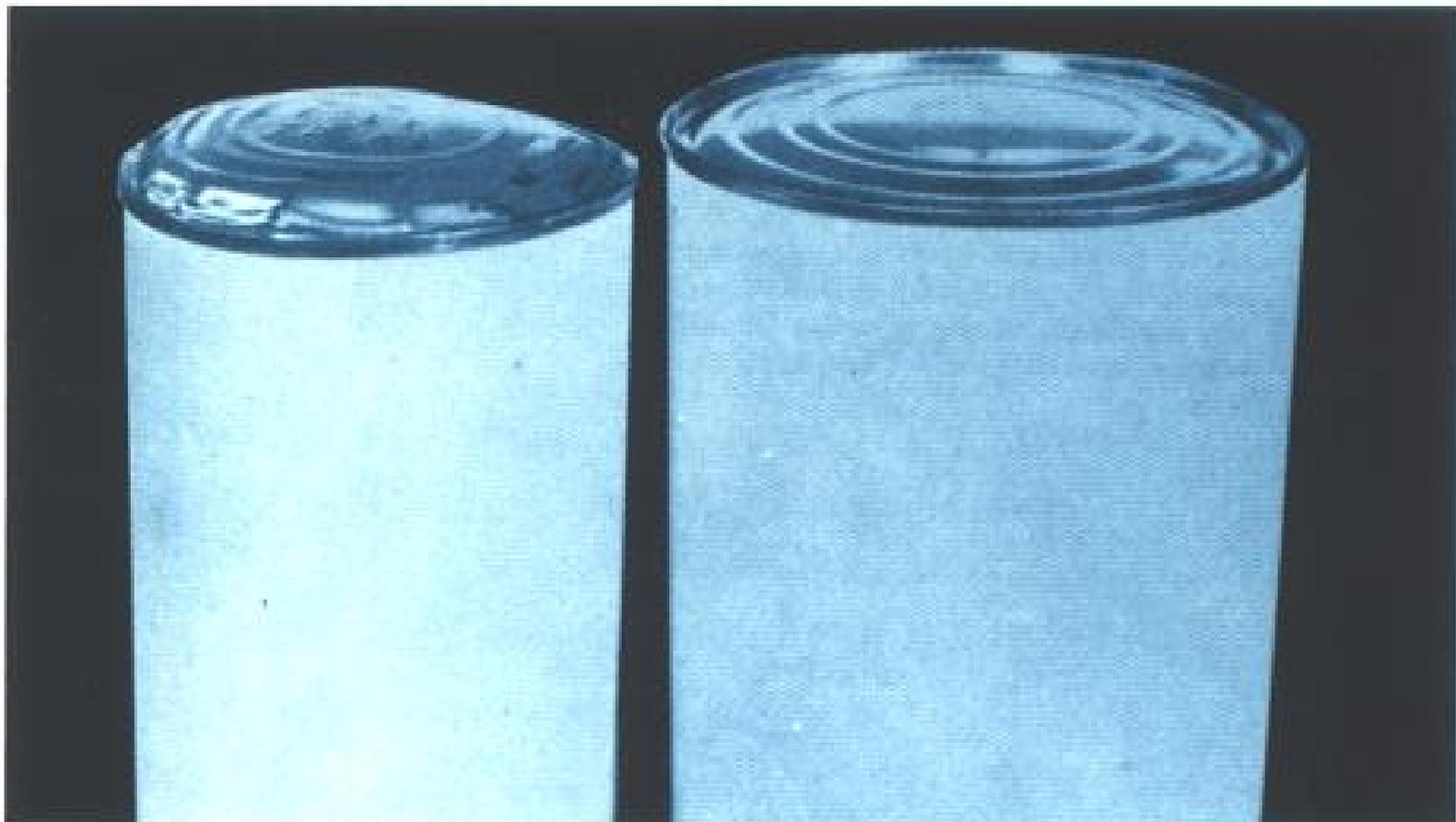


# Can Defects

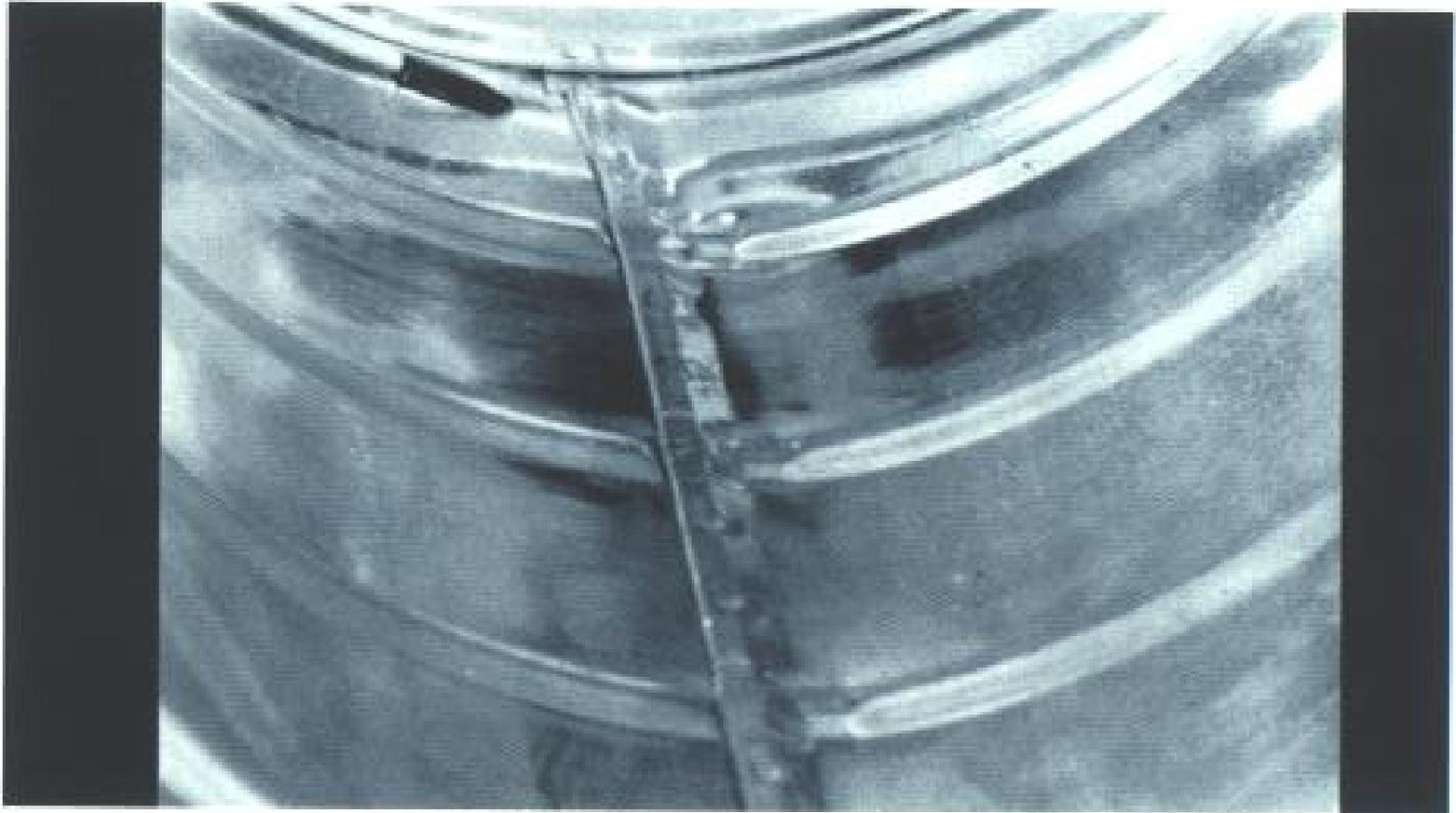
Examples of damage to metal cans  
and when damage requires return of  
merchandise.





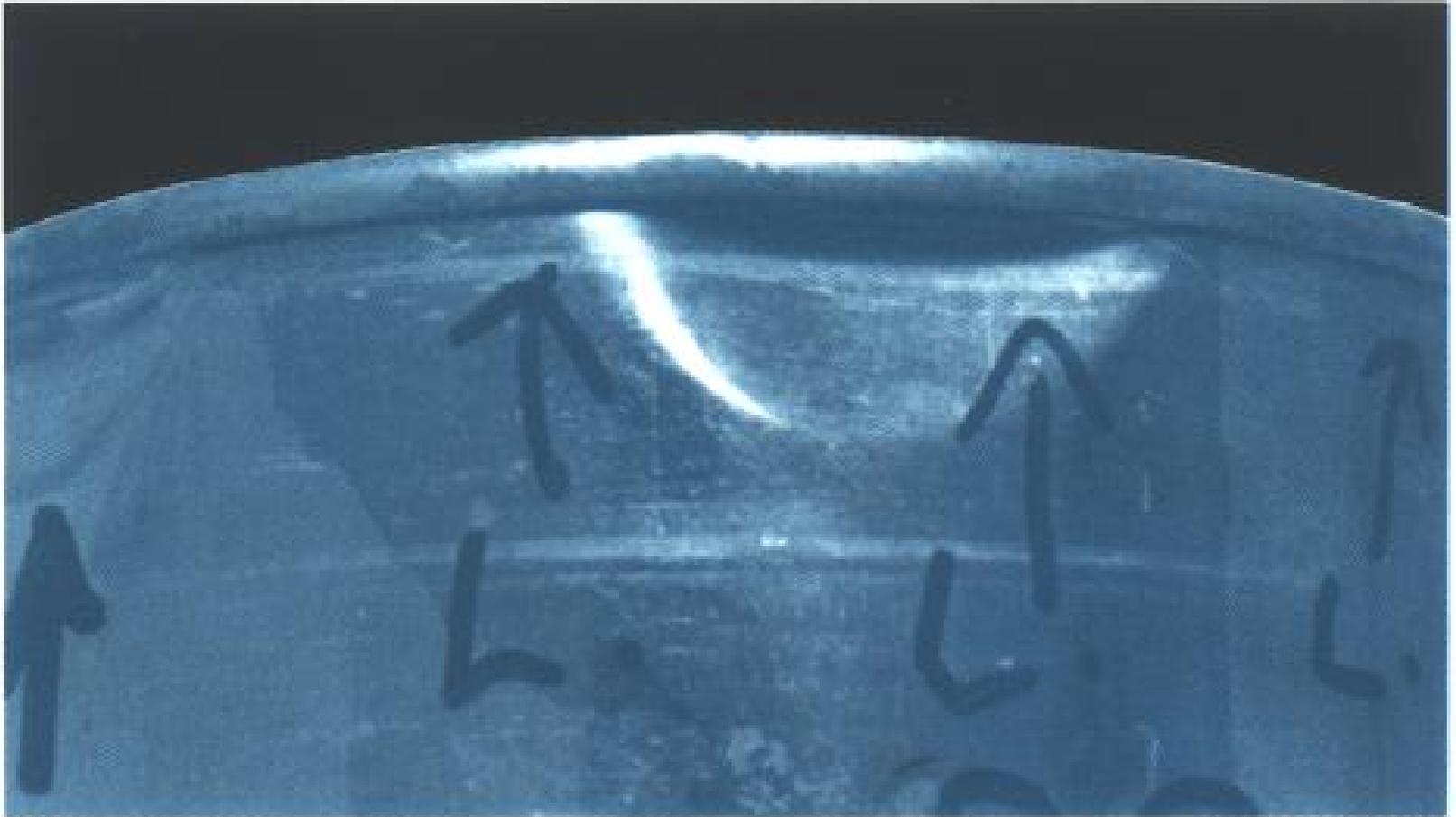
1.

Bulged and/or swollen ends from gas formation in can which causes one or both ends to swell producing a flipper, soft swell, hard swell, or blown can.



2.

Can with likely loss of hermetic seal and normally a leaker due to the mislocked side seam.



3.

An opening below the double seam or plate fracture.



4.

Plate fracture in double seam or can body. (Note position of red pointer).



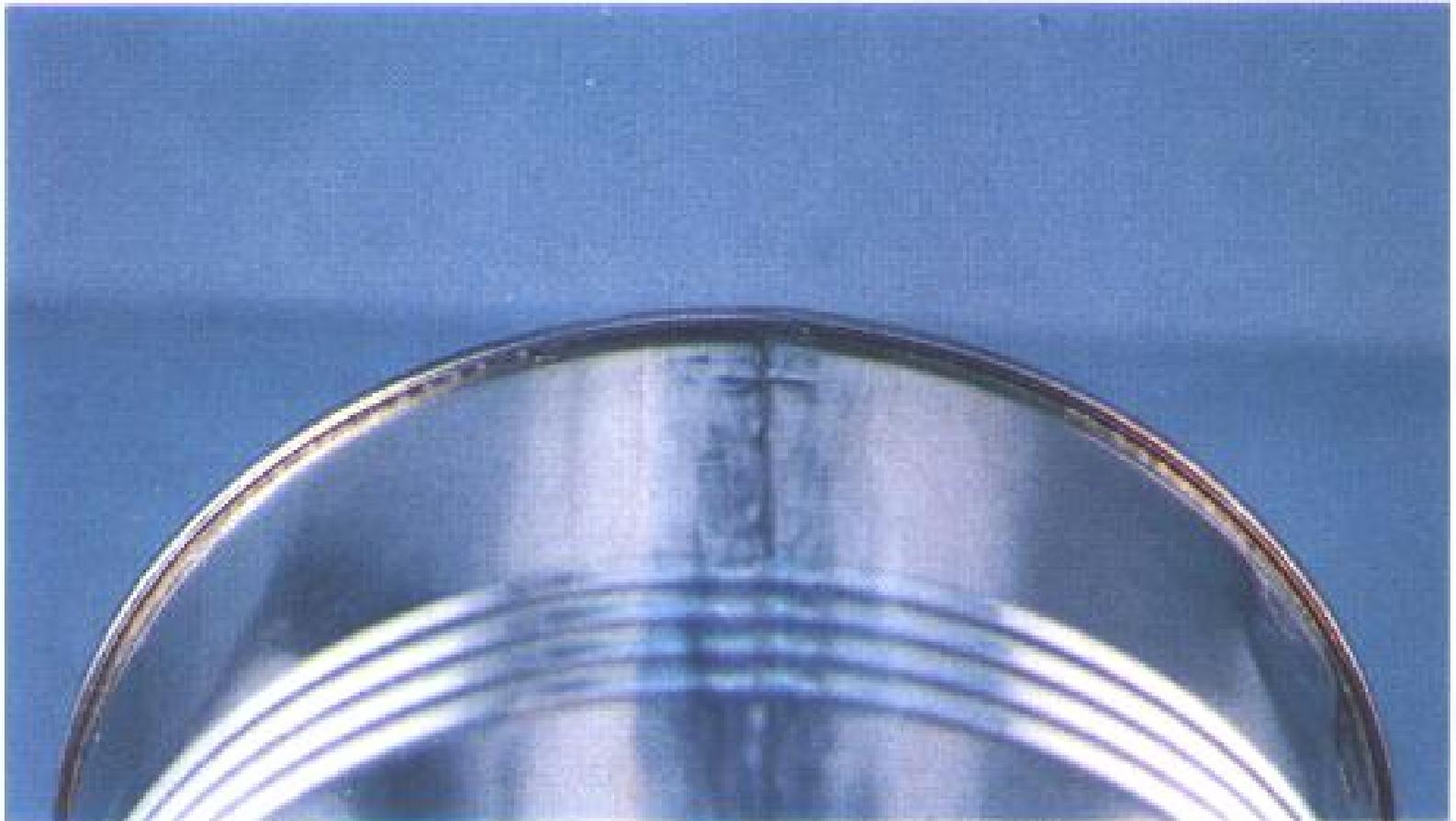
5.

Severe double seam dent plate fracture.



6.

Puncture in can body. Pinholes in can body plate also cause loss of hermetic seal.



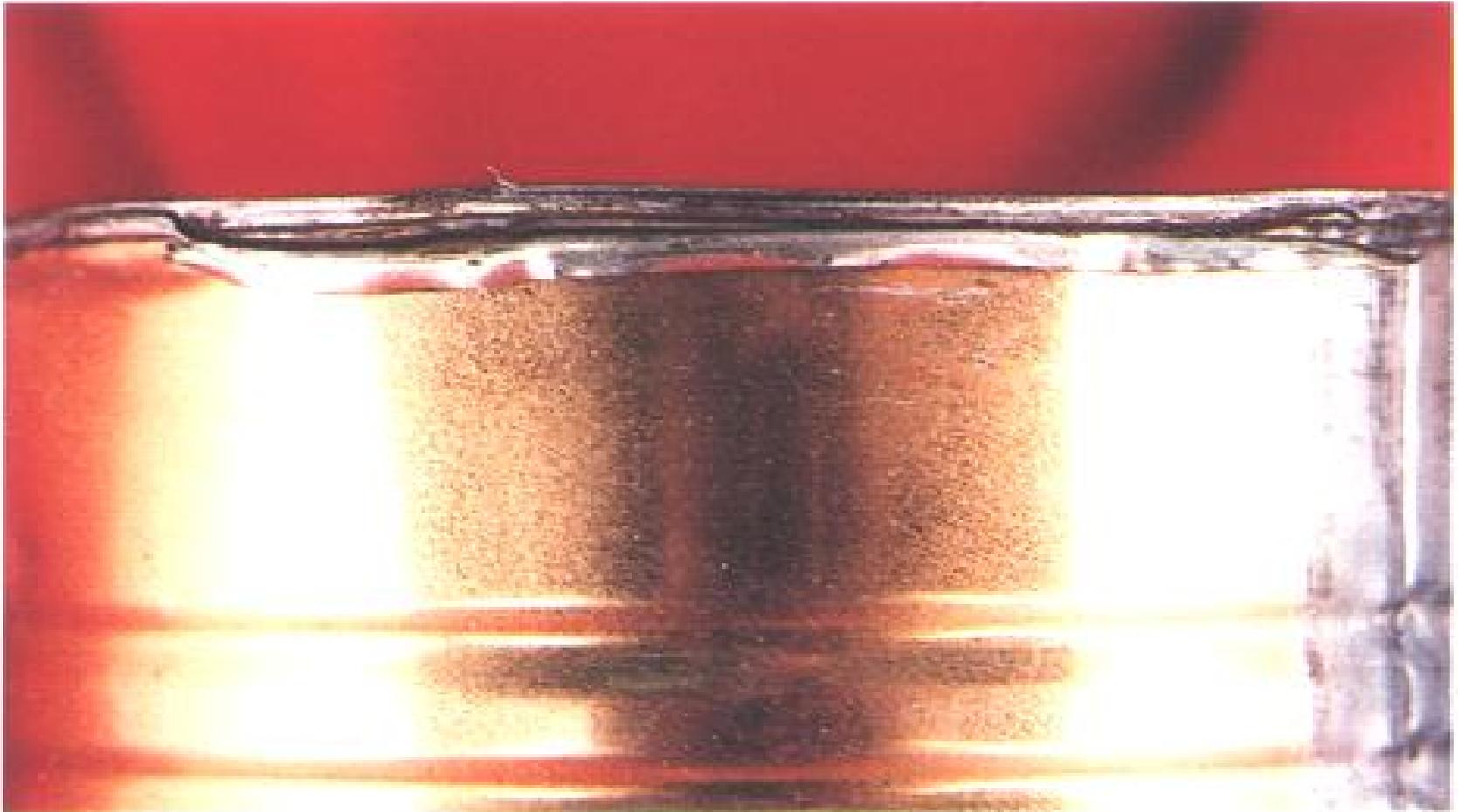
7.

Closure on end of can reflects incomplete double seam (Double seaming operation not completed by manufacturer).



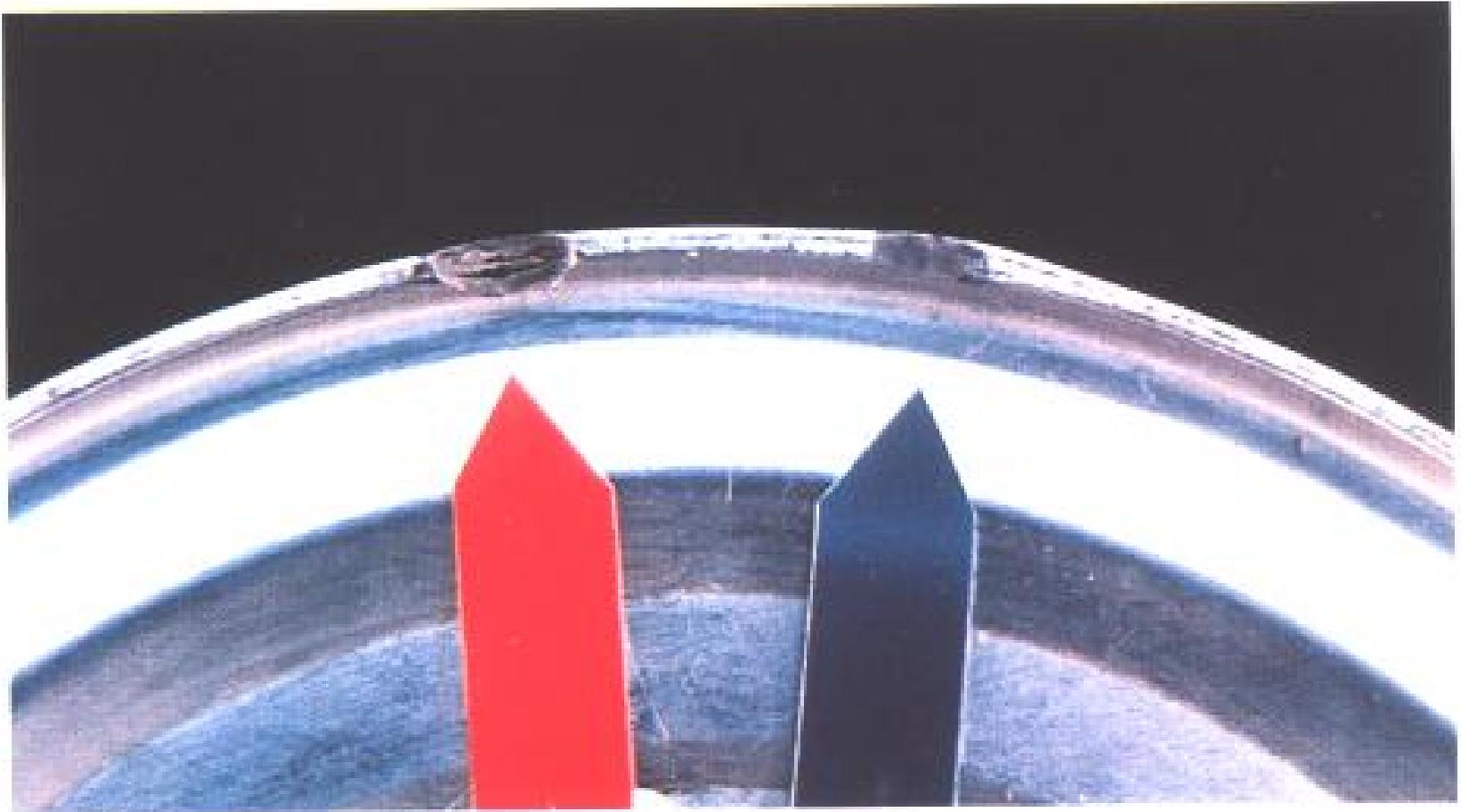
8.

Defect in end of closure on can (torn flange). Note arrow pointer.



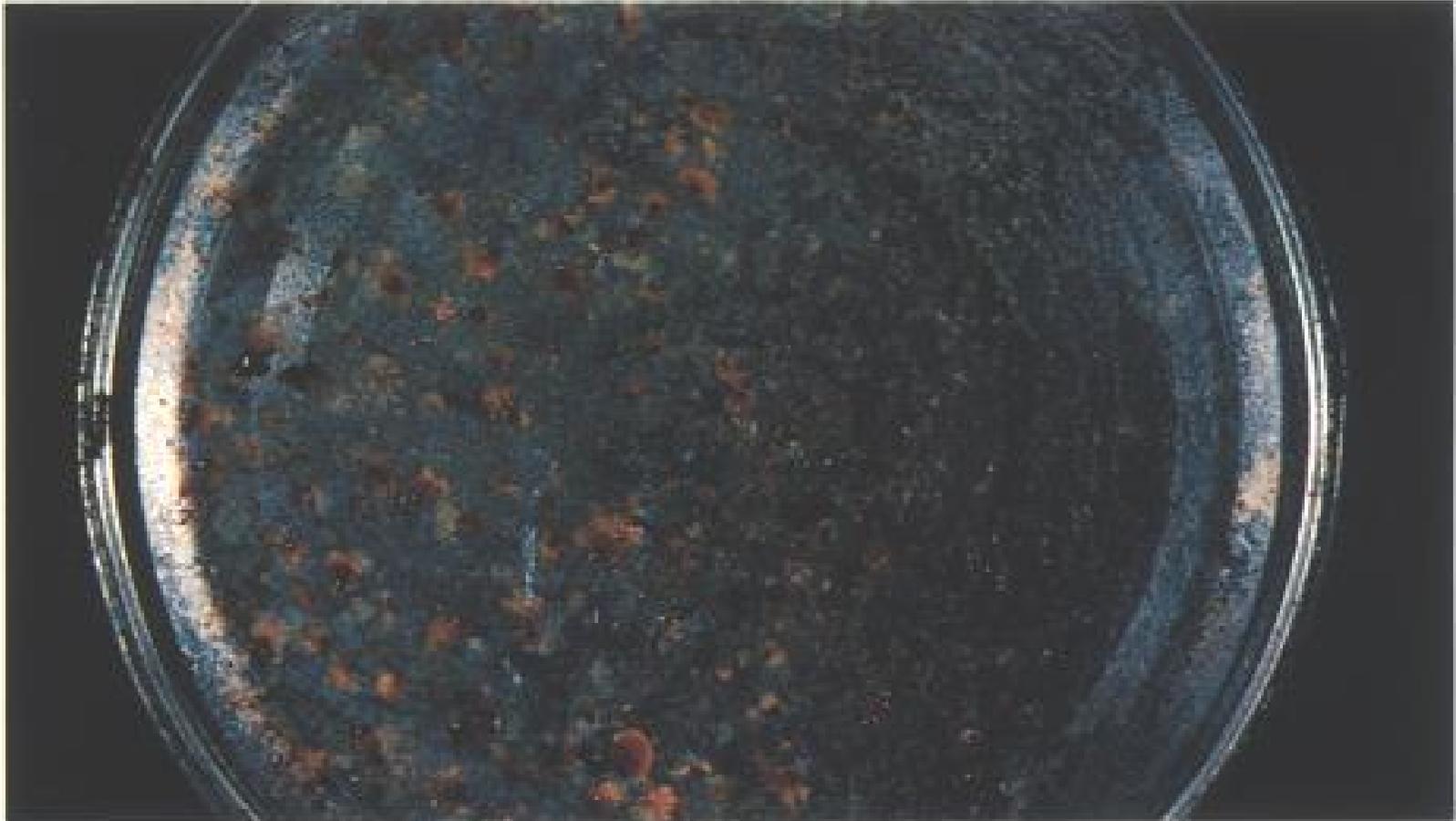
9.

Depicts a **false seam** with loss of hermetic seal. Seam is formed but not engaged properly. (Note knocked down flange).



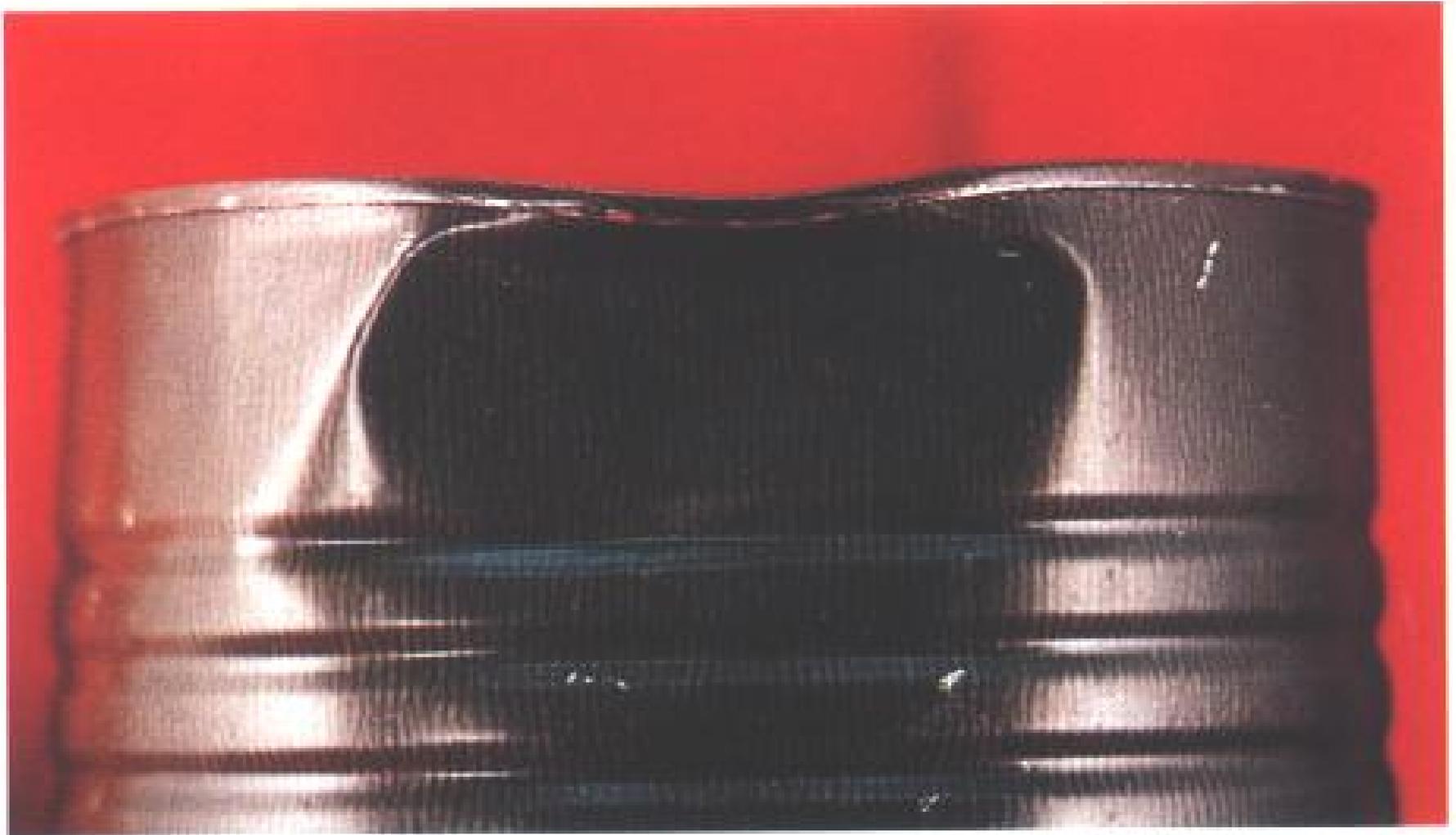
10.

Example of **cable cut** on can end. Red pointer shows "significant defect," i.e., cut through double seam. Blue pointer depicts cut/abrasion not through double seam.



11.

Severely rusted with deep pits near point of perforation.



12.

Major body dent which has impacted on double seam. (Plate may be fractured with loss of hermetic seal).



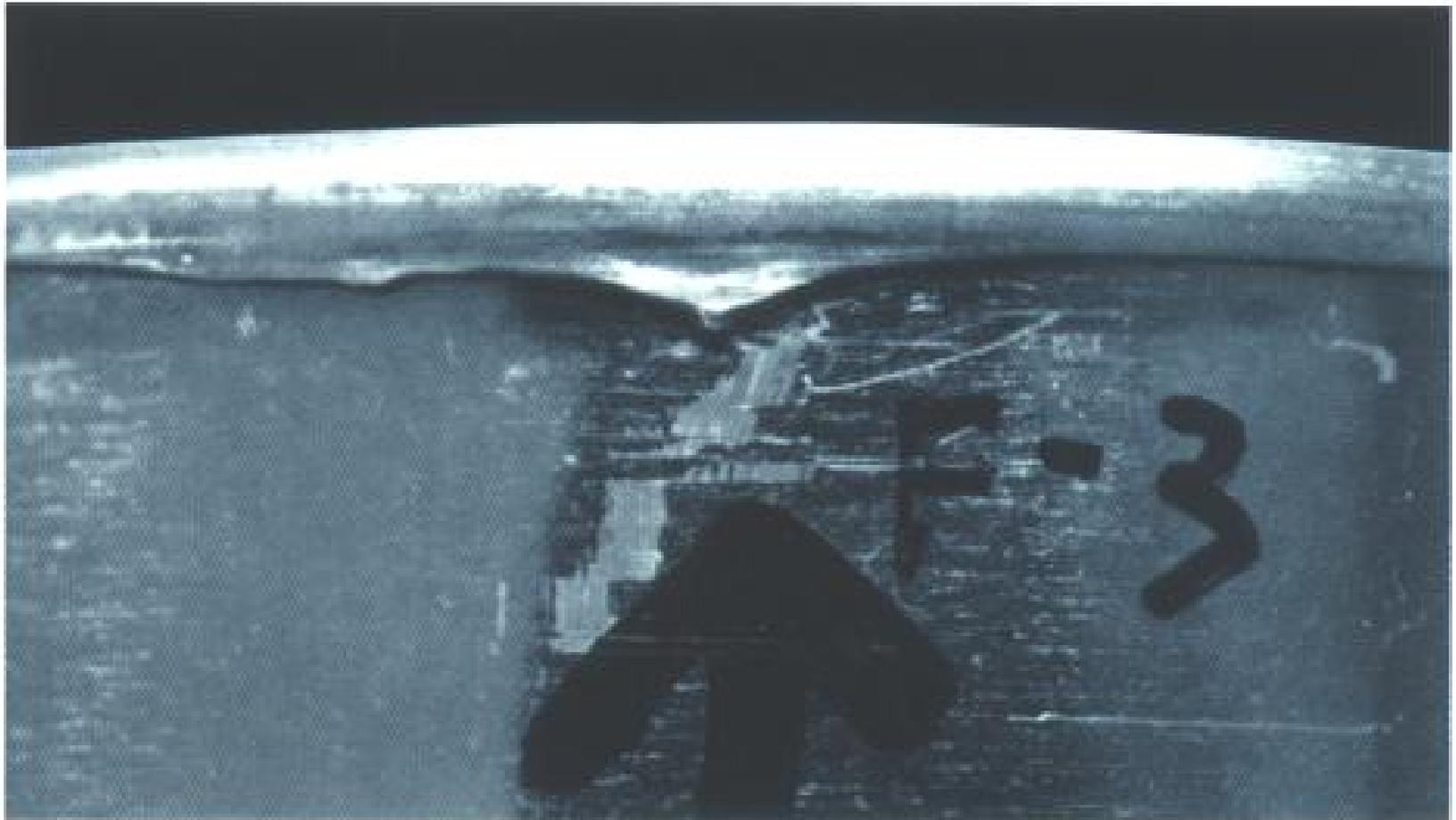
13.

Major dent in center of can body. (Plate may be fractured with loss of hermetic seal).



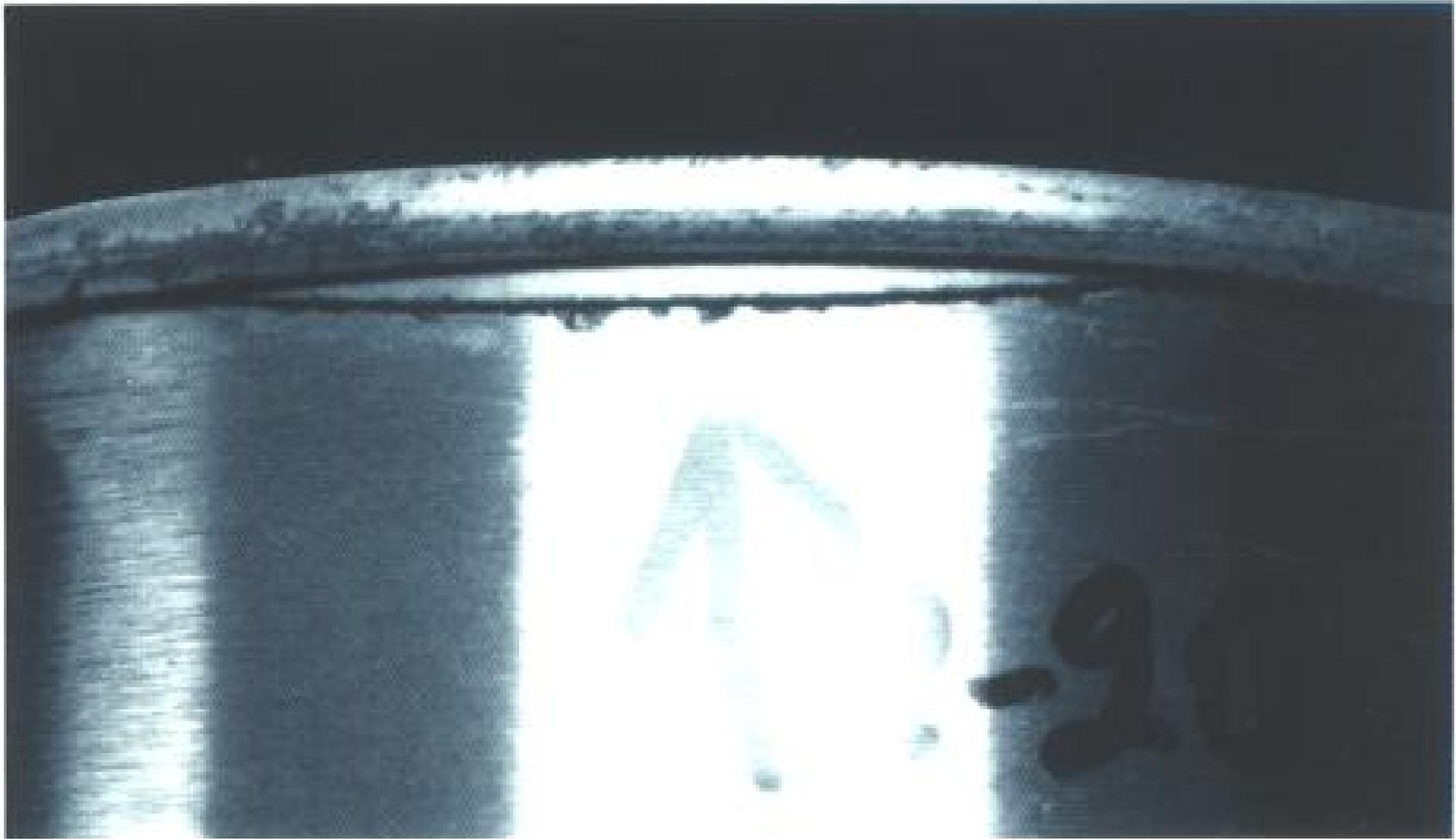
14.

"Cut-over" depicting sharp seam. (Observe for potential plate fracture or loss of hermetic seal).

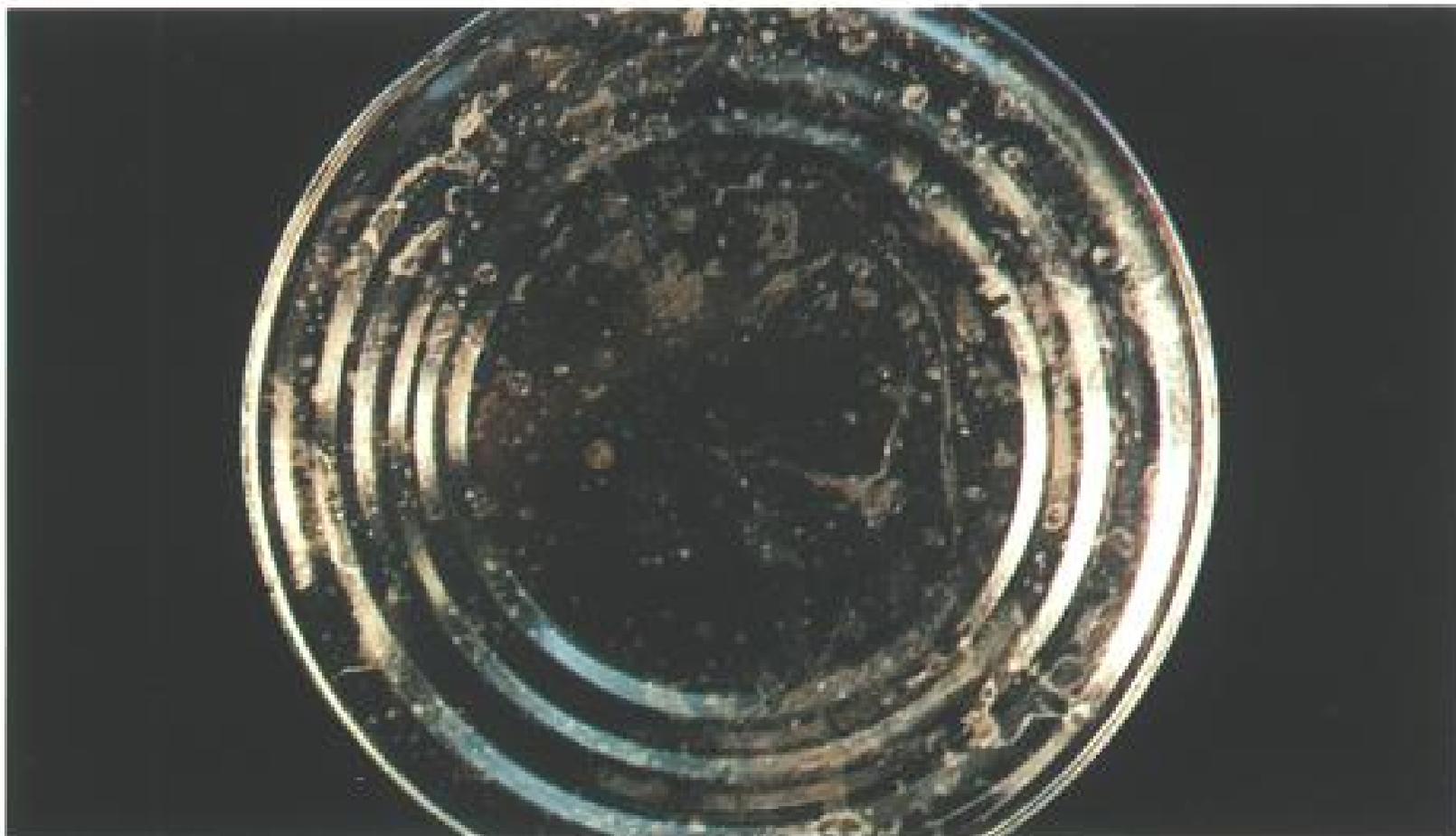


15.

Defect shown termed a "vee" or "spur" with end curl knocked down. Can be a potential leaker.

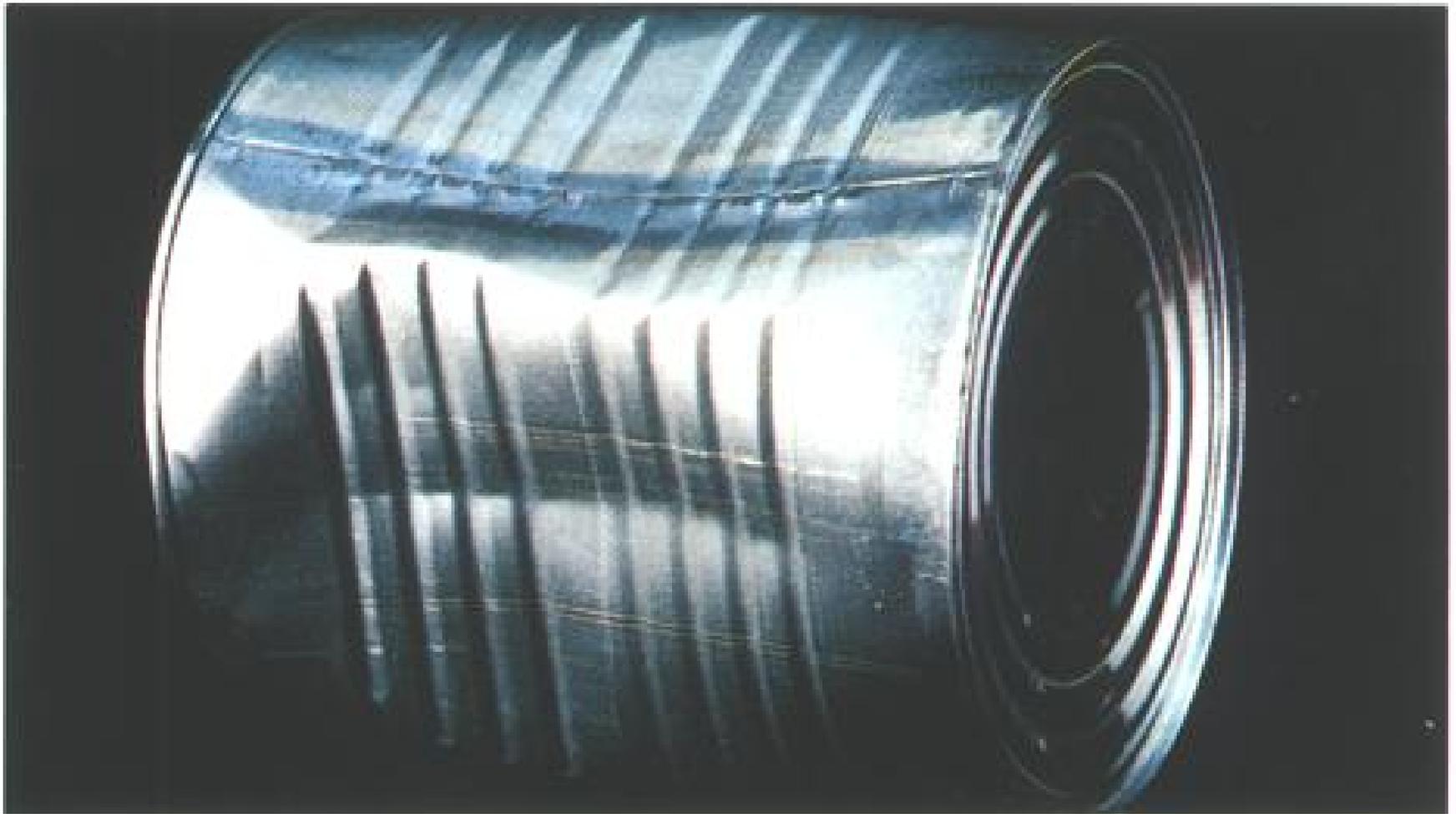


16. Pointer indicates "knocked down flange."



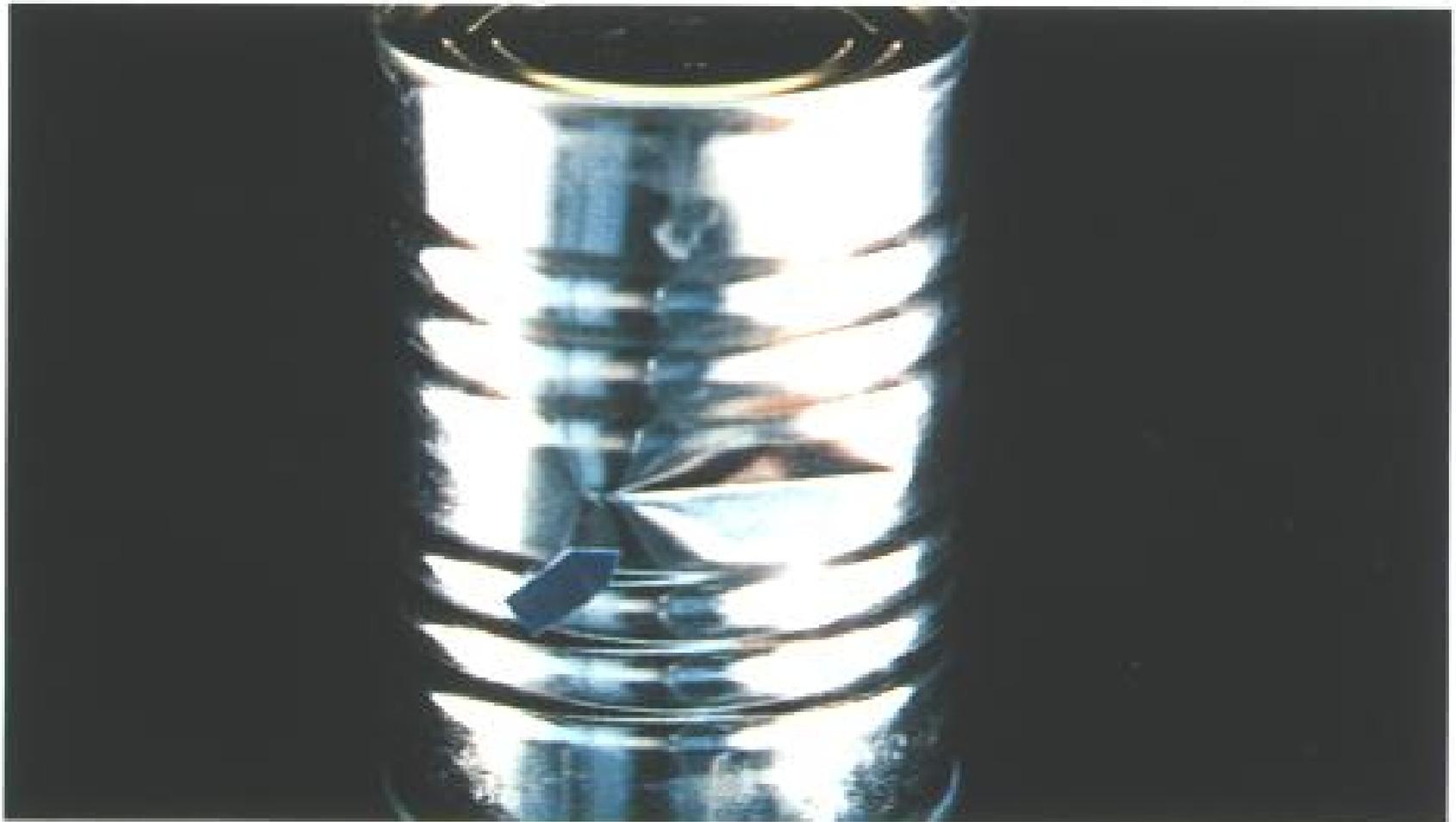
17.

Surface rust and residue food cooked on end of can. (Minor external rust and light superficial pitting easily removeable by light buffing is considered an insignificant defect).



18.

Paneled container without visible signs of loss of integrity, i.e., no plate fractures.



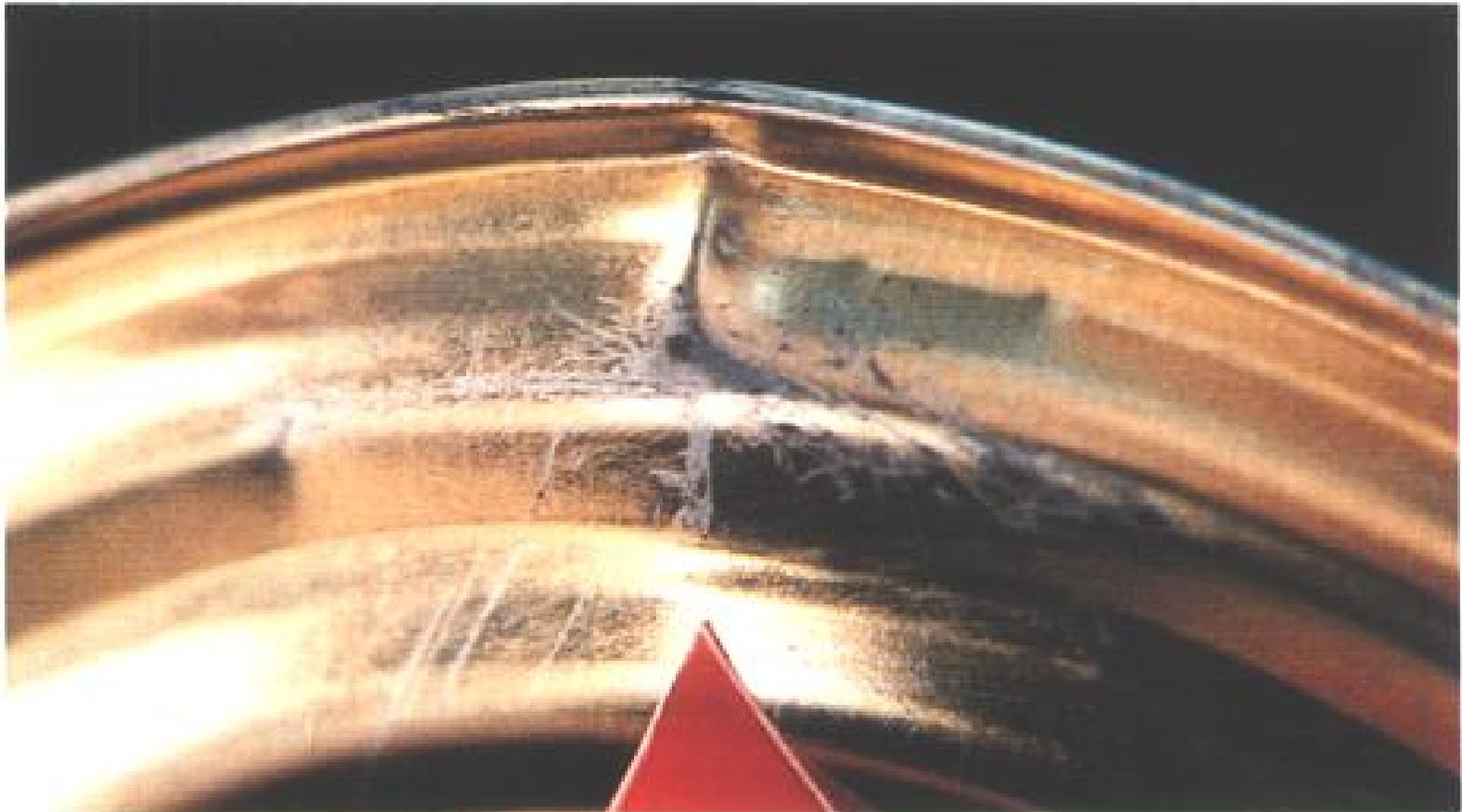
19.

Obvious body dent on side of container body. Side seam and/or double seams appear not significantly affected.



20.

Minor dent to double seam on end of can body, i.e., it does not appear creased or sharp.



21.

Minor "buckle" just extending into double seam on end of can body. (Double seam does not appear significantly affected.)