

	济南尔今进出口有限责任公司 Jinan Erjin Import & Export Co., Ltd.	File No.	EJPG-SOP-QA-028
		Version	A/1
	202 两片盖出口通用包装规范 Packaging Specification For 202END	Page	1/4
		Date	2019.9.12

1. Material Specification

1.1 End Stock

1.1.1 Gauge

1.1.2 Material

1.1.3 Temper

1.2 Tab Stock

1.2.1 Gauge

1.2.2 Material

1.2.3 Temper

2. Coating Type

2.1 External Lacquer

2.2 Internal Lacquer

3. Lining Compound

3.1 Lining Compound Type

3.2 Compound Weight

4. Physical Specification

4.1 Outside Curl Diameter

4.2 Curl Height

4.3 Countersink Depth

4.4 Curl Opening

4.5 Ends Per 2 inch

5. Functional Specification

5.1 Pop

5.2 Pull

5.3 Tab Strength

5.4 Buckle

5.5 ERV

6. Applications (应用)

- 适用于二片罐碳酸饮料及啤酒之常规生产工艺。用于充“氮”及高温杀菌饮料的包装，必须预先通知我司特别加工；
- 使用盐分含量“cl⁻”在 100ppm 以上的运动饮料的包装，罐身导电值必须严格控制在：个别值<10mA、平均值<3mA 并建议预先进行包装试验；
- 避免使用纯度差的“CO₂”用于充装(每罐空气含量应低于 2C.C)；
- 严格控制“CO₂”含量及预留空间（顶隙），避免因内压过高而造成“凸盖”；
- 成品存放时，收缩膜包装、纸箱包装，成品温度应大于结露温度 2℃，并确保盖面干燥，防止易开盖之切线的“应力腐蚀而破裂漏罐，成品库存区须控制温度及湿度；

1. 材料规格

1.1 盖材

1.1.1 厚度

1.1.2 材料

1.1.2 状态

1.2 拉环材

1.2.1 厚度

1.2.2 材料

1.2.3 状态

2. 内外涂种类

2.1 外涂

2.2 内涂

3. 封口胶

3.1 封口胶种类

3.2 封口胶干膜质量

4. 产品规格

4.1 钩边外径

4.2 钩边高度

4.3 埋头度

4.4 钩边开度

4.5 两英寸盖数

5. 功能规格

5.1 启破力

5.2 全开力

5.3 拉环强度

5.4 耐压强度

5.5 内涂膜完整性

0.224mm±0.005mm

Aluminum Alloy 5182

H19 / H38 / H39 / H48

0.270mm±0.005mm

Aluminum Alloy 5182

H38 / H39 / H48

Epoxy/Polyester (环氧树脂/聚酯)

Epoxy/Polyester (环氧树脂/聚酯)

Water Based Compound (水性胶)

20~40mg

59.44±0.25mm

2.03±0.15mm

6.86±0.13mm

≥2.72mm

24~27pcs

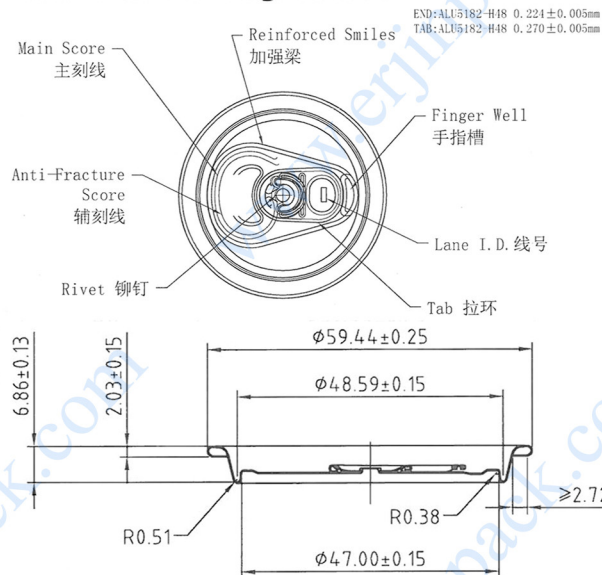
10.0-25.0 N

13.0-30.0 N

30.0~40.0 N

≥620Kpa (90Psi)

Max≤15mA, Avg≤5 mA



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冯国庆

Checked By:

刘亚楠

Approved By:

李秀英

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2/4

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1. Material Specification

1.1 End Stock

1.1.1 Gauge

0.224mm

1.1.2 Material

Aluminum Alloy 5182

1.1.3 Temper

H19 / H39 / H38 / H48

1.2 Tab Stock

1.2.1 Gauge

0.270mm

1.2.2 Material

Aluminum Alloy 5182

1.2.3 Temper

H38 / H39 / H48

2. Coating Type

2.1 External Lacquer

Epoxy/Polyester

2.2 Internal Lacquer

Epoxy/Polyester

3. Lining Compound

3.1 Lining Compound Type

Water Based Compound

3.2 Compound Weight

20~40mg

4. Physical Specification

4.1 Outside Curl Diameter

59.44±0.25mm

4.2 Curl Height

2.03±0.15mm

4.3 Countersink Depth

6.86±0.13mm

4.4 Curl Opening

≥2.72mm

4.5 Ends Per 2 inch

24~27pcs

5. Functional Specification

5.1 Pop

10.0-25.0 N

5.2 Pull

13.0-30.0 N

5.3 Tab Strength

30.0~40.0 N

5.4 Buckle

≥620Kpa (90Psi)

5.5 ERV

Max≤15mA, Avg≤5 mA

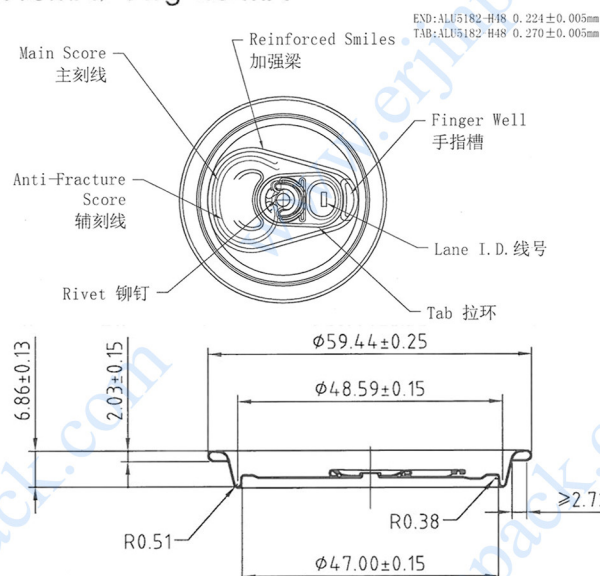
6. Applications

2-piece cans for beer and carbonated beverages.

7. Disclaimer

7.1 Ends must be dried completely after filling to avoid stress corrosion of the scores. They must be stored in conditions that are free from humidity variation.

7.2 It is filler's responsibility to conduct seaming and packing tests to ensure the ends are compatible with the cans prior to mass production.



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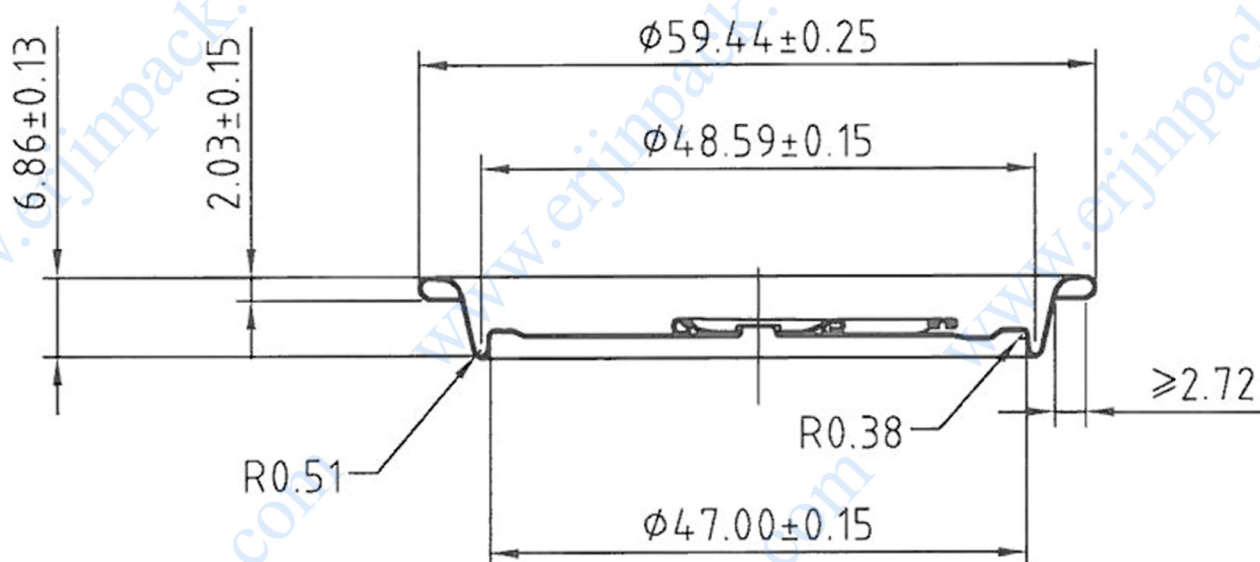
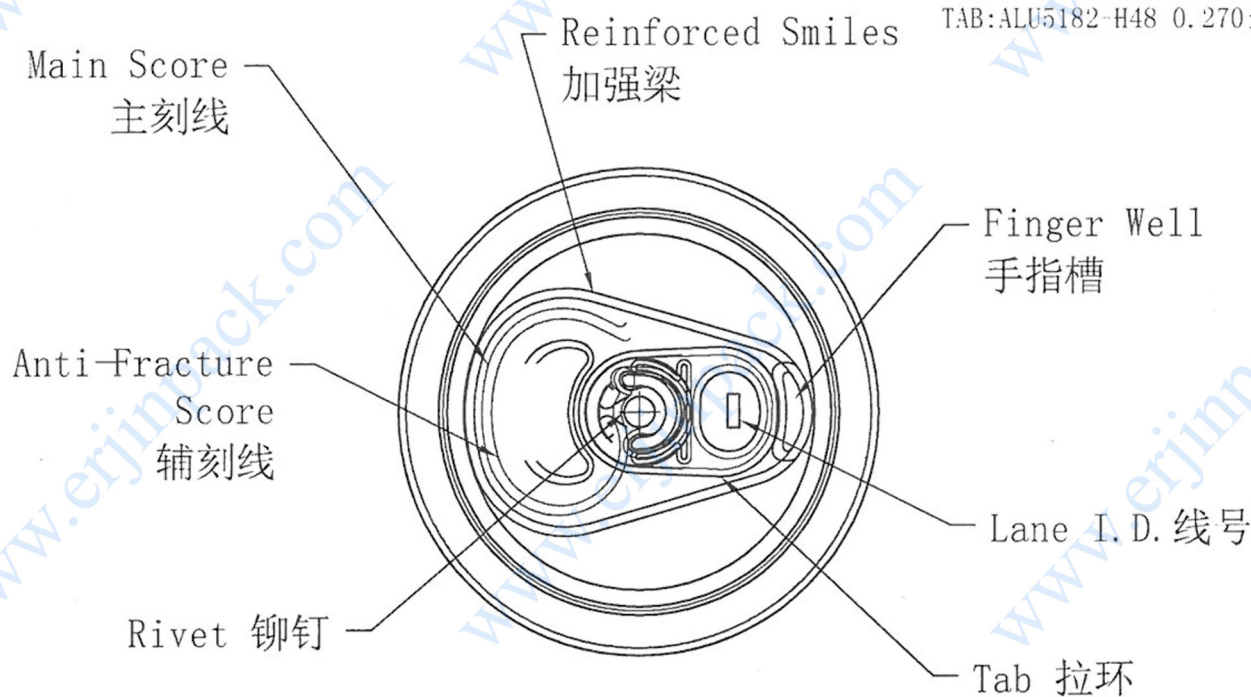
3/4

Date

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END:ALU5182-H48 0.224±0.005mm

TAB:ALU5182-H48 0.270±0.005mm



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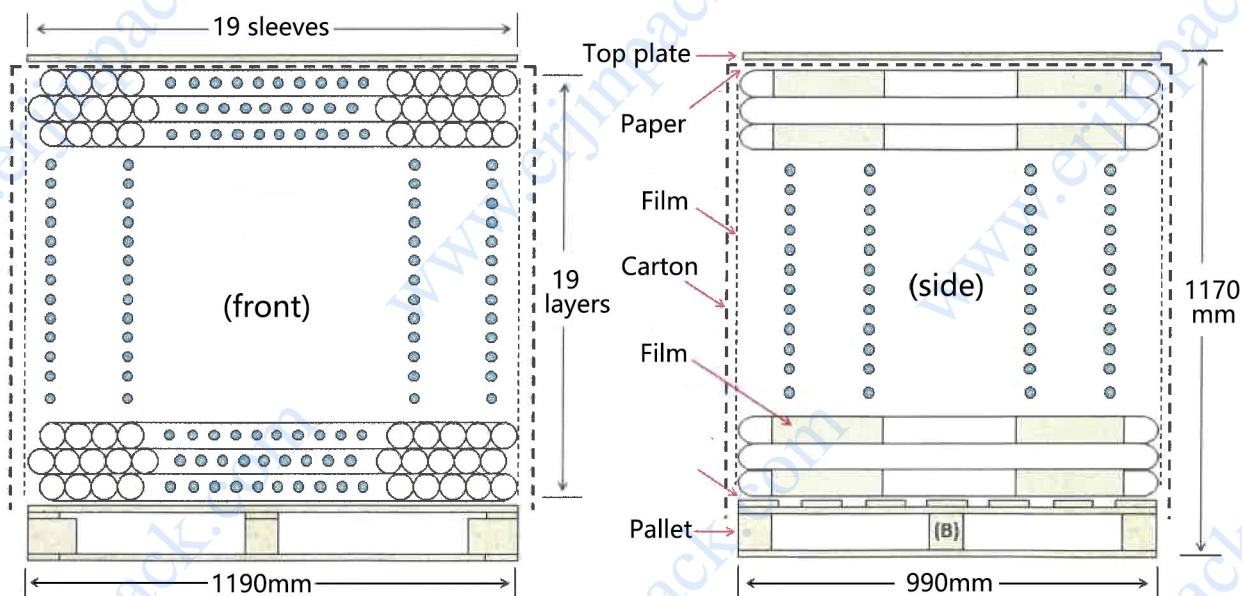
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No.	Item	Specification	Remark
1	Finish End	202RPT/SOT END For Two-Piece Can	
2	Pallet Dimension	L*W*H (mm) = 990 X 1190 X 140	Plywood, exported
3	Package Dimension	L * W * H (mm) = 990 X 1190 X 1170	
4	Sleeve Dimension	W*H*L (mm) = 70 X 35 X 1150	
5	Snake Film	W * T (mm) = 500 X 0.02	LLDPE, transparent
6	Package Method	500pcs/sleeve X 19sleeve/layer X 19layer/pallet = 180500pcs/pallet	
7	Sleeve/pallet	361 sleeves	
8	Quantity/pallet	180500 pcs	HDPE, transparent
9	Top Plate Cover	L * W * H (mm) = 990 X 1190 X 20	Plywood, exported
10	PET Strap	W * T (mm) = 16 X 1.0, 4pcs totally	
11	Store condition	Idea storage temperature of lined ends is less than 27°C. Prolonged storage in warehousing or during transportation above 32°C is not recommended. Avoid direct exposure to light which cause accelerated aging. Storage in a moist environment is also not recommended. The reason is the potential for metal corrosion, and possibility of mold and mildew growth.	



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