

How our Tubes are made

1. Slug Preparation

The process starts with the aluminium slugs being lubricated by a special metal soap to help with friction during the impact extrusion process.



2. Impact Extrusion

Once lubricated the slugs are held by jaws and punched with a hardened shaft. This forms the tube body.



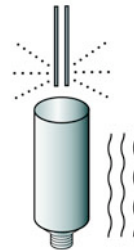
3. Trimming & Thread Rolling

Once formed, the cylinders are trimmed to the standard height and simultaneously the thread is rolled on the neck of the tube. The tube shoulders are then polished with steel brushes. The tube is still hard and springy and has to be softened by an annealing process with a temperature of 400–500 °C.



4. Internal Lacquering

All tubes receive an internal coating of a protective lacquer, spray-applied in two coats and then oven-cured.



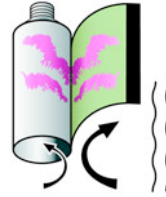
5. Basecoat Application

All tubes receive a total surface coating of base lacquer, e.g. white, colourless or special and oven-cured again.



6. Printing

The design is transferred from the printing blanket (offset) to the tube using a "wet in wet" indirect dry offset procedure. The printing inks are taken from the ink ducts and applied to the printing plates by transfer rollers. A rubber blanket between the blocks and the tubes takes on the colours of all the plates and applies them to the tubes (all 6 colours at the same time). As all the colours come to the tube at the same time an extremely precise positioning is required.



7. Screwing on tube caps

Caps are screwed onto the tube thread on a screw-on machine and then run through a test station to make sure the caps have formed a seal and are not overtightened. Next, if required a latex ring is applied to the inner tube end.



8. Packaging

Before they are packaged, all tubes are visually inspected again and are then packaged automatically. The cartons are labelled and stacked on pallets, before being shrink-wrapped for safe transportation.

