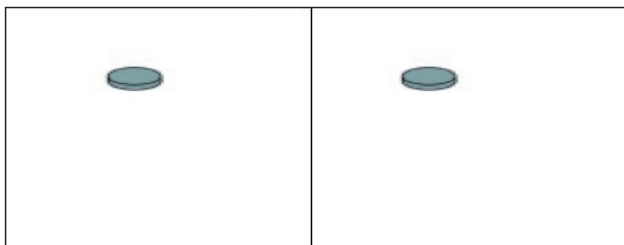


Principle ● CiC-System

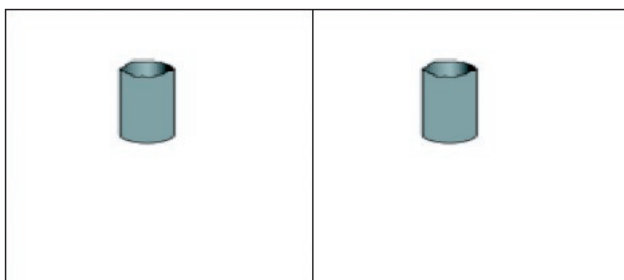
1. Inner bag and can are firmly connected to each other in the upper area.
2. The cavity between the bag and can base is used for holding the pressure medium.
3. During use, the inner bag is completely compressed. An emptying rate of up to 95% of the filled substance is possible.
4. The pressure medium is filled either via a hole in the base or by means of the sealing plug which is already inserted.

CAN IN ● CAN

Linie 7.1
Pouch



Linie 7.2
Outside container



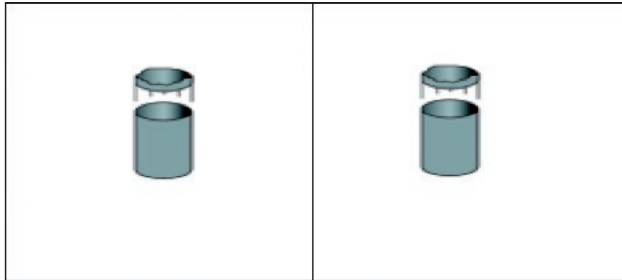
Operation

1. **Slug Preparation**
The slug of the outside container is being lubricated to help the impact extrusion process. The pouch slugs are powdered.
2. **Impact Extrusion**
Once lubricated or powdered the slugs are held by jaws and punched with a hardened shaft (250 tons). This forms the cylinder of the can or pouch.

Linie 7.1
Pouch

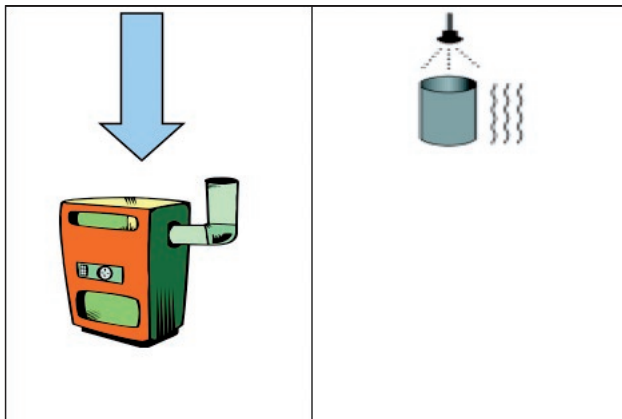
Linie 7.2
Outside container

Operation



3. Trimming & Brushing

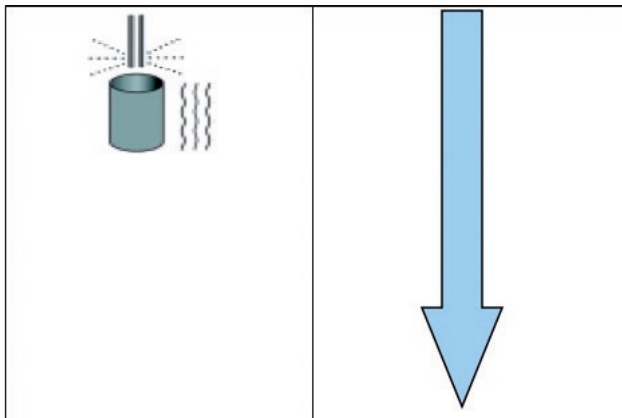
Once formed, the cylinders are trimmed to the standard height and brushed to remove any imperfection and create a uniform finish.



4. Washing & Drying of the outside container

During this operation any lubricant or shards of aluminium are removed. Afterwards the containers are dried in the oven.

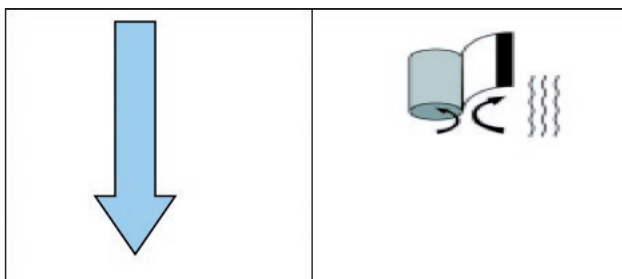
The pouch is fully soft-anneal in the oven. Any impurities will be burned during the drying-process.



5. Internal lacquering of the pouch

Spray nozzles apply a double coating of internal lacquer which is then being cured in the oven.

The outside container does not need any coating.



6. Basecoat application on the outside container

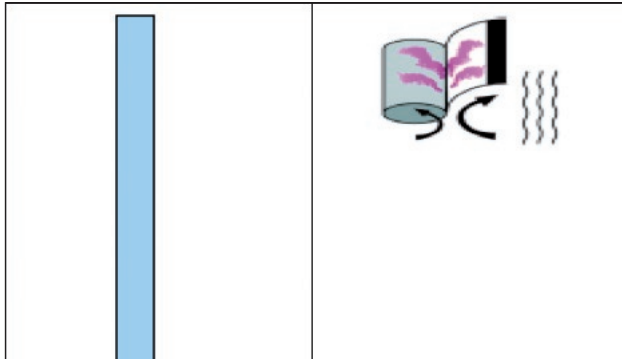
The outside containers are base lacquered, either with a white or a translucent lacquer.

The base coat needs to be dried in the oven.

Linie 7.1
Pouch

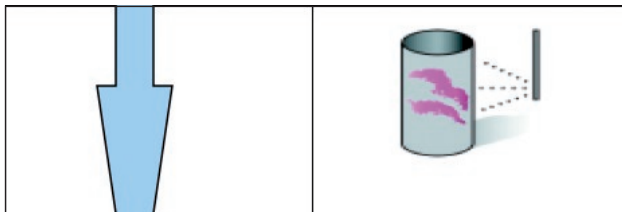
Linie 7.2
Outside container

Operation



7. Printing of the outside container

The all over decoration is being transferred from the printing plates on to the blankets. The process is called rotary offset wet on wet. This printing method does not allow to use the 4 process colours but we are working with spot colours (PMS-References) After the outside cylinder has been decorated, the ink needs to be dried in the oven.



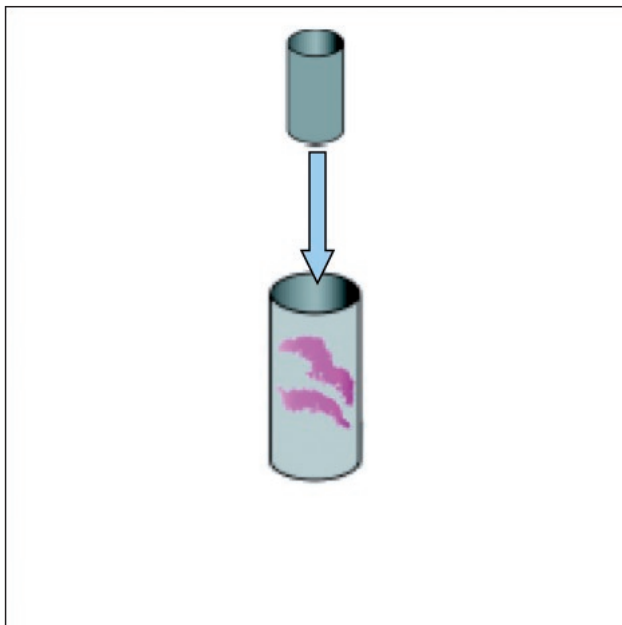
8. Over lacquering of outside container

A transparent over lacquer protects the decoration and needs to be dried again in the oven.



9. At the punching station

the bottom of the can body is brushed, the bottom is formed and is getting its bottom hole.



10. The pouch is pushed into the outside container

at a very special and complex station. Both parts are glued together and afterwards the sealing stopper is inserted in the bottom hole. A testing equipment tests the cans if they are fitted correctly with the sealing stopper.

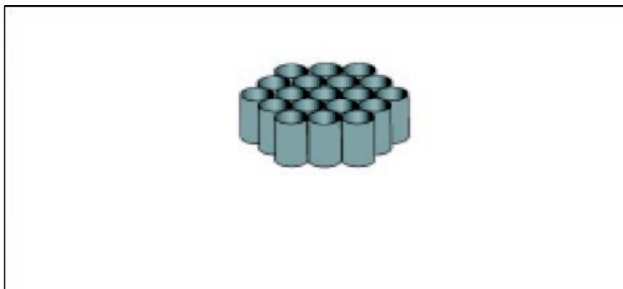
Linie 7.1
Pouch

Linie 7.2
Outside container

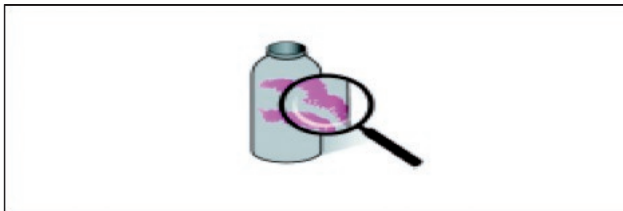
Operation



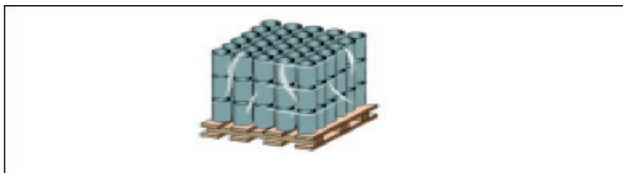
11. Necking
This is a key process which forms the shoulder, neck and bead in one operation.



12. Packaging
Depending on diameters, the cans are either packed in bundles or in trays. This packaging allows a safe transport.



13. Inspection
Once the cans are bundled, the operators make a visual final inspection. Now your cans are ready for despatch.



14. Palletising
The cans are either shrink-wrapped or stretched and safe for transport.