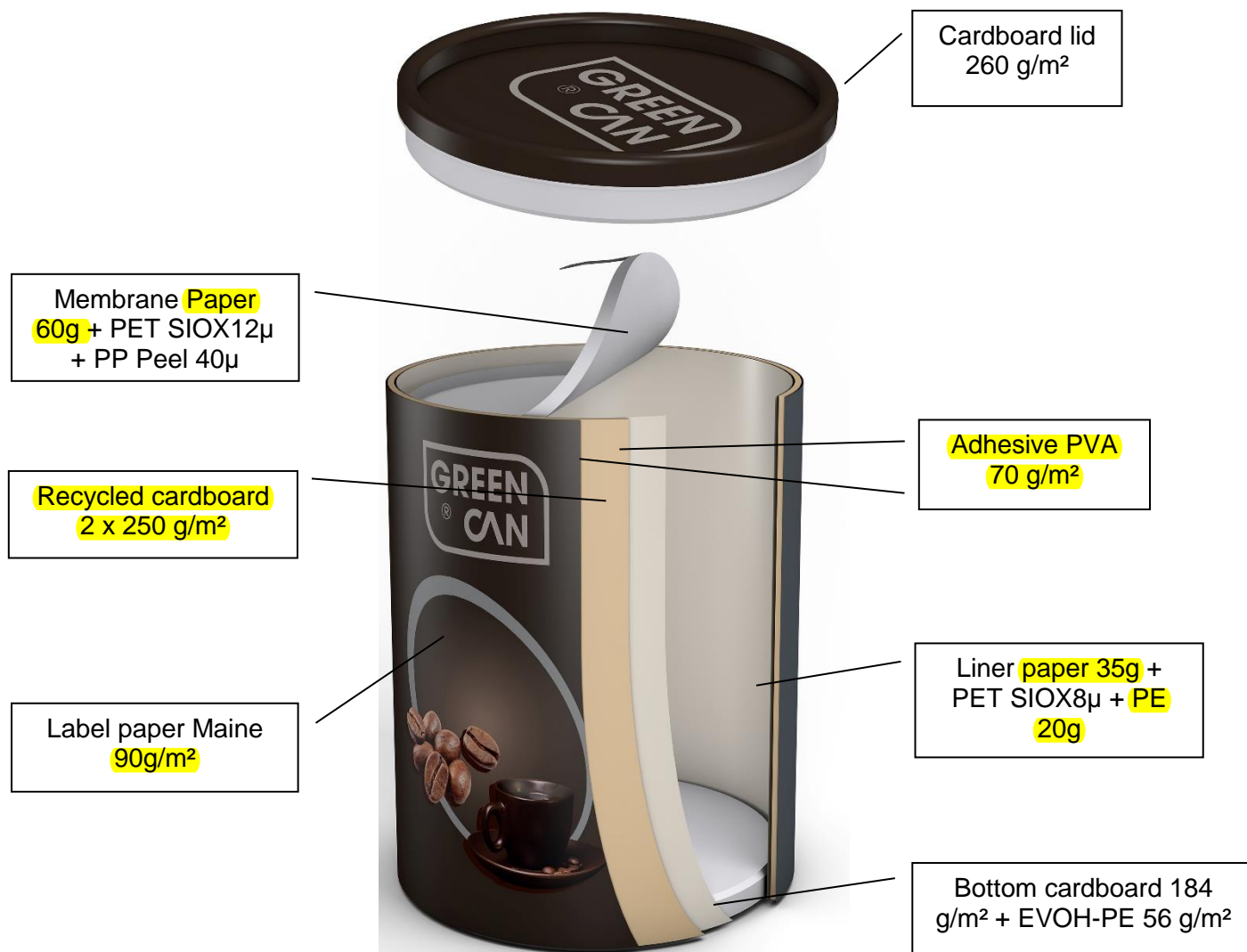


DESCRIPTION OF THE WHOLE CAN (see drawing below)

The GREENCAN can 73mm is composed of an inner layer (complex of multi material), 2 layers of recycled cardboard placed on top of each other and stuck, and an external printed label.

The printed cardboard lid is secured with 3 tamper-evident/attachments points and the membrane is placed and sealed by the cans manufacturer. Bottoms in cardboard are sent separately in reels to be formed and sealed by the conditioner



MATERIAL SPECIFICATIONS

1. Can body (from the inside to the outside)

Can components :	Materials :
Inner layer multi material (liner)	<ul style="list-style-type: none"> • PE 20 g/m² (sealing material) → in direct contact with food • PET SIOX 8 μ (barrier) • Paper 35 g/m² • Adhesive between each layer (type not precised by our supplier)
Body	<ul style="list-style-type: none"> • 2 layers of recycled cardboard (2x 250 g/m²) • Adhesive between each layer (water based adhesive)
Label	<ul style="list-style-type: none"> • Paper 90 g/m² offset printed, 4 colors + lacquer (mat)

2. Operculum with easy opening (from the inside to the outside)

Can components :	Materials :
Membrane with easy opening	<ul style="list-style-type: none"> • PP peel 40 µm → in direct contact with food • PET SIOX 12 µ (barrier) • Paper 60g/m² • Adhesive between each layer (type not precised by our supplier)

3. Placed lid – secured (from the inside to the outside)

Can components :	Materials :
Lid	<ul style="list-style-type: none"> • Cardboard pure cellulose 260g/m² (flexo printed, 4 couleurs + lacquer (UV mat)

4. Bottom for closing (delivered in reel, from the inside to the outside)

Can components :	Materials :
Direct bottom	<ul style="list-style-type: none"> • EVOH-PE 56 g/m² (barrier) • Cardboard pure cellulose 184 g/m² • Adhesive between each layer (type not precised by our supplier)

Delivered separately in reel to be formed and placed with the closing machine.

Information concerning the bottom sealing	Dimensions
Cutting diameter	83mm ± 0.25mm
Internal diameter of the bottom after placing	73mm ± 0.25mm
Push depth	5mm -0/+ 2mm
Thickness of the complex	0.570 mm ± 5%
Reel width	90 mm -0/+1mm

SPECIFICATIONS OF THE FINISHED CAN

1. Requirements of the finished can – bottom sealed

	Height
Height without bottom (cutting height)	79 +/- 1mm
Total height	70 +/- 1mm

Ø73 h 70 Spécifications et Composition	g/m²	Surface (m²)	Cardboard Weigh (g)	Plastic Weight (g)
Recycled cardboard: 2 x 250g	500	0.01890	9.45	0
Liner Papier 35g + PETSIOX 8µ + PE 20g	35 31.2	0.01920	0.67	0.60
Label : Paper Maine 90g/m²	90	0.01920	1.73	0
Adhesive: PVA	70	0.01890	1.32	0
Membrane Paper 60g + PETSIOX 12µ + PP Peel 40g	60 52.8	0.00720	0.43	0.38
Cardboard lid 260g	260	0.00720	1.87	0
Cardboard bottom 184g + EVOH-PE 56g	184 56	0.00670	1.23	0.38
Total can weight with membrane (g)	Components weight with membrane (g)		16.71	1.35
18.06	Components part with membrane (%)		92.50	7.50
Total can weight without membrane (g)	Components weight without membrane (g)		16.28	0.97
17.25	Components part without membrane (%)		94.35	5.65

1.1. Thickness of can body 0.86 mm ± 10%

1.2. External diameter maxi 74.72 mm maxi.

1.3. OTR (Oxygen transmission rate)

Material	Tests conditions	Values (cm³/m²/day)
Liner PET SIOX <i>Supplier data</i>	23°C, 0% HR	< 2
Membrane PET SIOX <i>Supplier data</i>	23°C, 0% HR	< 2
Cardboard bottom <i>Supplier data</i>	23°C, 50% HR	< 6

1.4. WVTR (Water Vapour transmission rate)

Matériau	Tests conditions	Values (cm³/m²/day)
Liner PET SIOX <i>Supplier data</i>	38°C; 90% HR	< 2
Membrane PET SIOX <i>Supplier data</i>	38°C; 90% HR	< 2
Cardboard bottom <i>Supplier data</i>	23°C, 50% HR	< 2

2. Palettizing et storage conditions

Palettizing :

Product :	Details
Cans	<ul style="list-style-type: none"> • 12 layer of 180 cans (= 2160 cans/layer), put in a cardboard tray, • Wooden lost palett • Palett wrapped with stretch film, 1 palett label on each big side of the palett (side 1200mm)
Bottom (in reel)	<ul style="list-style-type: none"> • Bobbin of maxi diameter 1000 mm, on carton internal diameter 76 mm core • Reel weight: 55,88 kg • Pallet, dimensions 1010 mm x 1010 mm, • 1 row of 11 reels : 11 reels/ pallet

Storage conditions :

In order to ensure that GREECAN boxes are used in the best conditions, it is important to store cans and bottoms reel according to the following conditions:

- In the original packaging
- Out of direct light and moisture.
- Storage temperature : 8°C<T<30°C
- Using temperature : 18°C<T<25°C
- Transport temperature : 8°C<T<40°C
- Humidity rate : maximum 65%
- Maximum storage time (shelf life) : 12 months

SPECIFIC REGULATORY REQUIREMENTS

Conformity to the following texts :

- Regulation (EC) N° 1935/2004 of 27th October 2004 on material and articles intended to come into contact with food ;
- Regulation (EC) No 2023/2006 of 22nd December 2006 amended on good manufacturing practices for materials and articles intended to come into contact with food;
- Regulation (EU) No 10/2011 of 14 January 2011 on plastic materials and articles intended to come into contact with food ;
- directive 94/62/CE on packaging and packaging waste, amended by directives 2004/12/CE, 2005/20/CE and 2013/2/CE.

Inks and lacquers :

Labels

- Conform to EuPIA Guidelines on Printing Inks applied to the non-food contact surface of food packaging materials and articles, but UV inks for lids;
- Conform to Good practices in production CEPE/EuPIA for inks applied to the non-food contact surface of food packaging materials and articles, but UV inks for lids

Lids (UV inks)

- Conform to Good practices in production CEPE/EuPIA for inks applied to the non-food contact surface of food packaging materials and articles, but UV inks for lids

Criteria for overall migration testing :

According to Regulation (EU) No 10/2011 of 14 January 2011 on plastic materials and articles intended to come into contact with food (for dry food):

	Referring Analyzes	Overall migration analysis
Can (without bottom)	Report ULY 17-018427-1/rebr from 24/11/17 (Wessling)	10 days at 40°C, value <10 mg/dm ²

Additionaln information :

Based on our suppliers statements, there is no intentional adds of following substances:

- BPA
- POSH/MOSH/MOAH (no guarantee of absence)
- Phtalates
- Nanomaterials

QUALITY SPECIFICATIONS :

Foreign body criteria:

Absences of foreign body (others than cardboard dust)

Quality controls :

- Quality controls are performed on 8 consecutive cans at starting, then every hour
- These controls are performed according to our internal standards (visual checks, tightness controls of the membrane with an alcoholic colored indicator, opening of the lid and the membrane, etc.), except if customer requires additional control points (to be agreed between the two parties).
- Concerning the presence of foreign bodies, we proceed to visual checks: absence of foreign bodies (others than cardboard dust, complex cardboard-plastic, related to the process).
- A sample of can is taken every hour and the cans are kept for 10 weeks, unless specified by the customer.