

# CAN DEFECT CATEGORIES

## HANDLING DEFECTS

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### DEFECT: CRUSHED

### CLASSIFICATION:

A crushed can is considered a **serious container defect**.

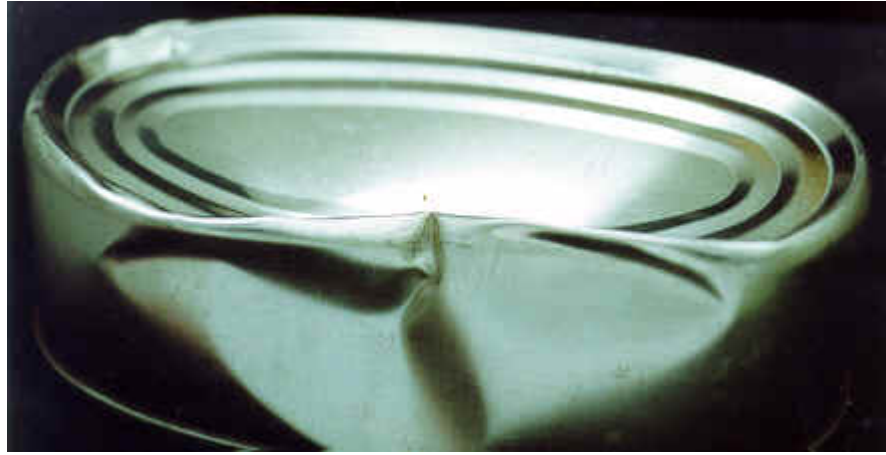
### DESCRIPTION:

An extreme mechanical deformation of the metal container.

### COMMON SOURCES:

1. Misfeed of the filled can in conveying equipment.
2. Transit damage.





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### DEFECT: DENT

#### CLASSIFICATION:

A dent is considered a **serious container defect** if the can body or end has been sharply distorted such that:

- the containers have bulged one or both ends, other than pressurized containers; or
- the body dent has pulled on the double seam such that the distortion of the end seam exceeds the countersink depth of that specific can size **and** results in the double seam dimensions being outside of the can makers published guidelines; or
- the metal plate has fractured, or the fracture of the coating has exposed metal which may react with a corrosive product; or
- the container shows evidence of content leakage.

#### DESCRIPTION:

The pronounced mechanical distortion of the metal container resulting in either significant reduction of the internal volume of the container or deformity of the can end or body, the double seam, or the side seam. Dents may crease the metal plate which may adversely affect the internal coating causing susceptibility to corrosion. Dents may distort the double seam or side seam such that vacuum loss may occur.

#### COMMON SOURCES:

1. Mishandling of the empty or filled cans during conveying, transporting, labelling, or preparing the product for marketing.
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**Lower limit of a serious body dent. Body dent is sharp and deep and the double seam has been pulled down below the level of the countersink depth of the can.**

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**Upper limit of a minor body dent. Body dent is sharp and deep. Need to assess the inside coating for possible fractures, if the contents are considered as being a corrosive product which will react with the container, and the double seam has been distorted so that the dimensions are outside of the can maker's guidelines.**

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### DEFECT: DOUBLE SEAM DENT

#### CLASSIFICATION:

A double seam dent is considered a **serious defect** when:

1. the dent is sharp, deep or has deformed the double seam in excess of 2 mm (1/16 inch);  
or
2. the containers have bulged one or both ends as a result of the impact to the double seam; or
3. the container shows evidence of content leakage.

#### DESCRIPTION:

The mechanical deformation of the double seam (can rim) of the container, caused by a sharp blow or excessive mechanical force to the double seam. Double seam (rim) dents can adversely affect the integrity of the double seam resulting in a potential for post-process contamination.

#### COMMON SOURCES:

1. Mishandling of the closed can either during pre-processing or post-processing. Post-processing is anytime after retorting, during labelling, transport or storage.



**Pulled Seam**



**Rim Dent**