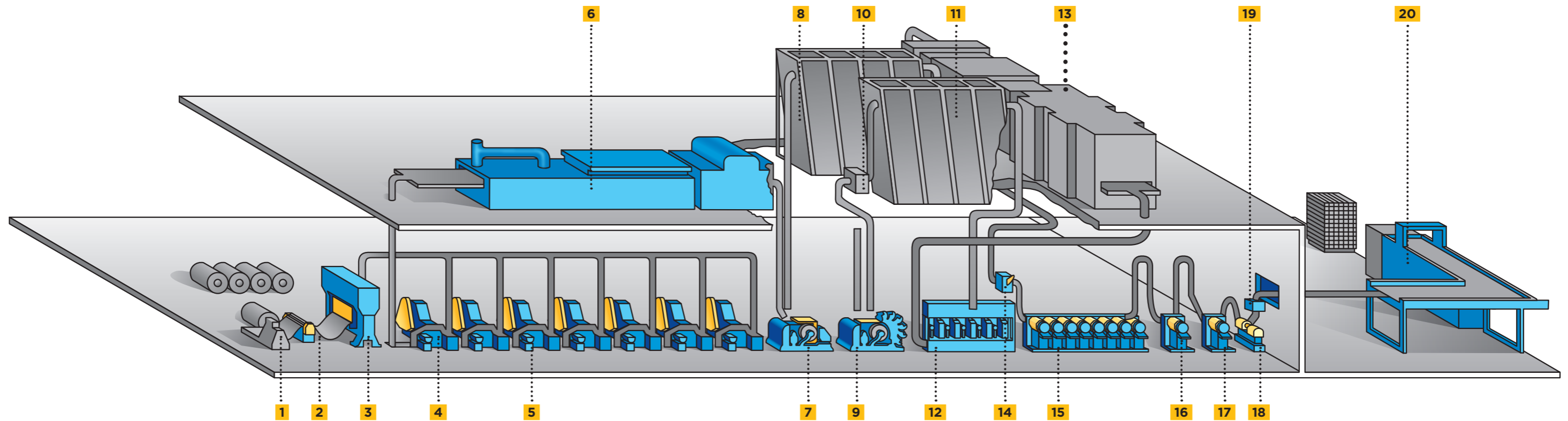


# Inside an Ardagh beverage can facility



**1 Aluminum Coils**  
are positioned on the uncoiler. Uncoiler unwinds the aluminum coil into the lubricator.

**2 Lubricator**  
applies a thin film of lubricant to the aluminum sheet and then feeds the metal into a cupper.

**3 Cupper**  
cuts out circular blanks of aluminum and forms the blanks into cups.

**4 Bodymakers**  
use a punch mounted on a ram to push the cups through a series of tooling dies that redraw and iron the cups into cans.

**5 Trimmers**  
trim the open end of the cans to a uniform height.

**6 Washer/Oven**  
washes, rinses and dries cans in preparation for the application of internal coatings and label printing.

**7 Basecoaters**  
are used only if required by the can design. Cans are conveyed to the basecoater where basecoat is applied to the outside of the cans as a base color for further printing.

**8 Basecoater Ovens**  
Cans are conveyed to the basecoater oven where the basecoat is cured onto the cans used.

**9 Printers**  
use either six or eight colors of ink to first print labels on the cans and then apply a thin film of lacquer over the entire label to protect it.

**10 Bottom Coater**  
applies a coat of lacquer to the rim around the bottom of cans to protect the aluminum.

**11 Deco Oven**  
cures the inks and coatings.

**12 Internal Coaters**  
spray a thin layer of lacquer on the inside of the cans to protect product integrity.

**13 Internal Coater Oven**  
cures the internal coating.

**14 Waxer**  
applies a thin coat of lubricant to the outside of the open edge of the cans in preparation for necking.

**15 Die Necker**  
squeezes can openings down to end specifications.

**16 Flanger**  
Rolls back the top edge of the can to form a lip used to attach an end to the can after it is filled.

**17 Reprofile/ Reformer**  
can either reprofile the outer dome for 202 stackability or reform the inner dome for strength

**18 Light Tester**  
checks all cans for possible pinholes.

**19 Camera Inspection**  
checks all cans for any internal damage.

**20 Palletizer**  
places finished cans on pallets, 389 cans per layer up to 21 layers high, for immediate shipment or storage.

**Filled Can**  
After being shipped to customer, the cans are filled at high speeds and the ends are attached.