

TECHNICAL DATASHEET

LACQUERED AND PRINTED TINPLATE AND TIN FREE STEEL

1. DESCRIPTION

Lacquered and Printed Tinplate (ETP) and Tin Free Steel (TFS) are a low carbon steel plate which have been coated or printed with polymeric coatings and inks, respectively. Those materials are commonly used for cans and cans component production, both for food (sanitary) and industrial applications.

The material is processed (coated and/or printed) according to the end use or design specified by the customer.

2. USES

Lacquered and printed ETP and TFS allow the brands to have a distinctive design in their cans, enhance the value of the product and help to keep the internal content stable.

This material can be used for stamped parts, lids and ends, oval and cylindrical two or three pieces cans, rectangular cans and crown caps for soft drinks and beer.

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3.0 TECHNICAL SPECIFICATIONS.

Almost all technical specifications for those material are related to ETP and TFS, except those specifications related to lacquers and inks. Please refer to ETP or TFS technical data sheet.

3.1 COATINGS AND INKS

Each case has to be confirmed between end user and supplier, however we can have availability of almost all coatings and inks global brands. In general terms, the following type of coatings and inks can be applied:

- Epoxyphenolic
- Epoxyester
- Organosol
- Polyester
- Acrylic
- Conventional inks (thermal inks).

3.2 LACQUERED AND PRINTED SHEETS AVAILABILITY

3.2.1. PACKAGES PRESENTATION

Lithographed sheets (Press)

Width	mm	710	1130
Length	mm	510	960
Maximum printing area	mm	1130 (Width)	945 (Lenght)
Package weight	Kg	N/A	2500
Package height	mm	N/A	450

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Lacquered sheets			
Width	mm	710	1130
Length	mm	510	970
Maximum printing area	mm	1130 (Width)	970(Length)
Package weight	Kg	N/A	2500
Package height	mm	N/A	450

4.0 RECOMMENDATIONS AND PRODUCT HANDLING.

- For maximum usage of the raw material, the following recommendations should be followed:
- ·The material should be stored in a humidity-free environment to prevent and risk of oxidation.
- ·Oxidation is the result of the interaction among the iron, exposed through imperfections in the coating, water (humidity) and oxygen in the air.
- ·To prevent oxidation it is necessary to take care when transporting, storing and handling the material by following these precautions:
- ·Demand appropriate transportation, with vehicles that have floors and roofs in good condition
- Inspect one hundred percent of each production order to check the general status of the packaging

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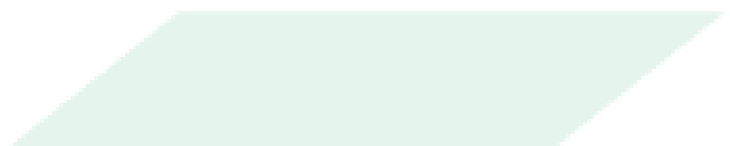
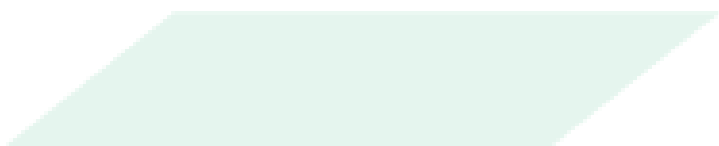
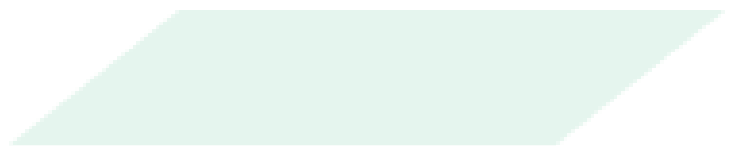
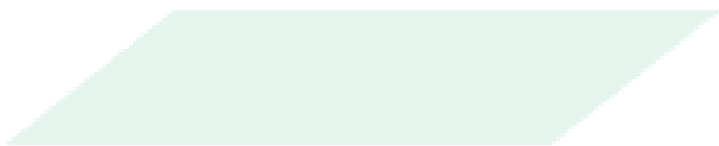
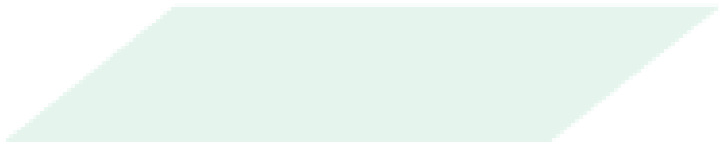
- Never leave the material outdoors
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- Store the material in closed warehouses with low relative humidity. In coastal areas or lots of rainfall, it is advisable to use equipment to reduce relative humidity to acceptable levels.
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- Do not store material without appropriate packaging
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- Do not make piles higher than 2.50 m.
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- Never handle material without gloves. The humidity and salts in perspiration attack material very quickly
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- If the material bundles have to be inspected, they should be covered again for storage. If humidity is seen during inspection, it is advisable to use that material immediately to prevent the oxidation process.
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- Use material immediately after opening it.
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- In production processes that use material and require cuts, the resulting parts should not be stored for a long time because the edges do not contain tin and become quickly oxidized
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- Special care should be taken in handling and fabrication of cans and caps to avoid scratching the material.
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- Do not rub the material with abrasive material or use inorganic liquids to clean it. Use cotton and a solvent compatible with the lacquer or ink that is going to be used.

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- Material storage should be as follows:
 - In general the lots with greater area or quantity should be located in the stack's lower side
 - Stack height should be necessary enough to keep visual control to avoid injuries. Moreover, the stability due the base/height and floor capacity resistant should be considered.



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