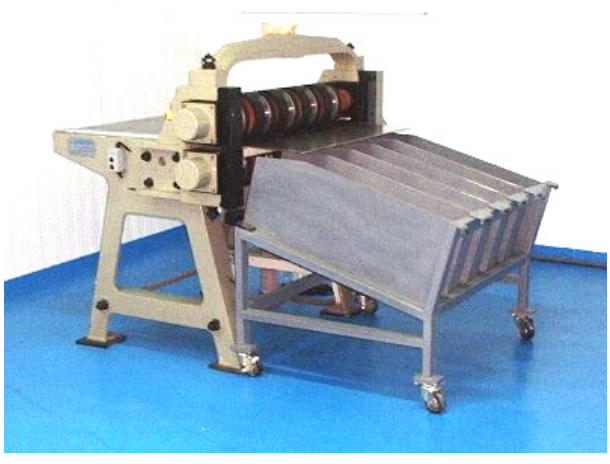
ALUMINUM ROPP CAP MANUFACTURING PROCESS

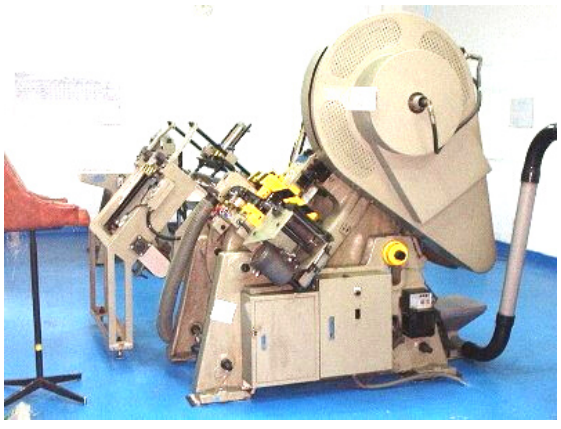


STAGE 1: SLITTING

Upon examination or inspection, aluminum sheets pass on slitting machine manually wherein sheets are being cut by means of two rotating shear cutters.

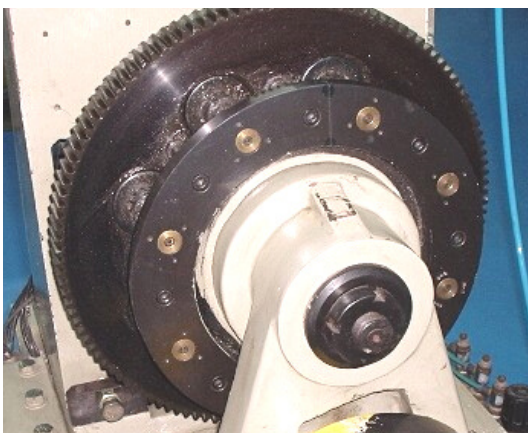
STAGE 2: BLANKING

Slitted sheets are drawn/formed into blanked caps and cut to size in one action called punching." Blanked caps will be sent to the deburring machine while the skeleton sheets will be sent to waste bin.



STAGE 3: CLEANING

Rings are separated from blanked caps by means of a cylindrical cage which rotates and simultaneously cleans and deburrs the caps. The deburred blanked caps will be sent to the storage tank while rings to waste bin.



STAGE 4: ROLLING

Forming of principal parts of the caps (knurl, grooves, beads, perforation, bridges and skirt)) happen in this stage. It is done by means of inner and outer forming dies which in a single meshing action, all parts are formed.

STAGE 5: LINER INSERTION

Using mechanical links, dispensed liners from the hopper are positioned at the top of the rolled caps by pusher plate. A vertical plunger then moves the liner downward onto the rolled cap. Rolled caps enter and exit the liner insertion machine by means of conveyor belt

STAGE 6: CAPPING MACHINE TEST

All caps undergo on the capping machine to test for its proper sealing and fitting to the bottle.