



1 Compound placement may extend up to the cut edge at a given point but should not exceed .50 inch total length along the cut edge.

300 OFFSET RIVET			
A	CURL DIAMETER	(in)	3.229 ± .010
B	CURL HEIGHT	(in)	.100 ± .005
C	INSIDE CURL DIAMETER	(in)	3.134 MIN
D	COUNTERSINK DEPTH	(in)	.297 ± .005
E	COMPOUND EDGE WIDTH	(in)	.040 ± .023
F	COMPOUND BAND WIDTH	(in)	.162 ± .038
	COMPOUND WEIGHT		48 ± 5 mg
		BEER	BEVERAGE
	BUCKLE PRESSURE	93 psi min	90 psi min
	POP	5.5 lbs MAX	
	PUSH	6 lbs MAX	
MATERIAL THICKNESS INFO			
	UNCOATED	(in)	.0142 ± .0002
	BEVERAGE COATING	(in)	.0146 ± .0003
	BEER COATING	(in)	.0144 ± .0003



METAL BEVERAGE CONTAINER OPERATIONS
 9300 W. 108TH CIRCLE
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300 OFFSET RIVET
BEER / BEVERAGE
.0142 GAUGE
MANUFACTURING SPECIFICATION

PRODUCT STANDARD

END-316

DATE CREATED 8/28/14
 APPROVED *[Signature]*
 CREATED BY ZANETELL
 APPROVED *[Signature]*

DATE REVISED
 REV. A