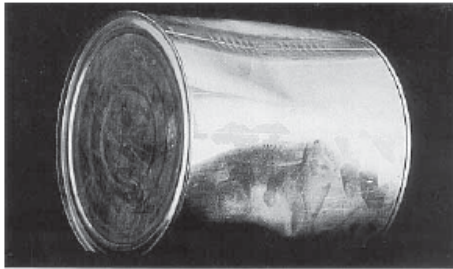


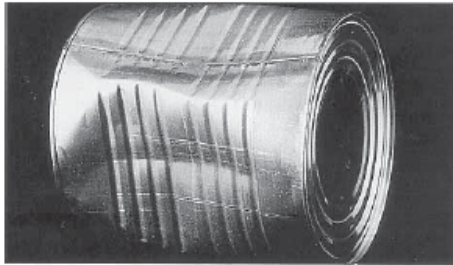
# HOW TO SPOT Visible CAN Defects

Defective cans may leak and allow micro-organisms to enter that may cause botulism and other forms of foodborne illness. The following examples of defective cans may help you recognize these potential hazards.

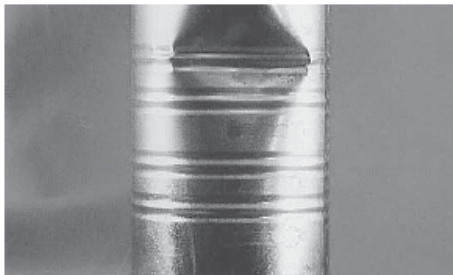
*See reverse side for definitions of defects.*



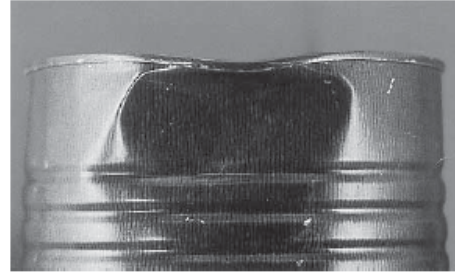
- 3 Panned non-beaded can. Materially affecting appearance, but not integrity, no plate fractures.



- 3 Panned, beaded can. Materially affecting appearance, but not integrity, i.e. no plate fractures.

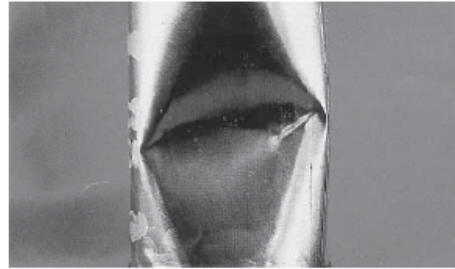


- 3 Moderate Denting. Double seam distorted, but not affected materially.



- 2 Severe body dent has affected double seam. Observe for fractured plate.

- 1 If fractured.



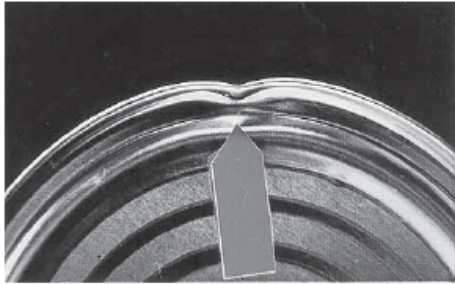
- 2 Severe body dent. Observe for fractured plate.

- 1 If fractured.



- 3 If the body dent does not significantly affect the side seam or double seams.

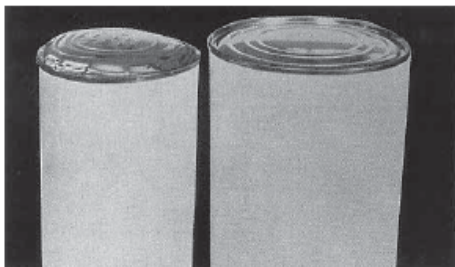
- 2 If side seam or double seams are significantly affected.



- 3 Double seam dent if not creased or sharp.
- 2 If creased or sharp.



- 3 Double seam not severely damaged.



- 1 Gas formation in can which causes one or both ends to swell producing a flipper, soft swell, hard swell, or blown can. Hold for investigation.

*Adapted from "Classification of Visible External Can Defects", AOAC International in cooperation with the Food and Drug Administration.*

## Definitions of Defects

Number ratings are used throughout for simplification.

If two classifications are given under a photo, the first classification listed is for the pictured defect.

From visual examination, if presence of microbial growth or evidence of loss of hermetic seal is in question (Class 1 or 2), the container must be examined in the laboratory.

- 1 Defects which provide evidence that the container has lost its hermetic seal (e.g., holes, fracture, punctures, product leakage, etc) or evidence that there is, or has been, microbial growth in the can contents.
- 1 is a critical defect rating which would be considered a potential public health problem. Any lot which is found to have a (1) defect must be set aside and thoroughly inspected and sorted to ensure that no containers that have lost their hermetic seal are distributed.
- 2 Defects that result in cans which do not show visible signs of having lost their hermetic seal, but are of such magnitude that they may have lost their hermetic seal.
- 2 is a major defect which may result in the loss of the hermetic seal and become a public health problem. Even though a (2) defect may not be health threatening by itself, a large number of cans with (2) defects necessitates more extensive sampling of such lots before sale. Evidence of a significant number of (2) defects may be considered a potential public health problem.
- 3 Defects which have had no adverse effect on the hermetic seal.
- 3 is a defect of minor significance from a public health standpoint. Examples shown here are not concerned with defects that only affect commercial sale. For example, dented cans which will not stack on shelves may be rated as a (3) when neither the double seam, side seam nor the body has been adversely affected. If the effect on the hermetic seal cannot be determined, sampling and examination would be appropriate.