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Visual Aids for Composite Container Defects

December 2019

This issue of the Visual Aids for Inspection of Composite Containers as applied to the United States Standards for Condition of Food Containers is the first issue.

This publication contains illustrations of defects applicable to the examination of the exterior condition of filled composite food containers under the United States Standards for Condition of Food Containers. They are intended for use as references by inspectors, graders, and others in interpreting and applying the Standards. Since the examination of such containers under the Standards also includes an examination of label or markings on the containers, illustrations of labeling and marking defects are included. The tables from the Standards which lists exterior composite container, labeling, and marking defects are shown on the next page.

In a few instances, an illustration shows the upper or lower limit of a defect. Otherwise, each illustration is considered to be a “typical” representation of the indicated defect.

The legend accompanying each illustration explains, in general terms, the reason(s) for the classification of the defect as critical, major, minor, or insignificant. It also identifies each illustration which shows the upper or lower limit of a defect. Standards for Condition for Food Containers is issued by the U.S. Department of Agriculture (USDA) after careful consideration of all data and views submitted during rulemaking. The Department welcomes suggestions for improving the standards in future revisions. Comments may be submitted to, and copies of the standards and visual aids obtained from:

Director, Specialty Crops Inspection Division Specialty Crops Program
USDA, Agricultural Marketing Service
1400 Independence Avenue, SW, STOP 0240
Washington, D.C. 20250

Authority: 7 U.S.C 1621-1627.

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DEFECT TABLES

Reminders:

- Related defects are defects on a single container that are related to a single cause. Only the most serious defect is scored.
- Unrelated defects are defects on a single container that result from separate causes. Each unrelated defect is scored.
- If there is a doubt as to whether defects are related or unrelated, score the defect as related using the most serious category of defects.

Type V – Composite Containers

Defects	Categories		
	Critical	Major	Minor
Type or size of container or component parts not as specified	None permitted.		
Closure incomplete, not located correctly or not sealed, crimped, or fitted properly	1		
Dirty, stained or smeared container			201
Easy open closure:			
(a) Missing or broken pull tab		101	
(b) Missing or incomplete score line		102	
Membrane top:			
(a) Poor seal (wrinkle, entrapped matter, etc.)		103	
(b) Short pull tab		104	
(c) Missing pull tab		105	
(d) Torn pull tab		106	
Open top with plastic overcap (when required):			
(a) Plastic overcap missing		107	
(b) Plastic overcap warped (making opening or reapplication difficult)		108	
Outside tinplate or coating on ends (when required):			
(a) Missing or incomplete			202
(b) Blistered, flaked, sagged, or wrinkled			203
(c) Scratched or scored			204
(d) Fine cracks			205
Collapsed container		109	
Paneled side materially affecting appearance but not usability			206
Leaker	2		
Wet or damp:			
(a) Materially affecting appearance but not usability			207
(b) Materially affecting usability		110	
Crushed or torn area:			
(a) Materially affecting appearance but not usability			208
(b) Materially affecting usability		111	

Table XI – Label, Marking, or Code

Defects	Categories	
	Major	Minor
Not specified method	101	
Missing (when required)	102	
Loose or improperly applied		201
Torn or mutilated		202
Torn or scratched, obliterating any markings on the label	103	
Text illegible or incomplete		203
Incorrect	104	
In wrong location		204

COMPOSITE CONTAINER DEFECTS

Misassembly/Incomplete Seam



Table V – Defect No. 1, Critical defect. End is not completely connected to the composite container.

Photograph was provided and printed with permission from Sonoco Products Company.

Misassembly/Incomplete Seam

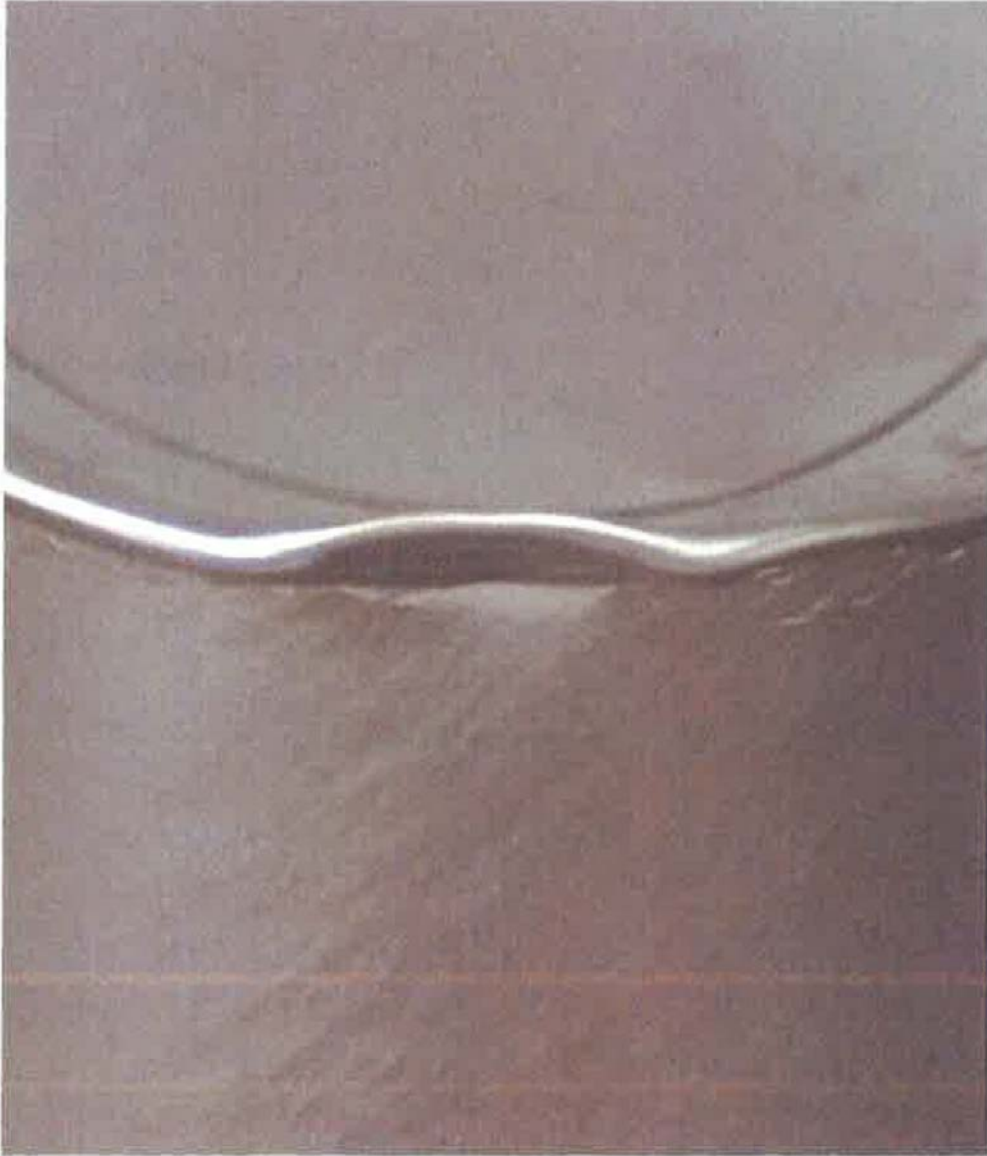


Table V – Defect No. 1, Critical defect. End is not completely connected to the composite container.

Photograph was provided and printed with permission from Sonoco Products Company.

Misassembly/Incomplete Seam



Table V – Defect No. 1, Critical defect. End is not completely connected to the composite container.

Photograph was provided and printed with permission from Sonoco Products Company.

Dirty, Stained, or Smearred Container



Table V – Defect No. 201, Minor defect. Any foreign material on the outside of the can other than glue from the label.

Photograph was provided and printed with permission from Sonoco Products Company.

Dirty, Stained, or Smearred Container



Table V – Defect No. 201, Not scorable. This photo shows label glue squeezing out at the overlap.

Photograph was provided and printed with permission from Sonoco Products Company.

Collapsed Container



Table V – Defect No. 109, Major defect. Top edge of the body wall collapsing.

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Wet or Damp Container



Table V – Defect No. 110, Major defect. Wet container materially affecting the usability of the product inside.

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Crushed or Torn Area - Unstuck Label



Table V – Defect No. 208, Minor defect. The label is not adhering to the body wall of the container.

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LABEL, MARKING, OR CODE

Torn or Mutilated, or Torn or Scratched, Obliterating any Markings on the Label



Table XI – Insignificant defect, Upper limit – not scored. Label torn or mutilated. If such a small tear obliterates any important text such as the ingredients or declared contents statement, the defect shall be classed as Defect No. 202 – Minor defect (nonmilitary purchases) or Defect No. 103 – Major defect (Military purchases).

Torn or Mutilated, or Torn or Scratched, Obliterating any Markings on the Label



Table XI – Defect No. 202 – Minor defect (nonmilitary purchases). Defect No. 103 – Major defect (Military purchases).

Text Illegible or Incomplete

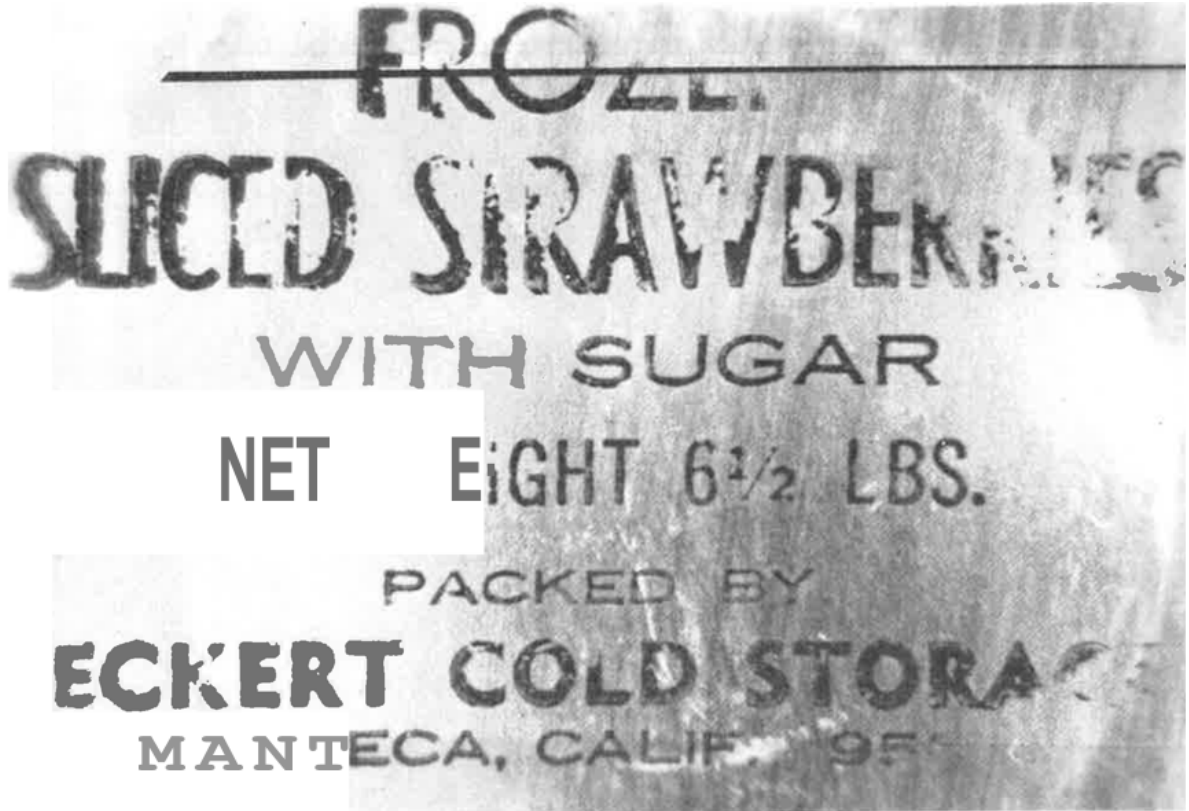


Table XI – Text or label illegible or incomplete. Insignificant defect – not scored.

Text Illegible or Incomplete

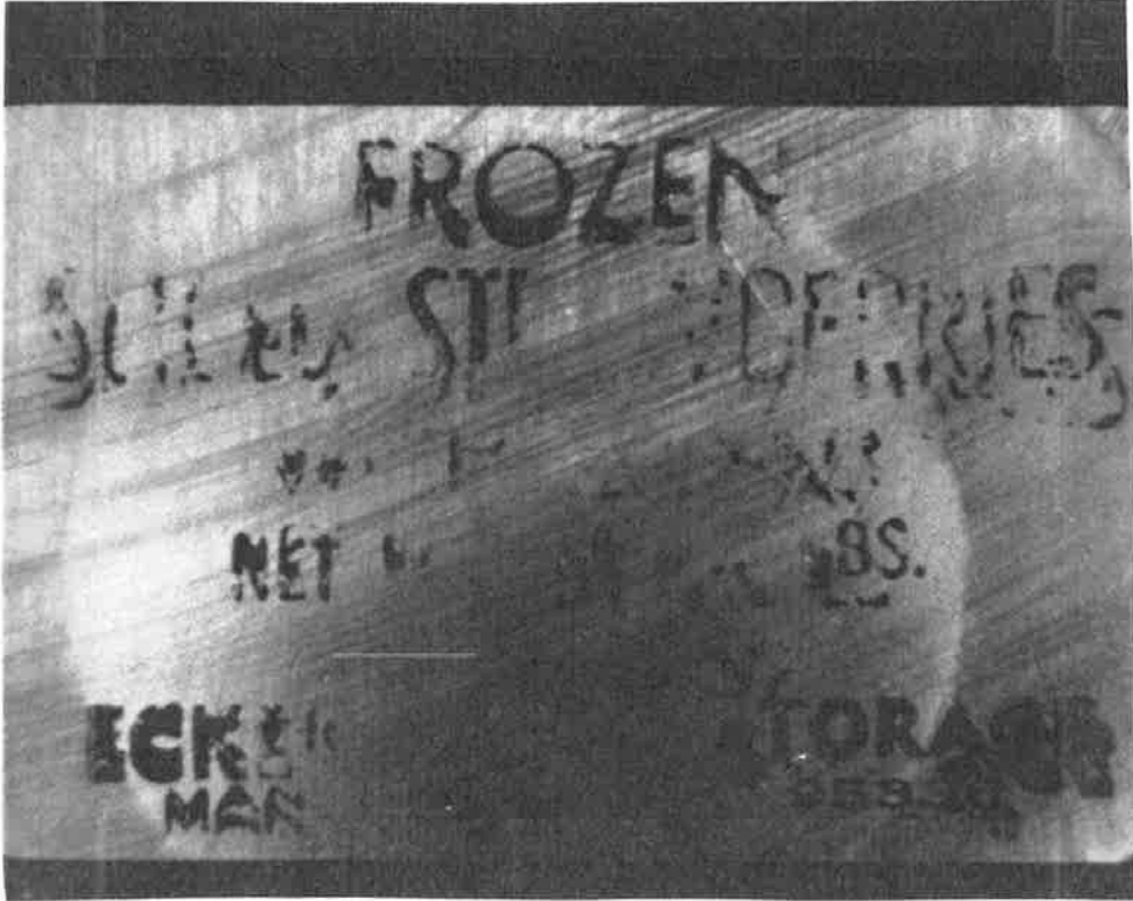


Table XI – Defect No. 203 – Minor defect. Defect No. 103 – Major defect (Military purchases).