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U.S. DEPARTMENT OF AGRICULTURE

**CONTAINER EXAMINATION WORKSHEET**

TABLE IV – METAL CONTAINERS

PRODUCT		TYPE AND SIZE OF CONTAINER	
LOT NO	LOT SIZE*	CONTRACT NO.	

Name and Address of Applicant	INSPECTION STATUS OF LOT*	INSPECTION POINT
	<input type="checkbox"/> ORIGINAL <input type="checkbox"/> RESUBMITTED *As stated by applicant.	

CODES AND APPROXIMATE NO. OF CONTAINERS PER CODE\* ADDITIONAL CODES SEE REVERSE

SAMPLING PLAN USED	No. of Sample Units	CRITICAL		MAJOR		TOTAL (Minor, Critical, and Major Defects)	
		AQL: 0.25		AQL: 1.5		AQL: 6.5	
		If other specify		If other specify		If other specify	
<input type="checkbox"/> Normal	CODE _____	Ac	Re	Ac	Re	Ac	Re
<input type="checkbox"/> Tightened	First Sample						
<input type="checkbox"/> Reduced	Second Sample						
	Total Sample						

Defect No.	Type of Defect	1 <sup>st</sup> Sample	2 <sup>nd</sup> Sample	Defect No.	Type of Defect	1 <sup>st</sup> Sample	2 <sup>nd</sup> Sample
	Type or size of container or component parts not as specified	NONE PERMITTED				Minor	
1	Closure incomplete, not located correctly or not sealed, crimped, or fitted properly: (a) Heat processed primary container	CRITICAL		209	RUST: (rust stain confined to the top or bottom double seam or rust that can be removed with a soft cloth is not scored as a defect) (a) Rust stain		
101	(b) Non-Heat processed primary container	MAJOR					
201	(c) Other than primary container	Minor		112	(b) Pitted rust	MAJOR	
202	Dirty, stained, or smeared container	Minor		210	Wet cans (excluding refrigerated containers)	MAJOR	
102	KEY OPENING METAL CONTAINERS (when required): (a) Key missing	MAJOR		211	DENT: (a) Materially affecting appearance but not usability	Minor	
103	(b) Key does not fit tab	MAJOR		113	(b) Materially affecting usability	MAJOR	
104	(c) Tab of opening band insufficient to provide accessibility to key	MAJOR		212	BUCKLE: (a) Not involving end seam	Minor	
105	(d) Improper scoring (band would not be removed in one continuous strip)	MAJOR		114	(b) Extending into the end seam	MAJOR	
106	METAL POP-TOPS: (a) Missing or broken pull tab	MAJOR		115	Collapsed container	MAJOR	
107	(b) Missing or incomplete score line	MAJOR		213	Paneled side materially affecting appearance but not usability	Minor	
108	FLEXIBLE POP-TOP: (a) Poor seal (wrinkle, entrapped matter, etc.)	MAJOR		116	Solder missing when required	MAJOR	
203	(b) Short pull tab	Minor		117	Cable cut exposing seam	MAJOR	
109	(c) Missing pull tab	MAJOR		118	Improper side seam	MAJOR	
204	(d) Torn pull tab	Minor		2	Swell, springer, or flipper (not applicable to gas or pressure packed product nor frozen products)	CRITICAL	
110	OPEN TOP WITH PLASTIC OVERCAP (when required): (a) Plastic overcap missing	MAJOR		3	Leaker or blown container	CRITICAL	
111	(b) Plastic overcap warped (making opening or reapplication difficult)	MAJOR		214	FROZEN PRODUCTS ONLY: (a) Bulging ends 3/16-inch to 1/4-inch beyond lip	Minor	
205	OUTSIDE TEMPLATE OR COATING (when required): (a) Missing or incomplete	Minor		119	(b) Bulging ends more than 1/4-inch beyond lip	MAJOR	
206	(b) Blistered, flaked, sagged, or wrinkled	Minor		4	METAL DRUMS: Leaking filling seal (bung) swell <sup>1</sup>	CRITICAL	
207	(c) Scratched or scored	Minor		120	Leaking filling seal (bung) swell <sup>1</sup>	MAJOR	
208	(d) Fine cracks	Minor			<sup>1</sup> Defect classification depends on the severity of the defect		

REMARKS

TABLE XI – LABEL, MARKING, OR CODE

101	Not specified method	MAJOR		202	Torn or mutilated	Minor	
102	Missing <i>(when required)</i>	MAJOR		203	Text illegible or incomplete	Minor	
103	Torn or scratched, obliterating any markings on the label	MAJOR		204	In wrong location	Minor	
104	Incorrect	MAJOR		OTHER (Specify)			
201	Loose or improperly applied	Minor					
First sample	Minor	Major	Critical	Total	ACTION TAKEN BASED ON FIRST SAMPLE		
					<input type="checkbox"/> LOT ACCEPTED <input type="checkbox"/> LOT REJECTED <input type="checkbox"/> SECOND SAMPLE		
Second sample					ACTION TAKEN ON SECOND SAMPLE (If required)		
					<input type="checkbox"/> LOT ACCEPTED <input type="checkbox"/> LOT REJECTED		
Grand total							
DATE INSPECTED					SIGNATURE OF INSPECTOR <i>(Print and Sign Name)</i>		

ADDITIONAL CODES

CONTAINER EXAMINATION WORKSHEET FOR INTERIOR DEFECTS

TABLE XII – INTERIOR CONTAINER DEFECTS <sup>2</sup>

101	De-tinning in metal container materially affecting usability	MAJOR		201	De-tinning metal container not materially affecting usability	Minor	
102	Enamel missing <i>(when required)</i> in metal container	MAJOR		202	Black spots in metal container	Minor	
103	Enamel breakdown in metal container material affecting usability	MAJOR		203	Enamel breakdown in metal container material not affecting usability	Minor	
104	Other defect(s) of the interior of the container (metal, plastic, paper, rigid, etc.) e.g., interior damage, tear, delamination, missing layer, off-odor, interior blisters, etc. that materially affects usability	MAJOR		204	Defect(s) of the interior of the container (Metal, plastic, paper, rigid, etc.) e.g., interior damage, tear, delamination, missing layer, off-odor, interior blisters, etc. that materially affects appearance, but not usability	Minor	
				OTHER (Specify)			

<sup>2</sup> Acceptance Numbers for Selected Sample Sizes for Interior Container Defects Found when Using Quality Samples are below:

Sample Size (n = number of containers)	Major		Total	
	Interior Defects		Interior Defects	
	Ac	Re	Ac	Re
n - 13	0	1	2	3
n - 21	1	2	3	4
n - 29	1	2	4	5
n - 38	2	3	5	6
n - 48	2	3	6	7
n - 60	2	3	7	8

Interior Defect Summary	Minor	Major	Total	ACTION TAKEN			
				<input type="checkbox"/> LOT ACCEPTED <input type="checkbox"/> LOT REJECTED			
DATE INSPECTED				SIGNATURE OF INSPECTOR <i>(Print and Sign Name)</i>			