



We package customers dreams™

CAN SLEEVING GUIDE



SAXCO SLEEVING

Saxco works with craft beverage brand owners of all sizes, and we work in markets that include RTDs, energy drinks, craft beer, kombucha, coffee and cannabis-infused beverages. With our in-house experts, quality assurance procedures, and new artwork management system, we set the standard for quality can sleeving. In addition, Saxco offers our services in three (3) locations across the United States making us your regional beverage partner.

- **Improved Shelf Appeal:** While the direct can printing process can limit the color and the design of your can, sleeves provide 360-degree high-resolution graphics coverage with a full-spectrum of colors, and tactile finishes such as matte, gloss and foil treatments.
- **Quicker Turnaround Times:** Shrink-sleeves get your product to market in a fraction of the time for a printed can – usually several weeks instead of several months.
- **Increased Durability:** Can sleeves are printed on the inside of the film, providing protection against scratches and scuffs that can occur during production and transportation.
- **Lower Minimums:** MOQs can be in the truckloads for printed cans, while sleeved cans can be ordered in quantities as low as ½ pallet, allowing you to test and respond to your market with smaller runs.
- **More Flexibility:** Don't discard those cans – sleeves can be used to cover up existing printed cans on obsolete inventory, turning a loss into a money maker.



SAXCO SLEEVING CAPABILITIES

Saxco works with qualified suppliers to ensure we have the most robust capabilities nationally.

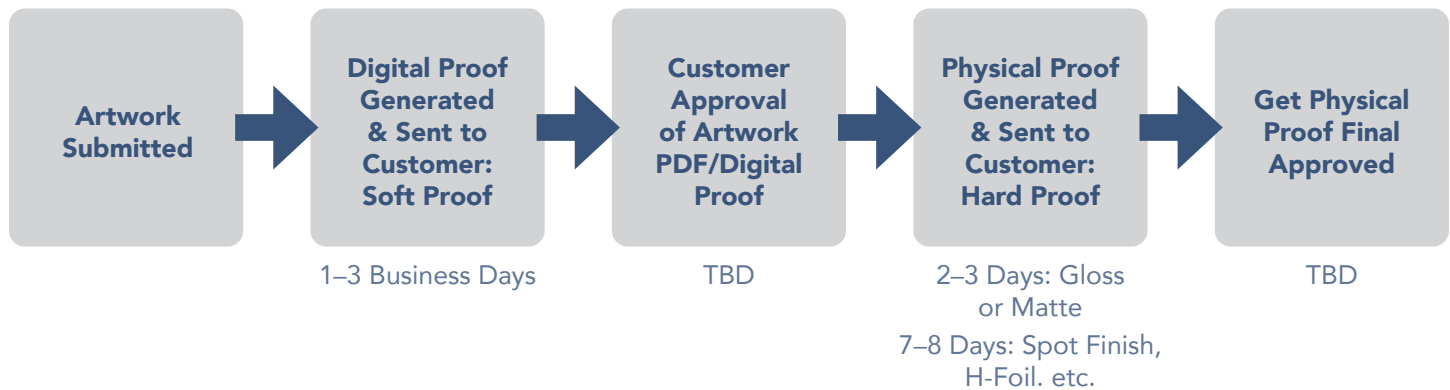
- **Gloss Finish:** PET substrate has a glossy finish; this is the standard.
- **Matte Finish:** After printing, film requires second pass to flood w/matte varnish. The matte varnish can also help with friction on a high-speed line.
- **Spot Matte:** Spot plate used to prevent varnish from covering certain images or areas of can, e.g., logo. There is a one-time plate fee for spot matte.
- **Cover-Up:** Metallic backed substrate used to cover up graphics on customer provided direct print can. After initial printing, the film requires a second pass to apply foil backing to the sleeve. The foil is full coverage behind the designs and white inks – can be done in both Gloss and Matte finish.
- **Double Varnish:** Bump on varnish that helps with high-speed lines greater than 200 cpm. After initial printing, film goes through second pass to apply varnish to outside of sleeve. Double varnish cannot be applied on Matte finish.
- **H-Foil:** Holographic foil substrate; background design chosen by customer and will print on top of H-foil.
- **Perforation:** Perforated sleeves can easily be removed by consumers, and we offer both single and double perforation options.

ARTWORK SPECIFICATIONS AND REQUIREMENTS

- **Artwork Approval:** Saxco encourages customers to ensure that their shrink sleeve artwork content meets appropriate federal or local laws. Saxco does not check for spelling, font, or content. Our main goal is to match all colors within industry standard tolerances against the approved soft or hard proof. For wines and RTDs, it is the customer's responsibility to understand and provide artwork associated with recycling redemption value.
- **Artwork Submission:** The art layout must be on a Saxco Sleeve dieline template. Dieline templates are specific to the capacity and type of can being used. These are available online at Saxco.com ([Shrink Can Sleeve Design Templates | Saxco](http://Saxco.com)).
 - The Artwork file needs to be Adobe Illustrator with high resolution vector graphics or high-resolution editable PDFs. Native files are preferred over PDF files.
 - All text fonts need to be outlined by the customer.
 - Colors should be provided in CMYK color mode for digital printing. Pantone and RGB colors will be converted to CMYK, 4 color process.
 - If Pantone inks are a necessity, please advise, and we will need to use flexographic or rotogravure print process.
 - White layer coverage needs to be noted – for either full coverage or partial.
 - Outer finish needs to be noted, e.g., matte or gloss, spot or full coverage.
 - Vertically orient UPC to minimize distortion.
- **Saxco Logo:** It is required that the Saxco logo be added to all artwork files for quality tracking purposes. Please follow the logo instructions in the artwork requirements and on the Saxco prepared dielines when placing the logo into your artwork file. Saxco will place the logo on the customer's behalf if the logo is not included in the originally submitted art file.

ARTWORK SPECIFICATIONS AND REQUIREMENTS (CON'T)

- **Printing Capabilities:** Saxco can run projects in either flexo or digital print.
 - **Flexo:** Ideal for runs > 100K qty per sku; exact pantone color; ability to run up to 9 colors; incur costs per plate.
 - **Digital:** Ideal for short runs; clean/exact image; not as exact on color matches.
- **Proofing:** Saxco will provide emailed PDF soft proof as well as a physical hard digital printed proof for approval by the customer. In cases where the graphics are unusually complex, or colors are extremely sensitive, a pilot can also be sent for approval. Saxco requires that the customer signs off on the content of the final proof before proceeding to production.



ORDER PROCESS FOR SHRINK SLEEVED CANS

The Saxco ordering process for shrink sleeve cans is surprisingly simple:

- Fill out customer set up forms; these are available online at Saxco.com ([New Customer Application | Saxco](#))
- Drop art files into the appropriate pre-designed Saxco Sleeving dielines. These are available online at Saxco.com ([Shrink Can Sleeve Design Templates | Saxco](#))
- Soft proof approval (Final PDF proof) is required on all orders; hard proof can be requested for projects (either print sample or pilot can).
- Once artwork is approved, we can proceed with order requirements.

SPECIFICATIONS FOR SHRINK SLEEVED CANS

- **Lead Time:** Standard lead time is 4-5 weeks from final artwork proof being signed. Lead times are subject to change based on seasonality, order size, and finishes other than gloss finish. Please inquire with specific questions regarding the finish and quantity of your order.
- **Quantity Variations:** Unless otherwise provided on Seller's Order Form, underruns of up to five (5%) percent of the total amount of product designated on the Order Form shall conclusively be deemed to constitute fulfillment of the order. This standard and acceptable yield differential should be considered when placing order quantities.
- **Pasteurization:** When placing an order, make sure to let your Saxco Sales Representative know if you are pasteurizing after filling. We will select the highest performing film for pasteurization for your order. However, while we do have films that do better for pasteurization, we cannot guarantee films performance when you run through pasteurization and do not have liability.

SHIPPING GUIDELINES

Our national sleeving locations are as follows: Portland, OR; Anaheim, CA; and Marietta, GA.

- **Expedited Orders** – Production time permitting, and only with Saxco prior approval/confirmation, expedited orders may be produced with possible additional fees.
- **Shipping Materials (Dunnage)** – Pallets are stacked between 7 to 23 layers depending on can size and palletization option (full height, ¾ height for LTL shipments, or half height as requested on order form). Below is palletization for most common formats produced:

CAN FORMAT	1/2 PALLET	LTL SHIPMENT	FTL SHIPMENT
200 ml Sleek (586 per layer)	11 layers; 6,248 cans	20 layers; 11,360 cans	22 layers; 12,496 cans
8 oz Sleek (506 per layer)	12 layers; 6,072 cans	20 layers; 10,120 cans	23 layers; 11,638 cans
8.4 oz Sleek (586 per layer)	9 layers; 5,274 cans	16 layers; 9,376 cans	18 layers; 10,548 cans
12 oz Standard (389 per layer)	10 layers; 3,890 cans	18 layers; 7,002 cans	21 layers; 8,169 cans
12 oz Sleek (506 per layer)	8 layers; 4,048 cans	14 layers; 7,084 cans	16 layers; 8,096 cans
16 oz Standard (389 per layer)	8 layers; 3,112 cans	14 layers; 5,446 cans	16 layers; 6,224 cans
19.2 oz (389 per layer)	7 layers; 2,723 cans	11 layers; 4,279 cans	13 layers; 5,057 cans

- **Shipping Damage Procedure** – Saxco does offer the ability to wrap pallets in shrouds to help secure products for shipping. No matter how carefully cans are packaged and protected some cans may arrive dented and damaged. Please note that because of the fragile nature of cans and the need for them to be handled and transported, there is a standard 2% yield loss that should be taken into account when placing order quantities.

CAN MANUFACTURER GUIDELINES & REQUIREMENTS:

- **Corrosion Testing:** We strongly encourage companies to use a reputable testing facility to do corrosion and shelf-life testing.
- **Can Sanitization:** Saxco recommends that customers perform an inversion and sanitization of the cans prior to filling.
- **Container Storage:** Cans must be stored in temperatures < 30°C, in a clean, dry environment, without exposure to UV light for optimal storage to maintain the integrity of the can.
- **Filled Product Storage:** Inventory should be inspected regularly, and any damaged cans should be removed. Any water, moisture, or humidity, from the product or otherwise, will increase the likelihood of secondary corrosion to the can exterior and can cause damage to the can that may result in a failure of the can.

ALL OF THE REST:

All goods and services purchased by customer from Saxco are subject to Saxco's standard terms and conditions which can be found at www.saxco.com/resources/terms-conditions/.

- **Saxco Supply:** Saxco supplies can bodies and ends from multiple manufacturers (MCC, Ball, Envases, Crown, Ardagh) and is not responsible for how customers canning line or seaming equipment interacts with the cans that we provide, however, please feel free to contact us should you have any questions or concerns.



We package customers dreams™

CAN SLEEVING GUIDE

1-877-641-4003 | [saxco.com](https://www.saxco.com)