

<p style="text-align: center;"><b>SECTION X</b></p> <p style="text-align: center;"><b>LABELLING</b></p>
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*GMP 10.1 Prior to labelling, the filled and sealed cans shall be examined to remove defective, swollen, rusty, dirty and damaged cans. Filled and labelled cans shall be examined as they leave the labelling area prior to being placed in cartons for shipment, and any defective, or damaged cans removed.*

**REASON**

Every cannery produces some cans with defects. Except for problems which become evident during storage, the final stage of processing at which defective cans can be identified and removed is during labelling and casing. The processor must ensure that all cans are inspected for abnormalities. Some methods of finding defective cans employ single or double dud testing and checkweighing, as well as hand culling. The latter is sometimes the only method of finding some defects such as scrap in die, metal plate flaw or false seams.

All can handling equipment from the labelling area through to the warehouse must be operated in such a manner that container damage is avoided. Dents on can bodies or damage to container ends may result in closure defects and leaker spoilage. Rough handling or improperly adjusted or maintained runways or conveyors may result in punctures, seam defects, or leaking containers. Careful handling of containers must continue through palletizing, casing, and storage or warehousing; in these areas, container damage and leaker spoilage may result from improper equipment operation, careless fork lift operation or improper stacking procedures.