



Ardagh Metal Packaging - GAPP Graphics Guidelines Policy

Ardagh proprietary & confidential

Ardagh Beverage Group
Graphic Arts/Pilot Press (GAPP)
2520 Lively Blvd
Elk Grove Village, IL 60007
3/19/26

Ardagh's Graphic Arts/Pilot Press department (GAPP), using customer supplied, color-separated artwork, provides the pre-press graphics and printing plates necessary to produce the highest quality printed cans.

Ordering/charge policy

Prior to any artwork development or can order, please contact your Ardagh Account Manager. To set up a new account with Ardagh, please contact our Account Director: Carol Bremer at Carol.Bremer@ArdaghGroup.com. Charges for development, proofing or reproofing may apply.

Artwork development procedure

Customer shall provide GAPP with fitted, color-separated artwork. Incomplete artwork may incur charges.

Color-separation: All artwork must be color-separated into no more than six (6) Pantone (solid coated) Matching System (PMS) colors for beverage can printing. White or black ink count against this total. Please note that we cannot accept artwork developed in 4-color process (aka CMYK). Artwork is to be submitted digitally in Adobe Illustrator Creative Cloud format with a composite PDF for reference.

Fitted artwork: Fitted artwork is defined as the required spacing between PMS colors to prevent ink overlap in the can printing process. Fits may be adjusted at GAPP due to various technical criteria.

Completed artwork proofs: Artwork proofs will first be submitted to the customer for approval via electronic transmission in PDF format via our SmartFlow online approval system. Customer shall review label graphics, wording, ingredients, UPC, and all other label details to ensure accuracy. These digital proofs are not for color matching.

Design changes: Design changes after PDF is approved will incur additional graphics charges and may delay the timing of label availability – both pilot line and production plant.

Color proofing

If the artwork received is for a new design, GAPP will determine if a color proofing is required. For all color proofs, GAPP will produce 1 set of color targets from the GAPP pilot decorator and send to the customer for review and approval.

- If there are existing cans in the market, please send them to GAPP for color matching.
- A new color proof will not be required for minor changes to existing graphics that have been previously color proofed. Ardagh will determine what changes constitute a re-color proof and any attendant charges that may apply.
- Color standards are set the day of the pilot. Customer representatives must have full authority to sign off on the standards for commercial production. Graphic designs are printed on straight walled cans. GAPP is located at 2520 W Lively Blvd, Elk Grove Village, Illinois 60007.
- Note: Cans produced on the pilot line are not fit for filling or consumption of any beverage. Color Standards set on the pilot line are produced on straight-walled cans only.

- Customer attendance is recommended. However, if the customer cannot attend, samples will be sent via FedEx for approval.
- Any changes to artwork after PDF creation and approval by customer may incur production delays and revision fees.
- Ardagh must receive final artwork before scheduling a pilot.
- Ardagh will not use plates supplied by the customer.

Design requirements

Please review the list below before sending in your artwork. By adhering to this, we can provide a quality product, reduce delays and eliminate additional changes and/or charges. If you should have any questions please contact GAPP.art@ArdaghGroup.com.

1. When sending in artwork files, please provide an identical PDF file for each design.
2. Use up to six (6) custom colors and not process colors (CMYK) in your separations.
3. Colors may not overprint.
4. Our software is Adobe Illustrator/Creative Suite Cloud. Submitted files must be compatible with this format.
5. Please outline your text or include the font files.
Note: Do not horizontally scale or condense fonts to the point of illegibility.
6. Place the design on a current Ardagh Group layout. The design must fit our type limits. If you need a layout, please visit the supplied [cloud storage site](#) or contact GAPP.art@ArdaghGroup.com.
7. Design must fit at least an 85% UPC symbol (standard or zero-suppressed); bars on printed cans must run horizontally (ladder-style).
8. Include a full set of UPC numbers assigned to design and space for at least 85% symbol.
9. Type must meet minimize size requirements (approx. 6pt; see Type Gauge document below).
10. Please specify the screen LPI and angle. No screen values less than 3% are visible on a printed can.
11. Please provide color information with the artwork (Pantone Matching System numbers and ink Transparency vs. Opacity) and if possible, a sample can to match for color.
12. Fitted artwork, the required spacing between PMS colors to prevent ink overlap in the can printing process, may be adjusted at GAPP due to various technical criteria. This needs to be least .003 of an inch around all colors (.005 of an inch if one of the colors is white) to prevent cross contamination of ink on the finished can. Any extremely fine detail smaller than .005 of an inch will be lost.

Example of fitted art

RAW ARTWORK - NOT FIT



.005" fit of aluminum between all colors



FIT ARTWORK



MINIMUM TYPE SIZE ALLOWED ON PLATE: 6 PT.

4 Pt. AaBbCcDdEeFfGgHh
5 Pt. AaBbCcDdEeFfGgHh

6 Pt. AaBbCcDdEeFfGgHh

7 Pt. AaBbCcDdEeFfGgHh

8 Pt. AaBbCcDdEeFfGgHh

9 Pt. AaBbCcDdEeFfGgHh

10 Pt. AaBbCcDdEeFfGgHh

4 Pt. AaBbCcDdEeFfGgHh
5 Pt. AaBbCcDdEeFfGgHh

6 Pt. AaBbCcDdEeFfGgHh

7 Pt. AaBbCcDdEeFfGgHh

8 Pt. AaBbCcDdEeFfGgHh

9 Pt. AaBbCcDdEeFfGgHh

10 Pt. AaBbCcDdEeFfGgHh

4 Pt. AaBbCcDdEeFfGgHh
5 Pt. AaBbCcDdEeFfGgHh

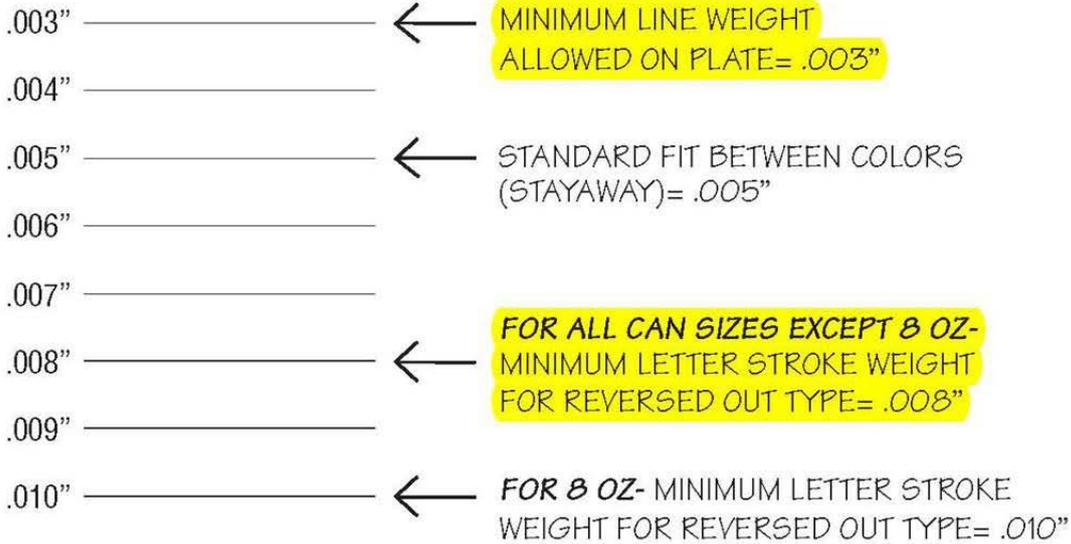
6 Pt. AaBbCcDdEeFfGgHh

7 Pt. AaBbCcDdEeFfGgHh

8 Pt. AaBbCcDdEeFfGgHh

9 Pt. AaBbCcDdEeFfGgHh

10 Pt. AaBbCcDdEeFfGgHh



ACCEPTABLE
TYPE > .003"
STROKE WEIGHT-

INGREDIENTS: CONTAINS

NOT ACCEPTABLE
TYPE < .003"
STROKE WEIGHT-

INGREDIENTS: CONTAINS

ALL SIZES (NOT 8 OZ.)
REVERSED OUT
TYPE > .008"
STROKE WEIGHT-

INGREDIENTS: CONTAINS

FOR 8 OZ. ONLY
REVERSED OUT
TYPE > .010"
STROKE WEIGHT-

INGREDIENTS: CONTAINS

