



Packing Final Assembly, Swedish Match

Packaging Final Assembly, Process Flow Diagram and Packaging Process, Swedish Match (Owensboro, Kentucky) for all, SM ID# 900510, 900520, 901510, 901520, 902510, 092520, 903510, 903520, 904510, 904520, 906510, 906520, 907510, 907520, 914510, 914520, 920510, 920520, 921510, 921520

INTRODUCTION

The manufacturing process for ZYN product described in this application is composed of two (2) processing stages, namely finished powder granulates (bulk) processing, and packing of finished product.

The packing of finished products includes packing of finished powder granulate into portion pouches that are packed into cans. Cans are wrapped into a roll as a retail unit, rolls are packed into cardboard boxes, and cardboard boxes are stacked on pallets and stored in a warehouse until shipping. A ZYN packaging final assembly process flow diagram is summarized in [Figure 1](#).

PACKING FINAL ASSEMBLY AND PACKAGING PROCESS

Finished powder granulate is transferred from the storage container to the pouch packing machine. (b) (4)

[REDACTED]

[REDACTED]

[REDACTED]

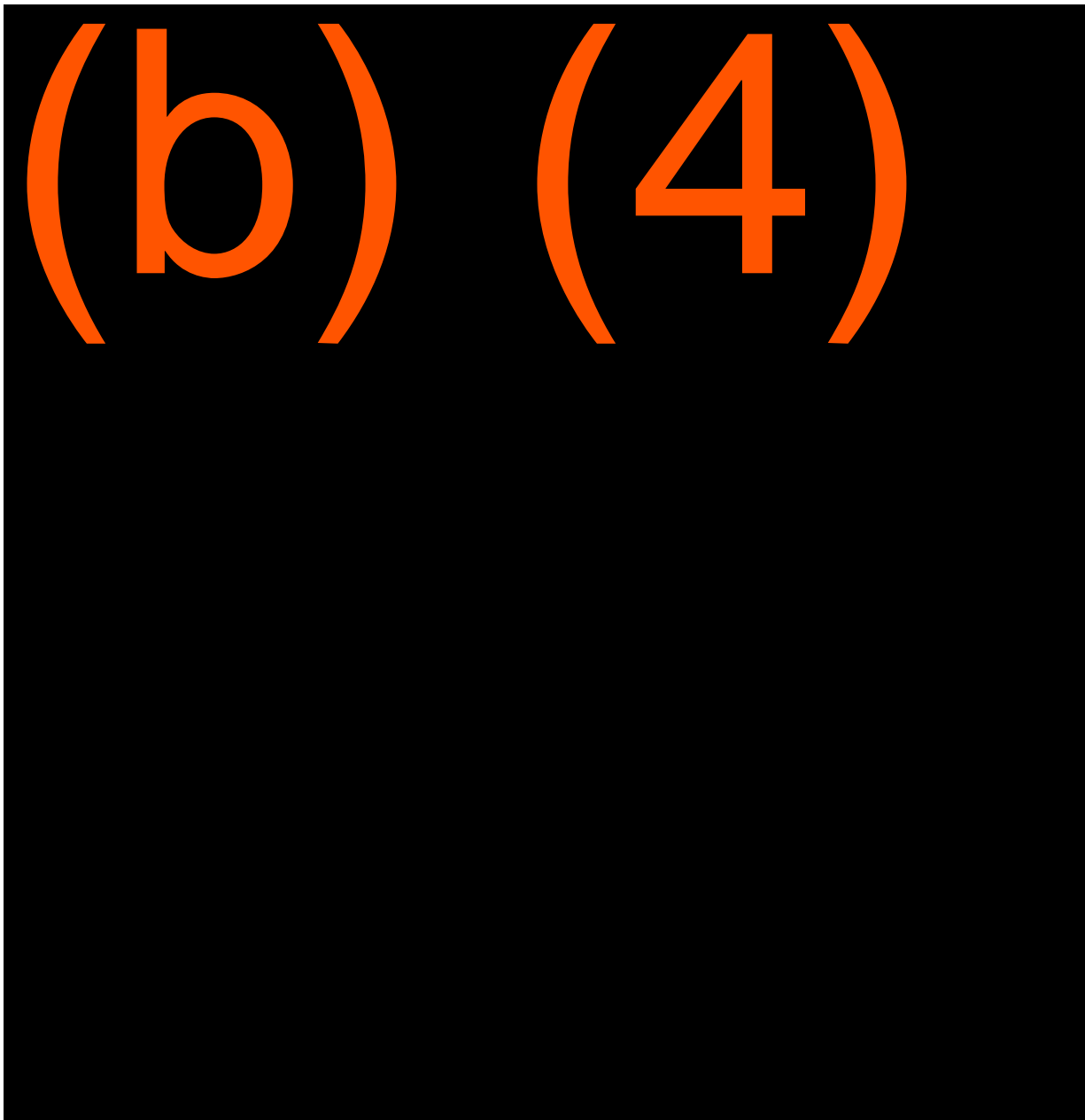
[REDACTED] The filled pouches at this stage are referred to as dry weight pouches, which is the final appearance of ZYN pouch products.

(b) (4)

[REDACTED]

[REDACTED] The approved cans are sealed with a side label and top and bottom labels are applied. Bottom labels are marked with the batch number and expiry date (see [Appendix A](#)). The packed cans are wrapped with a plastic shrink wrap as units (rolls) (see [Appendix B](#)). A roll label is applied and the units (rolls) are packed in a cardboard box (see [Appendix C](#)). Cardboard boxes are stacked on a pallet and transported to a warehouse.

Figure 1 **Packaging Final Assembly, Process Flow Diagram¹**



¹ Packaging Final Assembly, Process Flow Diagram for SM ID# 900510, 900520, 901510, 901520, 902510, 092520, 903510, 903520, 904510, 904520, 906510, 906520, 907510, 907520, 914510, 914520, 920510, 920520, 921510, 921520



Appendix A Example of ZYN bottom can labelling - U.S. and Sweden



Sweden



U.S.



Sweden

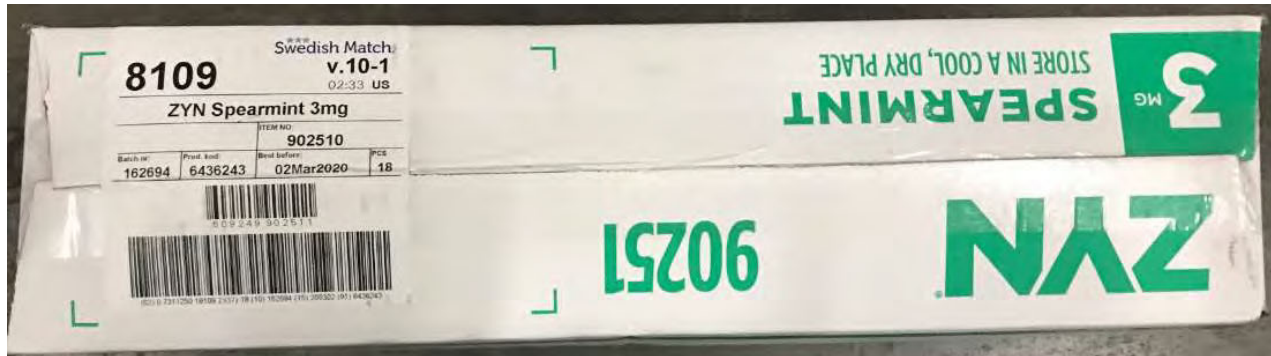


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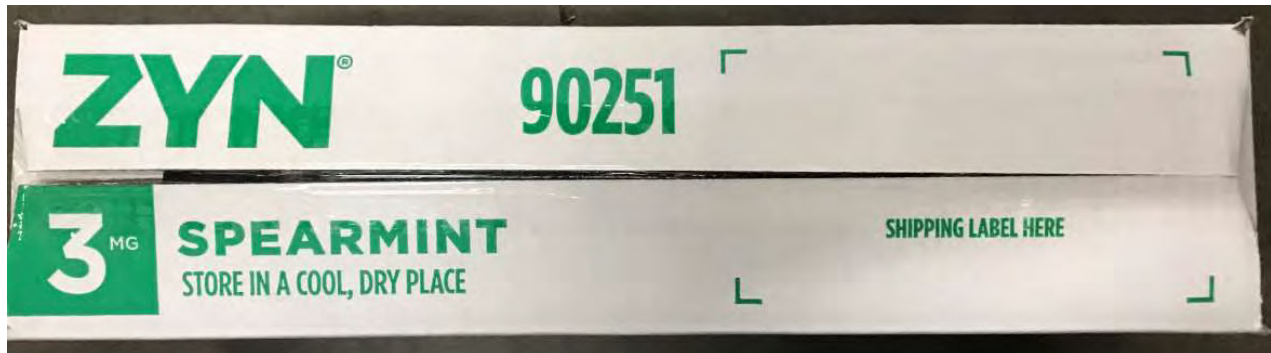
Assembly Flow Diagram

Swedish Match.

Appendix C ZYN case labelling - U.S. and Sweden



Sweden



U.S.

Swedish Match®

