

Crown and Closure Manufacturing: 2002

Issued December 2004

EC02-311-332115 (RV)

2002 Economic Census

Manufacturing

Industry Series



USCENSUSBUREAU

Helping You Make Informed Decisions

U.S. Department of Commerce
Economics and Statistics Administration
U.S. CENSUS BUREAU



CONTENTS

Introduction to the Economic Census	v
Manufacturing	ix
Tables	
1. Historical Statistics for the Industry: 2002 and Earlier Years ...	1
2. Industry Statistics for Selected States: 2002	2
3. Detailed Statistics by Industry: 2002	3
4. Industry Statistics by Employment Size: 2002.....	4
5. Industry Statistics by Primary Product Class Specialization: 2002	5
6a. Products Statistics: 2002 and 1997	6
6b. Product Class Shipments for Selected States: 2002 and 1997 .	--
7. Materials Consumed by Kind: 2002 and 1997.....	8
Appendixes	
A. Explanation of Terms	A-1
B. NAICS Codes, Titles, and Descriptions	B-1
C. Methodology	C-1
D. Geographic Notes	--
E. Metropolitan and Micropolitan Statistical Areas	--
F. Comparability of Product Classes and Product Codes: 2002 to 1997.....	F-1

-- Not applicable for this report.

Table 1. Historical Statistics for the Industry: 2002 and Earlier Years

[Data based on the 2002 Economic Census and the 2002 Annual Survey of Manufactures (ASM). For information on confidentiality protection, sampling error, nonsampling error, and explanation of terms, see note at end of table. For meaning of abbreviations and symbols, see introductory text]

Industry and year ¹	Com- panies ²	All estab- lish- ments ³	All employees		Production workers			Value added (\$1,000)	Total cost of materials (\$1,000)	Total value of shipments (\$1,000)	Total capital expendi- tures (\$1,000)	
			Number ⁴	Payroll (\$1,000)	Number ⁴	Hours (1,000)	Wages (\$1,000)					
332115, Crown and closure manufacturing	2002..	54	64	3 590	148 059	2 961	5 835	109 121	336 746	587 552	916 463	55 224
	2001..	N	N	4 526	158 874	3 357	6 330	107 342	359 052	519 950	889 625	21 167
	2000..	N	N	4 294	166 007	3 355	7 160	115 725	343 009	541 148	887 715	26 723
	1999..	N	N	4 107	158 597	3 461	7 521	119 444	329 043	565 114	896 325	30 796
	1998..	N	N	3 757	155 817	3 251	7 619	116 521	426 200	502 947	923 589	53 501
	1997..	55	66	4 576	161 511	3 787	7 949	120 527	430 618	519 503	953 864	51 421

¹Statistics presented for years ending in 2 and 7 are census data. Interim census years are derived in a representative sample of manufacturing establishments canvassed in the Annual Survey of Manufactures (ASM).

²For the census, a company is defined as a business organization consisting of one establishment or more under common ownership or control.

³Includes establishments with payroll at any time during the year.

⁴Number of employees figures represent average number of production workers for pay period that includes the 12th of March, May, August, and November plus other employees for payroll period that includes the 12th of March.

Note: The data in this table are based on the 2002 Economic Census and the 2002 Annual Survey of Manufactures (ASM). To maintain confidentiality, the Census Bureau suppresses data to protect the identity of any business or individual. The census results in this table contain sampling errors and nonsampling errors. Data users who create their own estimates using data from American FactFinder tables should cite the Census Bureau as the source of the original data only. For explanation of terms, see Appendix A. For full technical documentation, see Appendix C.

Table 2. Industry Statistics for Selected States: 2002

[States that are a disclosure or with less than 100 employees are not shown. Data based on the 2002 Economic Census. For information on confidentiality protection, nonsampling error, explanation of terms, and geographical definitions, see note at end of table. For information on geographic areas followed by *, see Appendix D. For meaning of abbreviations and symbols, see introductory text]

Industry and geographic area	E ¹	All establishments ²		All employees		Production workers			Value added (\$1,000)	Total cost of materials (\$1,000)	Total value of shipments (\$1,000)	Total capital expenditures (\$1,000)
		Total	With 20 employees or more	Number ³	Payroll (\$1,000)	Number ³	Hours (1,000)	Wages (\$1,000)				
332115, Crown and closure manufacturing												
United States.....	1	64	31	3 590	148 059	2 961	5 835	109 121	336 746	587 552	916 463	155 224
California	3	6	3	102	4 099	78	170	2 497	9 491	13 801	23 225	1520

¹Some payroll and sales data for small single-establishment companies with up to 20 employees (cutoff varied by industry) were obtained from administrative records of other government agencies rather than from census report forms. These data were then used in conjunction with industry averages to estimate statistics for these small establishments. This technique was also used for a small number of other establishments whose reports were not received at the time data were tabulated. The following symbols are shown where estimated data account for 10 percent or more of the figures shown: 1–10 to 19 percent; 2–20 to 29 percent; 3–30 to 39 percent; 4–40 to 49 percent; 5–50 to 59 percent; 6–60 to 69 percent; 7–70 to 79 percent; 8–80 to 89 percent; 9–90 percent or more.

²Includes establishments with payroll at any time during the year.

³Number of employees figures represent average number of production workers for pay period that includes the 12th of March, May, August, and November plus other employees for payroll period that includes the 12th of March.

Note: The data in this table are based on the 2002 Economic Census. To maintain confidentiality, the Census Bureau suppresses data to protect the identity of any business or individual. The census results in this table contain nonsampling errors. Data users who create their own estimates using data from American FactFinder tables should cite the Census Bureau as the source of the original data only. For explanation of terms, see Appendix A. For full technical documentation, see Appendix C. For geographical definitions, see Appendix D.

Table 3. Detailed Statistics by Industry: 2002

[Data based on the 2002 Economic Census and the 2002 Annual Survey of Manufactures (ASM). For information on confidentiality protection, sampling error, nonsampling error, and explanation of terms, see note 2 at end of table. For meaning of abbreviations and symbols, see introductory text]

Item	Value
332115, Crown and closure manufacturing	
Companies ¹	number.. 54
All establishments ²	number.. 64
Establishments with 1 to 19 employees	number.. 33
Establishments with 20 to 99 employees	number.. 15
Establishments with 100 employees or more	number.. 16
All employees ³	number.. 3 590
Total compensation	\$1,000.. 192 083
Annual payroll	\$1,000.. 148 059
Total fringe benefits	\$1,000.. 44 024
Production workers, average for year	number.. 2 961
Production workers on March 12	number.. 3 025
Production workers on May 12	number.. 2 988
Production workers on August 12	number.. 2 938
Production workers on November 12	number.. 2 888
Production worker hours	1,000.. 5 835
Production worker wages	\$1,000.. 109 121
Total cost of materials	\$1,000.. 587 552
Materials, parts, containers, packaging, etc., used	\$1,000.. 541 420
Resales	\$1,000.. 21 781
Purchased fuels	\$1,000.. 9 099
Purchased electricity	\$1,000.. 10 225
Contract work	\$1,000.. 5 027
Quantity of electricity purchased for heat and power	1,000 kWh.. 218 538
Quantity of electricity generated less sold for heat and power	1,000 kWh.. -
Total value of shipments	\$1,000.. 916 463
Primary products value of shipments	\$1,000.. 856 825
Secondary products value of shipments	\$1,000.. 27 210
Total miscellaneous receipts	\$1,000.. 32 428
Value of resales	\$1,000.. 26 363
Contract receipts	\$1,000.. -
Other miscellaneous receipts	\$1,000.. 6 065
Primary products specialization ratio	percent.. 97
Value of primary products shipments made in all industries	\$1,000.. 905 326
Value of primary products shipments made in this industry	\$1,000.. 856 825
Value of primary products shipments made in other industries	\$1,000.. 48 501
Coverage ratio	percent.. 95
Value added	\$1,000.. 336 746
Total inventories, beginning of year	\$1,000.. 104 446
Finished goods inventories	\$1,000.. 49 149
Work-in-process inventories	\$1,000.. 12 623
Materials and supplies inventories	\$1,000.. 42 674
Total inventories, end of year	\$1,000.. 110 300
Finished goods inventories	\$1,000.. 52 900
Work-in-process inventories	\$1,000.. 16 707
Materials and supplies inventories	\$1,000.. 40 693
Gross value of depreciable assets (acquisition costs) at beginning of year	\$1,000.. 467 675
Total capital expenditures (new and used)	\$1,000.. '55 224
Buildings and other structures (new and used)	\$1,000.. '7 154
Machinery and equipment (new and used)	\$1,000.. '48 070
Automobiles, trucks, etc., for highway use	\$1,000.. '211
Computers and peripheral data processing equipment	\$1,000.. '445
All other expenditures for machinery and equipment	\$1,000.. '47 414
Total retirements	\$1,000.. '41 072
Gross value of depreciable assets at end of year	\$1,000.. '481 827
Depreciation charges during year	\$1,000.. '33 419
Total rental payments	\$1,000.. 5 787
Buildings and other structures	\$1,000.. 4 018
Machinery and equipment	\$1,000.. 1 769
Total other expenses ⁴	\$1,000.. 56 189
Response coverage ratio ⁵	percent.. 83
Repair and maintenance services of buildings and/or machinery ⁴	\$1,000.. 19 353
Communications services ⁴	\$1,000.. 1 343
Legal services ⁴	\$1,000.. 608
Accounting, auditing, and bookkeeping services ⁴	\$1,000.. 257
Advertising and promotional services ⁴	\$1,000.. 970
Expensed computer hardware and supplies and purchased computer services ⁴	\$1,000.. 643
Refuse removal (including hazardous waste) services ⁴	\$1,000.. 1 436
Management consulting and administrative services ⁴	\$1,000.. 643
Taxes and license fees ⁴	\$1,000.. 4 332
All other expenses ⁴	\$1,000.. 26 603

¹For the census, a company is defined as a business organization consisting of one establishment or more under common ownership or control.

²Includes establishments with payroll at any time during the year.

³Number of employees figures represent average number of production workers for pay period that includes the 12th of March, May, August, and November plus other employees for payroll period that includes the 12th of March.

⁴Based on 2002 Annual Survey of Manufactures (ASM) sample data.

⁵A response coverage ratio is derived for this item by calculating the ratio of the weighted employment (establishment data multiplied by sample weight) for those Annual Survey of Manufactures (ASM) establishments that reported to the weighted total employment for all ASM establishments classified in this industry.

Note 1: The amounts shown for other expenses reflect only those services that establishments purchase from other companies.

Note 2: The data in this table are based on the 2002 Economic Census and the 2002 Annual Survey of Manufactures (ASM). To maintain confidentiality, the Census Bureau suppresses data to protect the identity of any business or individual. The census results in this table contain sampling errors and nonsampling errors. Data users who create their own estimates using data from American FactFinder tables should cite the Census Bureau as the source of the original data only. For explanation of terms, see Appendix A. For full technical documentation, see Appendix C.

Table 4. Industry Statistics by Employment Size: 2002

[Data based on the 2002 Economic Census. For information on confidentiality protection, nonsampling error, and explanation of terms, see note at end of table. For meaning of abbreviations and symbols, see introductory text]

Employment size class	E ¹	All establishments ²	All employees		Production workers			Value added (\$1,000)	Total cost of materials (\$1,000)	Total value of shipments (\$1,000)	Total capital expenditures (\$1,000)
			Number ³	Payroll (\$1,000)	Number ³	Hours (1,000)	Wages (\$1,000)				
332115, Crown and closure manufacturing											
All establishments	1	64	3 590	148 059	2 961	5 835	109 121	336 746	587 552	916 463	'55 224
Establishments with—											
1 to 4 employees	9	16	b	D	D	D	D	D	D	D	D
5 to 9 employees	8	9	58	2 439	50	108	1 986	6 501	7 014	13 515	'249
10 to 19 employees	2	8	112	5 115	83	180	3 461	14 826	15 494	29 854	'782
20 to 49 employees	5	8	238	8 523	194	401	5 890	20 327	25 454	45 735	'1 540
50 to 99 employees	1	7	506	20 875	406	798	15 259	71 885	55 328	128 337	'1 249
100 to 249 employees	—	15	2 336	96 712	1 930	3 935	70 379	230 362	418 583	639 724	'50 905
250 to 499 employees	—	1	e	D	D	D	D	D	D	D	D
500 to 999 employees	—	—	—	—	—	—	—	—	—	—	—
1,000 to 2,499 employees	—	—	—	—	—	—	—	—	—	—	—
2,500 employees or more	—	—	—	—	—	—	—	—	—	—	—
Administrative records ⁴	9	24	104	4 330	88	188	3 486	12 892	13 788	26 681	'484

¹Some payroll and sales data for small single-establishment companies with up to 20 employees (cutoff varied by industry) were obtained from administrative records of other government agencies rather than from census report forms. These data were then used in conjunction with industry averages to estimate statistics for these small establishments. This technique was also used for a small number of other establishments whose reports were not received at the time data were tabulated. The following symbols are shown where estimated data account for 10 percent or more of the figures shown: 1—10 to 19 percent; 2—20 to 29 percent; 3—30 to 39 percent; 4—40 to 49 percent; 5—50 to 59 percent; 6—60 to 69 percent; 7—70 to 79 percent; 8—80 to 89 percent; 9—90 percent or more.

²Includes establishments with payroll at any time during the year.

³Number of employees figures represent average number of production workers for pay period that includes the 12th of March, May, August, and November plus other employees for payroll period that includes the 12th of March.

⁴Some payroll and sales data for small single-establishment companies with up to 20 employees (cutoff varied by industry) were obtained from administrative records of other government agencies rather than from census report forms. These data were then used in conjunction with industry averages to estimate statistics for these small establishments. Data are also included in respective size classes shown.

Note: The data in this table are based on the 2002 Economic Census. To maintain confidentiality, the Census Bureau suppresses data to protect the identity of any business or individual. The census results in this table contain nonsampling errors. Data users who create their own estimates using data from American FactFinder tables should cite the Census Bureau as the source of the original data only. For explanation of terms, see Appendix A. For full technical documentation, see Appendix C.

Table 5. Industry Statistics by Primary Product Class Specialization: 2002

[Data based on the 2002 Economic Census. For information on confidentiality protection, nonsampling error, and explanation of terms, see note at end of table. For meaning of abbreviations and symbols, see introductory text]

Industry or product class code	Industry or primary product class	All establishments ¹	All employees		Production workers			Value added (\$1,000)	Total cost of materials (\$1,000)	Total value of shipments (\$1,000)	Total capital expenditures (\$1,000)
			Number ²	Payroll (\$1,000)	Number ²	Hours (1,000)	Wages (\$1,000)				
332115	Crown and closure manufacturing	64	3 590	148 059	2 961	5 835	109 121	336 746	587 552	916 463	'55 224
3321150	Crowns and closures	64	3 590	148 059	2 961	5 835	109 121	336 746	587 552	916 463	'55 224

¹Includes establishments with payroll at any time during the year.

²Number of employees figures represent average number of production workers for pay period that includes the 12th of March, May, August, and November plus other employees for payroll period that includes the 12th of March.

Note: The data in this table are based on the 2002 Economic Census. To maintain confidentiality, the Census Bureau suppresses data to protect the identity of any business or individual. The census results in this table contain nonsampling errors. Data users who create their own estimates using data from American FactFinder tables should cite the Census Bureau as the source of the original data only. For explanation of terms, see Appendix A. For full technical documentation, see Appendix C.

Table 6a. Products Statistics: 2002 and 1997

[Includes quantity and value of products of this industry produced by (1) establishments classified in this industry (primary) and (2) establishments classified in other industries (secondary). Transfers of products of this industry from one establishment of a company to another establishment of the same company (interplant transfers) are also included. Data based on the 2002 Economic Census. For information on confidentiality protection, nonsampling error, and explanation of terms, see note 2 at end of table. For meaning of abbreviations and symbols, see introductory text]

Product code	Product	Number of companies with shipments of \$100,000 or more	Quantity of production for all purposes	Product shipments		
				Quantity	Value (\$1,000)	
332115	Crown and closure manufacturing	2002..	N	X	X	905 326
		1997..	N	X	X	969 693
3321150	Crowns and closures	2002..	N	X	X	905 326
33211501	Metal commercial closures and metal home-canning closures, except crowns	2002..	N	X	X	827 152
		1997..	N	X	X	943 194
3321150101	Metal and metal-composite closures, including home-canning closures	2002..	18	X	X	683 093
		1997..	40	X	X	755 165
3321150103	Metal crowns (including soft drinks, beer, and all other)	2002..	3	X	X	D
3321150106	All other metal closures, including beer and roll-ons	2002..	5	X	X	D
		1997..	10	X	X	D
3321150Y	Crowns and closures, nsk, total	2002..	7	X	X	D
		1997..	N	X	X	78 174
3321150YWW	Crowns and closures, nsk, for nonadministrative-record establishments	2002..	N	X	X	26 499
		1997..	N	X	X	53 426
3321150YWY	Crowns and closures, nsk, for administrative-record establishments	2002..	N	X	X	14 595
		1997..	N	X	X	24 748
						11 904

Note 1: For some establishments, data have been estimated from central unit values that are based on quantity-value relationships of reported data. The following symbols are used when percentage of each quantity figure estimated in this manner equals or exceeds 10 percent of published figure: p-10 to 19 percent estimated; q-20 to 29 percent estimated. If 30 percent or more is estimated, figure is replaced by S.

Note 2: The data in this table are based on the 2002 Economic Census. To maintain confidentiality, the Census Bureau suppresses data to protect the identity of any business or individual. The census results in this table contain nonsampling errors. Data users who create their own estimates using data from American FactFinder tables should cite the Census Bureau as the source of the original data only. For explanation of terms, see Appendix A. For full technical documentation, see Appendix C.

Table 6b. **Product Class Shipments for Selected States: 2002 and 1997**

[Not applicable for this report.]

Table 7. Materials Consumed by Kind: 2002 and 1997

[Includes quantity and cost of materials consumed or put into production by establishments classified only in this industry. Data based on the 2002 Economic Census. For information on confidentiality protection, nonsampling error, and explanation of terms, see note 2 at end of table. For meaning of abbreviations and symbols, see introductory text]

Material code	Material consumed	Quantity	Delivered cost (\$1,000)
332115	Crown and closure manufacturing		
00900001	Total materials	2002.. X	541 420
		1997.. X	476 256
33272203	Metal bolts, nuts, screws, washers, rivets, and other screw machine products	2002.. X	D
		1997.. X	1 431
33200095	Other fabricated metal products (excluding castings and forgings)	2002.. X	D
		1997.. X	12 838
33151001	Iron and steel castings (rough and semifinished)	2002.. X	D
		1997.. X	874
33120071	Steel bars and bar shapes (excluding castings, forgings, and fabricated metal products)	2002.. X	D
		1997.. X	2 938
33120018	Steel sheet and strip (excluding tinplate)	2002.. X	D
		1997.. X	N
33120079	Steel plate	2002.. X	D
		1997.. X	D
33120025	Steel wire and wire products	2002.. X	D
		1997.. X	D
33120013	Steel tinplate, tin free steel, terneplate, and blackplate	2002.. S	99 754
	1,000 s tons	1997.. S	167 252
33120028	All other steel shapes and forms (excluding castings, forgings, fabricated metal products, wire, wire products, tinplate, tin free steel terneplate, and blackplate)	2002.. X	D
		1997.. X	N
33142111	Copper and copper-base alloy shapes and forms (excluding castings, forgings, and fabricated metal products)	2002.. X	D
		1997.. X	D
33131500	Aluminum and aluminum-base alloy sheet, plate, foil, and welded tubing	2002.. X	D
		1997.. X	N
33100049	Other aluminum and aluminum-base alloy shapes and forms (excluding castings, forgings, sheet, plate, foil, welded tubing, extruded shapes, and fabricated metal products)	2002.. X	30 855
		1997.. X	22 069
33100082	Other nonferrous metal shapes and forms (excluding aluminum and aluminum-base alloy and copper and copper-base alloy castings, forgings, and fabricated metal products)	2002.. X	D
		1997.. X	N
32521105	Plastics resins consumed in the form of granules, pellets, powders, liquids, etc.	2002.. X	30 433
		1997.. X	23 917
32551002	Paints, varnishes, stains, lacquers, shellacs, japans, enamels, and allied product	2002.. X	D
		1997.. X	N
32500051	All other chemicals and allied products (excluding plastics materials and resins and paints, varnishes and allied products)	2002.. X	D
		1997.. X	D
32610013	Plastics products consumed in the form of sheets, rods, tubes, film, and other shapes	2002.. X	5 369
		1997.. X	997
32221001	Paperboard containers, boxes, and corrugated paperboard	2002.. X	8 649
		1997.. X	9 720
32200007	Other paper and paperboard products	2002.. X	4 898
		1997.. X	6 353
33510000	Special dies, tools, die sets, jigs, and fixtures (excluding cutting tools for machine tools)	2002.. X	D
		1997.. X	1 623
00970099	All other materials and components, parts, containers, and supplies	2002.. X	14 808
		1997.. X	108 612
00971000	Materials, ingredients, containers, and supplies, nsk	2002.. X	42 407
		1997.. X	72 243

Note 1: For some establishments, data have been estimated from central unit values that are based on quantity-value relationships of reported data. The following symbols are used when percentage of each quantity figure estimated in this manner equals or exceeds 10 percent of published figure: p-10 to 19 percent estimated; q-20 to 29 percent estimated. If 30 percent or more is estimated, figure is replaced by S.

Note 2: The data in this table are based on the 2002 Economic Census. To maintain confidentiality, the Census Bureau suppresses data to protect the identity of any business or individual. The census results in this table contain nonsampling errors. Data users who create their own estimates using data from American FactFinder tables should cite the Census Bureau as the source of the original data only. For explanation of terms, see Appendix A. For full technical documentation, see Appendix C.