

202 MINI SEAM
RECOMMENDED DOUBLE SEAM SPECIFICATIONS

SEAMING CHUCK
FIRST OPERATION ROLL
SECOND OPERATION

ANGELUS
718L636 (or equiv.)
297L641-R-90 (or equiv.)
298L641-S-147 or 298L641-S-141 (or their equiv)

MACHINE SET UP SPECIFICATIONS (NOTE 1)

PIN HEIGHT

CAN SIZE	DESCRIPTION	INCHES	METRIC
202/211 X 307	8 oz SQUAT	3.125 ± .003	79,38 ± 0,08
202/211 X 310	8 oz SUPER SQUAT	3.305 ± .003	83,95 ± 0,08
202/211 X 409	333ml	4.250 ± .003	107,95 ± 0,08
202/211 X 413	12 oz	4.500 ± .003	114,30 ± 0,08
202/211 X 603	16 oz	5.880 ± .003	149,35 ± 0,08
202/204 X 402	7.5 oz (204) SLEEK	3.775 ± .003	98,89 ± 0,08
202/207.7 X 400	8 oz (207.5) SLEEK	3.675 ± .003	93,35 ± 0,08
202/207.5 X 403	8 oz (207.5) SUPER SLEEK RETORT	3.875 ± .003	98,43 ± 0,08
202 X 207.5 X 413	10 oz (207.5) SLEEK	4.500 ± .003	114,30 ± 0,08
202/207.5 X 510	12 oz (207.5) SLEEK	5.315 ± .003	135,00 ± 0,08
202/211 X 707	568ml (550ml BRE END)	7.091 ± .003	180,11 ± 0,08

BASE PLATE LOAD (LBS)

COLD FILL	100 lbs ± 5 lbs	45.36 ± 2.27
HOT FILL	130 lbs ± 20 lbs	58.97 ± 9.07

PRODUCT SPECIFICATIONS

DIMENSIONS AND PARAMETERS

SET UP SPECIFICATION

(IN) (METRIC)


OPERATING SPECIFICATION

(IN) (METRIC)

FIRST OPERATION SEAM THICKNESS		.076 ± .002	1,93 ± 0,05		
FIRST OPERATION COUNTERSINK DEPTH		.270 ± .003	6,86 ± 0,08		
SECOND OPERATION SEAM THICKNESS	.0085 GAUGE	.044 ± .001	1,118 ± 0,025	.042 - .046	1,07 - 1,17
	.0088 GAUGE	.045 ± .001	1,143 ± 0,025	.043 - .047	1,09 - 1,19
SECOND OPERATION COUNTERSINK DEPTH		.270 ± .003	6,86 ± 0,08	.270 ± .005	6,86 ± 0,13
SEAM HEIGHT	S-141	0.098 ± 0.002	2,489 ± 0,05	0.098 ± 0.003	2,489 ± 0,08
	S-147	0.100 ± 0.002	2,540 ± 0,05	0.100 ± 0.003	2,540 ± 0,08
BODY HOOK LENGTH		.065 ± .005	1,65 ± 0,13	.065 ± .010	1,65 ± 0,25
COVER HOOK LENGTH		.060 ± .005	1,52 ± 0,13	.053 min	1,35 min
TIGHTNESS RATING		100%	100%	90% min	90% min
ACTUAL OVERLAP		.035 min	0,89 min	.025 min	0,64 min

NOTE 1: Machine set up specifications are for initial setting only. Adjustments from these settings should be made as needed to achieve product specification requirements

NOTE 2: Double seam quality is the responsibility of the customer.

Date 10/19/09	Approved Traphagen	PRODUCT STANDARD 202 B-64 END .0085" & .0088" GAUGE ANGELUS S-141 & S-147 SECOND OPERATION DOUBLE SEAM ALUMINUM CAN	 METAL BEVERAGE CONTAINER OPERATIONS 9300 W. 108TH CIRCLE WESTMINSTER, CO 80021-3682 P.O. BOX 589, BROOMFIELD, CO 80038-0589 THE DESIGNS, INFORMATION AND DATA CONTAINED HEREIN ARE PROPRIETARY AND ARE SUBMITTED IN CONFIDENCE, AND SHALL NOT BE DISCLOSED, USED OR DUPLICATED IN WHOLE OR IN PART, FOR ANY PURPOSES WHATSOEVER WITHOUT THE PRIOR WRITTEN PERMISSION OF BALL CORPORATION. RECEIPT OF THIS DOCUMENT SHALL BE DEEMED TO BE AN ACCEPTANCE OF THE CONDITIONS SPECIFIED HEREIN.	PRODUCT STANDARD	REV
Drawn N Zanetell	Approved			SEAM - 231	F
Checked R McCauley	Approved				
Approved R McCauley	Approved				