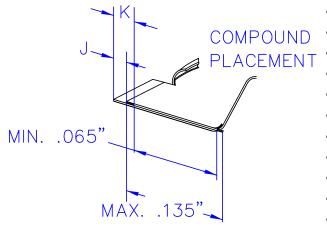


A - Curl Diameter.:	2.340" ±0.006" [59.436 ±0.152mm]
B - Curl Height:	0.080" ±0.005" [2.032 ±0.127mm]
C - Panel Depth: 0.096	55" ±0.005" REF [2.4511 ±0.127mm]
D - Curl Opening Diamter:	2.270" MIN [57.658mm MIN]
E - Countersink Radius:	0.020" ±0.005" [0.508 ±0.127mm]
F - Countersink Depth:	0.270″ ±0.005″ [6.858 ±0.127mm]
G - Countersink Dia.—Tool:	1.913″ [48.590mm]
J - MIN Distance from C. E.:	0.008″ [0.203mm]
K - MAX Distance from C. E.:	0.048″ [1.219mm]



Fraction $\pm 1/_{32}$

2 Place \pm 0.010

 $3 Place \pm 0.005$

4 Place ± 0.0005

Angles ± 0°30'

Machined Finishes 125

Page 1 of 2	DISTRIBUTED BY:	REF NO.:	
	\bigcirc	DWG31244	
DISCLAIMER	ipeline Packaging	DW031244	
	DESCRIPTION:		
DIMENSIONS. IT IS THE CUSTOMER'S RESPONSIBILITIES TO SELECT THE PROPER CONTAINER FOR PRODUCT AND APPLICATION COMPATIBILITY.	202 Aluminum Beverage Can Plain End for 12 oz & 16 oz 480 in Sleeve		

CUSTOMER CLOSING MACHINE SET-UP SPECIFICATIONS AND GUIDELINES TOOLING AND DOUBLE SEAM SPECIFICATIONS for <u>ANGELUS 120L/121L</u> SEAMERS.

202/211 x 413 (12 OZ.) CANS and 202/211 x 307 (8 OZ.) cans (16 OZ) 202/211x603 Cans -- .0104" Gauge .0085" Gauge Ends

Customer:	Loca	Location:			
Seaming Chuck Lip Height: .270"		Seaming Chuck Part Numbers			
Pin Gauge Height: 12OZ. 4.500"	± .003"	Flame Plated	Stoody Titanium		
8 OZ. 3.125"	± .003"	718L636JCB7	718L636ANKB9		
16 OZ 5.877	+/003				
Can Holding Chuck Force: 115# ±	5# @ .022"	771L636JCB7 (Dimple	ed) 771L636ANKB3 (Dimpled)		
see note #2 deflect	ion				
		Angelus Seaming Roll Part Numbers			
Angelus Seaming Rolls Profiles			<u>Ceramic Bearings</u>		
1 st Operation Seaming Rolls #R-90E		297L641ALWW3	297L641ALWH8		
2 nd Operation Seaming Rolls #S-141		298L641ASOW4	298L641ASOH0		
Optional 1 st Operation Roll #R-90		297L641ALVW4	297L641ALVH0		
Optional 2 nd Operation Roll #S-147		298L641ATCW5	298L641ATCH1		
Seam Dimensions		Set-Up	Operating		
1 st Operation Seam Thickness	.07	6" ± .002"			
1 st Operation Seam Height	.078" Maxii	mum .083 Ferrum			
1 st Operation Countersink Depth	.273	" Maximum			
2 nd Operation Seam Thickness	.04	-3" <u>+</u> 001"	.043" <u>+</u> .002"		
2 nd Operation Seam Height #S-141	.09	8" ± .002"	.098" ± .003"		
2 nd Operation Seam Height #S-147	.10	0" <u>+</u> .002"	.100" + .004003"		
2 nd Operation Countersink Depth	.27	0" ± .003"	.270" ± .005"		
Body Hook Length	.06	5" ± .005"	.065" ± .010"		
Cover Hook Length	.060" -	+ .010"005"	.053" Minimum		
Cover Hook Tightness Rating		100%	95% - 100%		
Overlap, Actual Optical Only	.040	" Minimum	.035" Minimum		
Pressure Ridge	VISIBLE	& CONTINUOUS AROUN	ID ENTIRE CIRCUMFERENCE		

Page 2 of 2	DISTRIBUTED BY:	REF NO.:	
5	\bigcirc	DWG31244	
DISCLAIMER	ipeline Packaging	00001211	
	DESCRIPTION:		
DIMENSIONS. IT IS THE CUSTOMER'S RESPONSIBILITIES TO SELECT THE PROPER CONTAINER FOR PRODUCT AND APPLICATION COMPATIBILITY.	202 Aluminum Beverage Can Plain End for 12 oz & 16 oz, 480 in Sleeve		