



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:	0.0965" ±0.005" REF [2.4511 ±0.127mm]
D - Curl Opening Diameter:	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]

**TOLERANCES UNLESS OTHERWISE SPECIFIED**

Fraction ± 1/32

2 Place ± 0.010

3 Place ± 0.005

4 Place ± 0.0005

Angles ± 0°30'

Machined Finishes  $\sqrt{125}$

**DISCLAIMER**

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REF NO.:

DWG31244

DESCRIPTION:

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 ANGELUS 120L/121L 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:**

**Location:**

Seaming Chuck Lip Height: .270"  
Pin Gauge Height: 12OZ. 4.500" ± .003"  
8 OZ. 3.125" ± .003"  
16 OZ 5.877 +/- .003  
Can Holding Chuck Force: 115# ± 5# @ .022"  
*see note #2* deflection

***Seaming Chuck Part Numbers***

Flame Plated	Stoody Titanium
718L636JCB7	718L636ANKB9
771L636JCB7 (Dimpled)	771L636ANKB3 (Dimpled)

***Angelus Seaming Roll Part Numbers***

<b><i>Angelus Seaming Rolls Profiles</i></b>		Ceramic Bearings
1 <sup>st</sup> Operation Seaming Rolls #R-90E	297L641ALWW3	297L641ALWH8
2 <sup>nd</sup> Operation Seaming Rolls #S-141	298L641ASOW4	298L641ASOHO
Optional 1 <sup>st</sup> Operation Roll #R-90	297L641ALVW4	297L641ALVHO
Optional 2 <sup>nd</sup> Operation Roll #S-147	298L641ATCW5	298L641ATCH1

Seam Dimensions	Set-Up	Operating
1 <sup>st</sup> Operation Seam Thickness	.076" ± .002"	
1 <sup>st</sup> Operation Seam Height	.078" Maximum .083 Ferrum	
1 <sup>st</sup> Operation Countersink Depth	.273" Maximum	
2 <sup>nd</sup> Operation Seam Thickness	.043" ± .001"	.043" ± .002"
2 <sup>nd</sup> Operation Seam Height #S-141	.098" ± .002"	.098" ± .003"
2 <sup>nd</sup> Operation Seam Height #S-147	.100" ± .002"	.100" + .004 - .003"
2 <sup>nd</sup> Operation Countersink Depth	.270" ± .003"	.270" ± .005"
Body Hook Length	.065" ± .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	<b>VISIBLE &amp; CONTINUOUS</b> AROUND ENTIRE CIRCUMFERENCE	

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