

**202 CDL+ MINI SEAM
RECOMMENDED DOUBLE SEAM SPECIFICATIONS**

	<u>ANGELUS 120L</u>	<u>ANGELUS 140S / 180S</u>
SEAMING CHUCK	514L836	1386646
FIRST OPERATION ROLL	297L641-R-90	35S841-R-90
SECOND OPERATION	298L641-S-141	36S841-S-141

**MACHINE SET UP
SPECIFICATIONS (NOTE 1)**

PIN HEIGHT


CAN SIZE	DESCRIPTION	INCHES	METRIC
202/211 X 409	333ml	4.284 ± .003	108,81 ± 0,08
202/211 X 413	12 oz	4.534 ± .003	115,16 ± 0,08
202/211 X 501	375ml	4.753 ± .003	120,73 ± 0,08
202/211 x 603	16 oz	5.912 ± .003	150,16 ± 0,08
202/204 X 402	7.5 oz (204) SLEEK	3.810 ± .003	96,77 ± 0,08
202/204 X 405	8 oz (204) SLEEK	4.035 ± .003	102,49 ± 0,08
202/204 X 602	12 oz (204) SLEEK	5.850 ± .003	148,59 ± 0,08
202/207.7 X 400	8 oz (207.5) SLEEK	3.709 ± .003	94,21 ± 0,08
202 X 207.5 X 413	10 oz (207.5) SLEEK	4.534 ± .003	115,16 ± 0,08
202/207.5 X 510	12 oz (207.5) SLEEK	5.350 ± .003	135,89 ± 0,08
202/211 X 707	568ml (550ml BRE END)	7.126 ± .003	181,00 ± 0,08

BASE PLATE LOAD (LBS)	COLD FILL	110 ± 10	49,90 ± 4,54
	HOT FILL	130 ± 20	58,97 ± 9,07

PRODUCT SPECIFICATIONS <u>DIMENSIONS AND PARAMETERS</u>	SET UP SPECIFICATION		OPERATING SPECIFICATION	
	(IN)	(METRIC)	(IN)	(METRIC)
FIRST OPERATION SEAM THICKNESS	0.074 ± 0.002	1,880 ± 0.051		
FIRST OPERATION COUNTERSINK DEPTH	0.230 -0.238	5,842 - 6,045		
SECOND OPERATION SEAM THICKNESS - BEER COATING	0.043 ± 0.001	1,092 ± 0,025	0.041 - 0.045	1,041 - 1,143
SECOND OPERATION SEAM THICKNESS - BEVERAGE COATING	0.044 ± 0.001	1,118 ± 0,025	0.042 - 0.046	1,067 - 1,168
SECOND OPERATION COUNTERSINK DEPTH	0.230 -0.238	5,842 - 6,045	0.228 - 0.238	5,791 - 6,045
SEAM HEIGHT	0.096 - 0.100	2,438 - 2,540	0.095 - 0.101	2,413 - 2,565
BODY HOOK LENGTH	0.065 ± 0.005	1,651 ± 0,127	0.055 - 0.075	1,397 - 1,905
COVER HOOK LENGTH	0.060 ± 0.005	1,524 ± 0,127	0.053 MIN	1,346 MIN
TIGHTNESS RATING	100%	100%	90% MIN	90& MIN
ACTUAL OVERLAP	0.035 MIN	0,889 MIN	0.025 MIN	0,635 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 9/9/04	Approved R McCauley	PRODUCT STANDARD 202 CDL+ END (.0082") DOUBLE SEAM ALUMINUM CAN ANGELUS S-141 SECOND OPERATION DOUBLE SEAM	 METAL BEVERAGE CONTAINER OPERATIONS 9300 W. 108TH CIRCLE WESTMINSTER, CO 80021-3682 P.O. BOX 589, BROOMFIELD, CO 80038-0589 <small>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.</small>	PRODUCT STANDARD SEAM-220	REV T
Drawn N Zanetell	Approved J Bathurst				
Checked Traphagen	Approved				
Approved J Vaughan	Approved				