

202 MINI SEAM  
RECOMMENDED DOUBLE SEAM SPECIFICATIONS

**ANGELUS**

SEAMING CHUCK  
FIRST OPERATION ROLL  
SECOND OPERATION

718L636 (or equiv.)  
297L641-R-90 (or equiv.)  
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		OPERATING SPECIFICATION	
	(IN)	(METRIC)	(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	.0086 GAUGE .0088 GAUGE	.044 ± .001 .045 ± .001	1,118 ± 0,025 1,143 ± 0,025	.042 - .046 .043 - .047
SECOND OPERATION COUNTERSINK DEPTH	.270 ± .003	6,86 ± 0,08	.270 ± .005	6,86 ± 0,13
SEAM HEIGHT	.096 - .100	2,438 - 2,540	.095 - .101	2,413 - 2,565
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 .0086" & .0088" GAUGE  ANGELUS S-141 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 SEAM - 231	REV E
Drawn N Zanetell	Approved				
Checked R McCauley	Approved				
Approved R McCauley	Approved				