

SECTION 8

CUSTOMER SPECIFICATION INDEX

SEAMING RECOMMENDATIONS

SPECIFICATION NUMBER		PAGE
SR-100	Recommended Seaming Rolls	1 of 2
	Seaming Profile Conversion Chart	2 of 2
SR-101	Typical Seam SAFERIM End/Plastic Can	1 of 2
	Typical Seam SAFERIM End/Plastic Can	2 of 2
	- Metric	
SR-102	Typical Seam SAFERIM End/Metal Can	1 of 2
	Typical Seam SAFERIM End/Metal Can	2 of 2
	- Metric	

RECOMMENDED SEAMING ROLL FOR METAL & COMPOSITE CANS

Spec No SR-100
Sheet No 1 of 2
Date 10-Nov-97

CAN DIAMETER	BODY MATERIAL	END TYPE	75# PLT.		2 ND OPERATION
			FIN SEAM THICKNESS	1 ST OPERATION	
202	Metal	SAFERIM®	.048	R-8	S-14
202	Metal	Pour Spout	.053	R-6J	S-14
201.5/202	Composite	SAFERIM		R-8	S-46
202	Composite	Pour Spout		R-6J	S-46
207.5	Metal	Pour Spout SOT STL			
208	Metal	Flat Panel EZOE	DS 95	A-12062	S-55
211	Metal	SAFERIM/All Profiles	.048	R-8	S-14
211	Metal	DOUBLESAFE®	.052	R-8	S-14
211	Composite	SAFERIM/DOUBLESAFE		R-8/R-42	S-46
211	Metal	Flat Panel EZOE	DS T7	R7	S-41G
300	Metal	SAFERIM/All Profiles	.052	R-8	S-14
300	Metal	SAFERIM - Vacuum	.054	R-8	S-14
300	Composite	SAFERIM		R-11/R-27	S-46
300	Metal	Printable Tennis Ball	DS 115	A 12002-W	A-12169
300	Metal	Pour Spout SOT STL		A-12000	A-12152
303	Metal	SAFERIM/All Profiles	.052	R-8	S-14
303	Composite	SAFERIM/All Profiles		R-11/R-27	S-46
307	Metal	SAFERIM/All Profiles	.052	R-8	S-14
307	Composite	SAFERIM/All Profiles		R-11/R-27	S-46
309	Metal	SAFERIM	.052	R-8	S-14
309	Composite	SAFERIM		R-11/R-27	S-46
401	Metal	SAFERIM®/All Profiles	.054	R-8	S-14
401	Composite	SAFERIM/All Profiles		R-27	S-46
401	Metal	DOUBLESAFE®		R-8	S-14
401	Composite	DOUBLESAFE		R-27	S-46
401	Metal	RIMSAFE®	DS T9	R-7	S-14
401	Metal	Tara Tara®		A-12002W	A-12067
401	Metal	Flat Panel EZOE		A-12002W	A-12067
502	Metal	Flat Panel EZOE	DS 67	A-12062	A-12122

Notes:

These specifications are only recommendations. User should select the most suitable roll combination for the cans being seamed. Seam thickness depends on body wall.
All profiles means PORTIONPOUR, Litter-Proof, Child Resistant.

SEAMING PROFILE CONVERSION CHART

Spec No. SR-100

Sheet No. 2 of 2

Date: 10-Nov-87

<u>ANGELUS</u>	<u>AMERICAN-NATIONAL</u>	<u>CROWN-CONTINENTAL</u>
R-4	X-959-6	A-12002W
R-6J	G-45	A-12151 or A-12062 or A-12600
R-7	G-658-3	N/A
R-8	X-758-8	A-12010
R-11	X-859-7	A-12000
R-21	X-758-6	A-12146
R-27	X-962-3	A-12000 or A-12062 or A-12167
R-29	S1	N/A
R-42	N/A	N/A
N/A	N/A	A-12076
S-10	04	A-12005**
S-14	G-46	A-12001 or A-12201*
S-15	X-860-2	A-12001 or A-12201*
S-27	X-860-2	A-12088
S-41 G	G-64	N/A
S-46	X-762-3	A-12149
S-55	N/A	A-12122
S-87	N/A	A-12107
S-125	N/A	N/A
N/A	N/A	A-12067
N/A	N/A	A-12169
N/A	N/A	A-12152

NOTE: N/A means not available.

Angelus prefix "R" denotes first operation.

Angelus prefix "S" denotes second operation.

* Use A-12201 for all non-interlocking Continental seamers.

** Use A-12205 for all non-interlocking Continental seamers.

CUSTOMER SPECIFICATION



AUTOMATED
CONTAINER
CORPORATION

Prepared by:
ZYSSET

Checked by:

Material: -
Date: **04-01-84**

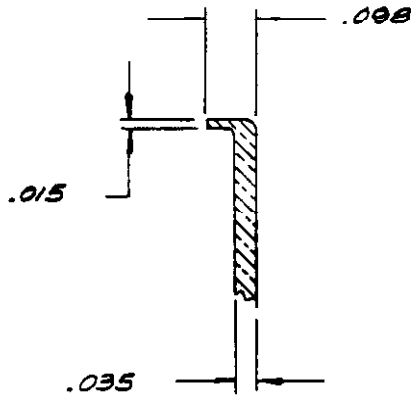
Spec. No. **SE-101**
Sheet No. **1 of 2**

Rev. **1**
Date **5-93**

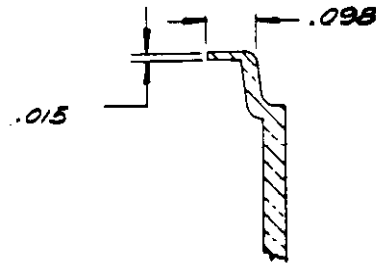
Name: **PLASTIC CAN, ALUMINUM END SEAMS**



THIRD ANGLE PROJECTION

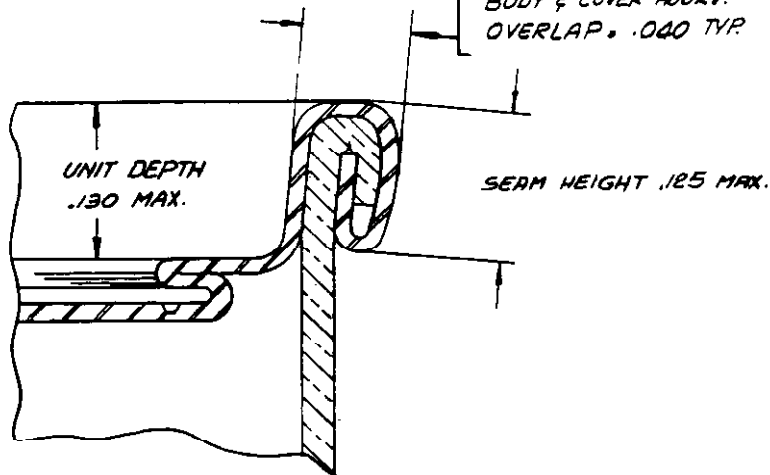



PREFERRED DESIGN



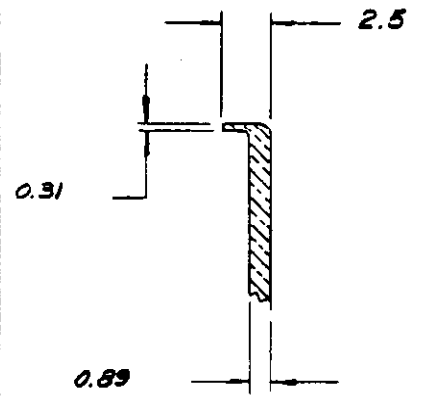
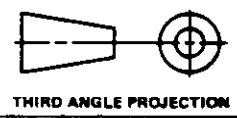
ALTERNATE

SEAM THICKNES:
1st. OP. .100-.105 TYP.
2nd. OP. .072-.079 TYP.
BODY & COVER HOOK.
OVERLAP .040 TYP.

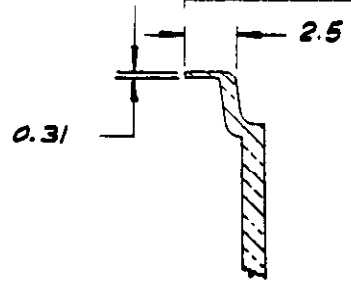


CUSTOMER SPECIFICATION  AUTOMATED CONTAINER CORPORATION	Prepared by:	Checked by:	Material:	Spec. No. <i>SR-101</i>	Rev. <i>1</i>
	<i>ZASSET</i>		Date <i>04-01-84</i>	Sheet No. <i>2 of 2</i>	Date <i>5-93</i>
Name PLASTIC CAN, ALUMINUM END SEAMS					

METRIC DIM.

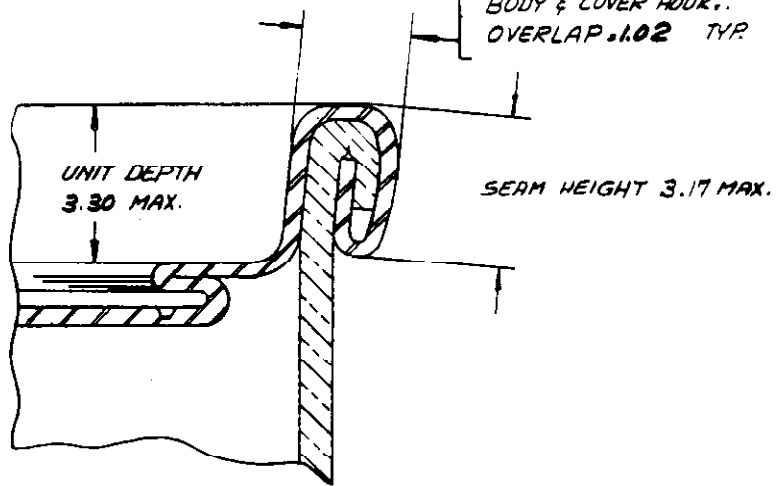


PREFERRED DESIGN



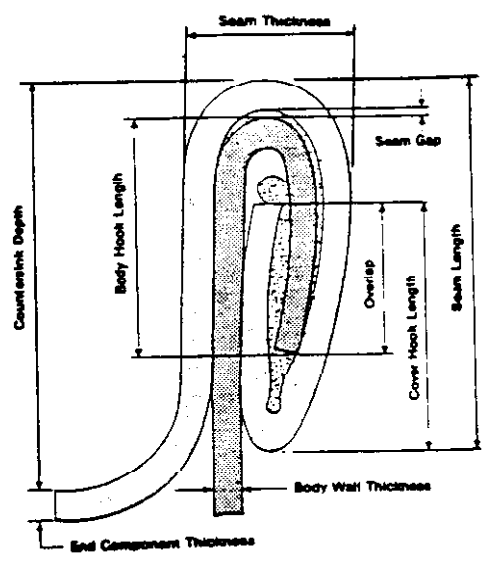
ALTERNATE

SEAM THICKNES:
 1st. OP. . 2.54 - 2.68 TYP.
 2nd. OP. . 1.83 - 2.01 TYP.
 BODY & COVER HOOK.
 OVERLAP . 1.02 TYP.



PAC 500 2/82

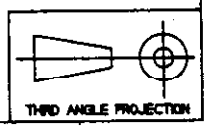
CUSTOMER SPECIFICATION  AUTOMATED CONTAINER CORPORATION	Rev.	AC	Adv.	Date	10/21/97	Specs.	SR102
	ZYSSET			Material		Sheet No.	1 OF 2
	Name						



ALUMINUM END PLATE		.0079	.009	.0097	.010	.0105
END TYPE		SR	SR	DS	SR	SR
1. Counterflank Depth	Max.	.125	.125	.105	.125	.125
2. Seam Length		.115-.120	.115-.120	.115-.120	.115-.120	.115-.120
3. Seam Thickness		.050-.055	.050-.055	.053-.058	.053-.057	.053-.058
4. Body Hook Length		.080±.005	.080±.005	.080±.005	.080±.005	.080±.005
5. Cover Hook Length		.080±.005	.080±.005	.080±.005	.080±.005	.080±.005
6. Overlap	Min.	.035	.040	.040	.040	.040
7. Tightness		85-100%	85-100%	85-100%	85-100%	85-100%

Note: Thickness ranges for reference only. Measurements will vary, depending on base weight of plate being used. Double seam specifications are for operating limits. Specifications should not change, based on type of seaming equipment used.

Rev.	
Date	

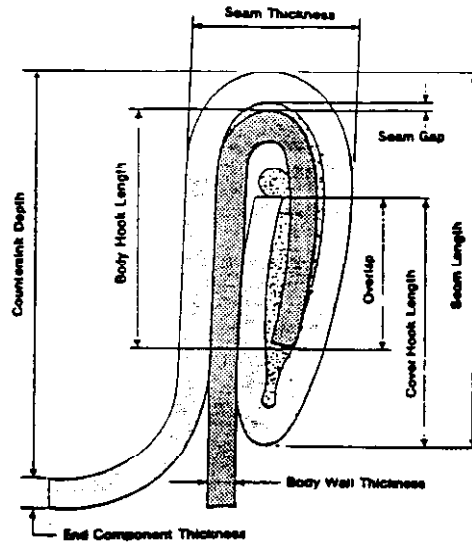


CUSTOMER SPECIFICATION



AUTOMATED
CONTAINER
CORPORATION

By ZYSSET	Ac.	Des.	Date 10/21/97	Specs. SR102
Name			Material	Sheet No. 2 OF 2
TYPICAL SEAM - SAFERIM END/METAL CAN METRIC DIM.				



ALUMINUM END PLATE	0.2	0.22	0.25	0.26	0.27
END TYPE	SR	SR	DS	SR	SR
1. Countersink Depth Max.	3.17	3.17	2.67	3.17	3.17
2. Seam Length	2.92-3.05	2.92-3.05	2.92-3.05	2.92-3.05	2.92-3.05
3. Seam Thickness	1.27-1.40	1.27-1.40	1.35-1.47	1.35-1.45	1.35-1.47
4. Body Hook Length	2.03±0.13	2.03±0.13	2.03±0.13	2.03±0.13	2.03±0.13
5. Cover Hook Length	2.03±0.13	2.03±0.13	2.03±0.13	2.03±0.13	2.03±0.18
6. Overlap	Min. 0.89	1.02	1.02	1.02	1.02
7. Tightness	85-100%	85-100%	85-100%	85-100%	85-100%

Note: Thickness ranges for reference only. Measurements will vary, depending on base weight of plate being used. Double seam specifications are for operating limits. Specifications should not change, based on type of seaming equipment used.

Rev.	
Date	

