

Basic technical conditions to be met by the bodies for parting with preflange:

In order to achieve the agreed output, an adequate quantity of bodies must be fed to the machine, and the downstream transport systems, machines and equipment must be able to handle these quantities.

The following conditions must be met for perfect body parting:

- a) The bodies must be perfectly upright when fed to the machines.
- b) The bodies must be round before parting: max. permissible deviation from roundness ± 3 mm.
- c) Overlapping must be such that there is no offset edge: max. permissible offset edge 0.2 mm.

Larger offset edges – up to 0.5 mm max. – may result in problems in the parter, i.e. the score line is no longer flush with the parting cutter.

- d) The score line must always be exactly in the middle of the bodies for parting: max. off-line ± 0.1 mm.
- e) Residual wall thickness after scoring must not exceed 30 % of the sheet gauge.
- f) The temperature of the weld seam on the bodies must not exceed 40°C max. (for powder-coated seams) upon entry into the machine.