

Basic technical conditions to be met by the bodies for parting without preflange

In order to achieve the maximum capacity, 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) The score line must always be exactly in the middle of the bodies for parting: both the variation in height of the score line itself in relation to the can and the score line matching offset must lie within ± 0.1 mm of the centre line of the can body.

Larger deviations may result in problems in the parter, i.e. the score line is no longer flush with the parting cutter

- d) Residual wall thickness after scoring must be 0.055 mm with a tolerance of $\pm 0,01$ mm.
- e) The temperature of the weld seam on the bodies must not exceed max. 40°C (for powder-coated seams) upon entry into the machine