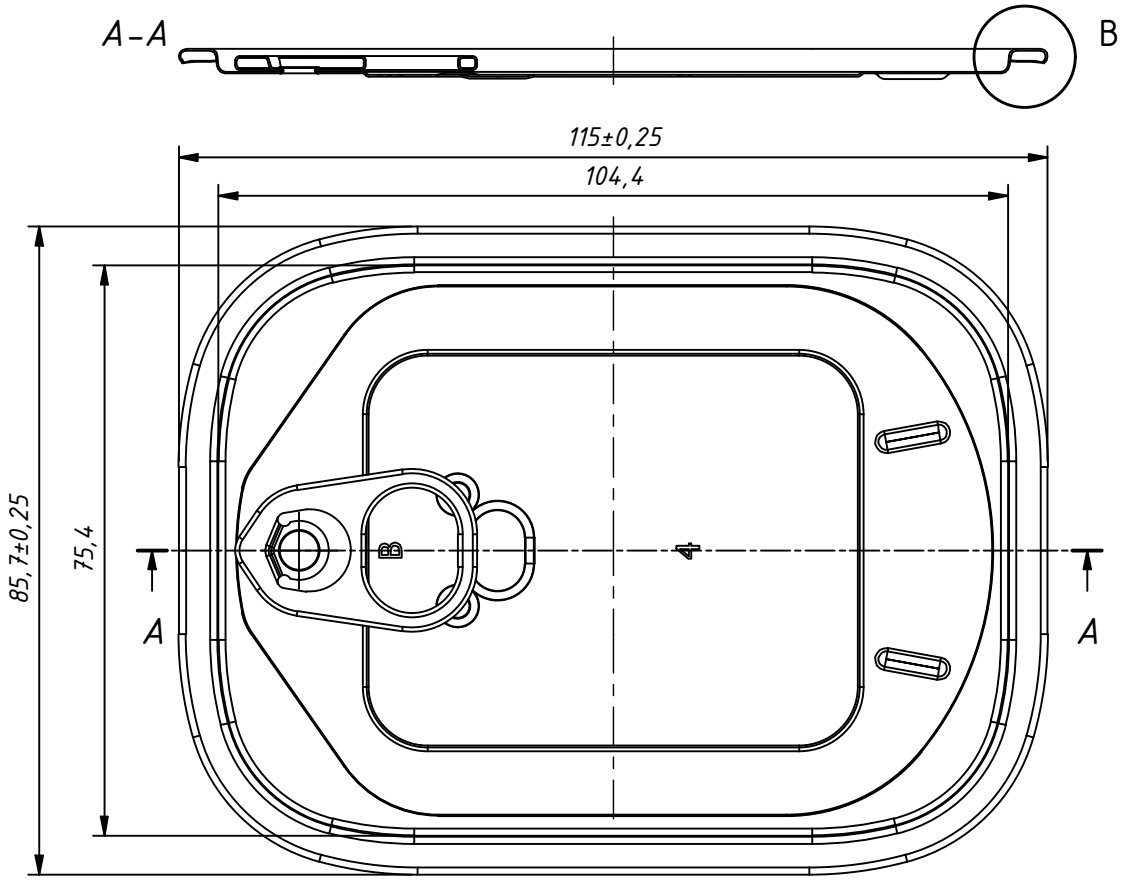
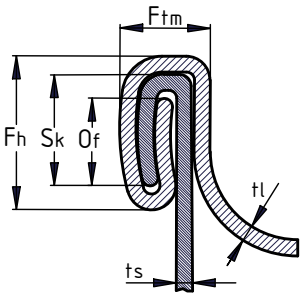
SKIVE	PRODUCT SPECIFICATION	DRAWING NO. 15-80015	REV. NO. 5
	END: DINGLEY END 105x76 EO		DATE / SIGN
		PREPARED	18/08/2017 MKJ



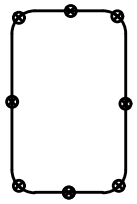
SEAMING ROLL (RECOMMENDED):
1 ST. OPERATION: B
2 ND. OPERATION: 11962

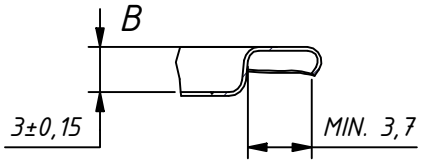
SEAMING ROLL (ALTERNATIVE):
1 ST. OPERATION: U25

SEAMING CHUCK (RECOMMENDED):
No.: 3025.06.01



POINTS OF CUTTING AND MEASURING:





DOUBLE SEAM SPECIFICATION:

		SPECIFIKATION [mm]	LIMITS [mm]
SEAM HEIGHT (IDEAL)	Fh	2,80	+0,30
BODY HOOK	Sk	1,90	±0,30
OVERLAP	Of	MIN. 1,0	MIN. 1,0
SEAM THICKNESS	Ftb	2*ts+3*tl+0,20	
SEAM COMPRESSION		Ftm - Ftb	±0,10
WRINKLES			MAX. 30%

* ONE WRINKLE MAX. 50% - ts AND tl TO BE MEASURED ON THE CONTROLLED CAN

RETORTING:
DIFFERENTIAL PRESSURE DURING RETORT ΔP max = 0,35 BAR

SEAMING CONTROL:
COMPRESSION IS CONTROLLED AT THE POINTS MARKED BY X, AND THE LOWEST AND HEIGHEST FIGURES ARE REGISTERED.

BODY HOOK AND OVERLAP ARE CONTROLLED VISUALLY AT ALL THE MEASURING POINTS, AND IN THE POOREST CUT FOUND BY VISUAL JUDGING THE SEAM HEIGHT, BODY HOOK AND OVERLAP ARE MEASURED ANG REGISTERED.

THE FINAL DETERMINATION OF THE SEAM INTEGRITY IS THE CUSTOMER'S RESPONSIBILITY.