

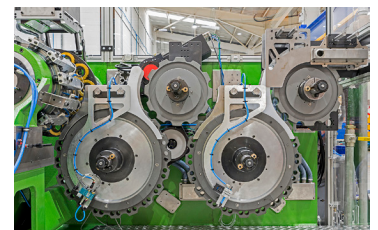
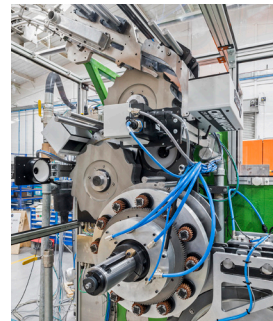
Die Necking The Stolle E-NCKR®

The new Stolle E-NCKR® represents another milestone in Stolle's complete line of value-added can production equipment. This modular machine is designed to neck 2-piece cans to accept a specified diameter end. In addition to necking, the machine can be equipped with modules to perform other processing functions on the cans, including flanging, base reforming and light testing. The Stolle E-NCKR can also be equipped with infeed and discharge vision inspection systems to perform 100% inspections of cans within the machine.

Cans enter the Stolle E-NCKR through an infeed module where starwheels gradually accelerate the cans to the desired pitch line spacing before the first process module. An integral waxer lubricates the exterior cut edge of the can bodies to facilitate the neck-forming process. Vision inspection cameras can be mounted on the infeed module to inspect the cans before necking for label verification, unprinted cans, cut edge damage, BMID and spray dot detection. On the discharge end of the machine, a light tester module inspects for pinholes in the can or flange damage. A separate discharge vision inspection module inspects for damage to the can neck, flange, body sidewall and base rim.

Each module of the Stolle E-NCKR includes a 20-pocket transfer wheel that moves the cans into a 12-pocket process turret wheel. Every process turret has cam-driven pushers that move the cans into the tooling. Modules with necking tools also have rear pushers to move tools into the cans for the neck forming process. Aided by air, the can is pushed from the tooling via the knockout while the pusher ram retracts, then the cans exit the turret and are transferred to the next module by its transfer wheel. This process is repeated through the required stages of the machine to perform all the steps of necking, as well as flanging, bottom reforming, light testing and vision inspection functions if so equipped. The finished cans exit the final process turret and are transferred by a customer-supplied air track to the plant can conveying system.

The Stolle E-NCKR is equipped with quick change height and diameter features so the machine can be easily and quickly modified to run different can sizes, and all process modules feature quick change tooling. All the bearings in the machine are sealed for life, including those of the cam followers. The Stolle E-NCKR also features full machine and process monitoring capability for integration into a plant-wide control and reporting system.



Left: Infeed module with integrated waxer and vision inspection cameras

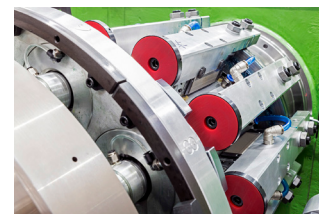
Above: Light tester, vision inspection and can discharge modules



Quick-change necking module



Flanging module



Bottom reformer module



Specifications

| | |
|-----------------------------|---|
| Process Material | Aluminum/Steel 2-Piece Cans |
| Can Diameter Range | 2 1/16" 52 mm (202) to 3 1/2" 89 mm (308) |
| Can Height Range | 1.97" 50 mm to 11" 280 mm |
| Process Pockets | 12 |
| Transfer Pockets | 20 |
| Pusher Cam Stroke | 1.9375" |
| Knock-Out Cam Stroke | .875" |
| Power Requirements | 380-480 VAC – 3 phase - 50/60 Hz (per customer) |
| Overall Machine Dimensions | 88" L x 33" W x 64" H per module |
| Machine Weight | 5940 lbs (2700 Kg) per module |
| Special Foundation Required | No |
| Control System | Customer preference |



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