

Basic technical conditions to be met by bodies for die necking

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

The following conditions must be met for perfect body necking:

- The bodies must be round before necking: max. permissible deviation from roundness ± 3 mm.
- Overlapping must be such that there is no body cocking: max. permissible body cocking 0.2 mm. Max. permissible weld tail 0.2 mm.
- The temperature of the weld seam on the bodies must not exceed 40° C (for powder-coated seams) upon entry into the machine.
- The sheet gauge in the weld seam zone (weld seam thickness) must not exceed 1.5 x S (see sheet gauge) without striping.
- On powder-coated seams, max. application thickness is 0.05 mm or 12 mg/10 mm stripe width.
- To avoid lacquer abrasion (which would contaminate the necking tooling), it must be ensured that the decoration on printed cans is completely covered by clear lacquer with good anti-friction properties.
- Uninterrupted welding seam without missing welding points at beginning and end.