300 DOUBLE SEAM

RECOMMENDED DOUBLE SEAM SPECIFICATIONS

	CCC	ANGELUS
SEAMING CHUCK	1366656	95L836
FIRST OPERATION ROLL	SRG126	R-6J
SECOND OPERATION	SRG224	S-41G

MACHINE SET UP SPECIFICATIONS (NOTE 1)		US STANDARD	METRIC
PIN HEIGHT (IN)	300/307 X 603	5.845 ± 0.010	148,46 ± 0,25
	300/307 X 710	7.265 ± 0.010	184,53 ± 0,25
BASE PLATE LOAD (LBS)		250 ± 20	113.40 ± 9.07

PRODUCT SPECIFICATIONS DIMENSIONS AND PARAMETERS	SET UP SPECIFICATION (IN)	(METRIC)	OPERATING SPECIFICATION (IN)	(METRIC)
FIRST OPERATION SEAM THICKNESS	0.108 ± 0.004	2,743 ± 0,102		
FIRST OPERATON COUNTERSINK DEPTH	0.298 ± 0.003	7,569 ± 0,076		
SECOND OPERATION SEAM THICKNESS	0.066 ± 0.002	1,676 ± 0,051	0.064 – 0.068	1,626 – 1,727
SECOND OPERATION COUNTERSINK DEPTH	0.298 ± 0.003	7.569 ± 0,076	0.298 ± 0.005	7,569 ± 0,127
SEAM HEIGHT	0.120 – 0.126	3,048 – 3,200	0.118 – 0.128	2,997 – 3,251
BODY HOOK LENGTH	0.080 ± 0.005	2,032 ± 0,127	0.080 ± 0.008	2,032 ± 0,203
COVER HOOK LENGTH	0.080 ± 0.005	2,032 ± 0,127	0.065 MIN	1,651 MIN
TIGHTNESS RATING	100%	100%	90%	90%
ACTUAL OVERLAP	0.040 MIN	1,016 MIN	0.035 MIN	0,889 MIN

NOTE 1: Machine set up specifications are for initial setting only. Adjustments from these settings should be made as needed to achieve product specification requirements

NOTE 2 **Double seam quality is the responsibility of the customer.**

Date: 4/2/04	Approved: R RAYBURN	Product: 300 END (.0142")	Ball	Metal Beverage Container Operations 9300 W. 108th Circle, Westminster, CO 80021-3682 P.O. Box 589 Broomfield, Co 80038-0589
Drawn: N ZANETELL	Approved: T NGUYEN			
Checked: ZANETELL	Approved:	DOUBLE SEAM ALUMINUM CAN US STANDARD & METRIC 300/307 X 603 300/307 X 710	THE DESIGNS, INFORMATION AND DATA CONTAINED HEREIN ARE PROPRIETARY AND ARE SUBMITTED IN CONFIDENCE, AND SHALL NOT BE DISCLOSED, USED OR DUPLICATED IN WHOLE OR IN PART, FOR ANY PURPOSES WHATSOEVER WITHOUT THE PRIOR WRITTEN PERMISSION OF BALL CORPORATION. RECEIPT OF THIS DOCUMENT SHALL BE DEEMED TO BE AN ACCEPTANCE OF THE CONDITIONS SPECIFIED HEREIN.	
Approved: R MCCAULEY	Approved:		PRODUCT STANDARD: SEAM-309	REV.: A