How Ball Makes Two-Piece D&I Cans

1. **UPENDER**
   Steel coils are positioned on the uncoiler.

2. **UNCOILER**
   The uncoiler unwinds the steel coil into the lubricator.

3. **LUBRICATOR**
   A thin film of lubricant is applied to the steel sheet which is then fed into a cupper.

4. **CUPPER**
   Circular blanks are cut out and formed into cups.

5. **CONVEYOR SYSTEM**
   The extensive network of mezzanine and underfloor conveyors route the cans to the next station. Cans are directed onto single conveyors or bulk conveyors depending on configuration needed for the next process. The system is also used as a temporary holding area for any overflow.

6. **BODYMAKER**
   The bodymaker uses a punch mounted on a ram to push the cups through a series of tooling dies that redraw and iron the cups into cans.

7. **FLANGER**
   The top edge of the can is shaped to form a lip used to attach an end to the can after it is filled.

8. **BEADER**
   Tooling creates one or more beads on the can to increase resistance to circumferential collapse.

9. **WASHER, WASHCOATER, DRYING OVEN**
   The cans are washed, rinsed, and receive a protective coating prior to drying in preparation for flanging and the application of an internal coating.

10. **LIGHT TESTER**
    The tester checks all cans for possible pinholes or other damage.

11. **IC SPRAYER**
    The IC sprayer applies a protective internal coating to the can body to protect the taste of a product.

12. **IC BAKE OVEN**
    The bake oven cures the internal coating applied in the previous step.

13. **FINAL INSPECTION**
    A camera checks for any contamination that might be in the can.

14. **PALLETIZER**
    Finished cans are placed on pallets for immediate shipment or storage.

15. **STRAPPER**
    Plastic bands are fitted around the stacked cans for added stability.