How Ball Makes Three-Piece Welded Cans

AUTOFEEDER
The autofeeder transports the individual body blanks from the slitter into a hopper on the welder bodymaker.

BULK COPPER WIRE
Copper wire is supplied for the bodymaker's welding operation.

BULK PALLETERIZER
Places finished cans on pallets for immediate shipment or storage.

SLITTER
The slitter uses revolving cutters to cut the steel sheets of tinplate into individual body blanks.

SOLDER FEEDER
A roll of approximately 1,700 steel sheets, previously cut to size and coated, is positioned in the slitter feeder. Individual sheets are picked up with suction cups and transported to the slitter.

SPRAY STATION
An acrylic or water spray is then applied to the welded seam on the interior of the can so no raw metal is exposed after the welding process.

CURING OVEN
The oven is a long narrow oven through which the welded cylinders are conveyed to gradually cure the inside spray.

NECKER
The necker, next to the three-piece can industry, uses die-folding to decrease the circumference of the top of the cylinder to permit the use of a smaller end.

FLANGER
The spin flanger has rotating heads containing a series of tapered rollers. These rollers are brought into contact with both ends of the can body, fitting the ends of the cylinder to form a flange.

ROTSFEED - SEAMER
The double seamer is automatically fed ends for the retort. The objective of the double seamer is to attach a compound flanged metal end to the can body by properly interleaving their flanged ends to form a hemmed seal.

TESTER
Here the can is checked for leakage before shipment to a customer.

STRAPPER
Fits plastic bands around stacked cans for added stability.

SHRINK WRAP UNIT
Covers stacked pallets with plastic wrap. The wrap protects containers from common environmental contamination such as dust or insects.