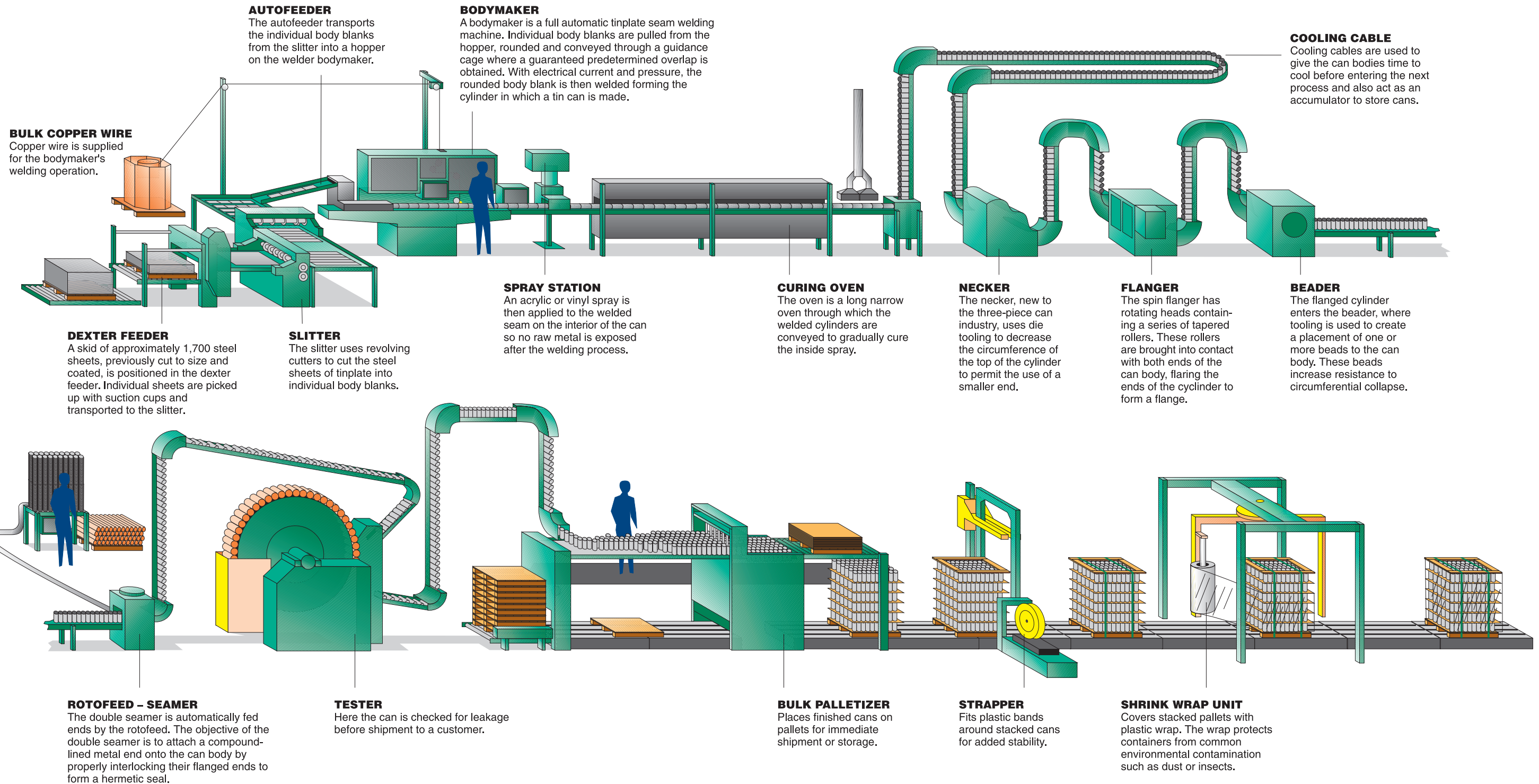


# How Ball Makes Three-Piece Welded Cans



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

**BODYMAKER**  
A bodymaker is a full automatic tinplate seam welding machine. Individual body blanks are pulled from the hopper, rounded and conveyed through a guidance cage where a guaranteed predetermined overlap is obtained. With electrical current and pressure, the rounded body blank is then welded forming the cylinder in which a tin can is made.

**COOLING CABLE**  
Cooling cables are used to give the can bodies time to cool before entering the next process and also act as an accumulator to store cans.

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

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

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

**SPRAY STATION**  
An acrylic or vinyl 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, new to the three-piece can industry, uses die tooling 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, flaring the ends of the cylinder to form a flange.

**BEADER**  
The flanged cylinder enters the beader, where tooling is used to create a placement of one or more beads to the can body. These beads increase resistance to circumferential collapse.

**ROTOFEED - SEAMER**  
The double seamer is automatically fed ends by the rotofeed. The objective of the double seamer is to attach a compound-lined metal end onto the can body by properly interlocking their flanged ends to form a hermetic seal.

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

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

**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.