Inside a Ball Beverage Can Plant

1. **ALUMINUM COILS** are positioned on the uncoiler. Uncoiler uncoils the aluminum coil into the lubricator.

2. **CUPPER** cuts out circular blanks of aluminum and forms the blanks into cups.

3. **BODYMAKERS** use a punch mounted on a ram to push the cups through a series of feeding dies that reduce and iron the cups into cans.

4. **TRIMMERS** trim the open end of the cans to a uniform height.

5. **WASHER / OVEN** washes, dries, and dries cans in preparation for the application of main coatings and labels.

6. **BASECOATERS** are used only if required by the can design. Cans are conveyed to the basecoater where basecoat is applied to the outside of the cans as a base color for further printing.

7. **BASECOATER OVENS** convey the cans to the basecoater oven where the basecoat is cured onto the cans.

8. **PRINTERS** use up to six colors of ink to print labels on the cans and then apply a thin film of lacquer over the entire label to protect it.

9. **INTERNAL COATERS** apply a thin layer of lacquer over the inside of the cans to protect the product integrity.

10. **DIE NECKER** squashes can openings down to end specifications.

11. **FLANGER** folds back the top edge of the can to form a lip used to attach an end to the can after it is filled.

12. **REPROFILE / REFORMER** can either reproduce the outer dome for 262 millimeters or reform the inner dome for strength.

13. **TESTER** checks all cans for possible pinholes or other damage.

14. **CAMERA INSPECTION** checks for any contamination that might be in the can.

15. **PALLETIZER** places finished cans on pallets. 308 cans per layer up to 21 layers high, for immediate shipment or storage.

16. **FILLED CAN** After being shipped to the customer, the cans are filled at high speeds and the ends are attached.