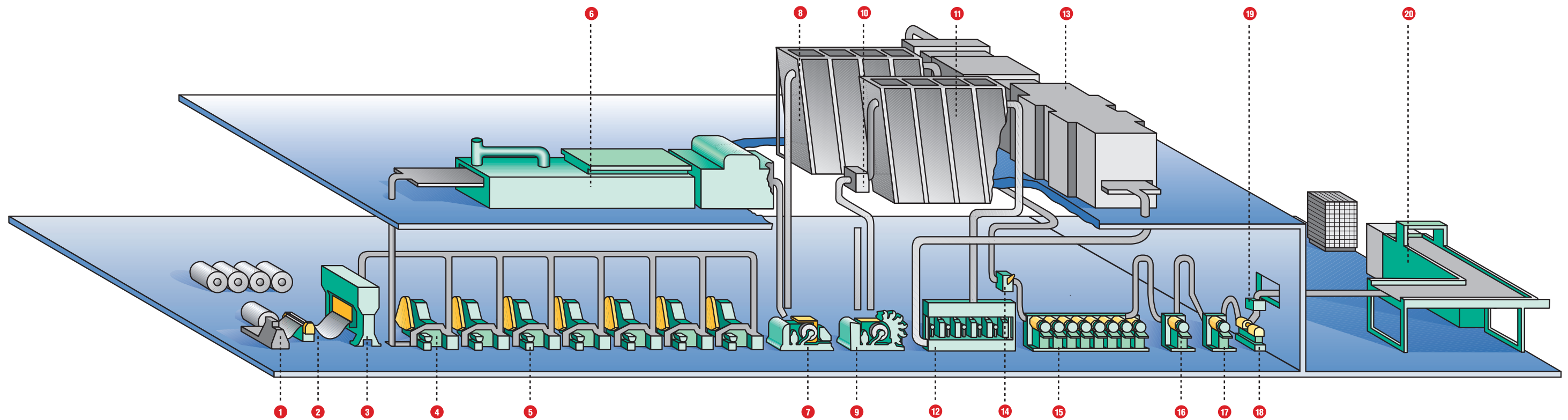


Inside a Ball Beverage Can Plant



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

2 LUBRICATOR
applies a thin film of lubricant to the aluminum sheet and then feeds the metal into a cupper.

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

4 BODYMAKERS
use a punch mounted on a ram to push the cups through a series of tooling dies that redraw and iron the cups into cans.

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

6 WASHER / OVEN
washes, rinses and dries cans in preparation for the application of internal coatings and labels.

7 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.

8 BASECOATER OVENS
Cans are conveyed to the basecoater oven where the basecoat is cured onto the cans used.

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

10 BOTTOM COATER
applies a coat of lacquer to the rim around the bottom of cans to protect the aluminum.

11 DECO OVEN
cures the inks and coatings.

12 INTERNAL COATERS
spray a thin layer of lacquer on the inside of the cans to protect product integrity.

13 INTERNAL COATER OVEN
cures the internal coating.

14 WAXER
applies a thin coat of lubricant to the outside of the open edge of the cans in preparation for necking.

15 DIE NECKER
squeezes can openings down to end specifications.

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

17 REPROFILE / REFORMER
can either reprofile the outer dome for 202 stackability or reform the inner dome for strength

18 TESTER
checks all cans for possible pinholes or other damage.

19 CAMERA INSPECTION
checks for any contamination that might be in a can.

20 PALLETIZER
places finished cans on pallets, 389 cans per layer up to 21 layers high, for immediate shipment or storage.

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