



STOLLE MACHINERY



C O N N E C T I N G
C U S T O M E R S + T E C H N O L O G Y

Located Where You Need Us

Stolle has strategically located facilities around the globe to reduce shipping times and locate our Rapid Response Field Service teams at your doorstep.

With warehousing and rebuild capabilities close to you, Stolle offers OEM parts, rebuild and repair services, and continual support in the fastest times possible - anywhere on the globe.





Stolle has invested in Precision Machining Centers across the globe to protect the quality and delivery of parts. Our Technical R&D facilities are dedicated to improving and advancing equipment.



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Stolle Global Systems

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Beverage End Lines

Food & Aerosol Can Lines

Food End Lines

Parts & Service

Rebuilding Services

Stolle Global Systems



Total Integration Services **from design through installation & beyond** **New facilities, line upgrades, size changes, or factory** **relocations with single source responsibility**

From a full can or end facility to a line upgrade, we design, engineer, coordinate, install and commission your project – additionally we can help you staff, train and maintain your plant.

- Beverage can lines
- Beverage end lines
- Food can lines – D&I or DRD
- Food end lines – EOE or sanitary
- Aerosol can lines

Hanacans
(Vietnam)



Great Metal China
(Taiwan)



Bangkok Can Manufacturing
(Thailand)



O.R.G. Packaging
(China)



CPMC
(China)



Abul Jadayel
(Jeddah, S. A.)



Rexam UAC
(Dammam, S.A.)
(Recife, Brazil)



Golden Era
(South Africa)



Al Jomaih
(Riyadh, S. A.)



Kian Joo
(Malaysia)



Helvetia Packaging
Helvetia Packaging
(Europe)



Many members of our team are former can plant employees who have the practical day-to-day experience to understand your issues and the experience to know how to handle them.

Process Consulting & Analysis for single machines or lines

Tooling, can and end design and optimization services
with complete technical support throughout

Stolle provides design and engineering expertise in all aspects of can and end production. Our experience and sophisticated software helps you run smoothly and profitably.

- Can & End Design
- Tooling Design & Optimization
- Production Process Consulting
- Technical Support
- Value Added Services



Ceylon Beverage Can
(Sri Lanka)



Next Can Innovation Co.
(Thailand)



SABECO
(Vietnam)



BAOSTEEL

Baosteel
(Chengdu, China)
(HCMC, Vietnam)



ROYAL
CAN MAKING CO.

**Royal Can Making
Company (Iraq)**



Mahmood Saeed
(Jeddah, S.A.)

DSC
DS CONTAINERS

DS Containers
(USA)



QUALITYPACK

Quality Pack
(Hungary)



AB InBev

AB InBev
(South America)



Vinacans
(Vietnam)



STOLLE MACHINERY

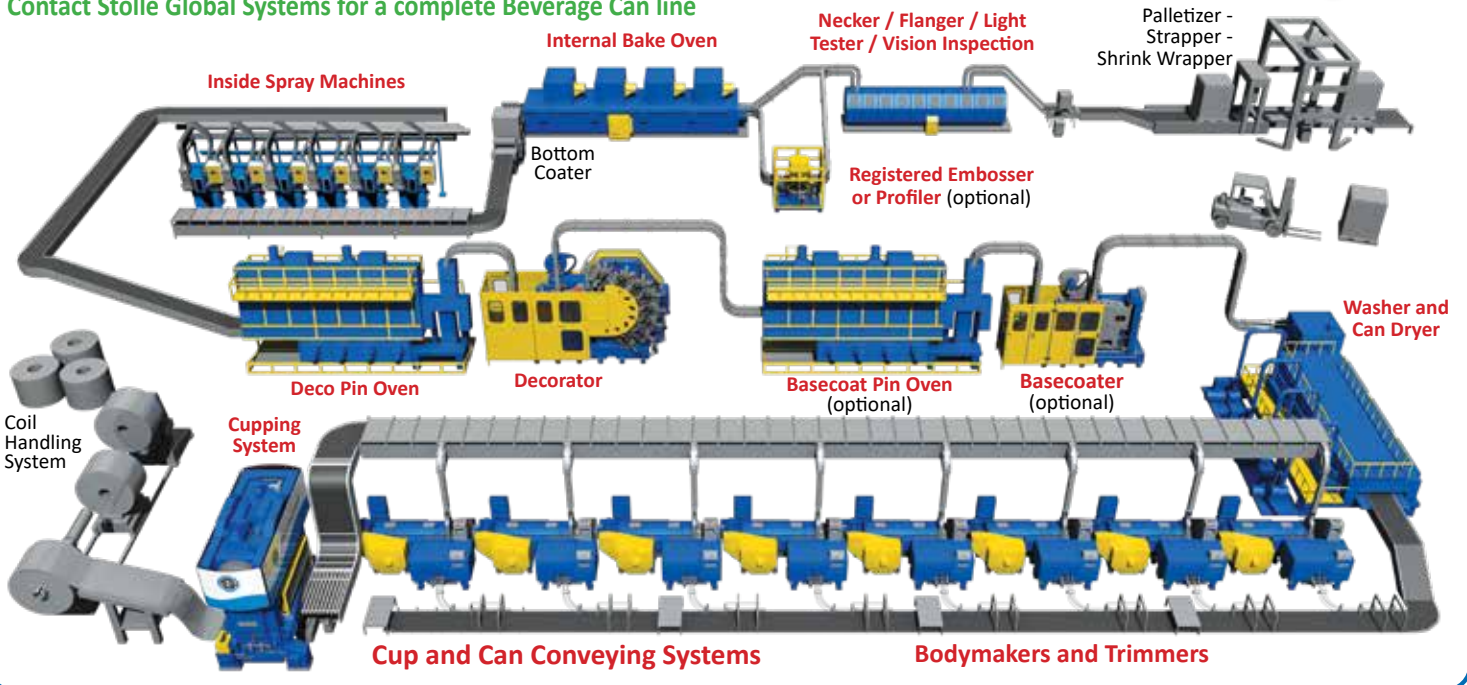
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Beverage Can Production



Contact Stolle Global Systems for a complete Beverage Can line



Stolle is the world's leading supplier of machinery for the high speed production of 2-piece beverage can bodies.

- All sizes of aluminum and steel beverage cans, including preforms for popular bottle cans. Every Stolle machine is proven to withstand the demands of high speed, high precision production with minimal maintenance and downtime.

Stolle designs, builds and services individual machines, lines, or complete canmaking facilities.

Cupping Systems

Quality can bodies begin with quality cups, and Stolle cupping systems produce the highest quality cups with maximum speed, reliability and material efficiency.

The 165-ton high volume **DynaForm** cupper features the latest cost-saving press technology, and the 150-ton **Triton** cupper is the most widely used and trusted cupping system in can plants around the world.



DynaForm Cupper



Triton Cupper

DWI Bodymakers

Stolle **Standun** and **Ragsdale Bodymakers** lead the industry in the production of two-piece D&I can bodies. These horizontal presses are engineered and built to maintain the extremely close tolerances required for can bodies day after day. They are available in a range of stroke lengths and tool pack sizes for producing small juice cans to tall aluminum bottle can preforms.



Standun Bodymaker



Ragsdale Bodymaker

Stolle Trimmer

The Stolle **Trimmer** provides maximum flexibility for multiple can sizes up to 10" high – a slide base allows the 3 trimming heads to be easily repositioned for different can heights with no change parts needed. The machine features stationary can pads and trimming heads that move the knives to the cans – the can bottoms remain in alignment with the domer which allows for simpler and more reliable crossover trackwork.



Coolant Filtration System



The Stolle **Coolant Filtration System** can process up to 660 gallons of coolant per minute to accommodate up to 20 bodymaker machines. It features two carbon steel pressure vessels with advanced design filter cartridges that deliver high flow in a compact housing, as well as a rapid cleaning cycle.

Optimus Can Washer

The **Optimus Can Washer** thoroughly cleans and treats the surface of aluminum or steel can bodies upon discharge by the bodymakers/trimmers. The multi-stage machine has wash, rinse and treat sections, and can be custom-built with other sections and features. Each Optimus washer is designed to meet specific customer requirements, which may include additional rinse stages, heated stages, counter-flows and backflows.



Optimus Can Dryer

The **Optimus Can Dryer** completely and efficiently dries the cans after they exit the washer with heated forced air. It incorporates a suction-type impingement recirculating air system which allows for a high heat transfer rate, while maintaining can stability via vacuum throughout the heating zone.



Basecoaters

For beverage label branding that requires basecoated cans, Stolle **Concord** and **Rutherford Basecoaters** apply a solid opaque coating to cans at speeds up to 2000 CPM (Concord 36MRT). Both machines have dual coating units with independent speed controls that produce highly accurate coating weights and a superior can finish with minimal overlap and slinging.



Concord Basecoater



Rutherford Basecoater

Decorators

Stolle **Concord** and **Rutherford Decorators** are the can industry's leading machines in high speed, high quality decoration of 2-piece beverage cans. Both machines feature 8 ink stations plus varnish for maximum production flexibility, while the Rutherford Decorator is also available with a 9-color print section equipped with High Performance Inkers. Both machines are available with Inkjector technology - automated fountains controlled from the HMI. Both are also available in special "tall" versions for decorating cans and bottle cans up to 10.5"H.



Concord Decorator



Rutherford Decorator

DecoCure Pin Oven

This specialized oven accepts cans on the pin chain from a decorator or basecoater machine and thermosets the coatings so the cans can be handled in the next steps of production without damaging the finish. The **DecoCure Oven** features next generation burners, superior temperature uniformity throughout, and an optimum heat transfer rate for energy savings and cost efficiency.



Inside Spray Systems

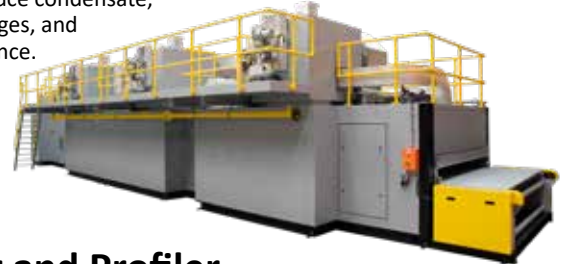
Stolle inside spray systems apply a coating to the inside surface of two-piece can bodies at high speed and with maximum production efficiency. Stolle

offers two ISM models that feature the latest in inside spray technology: the **DG-250** (dual gun) has two spray guns to coat the inside of the can, while the **TG-350** has a third gun to spray the can dome.



InterCure Oven

The Stolle **InterCure** internal bake oven cures the water-based coating inside can bodies, while finish-curing the inks and coatings on the outside. This oven is constructed with high quality materials and incorporates many features that reduce condensate, lower energy usages, and reduce maintenance.



Embosser and Profiler

These specialized machines are designed to add tactile patterns to the wall of DWI beverage cans for enhanced brand awareness. The **Registered Embossing Machine** embosses patterns in the can wall that register with the printed decoration, and the **Profiler Machine** creates concave flutes on the height of the can body which give it a distinct feel and improves its structural integrity.



Embossing Machine

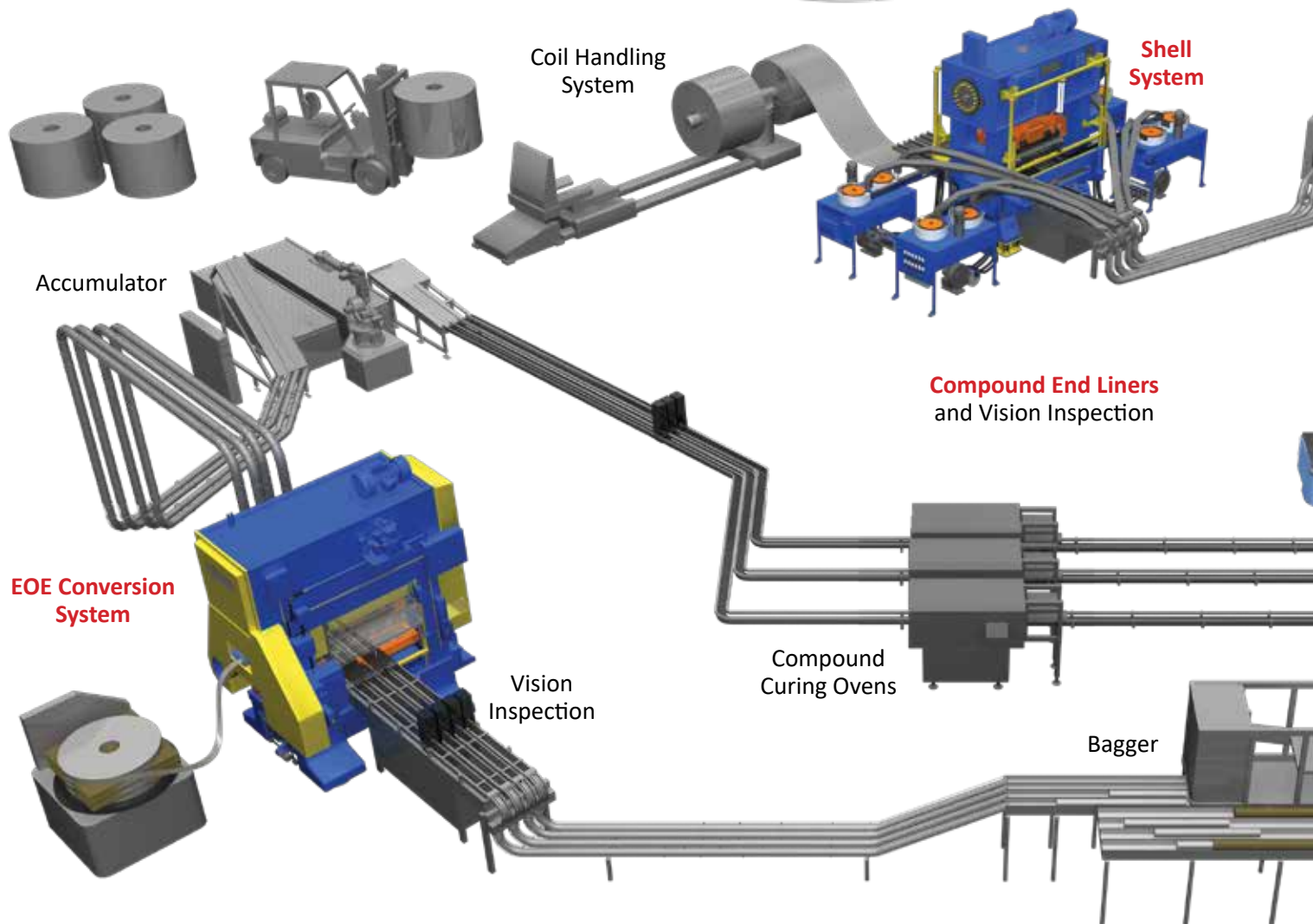
E-NCKR Die Necking System

The Stolle **E-NCKR** is versatile system for necking and performing other finishing functions such as flanging, bottom reforming, light leak testing. Complete infeed and discharge vision inspection can also be added.



Individual process modules can be customized to customer specs. The system features quick change tooling that greatly exceeds all other comparable equipment on the market. The Stolle E-NCKR can be quickly and easily be modified to run different can sizes.

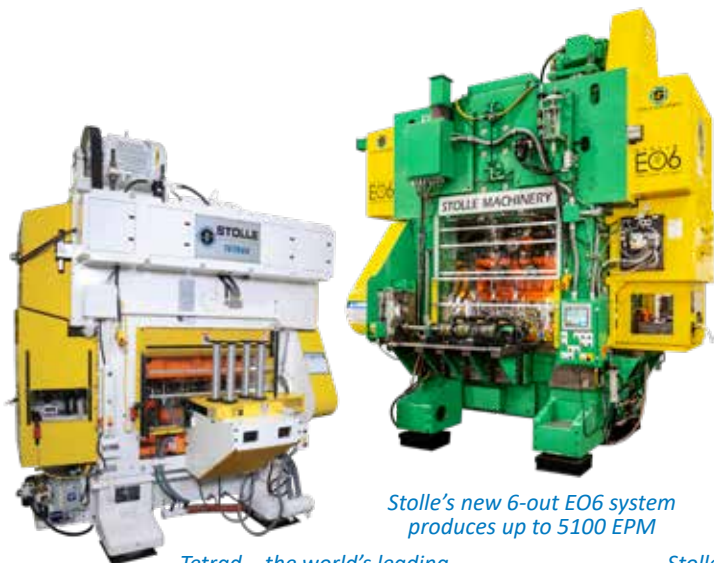
Beverage End Production



Contact Stolle Global Systems for a complete Beverage End line

Easy-Open End Conversion Systems

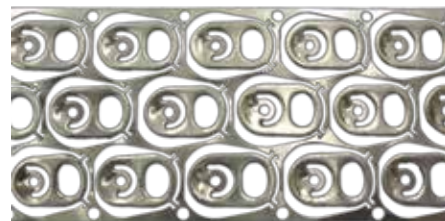
Stolle high speed conversion systems are the choice of canmakers around the world for producing easy open ends for beer and beverage cans. Introduced in early 2020, Stolle's new six-out EO6 system features a new design 140 ton press that operates up to 850 SPM to produce an astounding 5100 EPM. It features three 2-out lane dies and a new design 6-out tab die. The 4-out Stolle **Tetrad** is the world's leading EOE conversion system, producing up to 3000 ends per minute, while the 3-out **System H** produces in excess of 2100 EPM. Both of these systems use an industry-proven 125 ton single-action press that operates at speeds of 700+ SPM (depending on end size). Timely tooling design updates guarantee that a Stolle conversion system will provide leading edge EOE technology, providing customers with efficiency, economy and increased consumer value.



Tetrad – the world's leading beverage EOE conversion system

Stolle's new 6-out EO6 system produces up to 5100 EPM

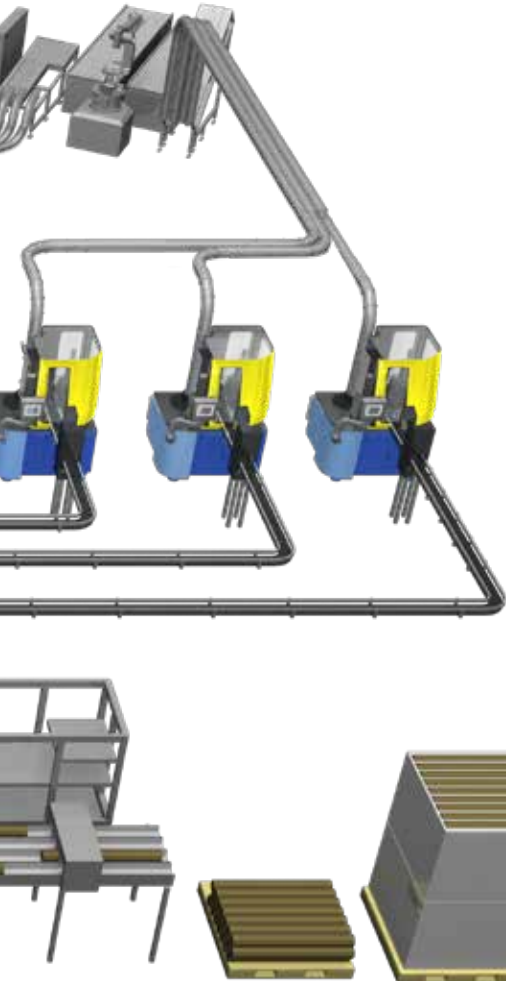
Stolle's exclusive X2 metal-saving tab is available for all Stolle beverage EOE systems



A constant flow of innovations, technology and ideas that benefit customers.

Conveying for any application

Accumulator



28-out wide coil SRC shell system



8-out narrow coil SRC shell system

SRC Shell Systems

Stolle **single-action rotary curled (SRC)** shell and end systems deliver speed, efficiency and consistently high end quality. These systems feature “Reverse Form” single-action tooling, which allows use of a simpler single action press with lower maintenance requirements. Air conveying positively transfers the shells from the die pockets to the curlers with no moving parts, and the external rotary curlers can be TEC-240 curlers configured up to four levels high. Individual air conveyors and curlers for each tooling pocket eliminate shell blending and increase system operating efficiency. These unique features allow Stolle SRC systems to offer the industry’s lowest tooling costs per 1000 shells, maximum shell consistency and easier set-up and maintenance. Systems are available in a variety of configurations to meet varying production requirements, including aluminum and steel material, sheet or coil-fed, and wide or narrow coil widths.

Rotary Compound End Liners

Stolle Liners lead the industry in applying sealing compound to beer-beverage shells with maximum production speeds and compound usage efficiency. Featuring up to 10 compound applicators, the **Vortex** liner can produce up to 2600 EPM – a 25% production increase in the same floor space as other liners. This greater throughput makes it possible to eliminate one liner in a high volume beverage end module. It also includes a number of design innovations, including advanced applicator controls and solenoid driver, precision index control, advanced diagnostics and a floor space-efficient modular design. Industry standard Stolle **VHSL** and **HSL** rotary liners are available for either water or solvent-base compound. Stolle also offers a full line of liner support equipment, including compound supply systems, conditioning systems for solvent-base compound, and a nozzle brush cleaning system for water-base compound liners.



Vortex Liner



VHSL Liner

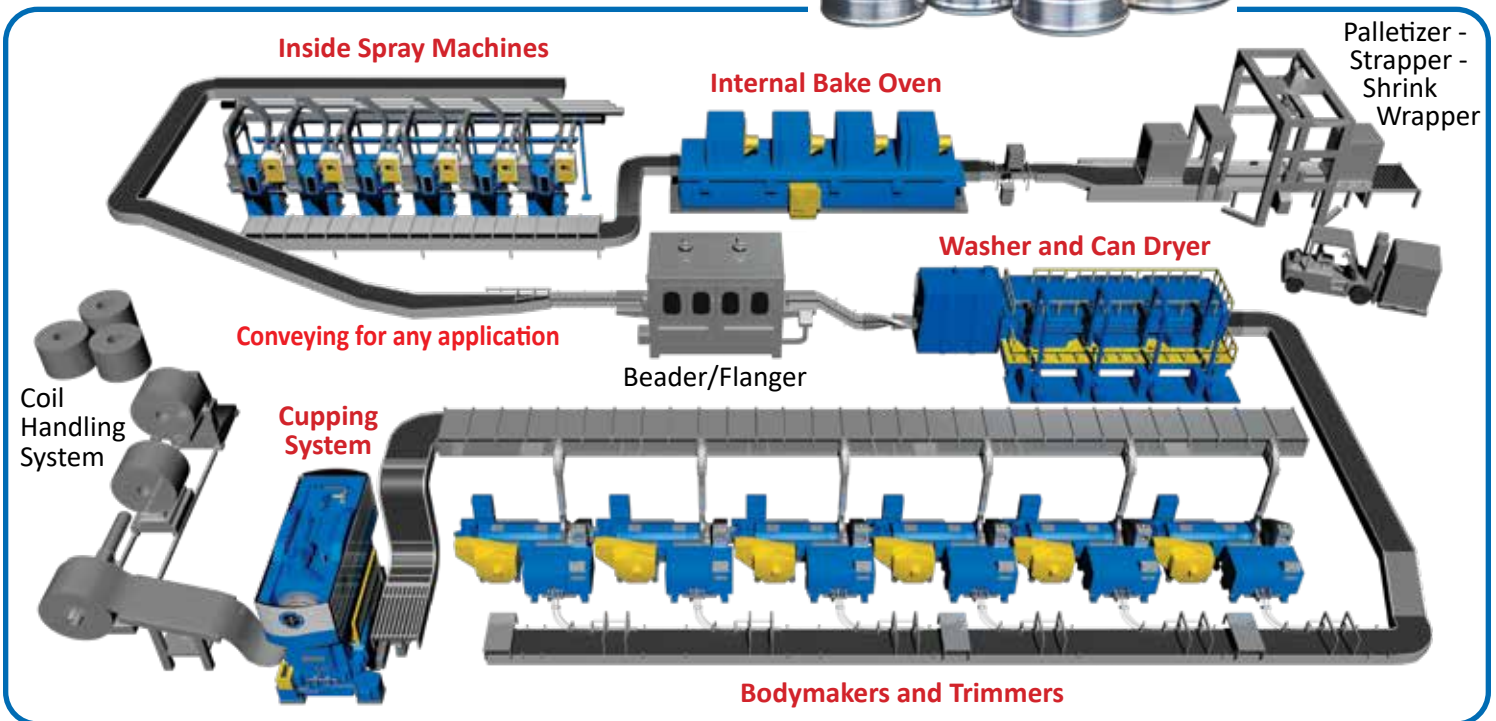


Accu-Riv Inspection System

The Stolle **Accu-Riv** is a bench inspection system for testing and verifying that rivet formation conforms to all specifications and tolerances at each step of the easy-open end conversion progression. The Accu-Riv provides a standard method to verify that lids manufactured on Stolle EOE presses conform to all specifications and tolerances. The system accurately measures bubble height and thickness, rivet form height and thickness, coin residual, “C” bead height and panel depth, stake rivet head residual and rivet restrike dimensions. The Accu-Riv can be used to measure an individual product characteristic or the characteristics of a complete lane progression, and more than one critical measurement can be obtained on several test areas. This allows the user to isolate the testing process to any stage of product development.

Food Can Production

D&I



The high volume production of 2-piece D&I food cans requires many of the same machines used to produce beverage cans. The major difference is that the walls of food cans are closer to the original thickness of the metal, and are typically beaded to add strength for the retort process which evacuates the air from the filled and sealed cans while sterilizing the contents. Stolle can provide a single machine or a complete line with machines that are customized to produce steel or aluminum food cans from sheet or coil-feed material. In addition, Stolle can supply a complete line to produce either easy-open or sanitary ends for the cans (see the following pages).

Stolle Machines for Producing D&I Food Cans

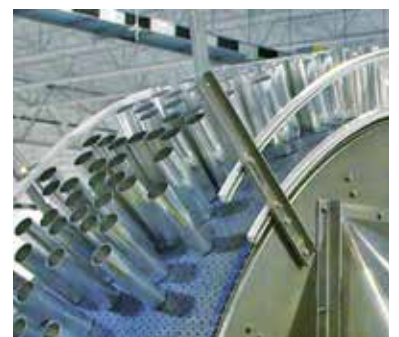
- Triton Cupping System
- Bodymakers
 - Ragsdale
 - Standun
- Coolant Filtration System
- Stolle Trimmer
- Optimus Can Washer & Dryer
- Inside Spray Machines
- Light Leak Testers
- InterCure Internal Bake Oven

For more information, on these machines, please see pages 6 & 7



2-Piece D&I Aerosol Cans

Many of the same machines used to produce D&I food cans are also used to produce metal-saving 2-piece aerosol can bodies. We have the capabilities and experience to supply individual machines or a complete line or can plant for high volume aerosol can production. In fact, Stolle designed and built the world's first high speed 2-piece can line for a major U.S. aerosol canmaker. We handled the design, construction, acquisition of non-Stolle equipment, machine installation, line start-up and commissioning. Talk to Stolle Global Systems about your high volume aerosol can production needs.



2-piece food cans – Drawn & Ironed (D&I) and Draw-Redraw (DRD)

The D&I method produces round food cans in higher production volumes in heights from 5.12" to 6.00" and diameters from 202 to 307. The DRD method can produce round or non-round cans in a wide variety of heights and diameters in lower volumes with more economical machinery. Stolle's extensive experience with both production methods means that we will supply the most efficient and productive machinery for your production goals.

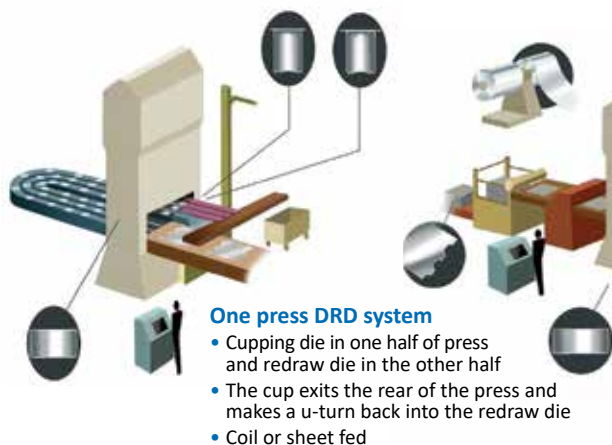
Food Can Production

DRD

Stolle designs and builds customized Draw-Redraw systems for any type of 2-piece food can, as well as other types of drawn containers such as aerosol cans, oil filter casings, propane cylinders, battery casings, etc. Stolle high volume two and three-press and low volume one-press DRD systems are designed to produce maximum strength containers from reduced gauge material in coil or sheet, including pre-printed sheet stock. Our systems can produce shallow or deep drawn, straight or tapered wall, or reduced sidewall containers that range from 200 in diameter to 507 in height. Both the cupping and redraw die sets are designed for fast changeover for converting to other can sizes with minimal downtime. Stolle's Electronic Servo cupping system features a servo motor-driven can transfer system in the redraw press that allows for greater production flexibility and faster can size changeovers.



Electronic Servo DRD System

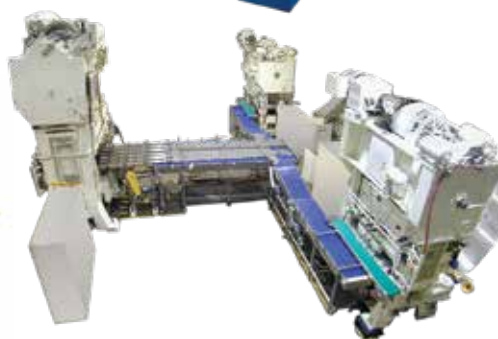
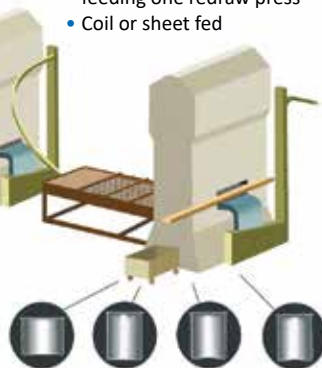


One press DRD system

- Cupping die in one half of press and redraw die in the other half
- The cup exits the rear of the press and makes a u-turn back into the redraw die
- Coil or sheet fed

Two press DRD system

- One cupping press feeding one redraw press
- Coil or sheet fed



Three press DRD system

- Two cupping presses feeding one redraw press
- Provides flexibility to run two different cup sizes at the same time
- Coil or sheet fed



Industry-standard rectangular meat can DRD system developed by Stolle

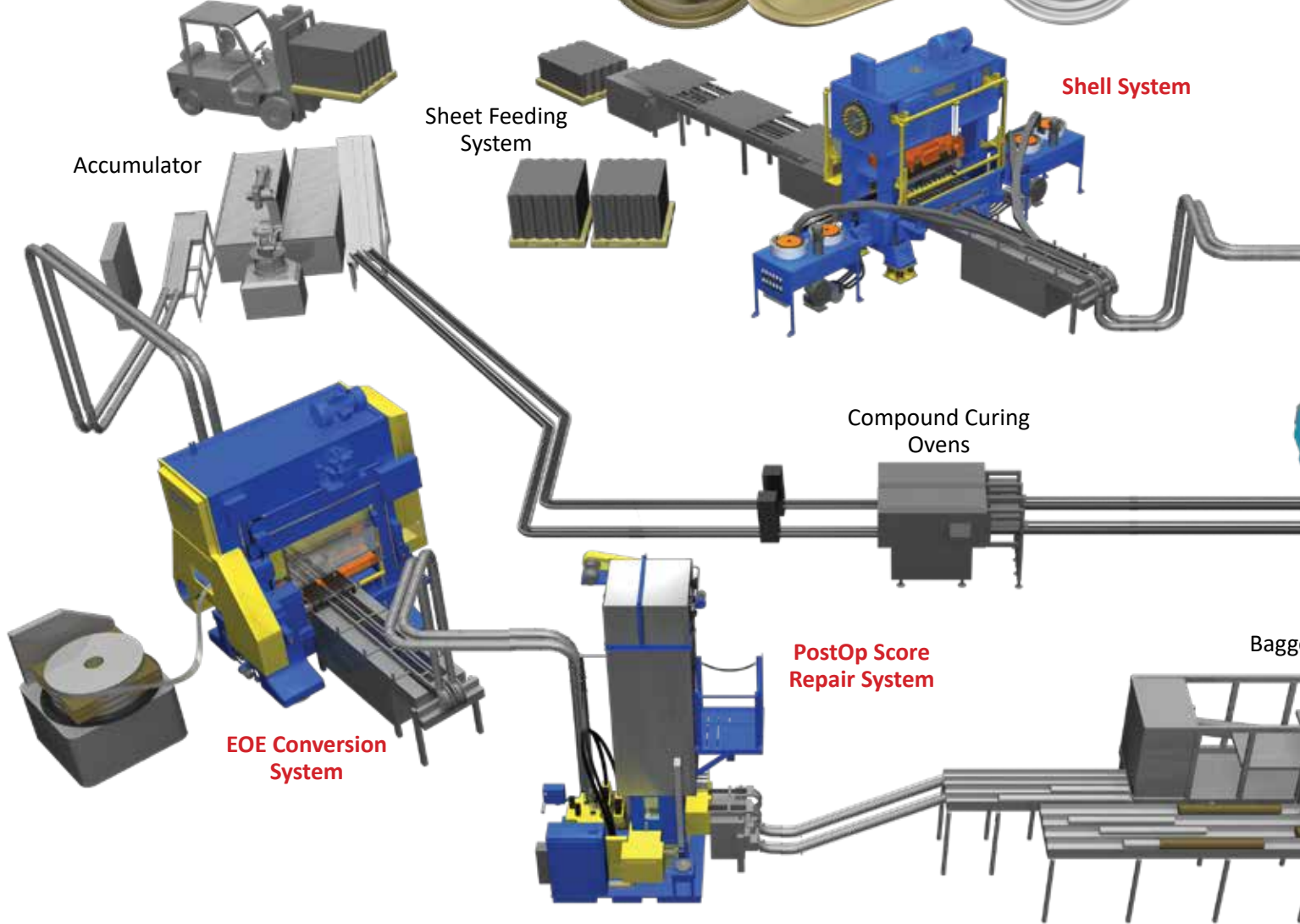
Stolle has experience in designing and building DRD systems for all types drawn cans and other metal products that meet any production volume requirement. A Stolle sales engineer will be happy to discuss your specific drawn product and production requirements and quote the best and most efficient DRD system to meet them.

Food Can Fillers

Stolle PRC WeightControl Fillers have a long reputation for quality and reliability with food and pet food companies around the world. Widely regarded as the most accurate filling machines available, they offer accuracies equal to $\pm\frac{1}{2}$ to 1%, even on difficult to fill products, which reduces wasted product due to overfilling and eliminates rejects due to underfilling. Stolle PRC WeightControl have a simple rotary design and few moving parts for low maintenance, and are ruggedly constructed of heavy-duty stainless steel and other non-corrosive materials to withstand daily cleansing. Talk to Stolle about your unique can and carton filling requirements, as well as OEM spares for all PRC food machines.



Food End Production



Contact Stolle Global Systems for a complete Food End line

Full Open End Conversion Systems

Stolle food end conversion systems provide adaptable and flexible solutions for all full-open end requirements. Incorporating the proven technology of our world-reknown beverage end systems, Stolle food end systems are custom-designed to convert steel or aluminum ends in a variety of sizes, shapes and metal thicknesses. Stolle offers several food end conversion systems to meet different production volume requirements, including the high capacity 4-lane **Mega 4** and the 3-lane **Mega 3** systems, and the lower capacity **Mega 2H** system. These systems can be configured to run round ends as well as square, rectangular, oval, $\frac{1}{4}$ club and $\frac{1}{4}$ Dingley shapes. Food system customers will benefit from Stolle's continuing technical innovations for full open ends, including rivet designs for single-reduced (SR) and double-reduced (DR) steel ends, a more consumer-friendly and metal efficient food end tab that offers reduced pop and pull force for both SR and DR steel ends.



Mega 2



Mega 4

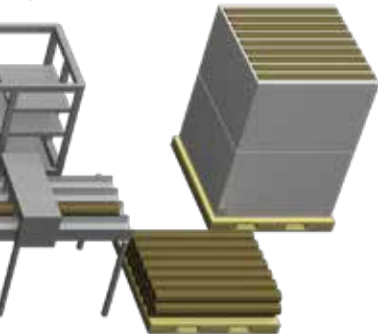
Stolle supplies food can makers a complete line for producing either full-open EOE food ends or sanitary ends. Whether aluminum or steel, coil or sheet-fed, high or low volume, round or non-round ends - Stolle has the equipment and expertise to deliver the most productive and cost-efficient end line available.

Conveying for any application

Compound End Liners and Vision Inspection



er / Palletizer



Shell and End Systems

Stolle single-action rotary curled (SRC) shell and end systems can be configured to produce any type of round food end from steel or aluminum, including shells for easy-open end conversion or finished sanitary ends. Our wide or narrow coil-fed systems can produce ends from 113 to 209 diameter, and our sheet-feed systems can produce shells and ends from 200 to 401 diameter. Our new FLEXOR system is designed for lower-volume producers of full-open or sanitary food ends, including fillers who produce their own lids. This advanced yet economical sheet-feed end making system features a lower cost portal press and versatile Stolle-design robotic sheet feeding system. All Stolle shell systems feature our exclusive "Reverse Form" single-action tooling, air shell conveying, and our TEC-240 external rotary curlers. These unique features allow Stolle SRC systems to offer the industry's lowest tooling costs per 1000 shells, maximum shell consistency and easier set-up and maintenance.



FLEXOR sheet feed shell and end system features a lower cost portal press and a robotic sheet feed system



6-out narrow coil shell system

VHSL Liner



Rotary Compound End Liners

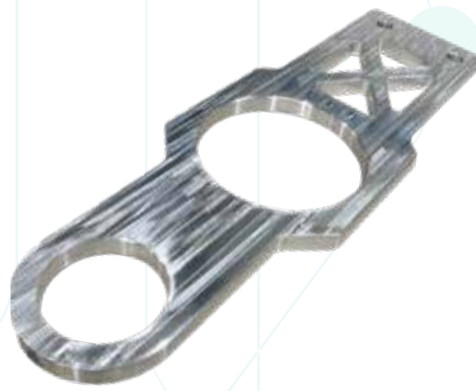
Stolle **VHSL** and **HSL** rotary liners are available with 4, 6 or 8 applicators for applying sealing compound to food ends from 200 to 603 diameter with maximum efficiency. The most popular compound liner in the world, the Stolle VHSL Liner has independent variable-frequency drives for the applicator turret and lower chucks that can adjust to varying line speeds.

For endmakers who produce one end size at a constant speed, the economical HSL Liner uses a single drive for the lower chuck and turret drive. Both machines are available for applying water or solvent-base compound, as well as plastisol compound for lining lug caps. A unique triple-screw downstacker ensures that larger diameter ends (above 307) are evenly supported and fed smoothly into the starwheel with no marks or scratches. Stolle also offers a full line of liner support equipment, including compound supply systems, conditioning systems for solvent-base compound, and a nozzle brush cleaning system for water-base compound.

PostOp Score Repair System



The Stolle **PostOp System** applies a food safe coating material to the score line and tab rivet head on round steel full open food ends from 202 - 401 to protect the exposed base steel. On both areas, the coating application eliminates the possibility of rust or corrosion that could negatively impact the can's consumer appeal. The most productive score repair system available, the Stolle PostOp has two lanes that operate at 500 EPM for a total throughput of 1000 EPM – equivalent to many two-out full-open end conversion systems. The PostOp system includes a reliable Stolle high speed end transfer system, coating spray system and a vertical gas-fired curing oven. Stolle's innovative servo-driven oscillating spray head uses two nozzles that each coat half the end at half the speed as a single nozzle spray head, which reduces coating usage, maintenance and overspray. The patented rivet spray system uses high speed cameras on both lanes to locate the position of the tab rivets, and servo motors move separate 2-nozzle spray assemblies to apply coating precisely to the rivet heads.



Global Parts and Service

Stolle is constantly evolving to get our quality OEM parts and Rapid Response service to you faster and more economically than ever before. With expanded service centers around the globe, our technical teams offer expert service with reduced travel times and fewer language barriers.

Stolle customers also have access to a large parts inventory, highly trained technicians and the latest technology, training and engineering support all located to help reduce your downtime and maximize your profits.

- The most reliable, highest precision OEM replacement parts available for rapid delivery
- Expert field technicians and rapid response teams are located throughout the world and trained in every aspect of the assembly, maintenance and operation of our machinery.
- Comprehensive equipment training materials and programs delivered by skilled and experienced training and service personnel.



Stolle Parts and Service Centers Around the Globe

Centennial

- Standun and Ragsdale Bodymakers
- Concord and Rutherford Decorators & Basecoaters
- Concord and Rutherford Inkers
- Inside Spray Machines
- Reynolds and Alcoa (Borden/Randolph) Light Testers
- Embosser and Profilers
- Stolle PRC Fillers and other food equipment

Canton

- Cupping Systems
- Wide and narrow shell systems and die sets
- Redraw dies and transfer systems

Sidney

- Beverage & Food EOE Conversion Systems and die sets
- VHSL and HSL Compound End Liners
- PostOp Score Repair System

Stolle Brazil

- Cupping System
- Standun and Ragsdale Bodymakers
- Concord and Rutherford Decorators
- Inside Spray Systems
- Can Body Light Testers
- Shell Systems
- VHSL and HSL Compound End Liners
- Vortex Liners
- Conversion Systems & die sets

Stolle Europe

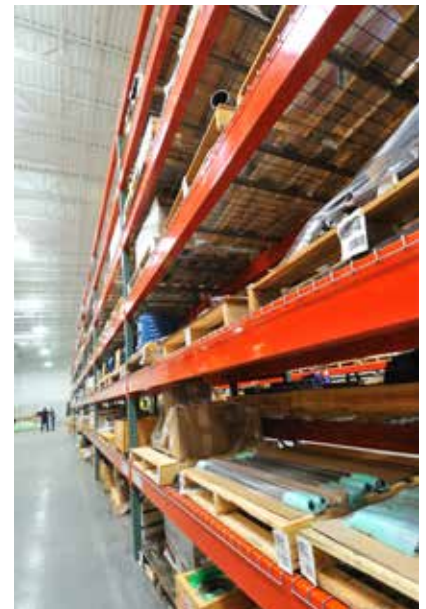
- Cupping Systems
- Standun and Ragsdale Bodymakers
- Coolant Filtration System
- Can Washer and Dryers
- Concord and Rutherford Decorators
- Pin Ovens
- Inside Spray Machines
- Internal Bake Ovens
- Light Testers
- Embosser and Profilers
- Shell Systems
- Compound End Liners
- EOE Conversion Systems

Stolle China

- Cupping Systems
- Standun and Ragsdale Bodymakers
- Trimmer
- Concord Decorators & Basecoaters
- Inside Spray Machines
- Shell Systems
- EOE Conversion Systems

Stolle Asia Pacific

- Cupping Systems and die sets
- Standun and Ragsdale Bodymakers
- Concord and Rutherford Decorators
- Inside Spray Machines
- EOE Conversion Systems





Stolle Rebuilding Services

Stolle can bring new life to die sets and machinery with our comprehensive rebuilding services. All dies are rebuilt with OEM parts from Stolle's own machining facilities or OEM suppliers to ensure compatibility and accuracy. Our Canton and Europe facilities have high precision SIP machining centers for machining cupping die shoes to the original specifications. We can also rebuild complete Stolle-built machines, as well as presses for cupping, shell and conversion systems with OEM parts and technicians. Since we can rebuild many die sets and machines at our facilities around the world, shipping costs are lower while still maintaining Stolle quality and attention to detail.

A Partial Listing of our Global Rebuild Capabilities

Centennial

- Standun and Ragsdale Bodymakers
- Trimmers
- Concord and Rutherford Decorators, Basecoaters, Inkers and OV units
- Inside Spray Systems
- Reynolds and Alcoa (Randolph) Can Body Light Testers
- PRC Fillers and other food equipment

Canton

- Cupping and Draw-Redraw die sets
- Wide and narrow shell die sets
- Cupping and Draw-Redraw presses

Sidney

- Beverage & Food EOE Conversion Systems and die sets
- VHSL and HSL Compound End Liners

Stolle Europe

- Cupping die sets
- Standun and Ragsdale Bodymakers
- Trimmers
- Concord Decorators, Basecoaters, Inkers and OV units
- Rutherford Decorators, Basecoaters, Inkers and OV units
- Inside Spray Systems
- Light Testers
- Wide and narrow shell die sets

Stolle Brazil

- Standun and Ragsdale Bodymakers
- Rutherford Decorators, Inkers and OV units
- Cupping Systems and die sets
- Shell Systems – wide and narrow shell dies
- EOE Conversion Systems – lane and tab dies
- Inside Spray Machines
- Compound End Liners
- Reynolds and Alcoa (Randolph) Light Testers
- Controls & electronics upgrades/updates (NR-12 Certified)
- Sencon Gauges – calibration and upgrades

Stolle Asia Pacific

- Ragsdale Bodymakers
- Inside Spray Machines
- Concord and Rutherford Decorators, Inkers and OV units
- Cupping Presses & die sets

Stolle China

- Cupping die sets
- Standun and Ragsdale Bodymakers
- Rutherford Decorators, Basecoaters, Inkers and OV units
- Concord Decorators, Basecoaters and Inkers and OV units
- Inside Spray Systems



Stolle is the world's leading supplier of two piece can and end-making machinery for the global canmaking industry. We develop and guide a constant flow of innovations, technology and new ideas that benefit customers and enhance the metal packaging industry.



Can Machinery
End Machinery
Dies and Tooling
Field Service
Food Fillers
OEM Parts
Training
Engineering
Complete Lines
Conveying Systems
Machine Rebuilding
Production Analysis

Centennial, CO US
Canton, OH US
Sidney, OH US
Indaiatuba, BR
Carlisle, UK
Altham, UK
Gliwice, PL
Amman, JO
Bangalore, IN
Shanghai, PRC
Guangzhou, PRC
Ho Chi Minh City, VN



STOLLE MACHINERY

www.stollemachinery.com