STOLLE MACHINERY

October 30, 2026

Cupper Die Service Update

Dear Valued Customer,

Effective immediately, Stolle Machinery is updating the terminology and service options for cupper die re-seals/rebuilds. Level 1 and Level 2 services will be designated as Re-Seals, and Level 3 service will be designated as a Rebuild. The service scopes are detailed on the following pages.

Service level	Scope overview
Level 1 Re-Seal	Seal replacement, cylinder liner installation, leak testing, and a visual die set audit with report.
Level 2 Re-Seal	Seal and guide pin replacement, cylinder liner installation, leak testing, and a dimensional die set audit with report.
Level 3 Rebuild	Expanded component replacement, machining as needed, scrap cutter realignment, leak testing, and a dimensional die set audit with report.

Level 1 and Level 2 Re-Seals are available as parts kits, with the option to have the work performed on-site by a Stolle service technician. All Re-Seal kits are quoted and supplied by our North Canton facility.

On-site Level 2 Re-Seal service requires a granite table large enough for the cupper die, maintained to Grade A, and a SquareMaster with right-angle calibration granite. If these requirements cannot be met, the die must be returned to Stolle for service.

Before sending a die to Stolle for a Level 3 Rebuild, please contact me or Nathan Thomas to request a quote and/or an RMA.

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We appreciate your understanding of this change and your continued business with Stolle Machinery. We remain committed to providing you with the best possible parts and service in the can-making industry.

Thank you,

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Cupper Die Service Scopes

Level One (1) Die Re-Seal (On-Site)

- One (1) lot rubber seals.
- One (1) lot new fasteners.
- Install stock plate cylinder liners.
- Install cup marker cylinder liners.
- Install Stock Plate Piston Retainers (Optional).
- Install Cup ID Marker Retainers (Optional).
- Die Set Disassembly.
- Installation of all new rubber seals.
- Die set re-assembly.
- Leak testing.
- Die set audit and report generation to include visual audit of parts and recommendations for future overhauls.

Level Two (2) Die Re-Seal (On-Site)

- One (1) lot rubber seals.
- One (1) lot new fasteners.
- One (1) set of outer guide pin assemblies.
- One (1) set of inner guide pin assemblies.
- Install stock plate cylinder liners.
- Install cup marker cylinder liners.
- Install Stock Plate Piston Retainers (Optional).
- Install Cup ID Marker Retainers (Optional).
- Die Set Disassembly.
- Installation of all new rubber seals.
- Installation of inner and outer guide pin assemblies.
- Die set re-assembly.
- Leak testing.
- Die set audit and report generation to include Die Flatness, Guide Pin Perpendicularity, and Tram readings. Also, any further recommendations for Future Overhauls.

Please Note: For Level 2 Re-Seal on site, customer will need to have Granite Table (maintained to Grade “A” Standard) and SquareMaster (to check Guide Pin Perpendicularity).

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Cupper Die Service Scopes

Level Three (3) Die Rebuild (Sent to Stolle Canton)

- One (1) lot rubber seals.
- One (1) lot new fasteners.
- One (1) set of outer guide pin assemblies.
- One (1) set of inner guide pin assemblies.
- One (1) lot hardened retainers.
- Stock plate pistons.
- Stock plate piston retainers.
- Stock plate bolts.
- Stock plate piston cylinder liners.
- Die set disassembly.
- Complete wipe down and cleansing of die set, tooling and internals.
- Machining of inner, outer and lower die holder as needed to return the die set to original specifications.
- Machining of guide pin mounting surfaces as needed.
- Installation of new Blank & Draw Die Retainers.
- Installation of all new rubber seals.
- Installation of inner and outer guide pin assemblies.
- Scrap cutter realignment.
- Die set re-assembly.
- Leak testing.
- Die set audit and report generation to include Die Flatness, Guide Pin Perpendicularity, and Tram readings. Also, any further recommendations for Future Overhauls.
- Update and maintain print package.
- Shipping labor (box and crate).