Stolle Beer-Beverage EOE 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. For the highest volume production needs, the Stolle **EO6** has 6 lanes of conversion and tab tooling, and can produce up to *5100 ends per minute* – a 70% increase in volume over a 4-lane Tetrad system. In an end module with a 24-out shell system and 6 liners, this increased throughput will allow three Tetrads to be replaced with two EO6 machines while increasing end production from 9000 EPM up to 10,200 EPM.

STOLLE EO6 Easy Open Six Lane

The world's most productive beverage EOE conversion system

Stolle E06 Conversion System Features:

- Three 2-out transfer belts
- Improved design 6-out tab die
- New design 140 ton Minster ECH-140 press
  - Speeds up to 850 SPM
  - Shorter 1.25" stroke for more efficient operation
  - AIM (Adjust In Motion) – ram shutheight can be adjusted while press is in operation which reduces end spoilage
  - Low deflection slide increases tooling precision
  - 4" ram quick lift for tooling access (higher than 2½" on Tetrad)
- Reliable Stolle end transfer system
- Cast frames on all feed assemblies
- Oil cooling for both transfer belt and tab stock indexers

EO6 discharge side showing three 2-out lane transfer belts and end leak testers

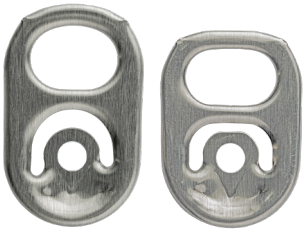
The most widley-used conversion system in the world, the 4-out Stolle **Tetrad** produces up to 3000 ends per minute. Based on a Minster ECH-125 press, the Tetrad features two 2-out lane dies and transfer belts, and a single metal-efficient tab die. Also based on the ECH-125 press, the 3-out **System H** operates at speeds of 700+ SPM (depending on end size) and produces in excess of 2100 EPM.

The Stolle Tetrad is used in more beverage end lines around the world than any other EOE conversion system

System H 3-out high speed conversion system

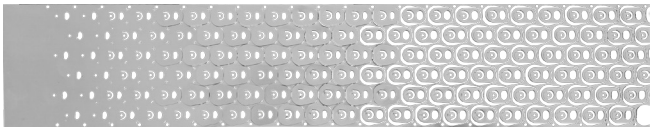
All Stolle conversion systems feature:

- Patented rivet designs and features
- Exclusive tab designs that offer superior opening characteristics and metal efficiency
- Swing-away feed apron provides easy access to tooling
- Belt-driven oil-less downstacker design
- Long life non-metallic transfer belts
- Composite lift gate extends transfer belt life
- Easy-thread push-feed tab stock feeder
- Optional bubble, score, and stake die heaters
- Single blower vacuum system saves energy and reduces maintenance
- Operator-friendly programmable control system
- Strategically-located sensors monitor all system operations
- Sencon or Prime Controls end testers mount on unload assembly



X1 X3

Stolle's exclusive metal-efficient tabs feature easier opening and lower push forces, and are available for all Stolle beer-beverage EOE conversion systems



Timely tooling design updates guarantee that a Stolle conversion system will continue to provide leading edge EOE technology, providing customers with efficiency, economy and increased consumer value.

SUSTAINABLE TECHNOLOGY LEADERSHIP

STOLLE MACHINERY

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Beer-Beverage Conversion Systems

Specifications

	EO6	Tetrad	System H
Press Size	140 ton single action	125 ton single action	125 ton single action
Number of Lanes	6	4	3
Max. Strokes per Minute	850	750	700
Output (maximum EPM)	5100	3000	2250
End Diameter Range	113 – 202	113 – 206	113 – 209
Overall Dimensions - Front-Back	120” (3.048 meters)	113” (2.870 meters)	113” (2.870 meters)
Height (with isolation mounts)	176” (4.4704 meters)	162” (4.115 meters)	162” (4.115 meters)
Weight (approximate)	120,000 lbs (54431 kg)	76,000 lbs (34,473 kg)	70,000 lbs (31,751 kg)
Floor space	12’ W x 13’ L = 156 sq. ft. (14.5 sq. meter) (press & electrical panel; does not include tab stock uncoiler or other equipment)	12’ W x 12’ L = 144 sq. ft. (13.378 sq. meter)	12’ W x 12’ L = 144 sq. ft. (13.378 sq. meter)
Water Supply Requirements	TBD by Minster	The customer-supplied Heat Extraction System to cool the water from the press requires a minimum capacity of 57,350 BTU/HR at an ambient temperature of 90°F	
Electrical Power Requirements	All systems require 380–460 volts – 3 phase – 50/60 Hz (per customer’s requirement)		
	250 Amp service	200 Amp service	200 Amp service
Total Connected HP	123 HP	108.75 HP	108.75 HP
Press Drive Motor	75 HP AC	60 HP AC	60 HP AC
Vacuum Blowers	(1) 30 HP AC	(3) 10 HP AC	(3) 10 HP AC
Ram Quick Lift	4”	2.5”	2.5”
Ram Adjust in Motion	Yes	No	No

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