

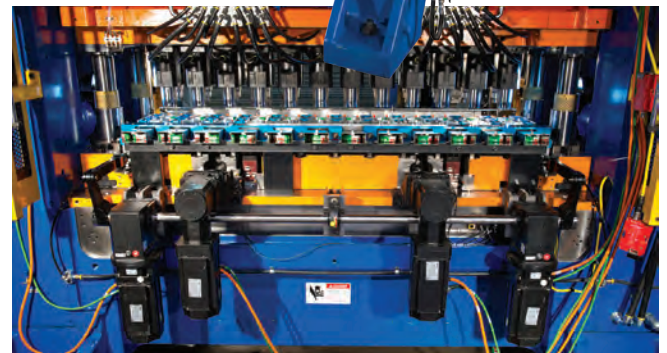
Stolle Draw-Redraw Systems

Connecting

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. These systems 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 Servo DRD system uses a less costly single-action cupping press, and the redraw press features a programmable servo motor-driven can transfer system instead of a press-driven mechanical transfer system. Stolle shallow can systems use one press for both the cup and redraw operations, and include the wide coil ME-CA and narrow coil SDS systems.

Stolle Draw-Redraw System components:

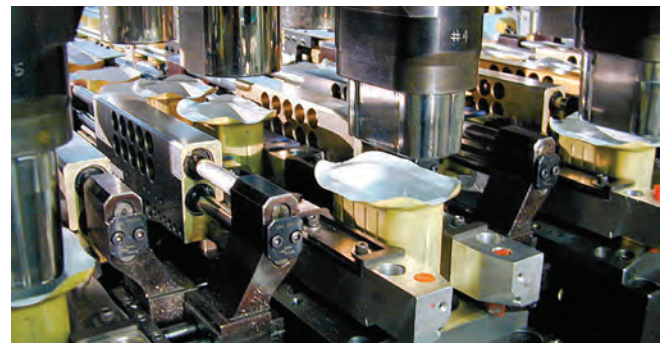
- Sheet or coil-handling equipment
- In-line waxer (if required)
- 100-150 ton double-action cupping press
- Multiple station cupping die
- Cup conveying and accumulating system
- 150 or 300 ton double-action redraw press
- Multiple lane redraw die set with tooling stations that can include first redraw, sidewall reduction, second redraw, panel forming and flange trimming operations
- PLC controls for operating and monitoring the system
- Can conveying to the downline equipment



Above: The Stolle Servo DRD system features a servo motor-driven can transfer system

Left: Low volume single-press SDS shallow can system

Below: Industry-standard rectangular meat can and DRD system developed by Stolle



TECHNOLOGY LEADERSHIP IN CAN & END MAKING

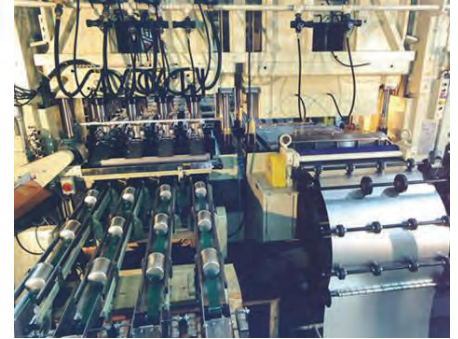
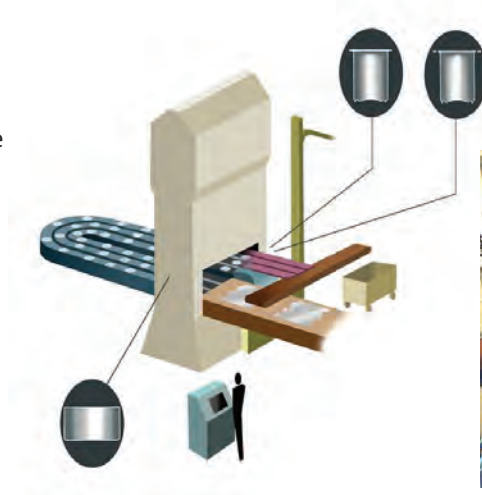


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System Configurations

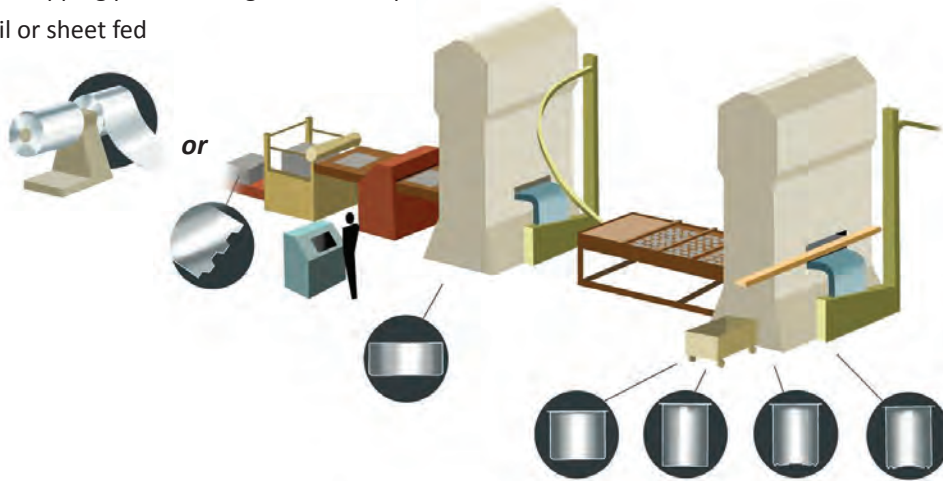
One press DRD system

- 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



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.

Mike Raderchak – Primary Product Contact
+1 330-244-0558 • mike.raderchak@stollemachinery.com

Bob Turnbull – Secondary Product Contact
+1 330-244-0550 • robert.turnbull@stollemachinery.com

Kelly Hurst – Spare Parts
+1 330-244-0555 • kelly.hurst@stollemachinery.com

Brad Brahler – Field Service
+1 330-244-0553 • brad.brahler@stollemachinery.com



STOLLE MACHINERY

Stolle Machinery Company
6949 South Potomac Street, Centennial, CO 80112 USA
303.708.9044 ~ Fax 303.708.9045
sales@stollemachinery.com ~ www.stollemachinery.com