

# Stolle PostOp Post Repair System

Connecting

The Stolle PostOp System is a revolutionary way to repair the scores and rivets of round steel full-open food ends at high speed and low cost. The machine applies a food-safe coating material to the score line to protect the exposed base steel, and in an independent operation applies the same coating to the tab rivet preventing corrosion and adding tab rotation resistance (tab torque). On both critical areas of the EZO end, the coating application eliminates the possibility of rust or corrosion that could negatively impact a steel food can's consumer appeal.

As the most productive score repair system available, the Stolle PostOp System has two lanes that operate at 500 EPM each for a total throughput of 1000 EPM, the equivalent of many two-out full-open end conversion systems. The system includes a high speed end transfer system, coating spray system and a vertical 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. The lower spray head speed reduces coating usage and machine maintenance by more accurately applying the coating with less overspray.

The patented new rivet spray system uses a high speed video camera on each lane to locate the position of the rivets on every end. This position information is relayed to a servo motor that moves a separate 2-nozzle spray assembly to apply coating precisely on the rivet head however the end is oriented in the transfer belt.

Stolle's custom-designed vertical gas curing oven saves valuable plant floor space, and saves energy by recycling some heated air while maintaining VOCs at safe levels. The two lanes of repaired ends are cooled by high velocity fans before exiting the oven on high speed magnetic belts that deliver them to the plant conveying system. The PostOp System can run end sizes 202 - 401, and a complete end size changeover can usually be accomplished in less than one shift.

## Stolle PostOp System features:

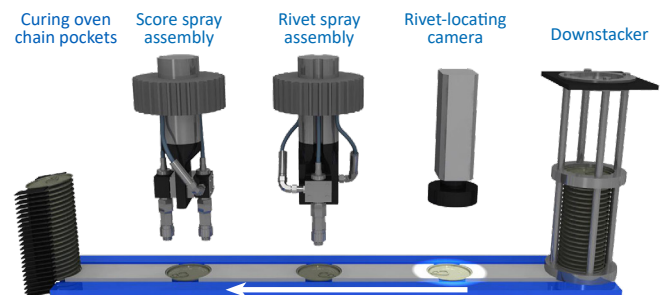
- Patented servo-driven 2-gun spray technology reduces overspray and increases machine efficiency
- Patented Rivet Spray technology coats and protects the exposed metal of the tab rivet
- Optional automated mixing system guarantees coating mixtures and increases line efficiency
- Reliable Stolle servo-driven downstackers
- Long life non-metallic transfer belts minimize end enamel damage
- Easy-to-clean vacuum overspray removal chambers
- Custom-designed high-efficiency vertical gas curing oven
- Operator-friendly touch-screen control system
- Lift mechanism on downstacker and spray assembly provides easy access to transfer belts and spray gun nozzles
- Strategically-located sensors monitor all system operations
- Single machine base for easy installation



Servo-driven oscillating spray head reduces coating usage and machine maintenance



Optional auto mixing system ensures accurate coating mix



Patented rivet spray system and oscillating spray head technology

TECHNOLOGY LEADERSHIP IN CAN & END MAKING



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## Specifications

End Diameter Range	202-401 (52-99mm)
Number of Lanes	2
Main Drive (Indexer) Speed	Adjustable from 70 to 500 ends (indexes)/minute
Output (maximum EPM)	1000
Overall Dimensions - Front-Back (feed direction)	145" (3,683 mm)
Overall Dimensions - Right-Left	95" (2,413 mm)
Height	240" (6,096 mm)
Weight (approximate)	16,000 lbs (7,257 Kg)
Floor Space	12' W x 7 3/4' L = 94 sq. ft. (does not include other equipment)
Air Supply	90-100 PSI – 5 SCFM @ 100 PSI
Electrical Power	380-460 volts – 3 phase – 50/60 Hz (per customer's requirement)
Service Size	90 Amp
Oven Type	Convection rated for natural gas and propane
Natural Gas Requirement	Supply: 7PSI maximum Start-up: 400 CFH, 6" WC Typical Usage: 200 CFH@1.5" WC
Propane Requirement	Supply: 7PSI maximum Start-up: 160 CFH, 2.4" WC Typical Usage: 80 CFH@0.6" WC
Coating Tank Options	A) Single 15 gal. tank system – 110 PSI maximum B) Two 15 gal. tank system – 110 PSI maximum C) Automated batch mixing system capable of handling 3 components and adjusting ratios of mixture - 110 PSI maximum
Coating Material Options	A) PPG two components, P-2987804/P-2987805 B) ICI two components, 657HW595/657HW596 C) UBIS three components, UR200A/UR200B/V131
Spray Application Method	Circular translating mechanism, airless nozzle
Spray Control Method	Adjustable spray angle (typical 90° to 270°), increments of 1°
Over-Spray Removal	Vacuum ring at each spray head
End Jam Detection	After downstacker, at oven entry and at oven exit
Oven Temperature	Adjustable from 50 to 150° C
Oven Temperature Regulation	+/- 1° C
Oven Gas Train and Control	Designed to NFPA 86
Oven Safeties	Monitoring of valves, flame, gas pressure and air flows
Total Connected HP	30.5 HP
Main Drive Motor	10 HP AC
Indexer Heat Exchanger	2 HP AC indexer circulating pump, 1/4 HP AC tank circulating pump
Vacuum Blower	6 HP AC
Oven Circulation Fan Motor	5 HP

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