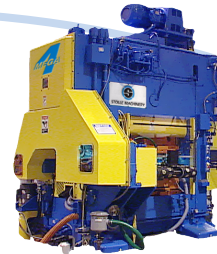


Downgauged Steel Food Tab With Hemmed Rivet Hole

for Stolle Full Open End Conversion Systems

**Stolle
Conversion Systems**
Technical Update 1204-2

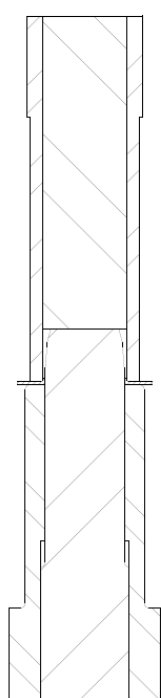


Stolle has developed a downgauged steel food tab that will save metal costs and perform comparably to current tabs. The new tab is made from .010" steel tab stock which is more economical than the current .012" steel stock.

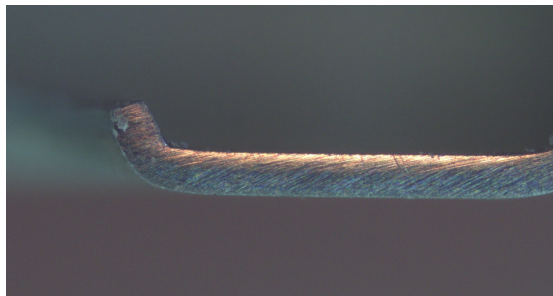
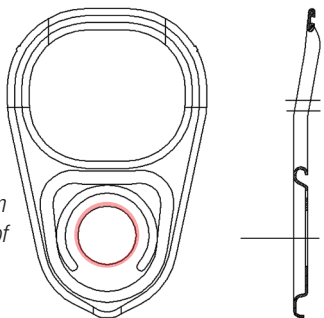
In order to make the downgauged tab perform reliably, Stolle had to address an issue with the rivet hole that resulted from the thinner tab stock. When the tab is lifted to break the score, the metal in the tongue around the rivet hole tended to elongate, which could cause the tab to detach from the lid. Stolle engineers solved this problem by designing a hemming process to reinforce the inside of the rivet hole. The rivet hole is pierced in the first forming operation in the tab die, then the edge of the hole is wiped up in the second operation. In the third operation, the hem is reformed (coined and reshaped), which significantly strengthens the area around the rivet hole. In the fourth "stake" operation, the tab is placed over the rivet button on the lid which is flattened to hold the tab to the lid. The hemmed rivet hole slips down over the formed rivet button, seats well against the rivet base and retains to the end with less rivet head diameter.



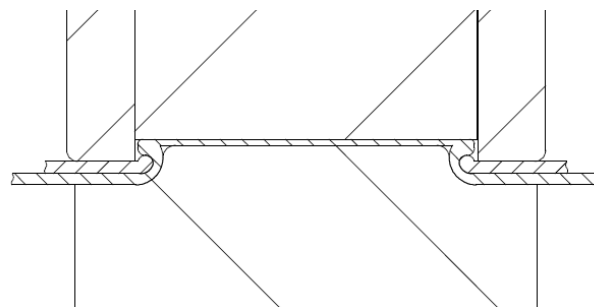
In addition to the patent-pending hemmed rivet hole, the new downgauged tab also features Stolle's patented X1 technology for improved curl strength. The hemmed rivet hole also helps to improve the final formed rivet geometry. The result is a more economical steel tab that performs reliably on full open ends.



Highlighted hem area on inside of tab rivet hole



Second operation tooling (left) performs the hem wipe-up (above) on the edge of the rivet hole



Stake station tooling (above) and close up of hemmed rivet hole and rivet after the stake operation (below)



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