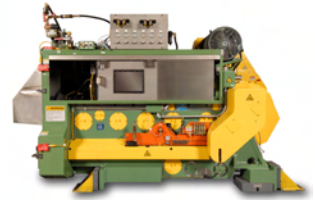




Chrome Plated Ram Notice

For the Stolle Ragsdale Bodymaker
May 2007

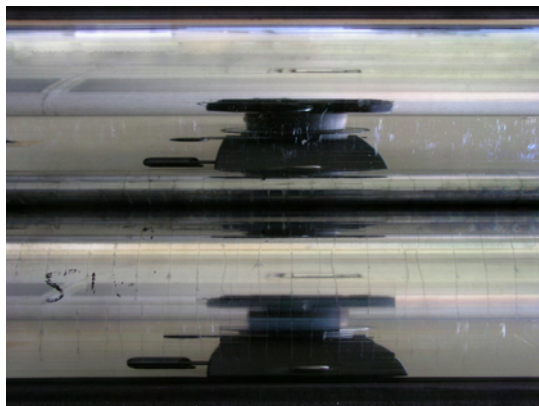


When the rams of Stolle Ragsdale Bodymakers become worn, many customers have them refurbished. This process usually involves grinding the ram surface, then chrome plating the ram and regrinding it to bring it back to its original diameter.

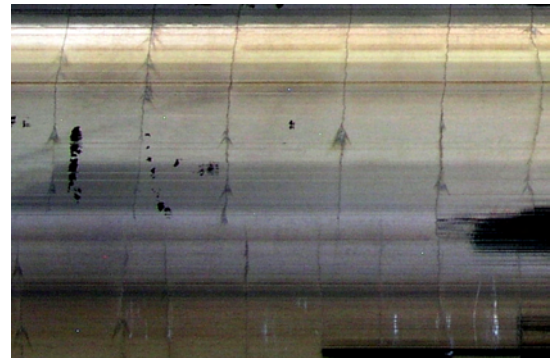
Metallurgical analysis of a customer-supplied refurbished ram shows cracks in the chrome plating that were likely caused by increased flex in the ram, which may have resulted from domer misalignment. As can be seen in the ram analysis photographs, the cracks can propagate from the chrome plating into the base metal. This condition can cause a catastrophic failure of the ram at bodymaker operating speed, which could cause injury to can plant personnel. Fortunately, the operator of this bodymaker noticed the cracks in the ram, and had it removed before it failed.

Stolle CMD strongly recommends that our customers do not chrome plate rams, or any moving parts to refurbish them. We recommend that customers replace bodymaker rams and other moving parts with new OEM parts when they become worn. This will ensure the safety of plant personnel, as well as maximize the system uptime and production capabilities of the machine.

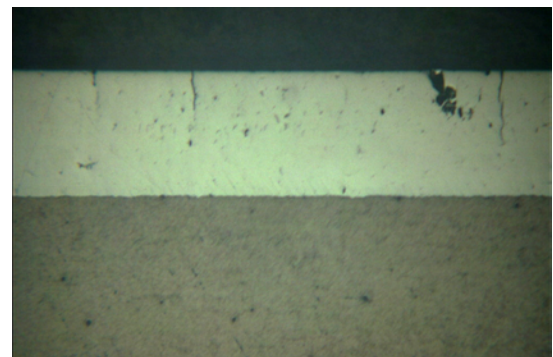
For more information, please contact Stolle CMD at 303-708-5063.



Both halves of chrome plated ram showing cracks along one side of ram



Close up of cracks in chrome surface



100X section view of chrome layer showing cracks in surface



50X section view of 12 mil chrome layer (.012") showing crack propagating into ram base metal



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