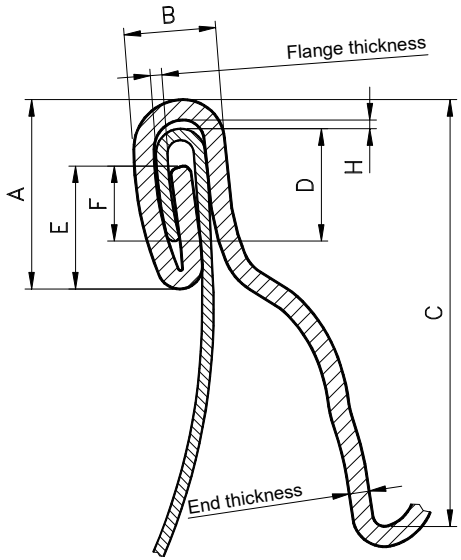

Critical parameters		
-	Tightness rating	100%
-	Body hook butting	72 - 97% for Aluminium 72 - 92% for Steel
B	Seam thickness	See note 2
F	Overlap	0.75 mm min.
H	Seam gap (directly after seaming)	0.10 mm max. (aim for 0.05 mm)

Other parameters		
A	Seam length	2.50 ±0.15 mm
C	Countersink depth	6.35 ±0.15 mm
D	Body hook	1.6 ±0.2 mm
E	End hook	1.6 ±0.2 mm

To guarantee seam integrity the critical parameters have to be run to optimum setting, all parameters have to be within specification.

Notes

1. The double seam quality is the Fillers responsibility.
2. Seam thickness is calculated as 3x measured End thickness plus 2x Canmakers stipulated Can flange thickness, plus 0.13 mm for compound, with a tolerance of ±0.05 mm.
   When calculating the seam thickness the calculation should account for 3 decimal places for Can flange & End panel thickness.
   Alternatively refer to section “Nominal Seam Thickness” and “Freespace”.
3. These operating standards should be used in conjunction with the attached explanatory notes to maintain good double seam quality.
4. All dimensions have to be measured at 3 points on the circumference of the Double Seam. Where measurements are outside of the tolerance range, machine adjustments should only be carried out where the results of wrinkle assessment identifies that the seam is less than 100% tight and if a second check with another can/end shows the same difference.