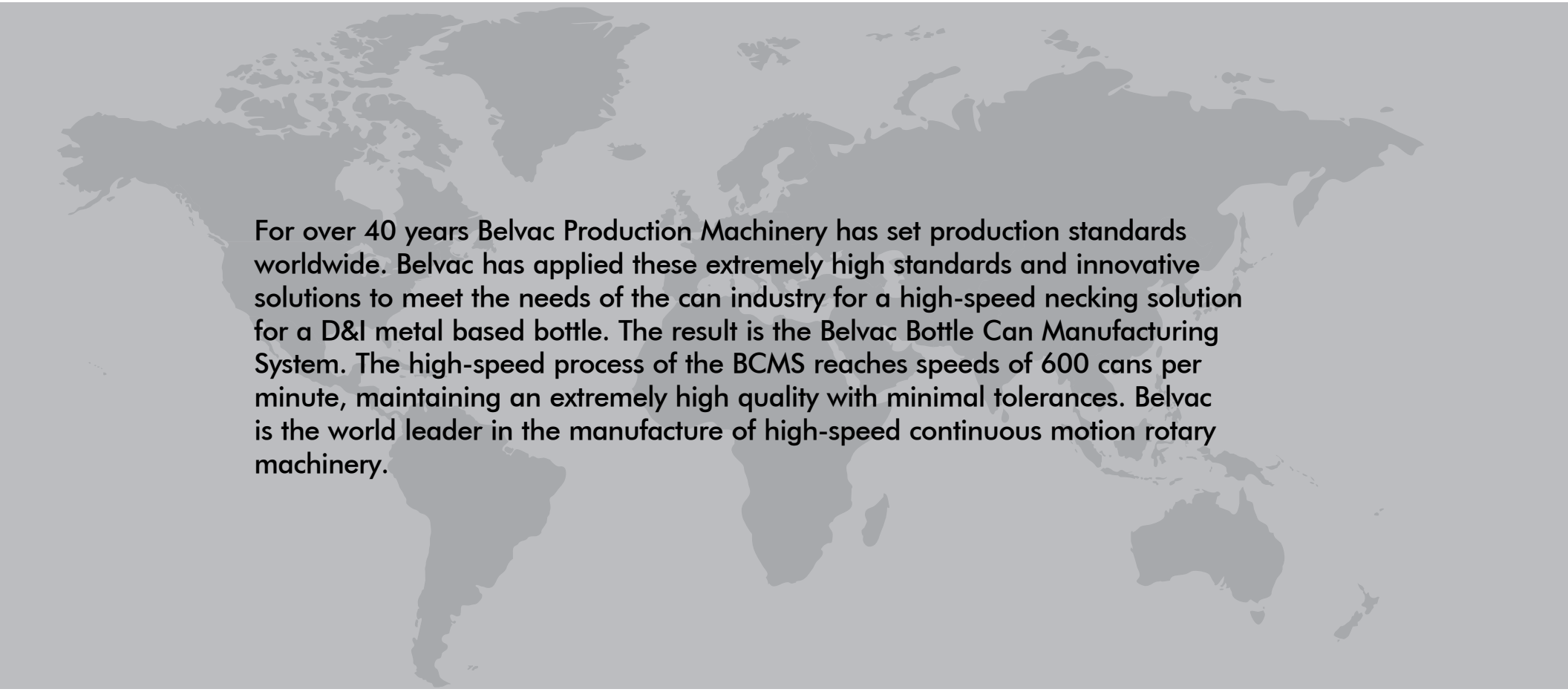


BOTTLE CAN MANUFACTURING SYSTEM

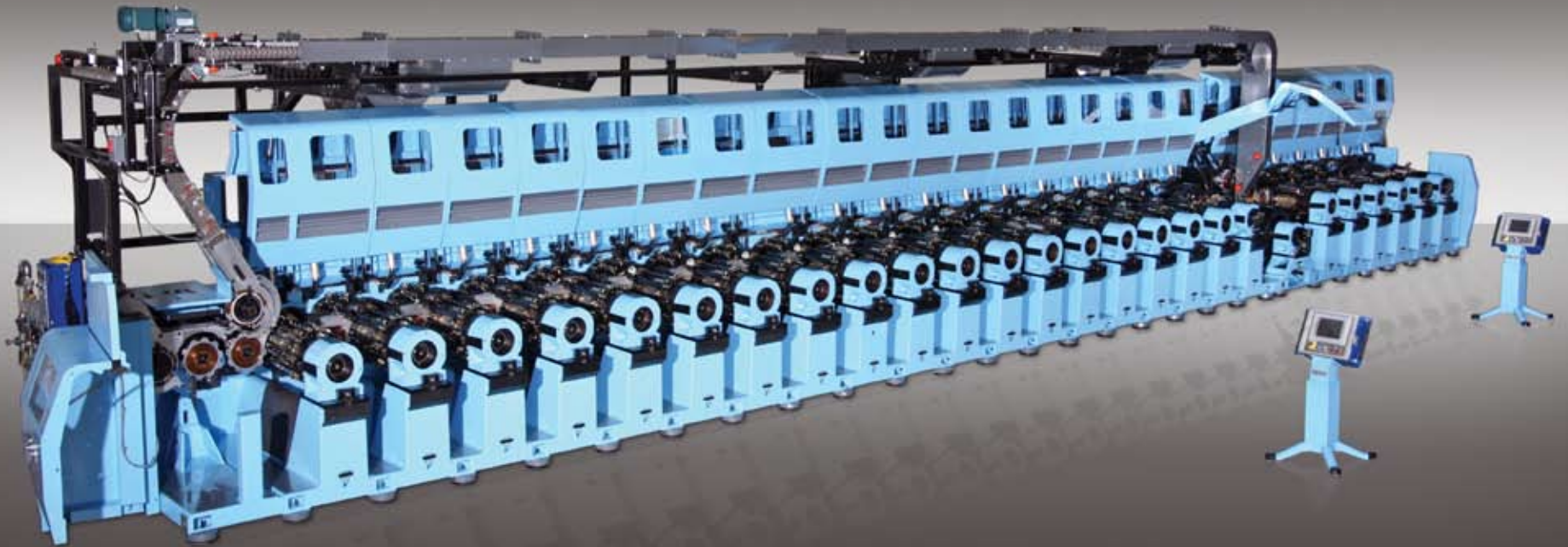




For over 40 years Belvac Production Machinery has set production standards worldwide. Belvac has applied these extremely high standards and innovative solutions to meet the needs of the can industry for a high-speed necking solution for a D&I metal based bottle. The result is the Belvac Bottle Can Manufacturing System. The high-speed process of the BCMS reaches speeds of 600 cans per minute, maintaining an extremely high quality with minimal tolerances. Belvac is the world leader in the manufacture of high-speed continuous motion rotary machinery.

HYDRAULIC GUARD SYSTEM

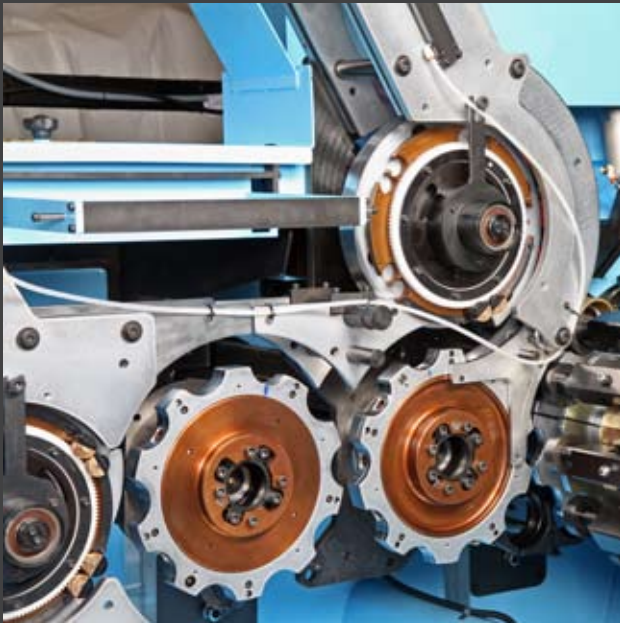
3



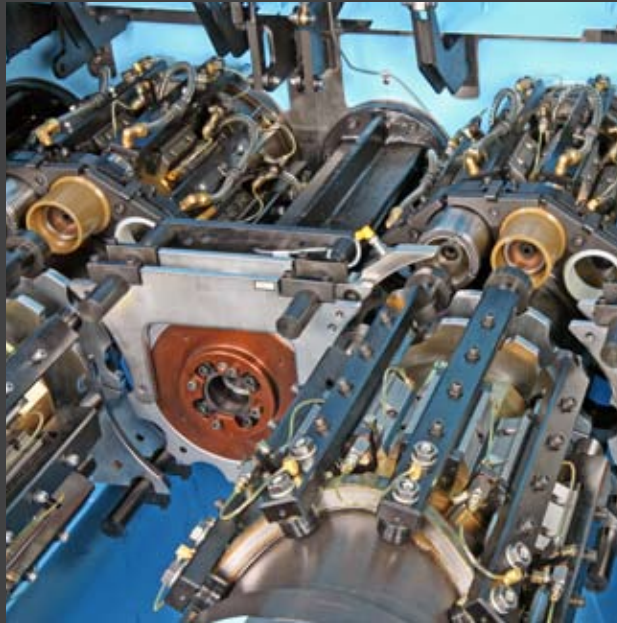
This machine is a 27 stage recirculating necker with a primary bottle size of 14 oz. with a 38mm screwed neck finish. Based on the 10-pocket 810-K Necker the BCMS has a diameter range of 211 to 307, a height range from 307 to 804, and a 2.75 inch neck capacity. The BCMS features a unique recirculation system.

THE PROCESS

4



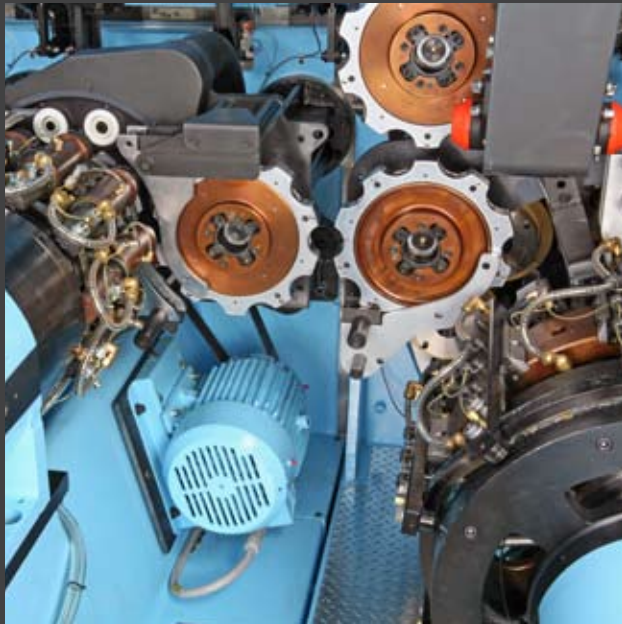
Cans enter the dual infeed for the first pass, are waxed, and fed into odd numbered pockets of the first necking turret.



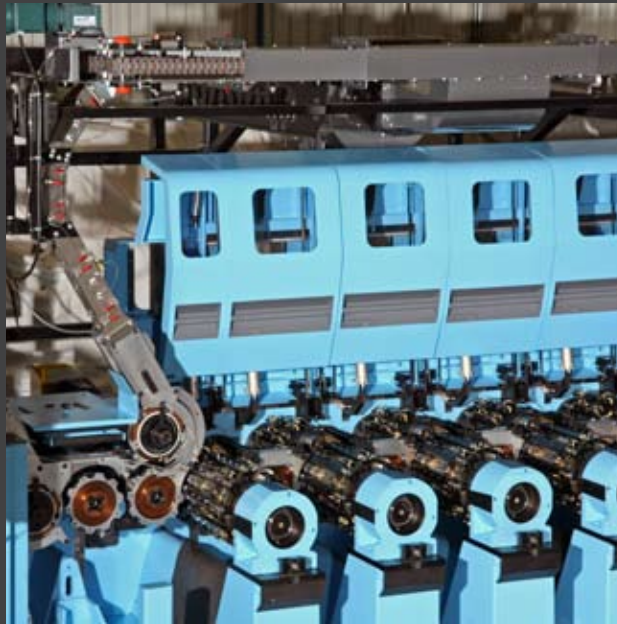
The cans then pass through 18 stages of necking.



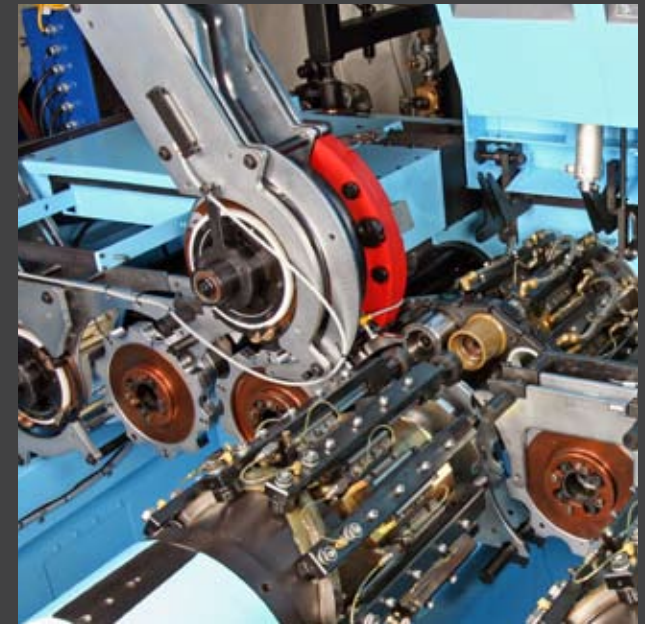
They are then trimmed to remove "earing" from the necking process before entering the dual discharge.



The odd pocket cans are removed after they enter the dual discharge.



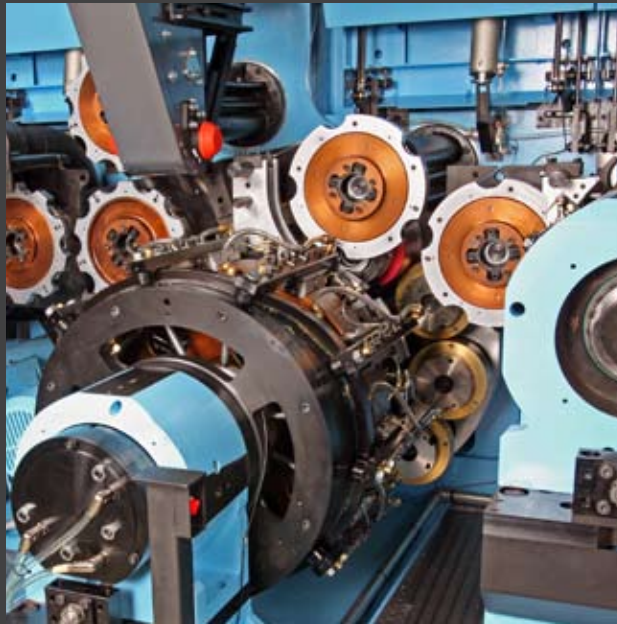
The unique "Recirculating System" returns the cans to the dual infeed module.



The cans are then waxed the second time and enter the even numbered pockets for a second pass through the 18 necking turrets.



After the cans complete the second pass of necking they are expanded and then trimmed for a second time.



The cans then pass through the dual discharge and enter the finishing stages.



The cans are then expanded, threaded, and curled to complete the finishing operation.



The BCMS threading module



The BCMS curling module



The innovative technology of the BCMS is capable of producing a wide range of finished product and can provide value for many diverse Bottle Can manufacturing applications.

Specifications

Can Body Size Range	211 thru 307
Can Neck Size Range	307 to 28mm
Maximum Can Height	804
Minimum Can Height	307
Material Specification	.0091" (0.231mm), aluminum
Number of Necking Turrets: Recirculating Machine	~17 ~29
Number of Pockets per Turret	10
"Active" Pockets (Recirculating)	5
Rated Speed (CPM): Recirculating Machine	600
Maximum Turret Speed (RPM)	120
Maximum Neck Shoulder Dimension	Approx 2.90" (73.8mm)
Maximum Neck Length	2.63" (69.6mm)
Minimum Neck Length	0.23"
Effective Push Cam Stroke (Less BIS)	4.500"
KO Cam Stroke	2.870"
Cam Dynamics	Similar to 595SK at rated speed
Cam Style	Matched Velocity
Diameter Change Capability	One QC parts kit per can diameter
Height Change Capability	"Quick Change"
Ram Assembly Style	New precision linear bearing slide
Main Shaft Style	New longer 810 Style
Guard Style	Lengthened 595 Modular Bi-Fold
Drive Gearing	595

Specifications

Gearbox	595
Transfer Housing Assembly	Lengthened 595 Modular
Transfer Shaft Assembly	QC Capable Lengthened 810K Modular
Blowers	595 Floor Standing
Infeed Starwheel	5 pocket (recirculating)
Transfer Starwheel	10 pocket
Discharge Starwheel	5 pocket (recirculating)
Ram Blocks	New 10 pocket faceted
Face Seal Manifold	(10) Pocket 595 Modular FSM
Main Drive Side Bearing	New (Tapered Roller Bearing)
Pusher Side Bearing	New (Spherical Roller Bearing)
Discharge Style	Horizontal
Integrated Lubrication	480
Recirculating Conveyor	Belvac Supplied, vacuum airtrack
Wiring System	37 Pin (Tri-Net) ASI Bus
Main Drive Motors	Dual Drive, Allen-Bradley
Logic & Control Panel	3-Bay, Belvac Supplied
Operator Control Stations	(2) Stand-Alone Stations

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