Six-out conversion system for steel ends

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Guangdong-based Fortune Precision has launched a six-out conversion line for easy-open food ends, which is claimed to be the first in the world to manufacture 211-diameter steel easy-open ends for food cans.

The conversion system has three sets of double lanes and includes a post-repair system. Each lane has capacity to produce up to 500 ends per minute, offering a total output of 3,000epm.

Based on a Minster PM3-200 press running at up to 400 strokes per minute, the system is fitted with two sets of three-out tooling dies with the facility to be changed from 211 to 200. The line is also capable of converting aluminium shells.
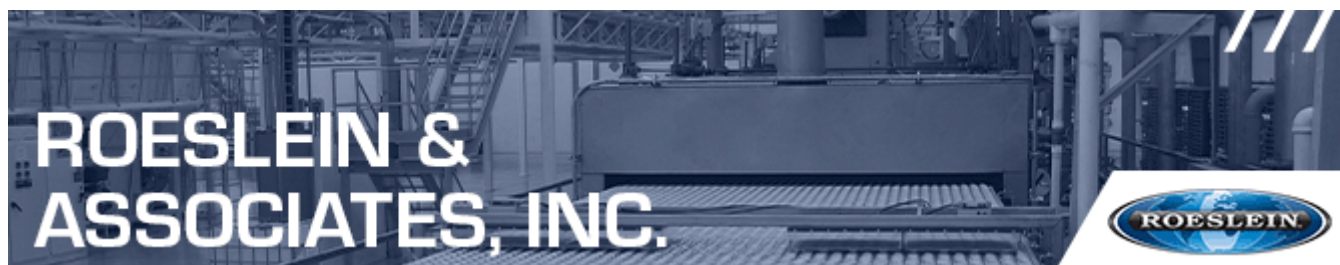
According to Fortune Precision's sales director Dingo Zha, the design of the line was very challenging: "The working table in the Minster conversion press has a very limited space to fit the conversion tooling system. We designed the system underneath it, considering the balanced force distribution of the punch when continuously running."

The team also had to carefully consider the design of the down-stacker, to offer enough precision when handling the 0.18mm-gauge steel shells. A 6-out tabstock feeding layout was developed to maintain a large span, high-speed forming capability and enough physical strength in the six lanes simultaneously. The design, based on 0.254mm gauge tabs, is said to offer a utilisation rate of up to 61.2 per cent.

The design of the ends was also improved with an arrangement for the tab nose to be adjusted relative to the tangent of the score for the successful opening of the easy-open end. A larger rivet design with a 7mm diameter was developed to improve the appearance of the pull tab.

First customer to use the conversion line is Jieyang City Hualong EOE.

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