

Improved Beverage Tab

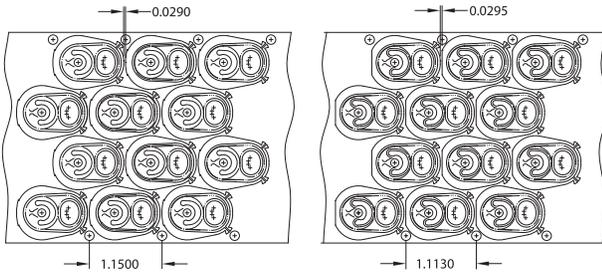
for Stolle Beer-Beverage Conversion Systems

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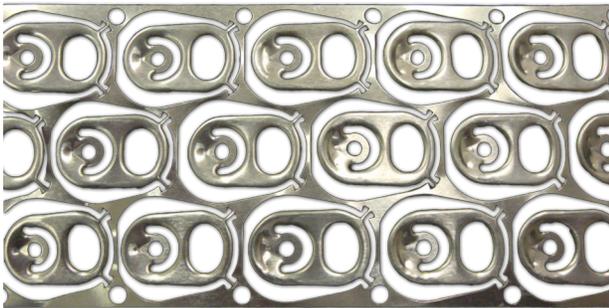
Technical Update 1203-1



Stolle has developed an improved beer-beverage tab design that provides customers with dramatic metal savings along with the latest tab and die set features. By changing the geometry of the lance station at the nose end of the tab, Stolle Engineers were able to shorten the progression to 1.1130". The result of this shorter progression is that **285,000 more tabs** can be produced from a ton of tab stock in a 3-out configuration from .010 tab stock thickness. In a 4-out configuration, **72,211 more tabs** can be produced per ton of tab stock. This greatly improved metal economy is possible without compromising the strength and integrity of the tab.



Previous 1.1500 progression tab strip (left) compared to new 1.1130 progression tab strip (right) with the "half moon lance" at the nose end of the tab



Improved tab progression in a 3-out configuration

In addition to the dramatic metal savings, Stolle has incorporated a number of other innovations in the tab die:

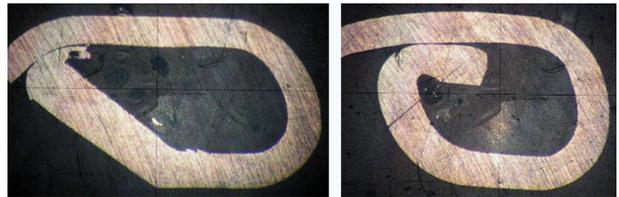
- Like the 4-out Tetrads design, the 3-out tab die now has separate wear tools in all stations allow the tools to be more easily sharpened or replaced for a lower cost.
- The 3-out rivet hole reform has been greatly improved by moving the station closer to the rivet pierce.

- X1 curl technology that was originally developed by Stolle for thinner food tabs has been incorporated in the die set. This technology eliminates the buckling behavior or "wrinkling" during the precurl, wipedown and final curl steps which negatively impacts the tab's strength and consistency. In tests using 0.010" tab stock, Stolle's X1 curl technology raised tab strength over 0.500 lbs., and reduced the standard deviation to 30% of the standard 0.0110" beverage tab.
- Stolle's "long leg - short leg" tongue shape lowers the required opening forces by .7 lbs by throwing more force to one side to more efficiently break the score.

Die sets to produce this new and improved tab design are available for any Stolle beer-beverage EOE conversion system – 4-out (Tetrad) and 3-out (System H, System 8, Tri-7, Triad) configurations. Many customers save system downtime by converting their Stolle systems to produce this improved tab when converting to a reduced cut edge shell profile to produce the lowest cost end.



Tab with standard nose curl (left) and X1 technology curl (right) showing how wrinkling is controlled. This photo also clearly shows the "long leg - short leg" tongue shape.



Cross section of standard curl (left) and X1 curl

To learn more about how Stolle's improved beer-beverage tab and die set can benefit your EOE production and economy, please contact Greg Williams at Stolle Sidney at +1 937-497-5441 or greg.williams@stollemachinery.com.



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