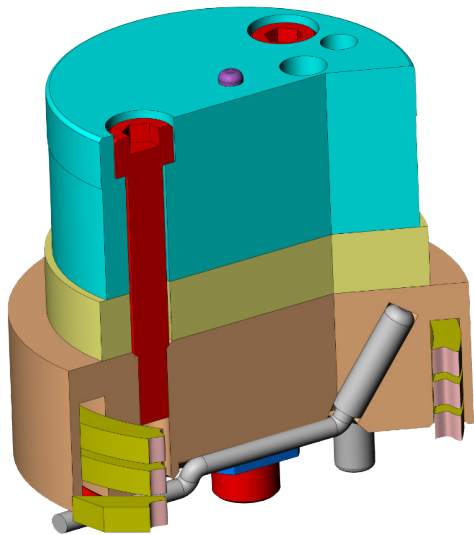


Thermal Score Anvil

for Stolle Beer-Beverage and Food EOE Conversion Systems

Stolle Sidney has developed a thermal score anvil for our easy open end conversion systems. This optional tooling retrofit allows the system operator to precisely adjust the depth of the score by thermally changing the height of the lower score anvil in relation to the upper score die.

The thermal score anvil consists of a heater installed in a thermal adjustment spacer below the tooling cap in the lower score tool stack. This heater can thermally change the height of the tool cap in precision adjustments of 0.0001" up to 0.001" total. An RTD sensor (Resistance Temperature Detector) below the thermal adjustment spacer monitors the temperature of the of the spacer and provides feedback to the control system to ensure accurate and consistent score adjustments.



The benefits of installing thermal score anvils in your EOE conversion systems include the ability to adjust the score depth during production, easier lane die maintenance, and less intervention by plant personnel is required to make tooling adjustments to keep ends within specifications.

Thermal score anvils are available for all Stolle beer-beverage and full open food end conversion systems, and are easy to install including control system updates.



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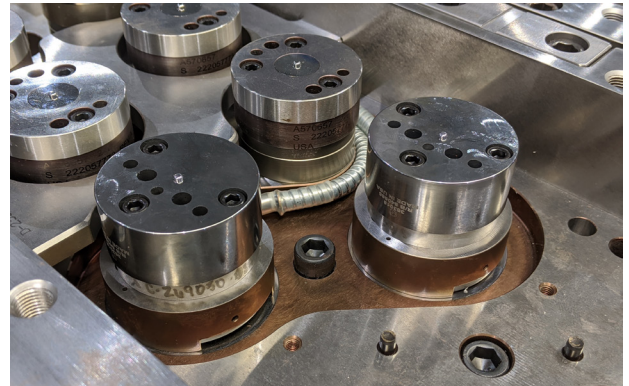
Stolle EOE Conversion Systems Technical Update 2009-1



Tetrad



Mega 4



Thermal score anvils installed in a lane die of a Tetrad beer-beverage EOE conversion system

Thermal Scores Screen

All values shown are temperature in degrees Celsius (C).
A typical nominal score temperature is 50°C.

| Heater On / Off | | Actual Value | | Setpoint (Press to Change) |
|-----------------|---|--------------|-----|----------------------------|
| Lane A On | A | 50.1 | ▲ ▼ | A 50.0 |
| Lane B On | B | 47.9 | ▲ ▼ | B 48.0 |
| Lane C On | C | 50.0 | ▲ ▼ | C 50.0 |
| Lane D On | D | 48.9 | ▲ ▼ | D 49.0 |

NOTE: Inform Quality Department if a setpoint is changed.

Displaying Celsius Push for (F) GO TO MAIN SCREEN GO BACK ONE SCREEN

Thermal scores control screen that appears on the conversion system HMI

For more information about thermal score anvils for Stolle easy open end conversion systems, please contact Stolle Sidney: Greg Williams at +937-497-5441 or greg.williams@stollemachinery.com, or Jason Davidson at +937-497-5432 or jason.davidson@stollemachinery.com.