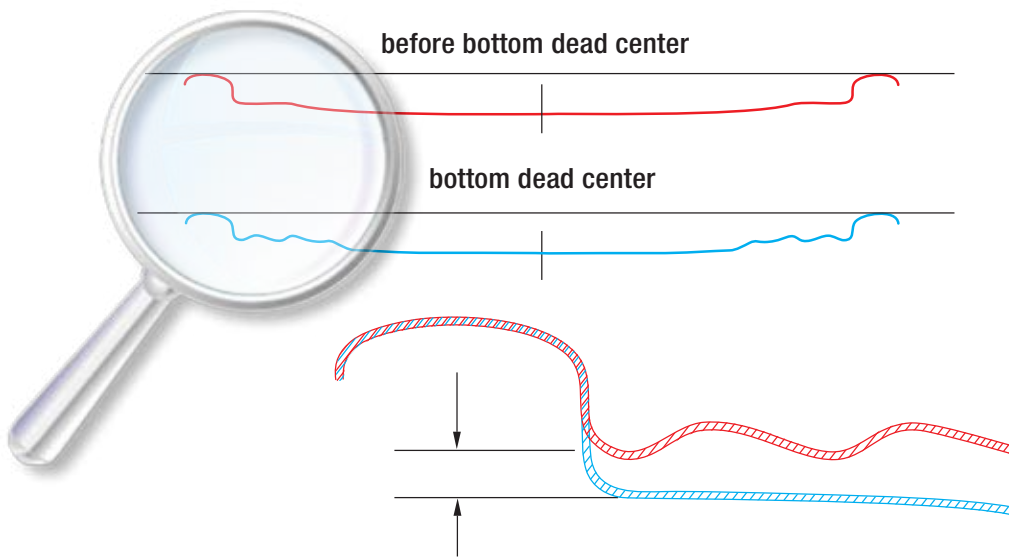
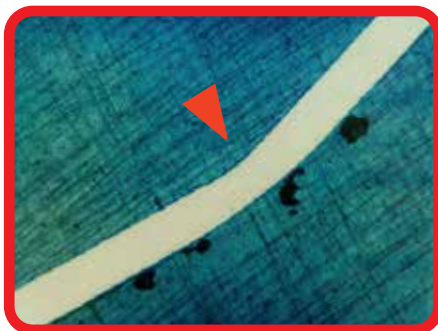


Downgauging of sanitary ends using DR plate



END DIAMETER	MATERIAL THICKNESS	BUCKLE PRESSURE
65 mm / 211	0.15 mm / 55#	2.9 bar / 42 psi
70 mm / 214	0.14 mm / 50#	2.69 bar / 39 psi
75 mm / 300	0.16 mm / 57#	2.9 bar / 42 psi
83 mm / 307	0.18 mm / 65#	2.6 bar / 38 psi
99 mm / 401	0.20 mm / 70#	1.7 bar / 31 psi
153 mm / 603	0.22 mm / 80#	1.5 bar / 22 psi

Up to 25% savings



Conventional Process - thinning



Precision Form Process - no thinning

Downgauging of pressure can bottoms using DR plate



MATERIAL THICKNESS in mm	BUCKLE PRESSURE in bar	BURST PRESSURE in bar
0.24 DR	13	15
0.26 DR	15	17
0.28 DR	18	20

Remark: buckle pressure values are 50% higher than the accepted pressure values inside the cans at 50°C

Up to 20% savings