

Cut blank

For Soudronic welding machines
 Standard 0611
 March 2021

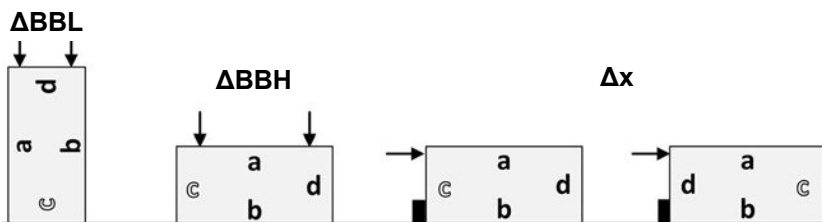
Can-body inside diameter 45 - 330 mm
 Can-body height (BBH) 50 - 540 mm
 Headpiece overlap 0.32 - 0.8 mm

Calculation of the sheet development according to formula: $BBL = [(d + s) \pi] + \ddot{U}$

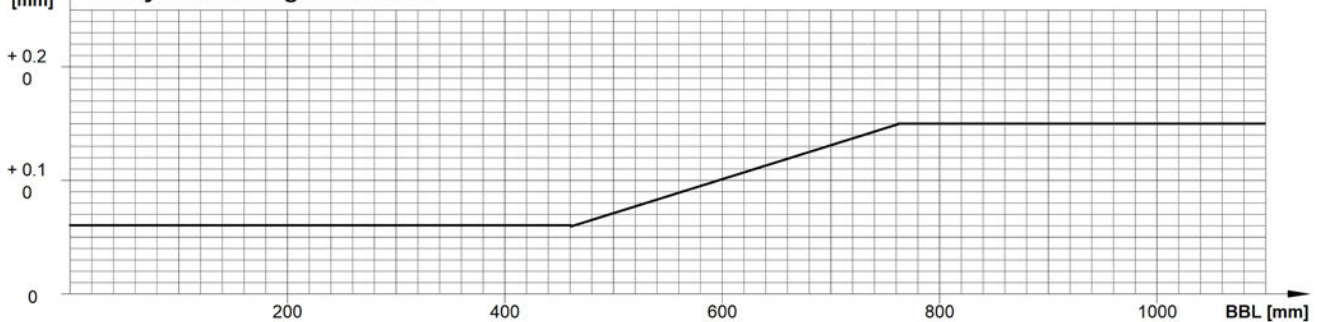
BBL Body Blank Length (sheet development)	B Cutting burrs: max. 0.15 x sheet thickness s	
d Can-body inside diameter	Δx Out-of-squareness tolerance	
s Sheet thickness	ΔBBH Can height tolerance	
BBH Body Blank Height (can-body height)	ΔBBL Development tolerance	
π 3.1416	Ü Overlap allowance: headpiece overlap + 0.1 mm	

Note:

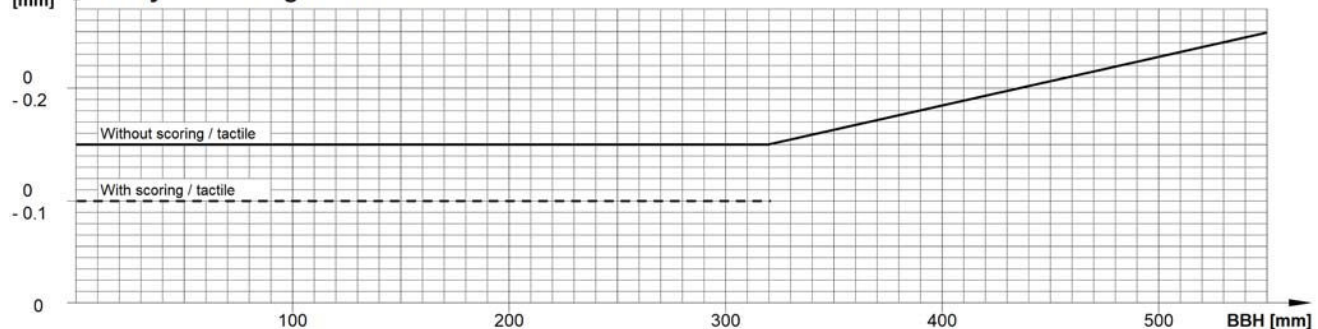
- Each cut blank must meet the cutting tolerances to prevent processing problems (e.g. welding, parting, seaming)
- Measurements must be made 5 mm away from the reference edge.



ΔBBL [mm] Body Blank Length tolerance



ΔBBH [mm] Body Blank Height tolerance



Δx [mm] Out of squareness tolerance

