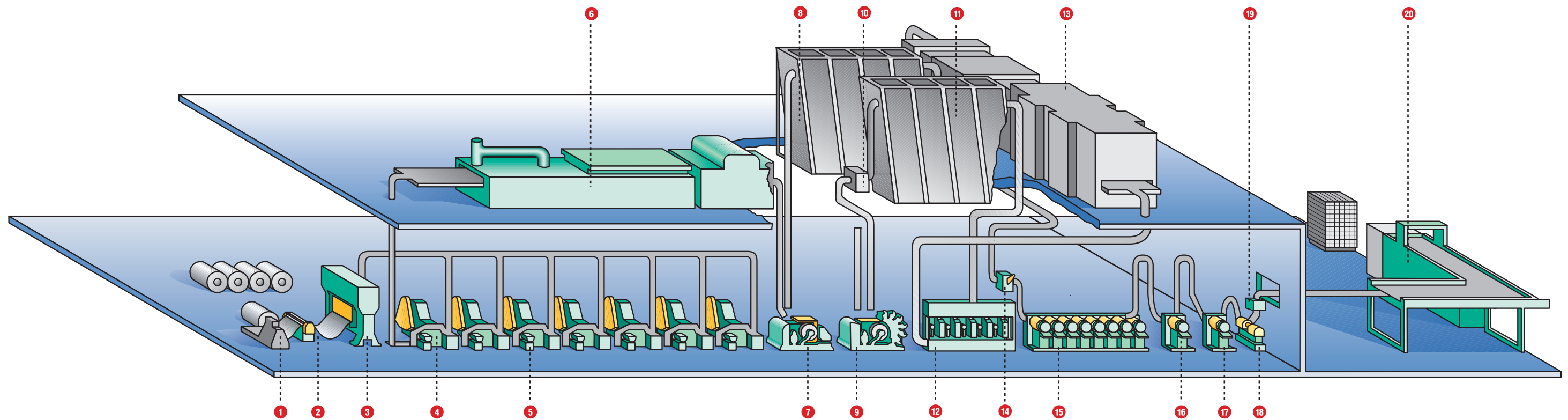


# Inside a Ball Beverage Can Plant



**1 ALUMINUM COILS**  
are positioned on the uncoiler. Uncoiler unwinds the aluminum coil into the lubricator.

**2 LUBRICATOR**  
applies a thin film of lubricant to the aluminum sheet and then feeds the metal into a cupper.

**3 CUPPER**  
cuts out circular blanks of aluminum and forms the blanks into cups.

**4 BODYMAKERS**  
use a punch mounted on a ram to push the cups through a series of tooling dies that redraw and iron the cups into cans.

**5 TRIMMERS**  
trim the open end of the cans to a uniform height.

**6 WASHER / OVEN**  
washes, rinses and dries cans in preparation for the application of internal coatings and labels.

**7 BASECOATERS**  
are used only if required by the can design. Cans are conveyed to the basecoater where basecoat is applied to the outside of the cans as a base color for further printing.

**8 BASECOATER OVENS**  
Cans are conveyed to the basecoater oven where the basecoat is cured onto the cans used.

**9 PRINTERS**  
use up to six colors of ink to first print labels on the cans and then apply a thin film of lacquer over the entire label to protect it.

**10 BOTTOM COATER**  
applies a coat of lacquer to the rim around the bottom of cans to protect the aluminum.

**11 DECO OVEN**  
cures the inks and coatings.

**12 INTERNAL COATERS**  
spray a thin layer of lacquer on the inside of the cans to protect product integrity.

**13 INTERNAL COATER OVEN**  
cures the internal coating.

**14 WAXER**  
applies a thin coat of lubricant to the outside of the open edge of the cans in preparation for necking.

**15 DIE NECKER**  
squeezes can openings down to end specifications.

**16 FLANGER**  
Rolls back the top edge of the can to form a lip used to attach an end to the can after it is filled.

**17 REPROFILE / REFORMER**  
can either reprofile the outer dome for 202 stackability or reform the inner dome for strength

**18 TESTER**  
checks all cans for possible pinholes or other damage.

**19 CAMERA INSPECTION**  
checks for any contamination that might be in a can.

**20 PALLETIZER**  
places finished cans on pallets, 389 cans per layer up to 21 layers high, for immediate shipment or storage.

**FILLED CAN**  
After being shipped to customer, the cans are filled at high speeds and the ends are attached.