



CUT-SCORING

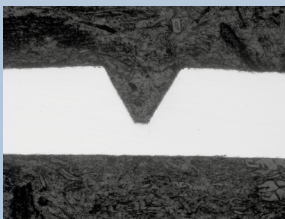
A method for scoring can bodies when standard scoring (V-scoring) reaches its limits.

PROCESS

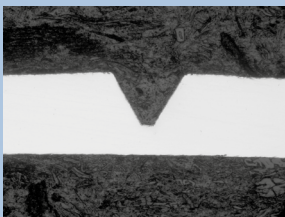
In cut-scoring the cold deformation of the material is much lower. The remaining ductility is therefore much higher than in V-scoring, which is preferable for necking and flanging.

In the cross-section, the remaining wall strength is symmetrical in the neutral fibres. This facilitates the parting process. The break edge is thus much smaller. The small burr enables excellent neck and flange results with extremely thin sheet thicknesses.

V-scoring



after scoring



after rollforming

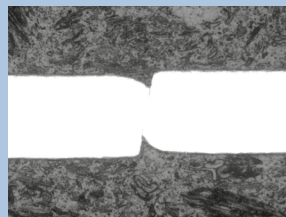


after parting

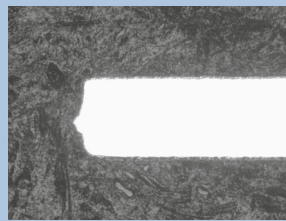
Cut-scoring



after scoring



after rollforming



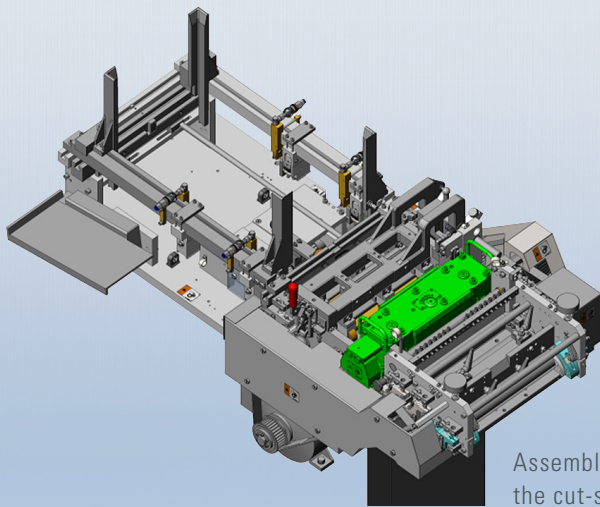
after parting

ADVANTAGES COMPARED WITH V-SCORING

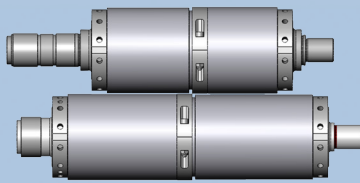
- Easy processing of material thicknesses to a minimum sheet thickness of 0.10 mm
- Initial settings can be made outside the machine. This saves on refitting time.
- Lower process force when parting
- More flexibility with product design because the scored end of the can body has perfect neck and flange properties.
- The scoring blades can be re-ground and sharpened on the end face

APPLICATION

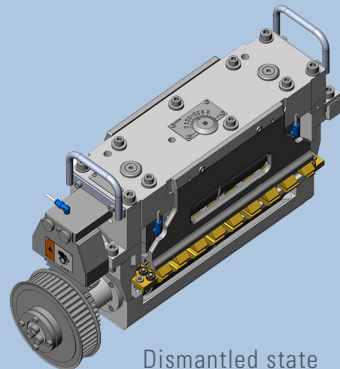
The SOUCAN 600/700/800/1000/2000 series are capable of cut-scoring. The design structure is similar to the V-scoring unit. The main advantage compared with V-scoring, however, is that the scoring position, depth and blade gap can be set outside the machine.



Assembly situation of the cut-scoring unit



Cutting rollers



Dismantled state on the workbench

RETROFITTING

Cut-scoring can be retrofitted on all SOUCAN600/700/800/1000/2000 machines that support V-scoring.