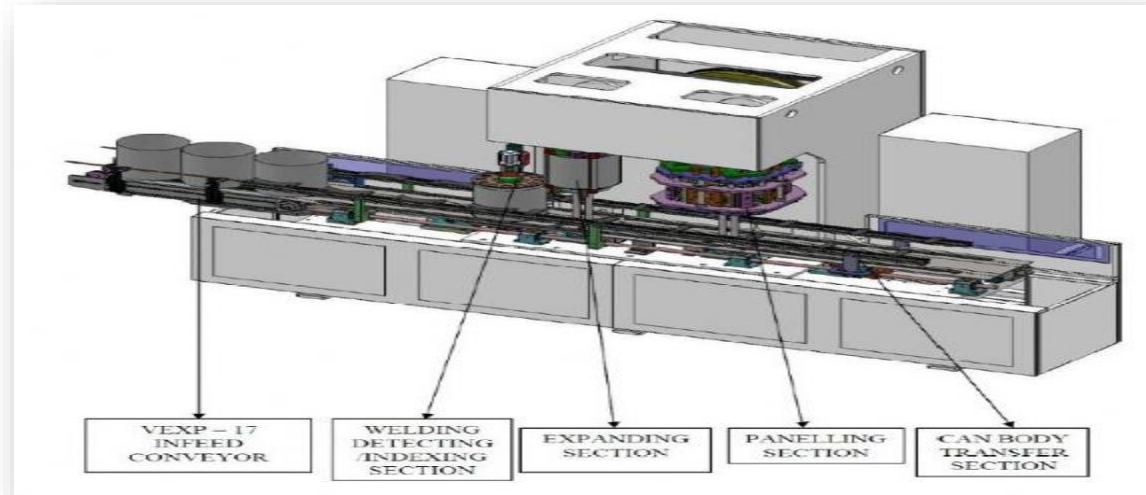


Square Can Machines Details

WELD POSITION, EXPANDING AND SQUARE FORMING



Applicable & Diameter:

- Diameter =895.00
- Height =minimum -214mm maximum- 334,

Machine Type:

- (VATAN MAKINA) VEXP20 Automatic vertical Expanding & Paneling Machine.

Square Can Machines Details

FLANGING



Applicable & Diameter:

-Diameter =895.00

Square Can Machines Details

- Height =minimum -214mm maximum- 334,

Machine Type:

(VATAN MAKINA) VEXP20 Automatic flanging Machine.

Operation Guidelines:

*Clean the machine before use.

*Turn up the machine.

*Change the machine to required height.

*Pass one can thru Flange machine and check Inspection of flange:

-Dimensional inspection:

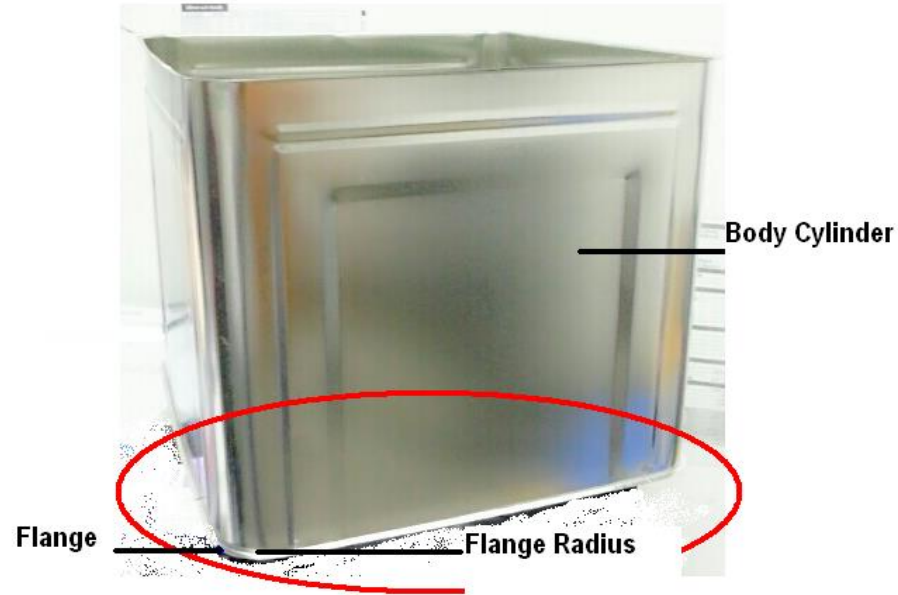
- Flange Width – top and bottom, Flange Body Height.

-Visual Inspection: Mushroom Flange, Split Flange, Damage Flange. , Turn-in Flange, Cracked Weld.

*Continue Production If flange is OK.

*In case of any non conformance, stop ,recheck / reset and run the line. Identify the non conforming material with appropriate tag and inform supervisor for necessary action

Square Can Machines Details



SEAMING

Square Can Machines Details

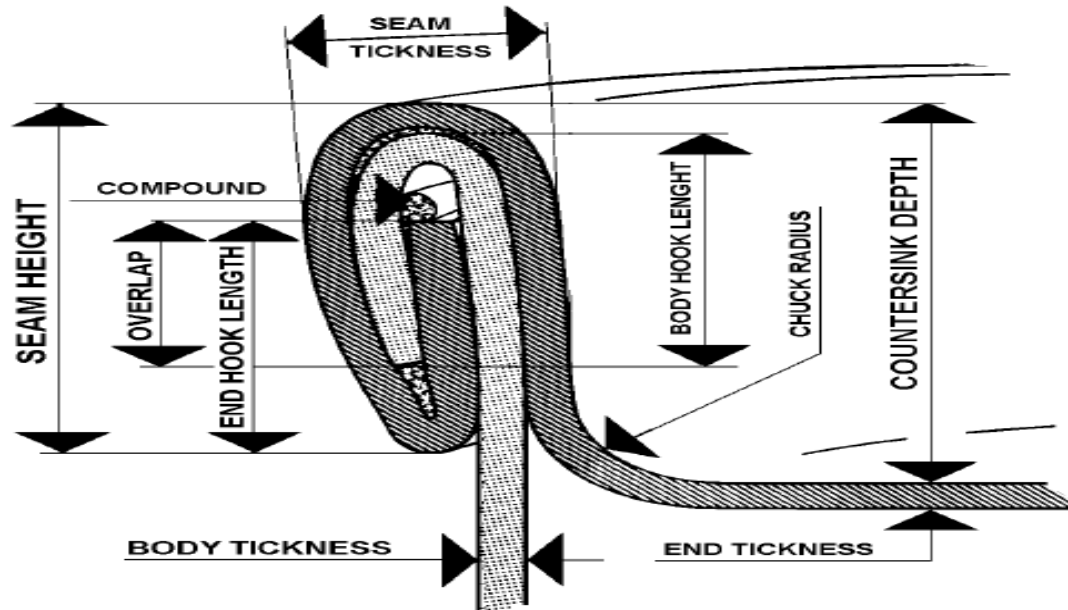


Acceptable & Diameter:

- Diameter =895.00
- Height =minimum -214mm maximum- 334,

Machine Type:

(VATAN MAKINA) VEXP20 Automatic Seaming Machine.



Square Can Machines Details



Square Can Machines Details

PALLETIZING AND FINAL INSPECTION



Acceptable & Diameter:

- Height =minimum -214mm maximum- 334,

-Diameter =895.00

Machine Type: (VATAN MAKINA) VEXP20 Semi-Automatic Palletizing Machine. Able to accommodate pallet size 100X120mm .

Operation Guidelines:

use.

*Turn up the machine.

*Clean the machine before

*Set the palletizer as per packing standard referred in the Job card.
oriented properly and not exceeding the pallet.

*Ensure the cans are

*Turn on the machine in AUTO mode.

*Ensure the right pallet, layer pad and loaded to designated place.
put one layer pad between every layer.

*Continue the operation and

*the finished pallet moved automatically to exit point.

*In case of any non conformance, stop ,recheck / reset and run the line. Identify the non conforming material with appropriate tag and inform supervisor for necessary action.

LEAK TESTER

Square Can Machines Details



Leak Testing Procedure:

- *Set air pressure gauge 0.5 bars.
- *Put the appropriate amount of water mixed with a little bit of soap.
- *Open the air valve and make sure the absence of any air bubbles in the tube from bottom seaming or welding side.
- *After finishing checking remove the can and clean it from water bubbles.
- *In case of any non conformance, stop ,recheck / reset and run the line. Identify the non conforming material with appropriate tag and inform supervisor for necessary action.

PACKAGING

Square Can Machines Details



Review
ed By:

Approv
ed By:

Square Can Machines Details

Tariq Al-Faqih
Line Supervisor

Benny Joseph
Industrial Prod.
Manager

Benny Joseph
Industrial Prod.
Manager



Square Can Machines Details



Square Can Machines Details

