

# ADVANCED SEAMING ROLLS

## STRUCTURE AND SIGNIFICANCE OF PART NUMBERS

CarnaudMetalbox Engineering seaming rolls are allocated a part number of eight digits, followed by the alpha character R or X and two further digits. An abbreviation for any special treatment follows, then a code letter for 'Eco-Seal' fitted rolls, with the manufacturing date code at the end of the number.

Roll features are identified as follows:

Typical part number

**13057 15 1X 64 ARC E A04S**

- Seaming profile number:  
12000, 13000, 14000 or 16000 Series
- Roll design variant number:  
Geometry
- Material used:  
1 = Stellite (Stoody® Cobalt Chrome)  
4 = AISI 440C
- Bearing type:  
X = Ceramic ball  
R = Steel roller or ball
- Seamer or Closer code (type):
- Special treatments:  
ARC = Advanced Roll Coating  
APC = Anti Pick-up Coating
- E = 'Eco-Seal'
- Manufacturing code:  
eg. A04S = January 2004 Shipley



### TECHNICAL SPECIFICATION (NON-INTERLOCKING TYPE)

- Material:  
AISI 440C High Chrome Steel 56 - 58 RC  
Stellite Stoody® Cobalt Chrome 50 - 53 RC
- Profile tolerance:  
Within 0,025mm (0.001") of master profile
- Concentricity:  
0,05mm (0.002") Max Tir (Total Indicated Runout)
- Coating:  
Chemical Vapour Deposition (CVD)  
Coating Depth 3 - 6 microns
- Bearing end play when new:  
Taper roller 0,025mm (0.001") maximum  
Ceramic 0,025mm (0.001") maximum
- Dynamic Load Capacity:  
Taper roller 4220N (950lbs)  
Ceramic 8767N (1945lbs)
- Lubrication:  
Preferably Grade '0' grease, but not greater than Grade '1' (mineral or synthetic)  
Taper roller 2 shots every 4 hours (all applications)  
Ceramic 2 shots every 72 hours (sanitary food)  
2 shots every 144 hours (beverage)

Note:

On autolube grease machines it is recommended that provision is made to convert seaming rolls to grease nipple, manual lubrication where ceramic bearings are fitted.



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