

## Blank Tolerances (Standard)

Calculation of the sheet development:

$$A = [(d + s) \pi] + O$$

A = Sheet development [mm]

d = Body blank inside diameter [mm] (round up to two decimal digits)

s = Sheet thickness [mm]

$\pi = 3,14159$

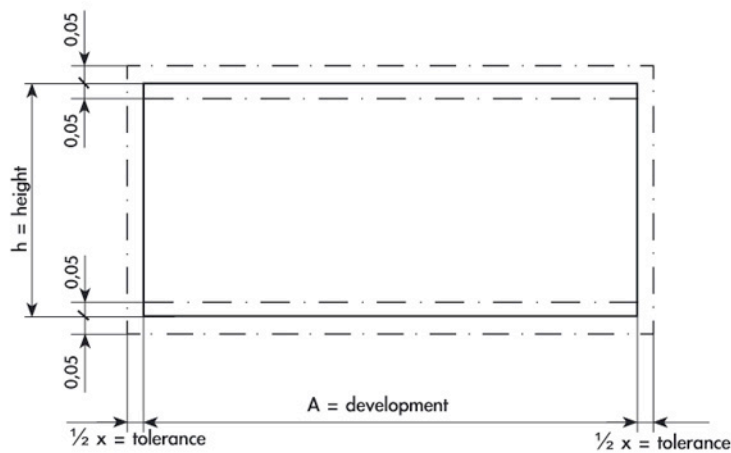
O = Overlap

Angular error:

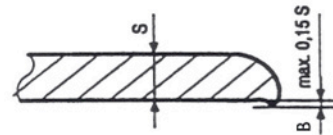
h = Canbody height [mm]

Angle = 90° (Angular errors acceptable only within tolerance zone x)

x = Development tolerance [mm] (according to line in the graph below)



Burr:

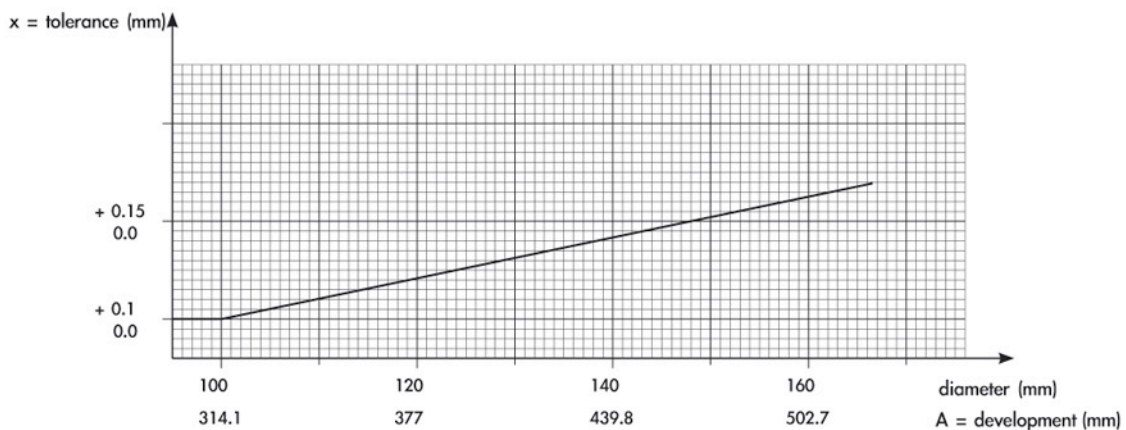


B = Cutting burr [mm]

s = Sheet thickness [mm]

Example: s = 0.20 mm

B = 0.15 x 0.20 mm = max. 0.03 mm



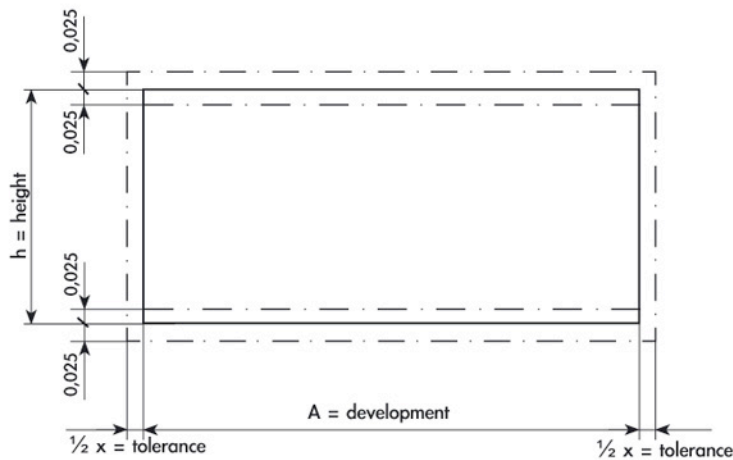
## Blank Tolerances with built-in Scoring Unit

Calculation of the sheet development:  $A = [(d + s) \pi] + O$

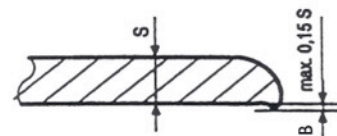
- A = Sheet development [mm]
- d = Body blank inside diameter [mm] (round up to two decimal digits)
- s = Sheet thickness [mm]
- $\pi = 3,14159$
- O = Overlap

### Angular error:

- h = Canbody height [mm]
- Angle = 90° (Angular errors acceptable only within tolerance zone x)
- x = Development tolerance [mm] (according to line in the graph below)



### Burr:



- B = Cutting burr [mm]
- s = Sheet thickness [mm]
- Example:  $s = 0.20$  mm
- $B = 0.15 \times 0.20$  mm = max. 0.03 mm

