



Blank cutting report and qualification (1 per format)

Customer Name: _____

Quantity ordered: _____

Machine type: _____

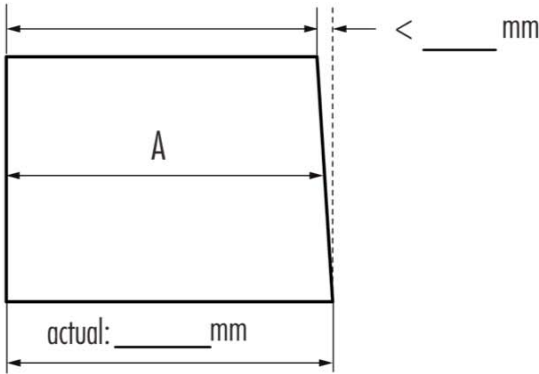
Quantity delivered: _____

Serial no.: _____

Total Qualification: very good

good

bad

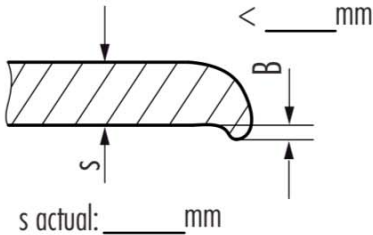
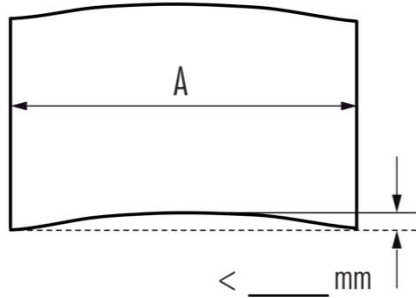
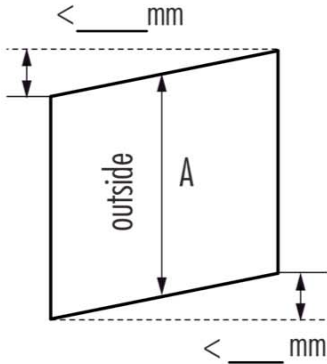
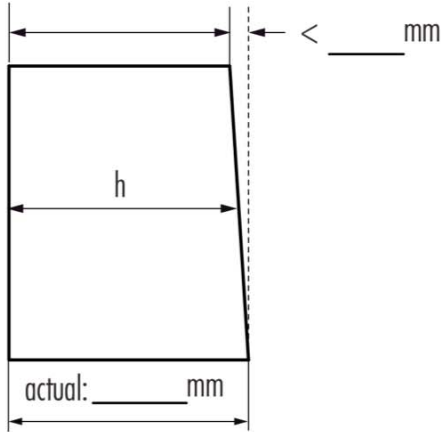


A Ref: _____ mm (development)
h Ref: _____ mm (height)
s Ref: _____ mm (thickness)

direction of rolling:

parallel to seam

crosswise to seam



Name: _____

Date: _____

Blank Calculations and Tolerances

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

A = Sheet development [mm]

s = Sheet thickness [mm]

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

$\pi = 3,14159$

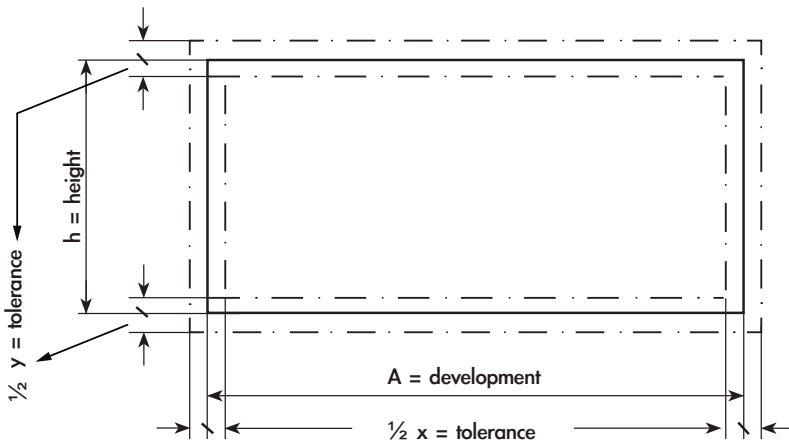
O = Overlap

Angular error:

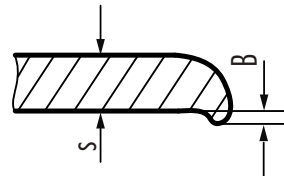
h = Canbody height [mm]

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

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



Burr:

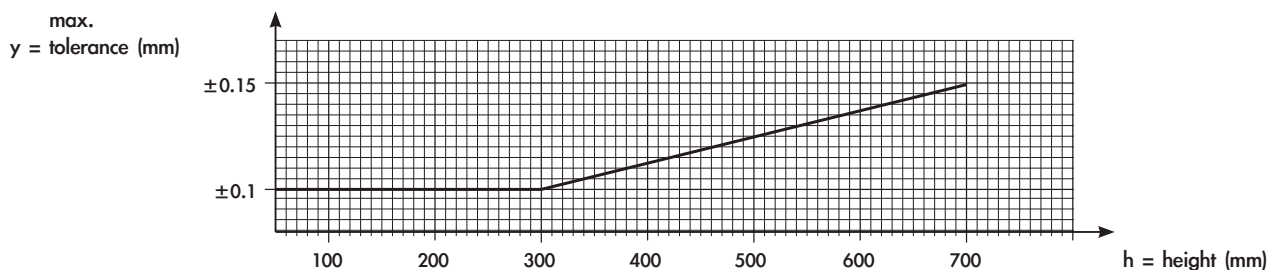
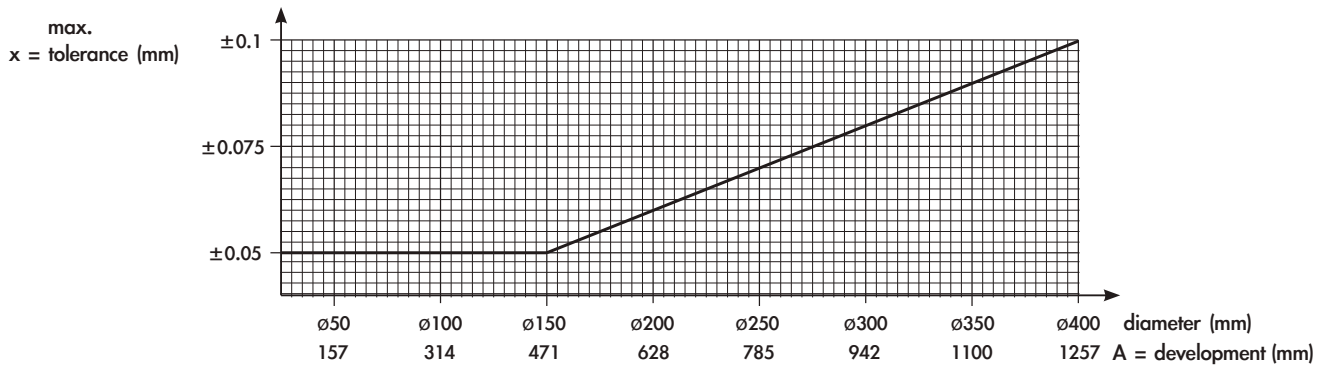


B = Cutting burr [mm]

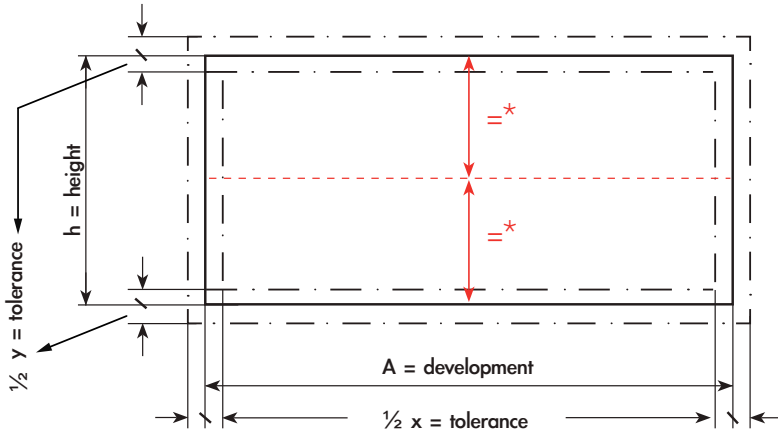
s = Sheet thickness [mm]

Example: s = 0.20 mm

B = 0.15 x 0.20 mm = max. 0.03 mm

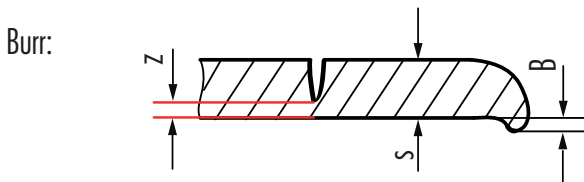
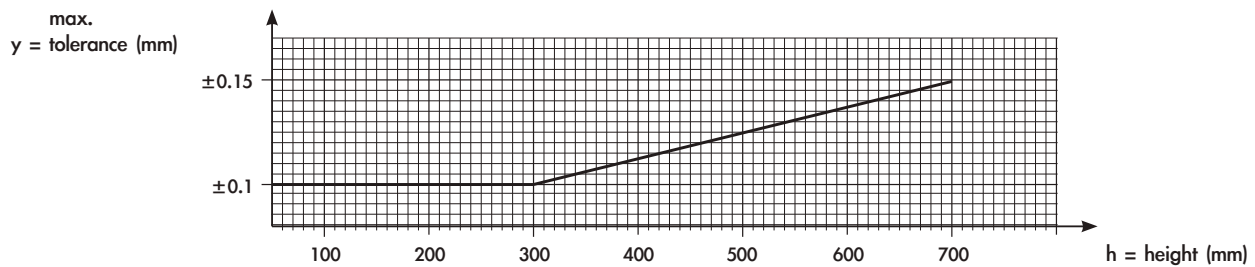
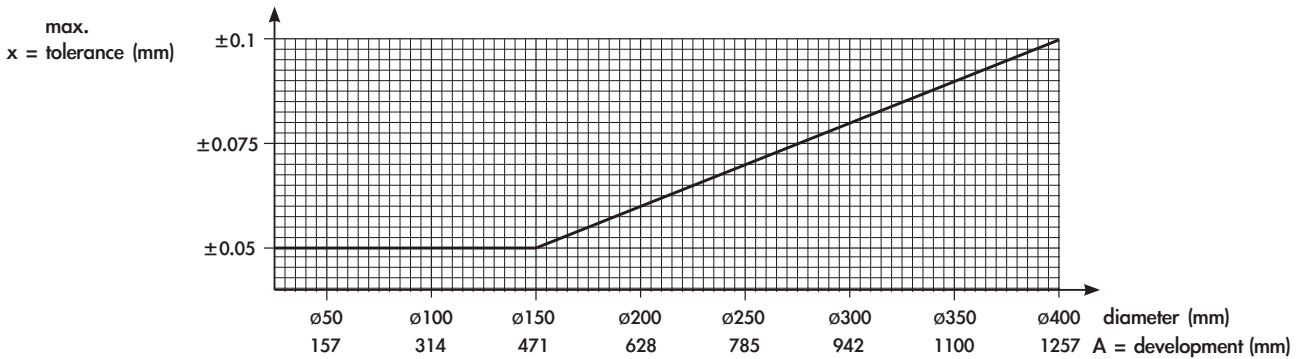


Blank Tolerances with built-in Scoring Unit



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)

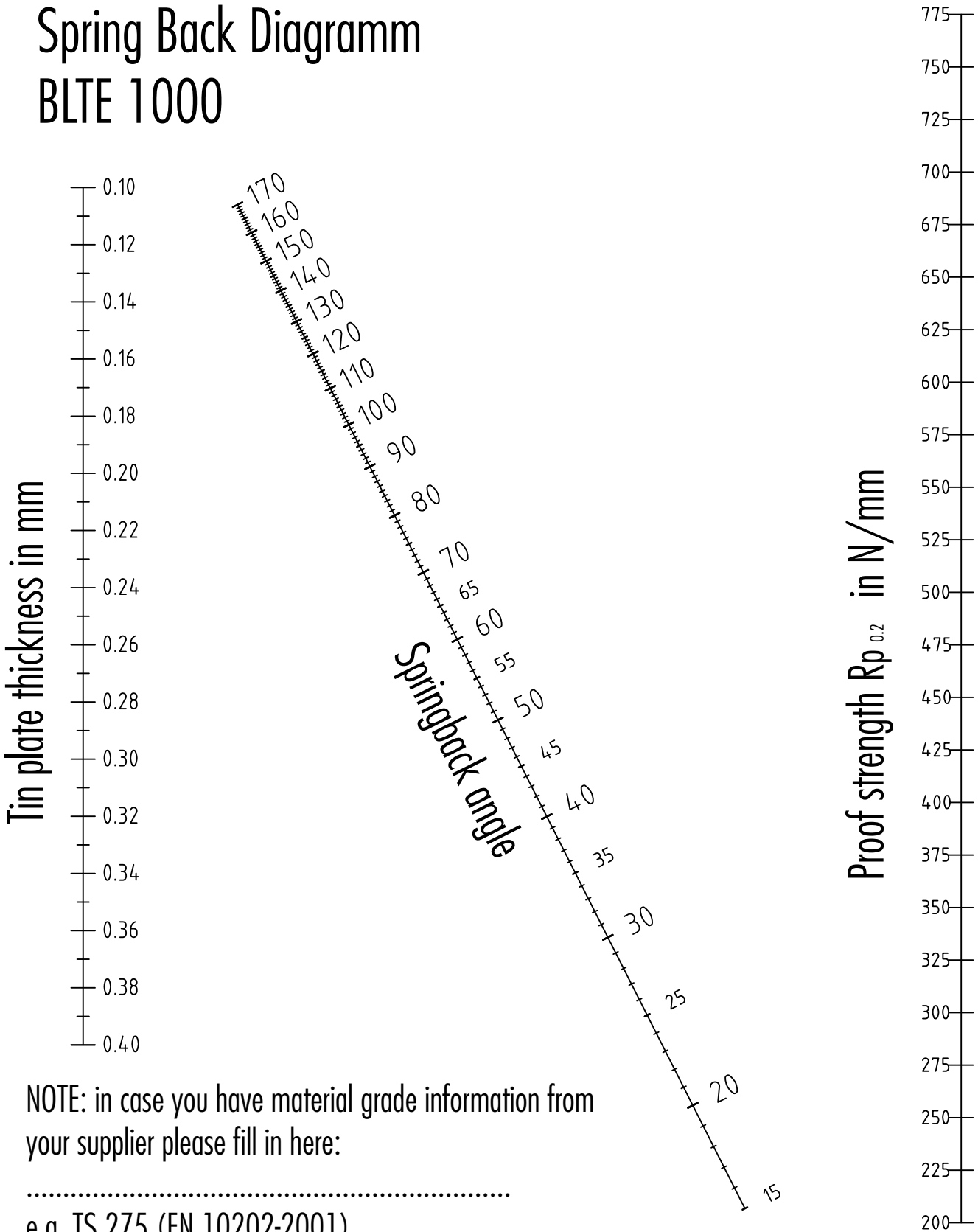
* The score line must always be exactly in the middle of the cylinder height. Both the deviation of the score line in height as well as the offset at the welded seam must be within ± 0.1 mm. Larger deviations may result in problems because the score line is no longer flush with the parting cutter.



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

z = Residual wall thickness after scoring must be 0.05 mm with a tolerance of ± 0.005 mm and must not exceed 30% of sheet gauge. A scored blank must break when folded at an angle of 90° .

Spring Back Diagramm BLTE 1000



NOTE: in case you have material grade information from your supplier please fill in here:

.....
e.g. TS 275 (EN 10202-2001)

Important:

When you print this document, you need to check the printing menu. Set to no edges and to 100% without reduction, otherwise the scale will be wrong!