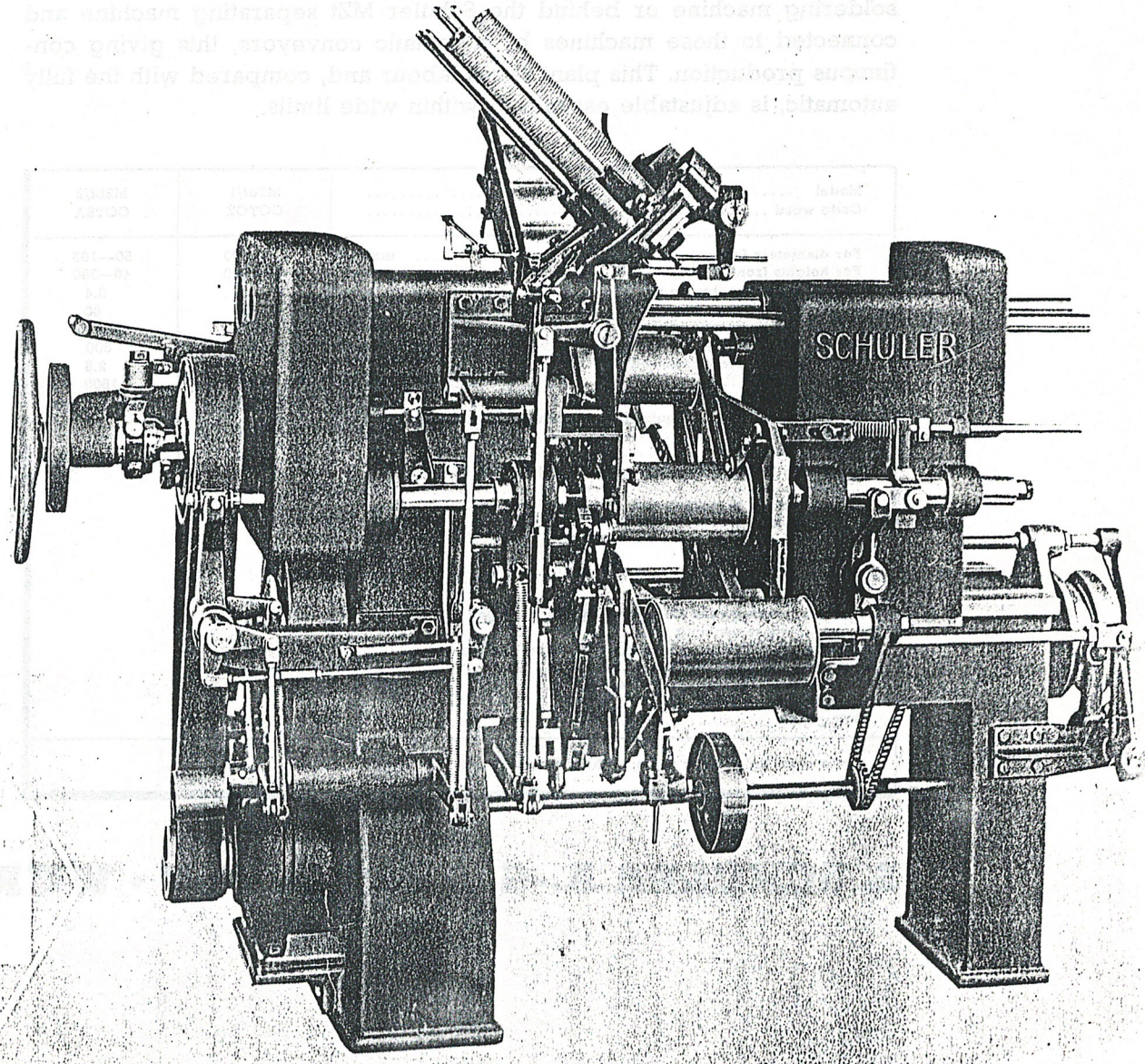
Automatic Double Flanging and Bottom Seaming Machines

Schuler M2bf fully automatic double flanging and bottom seaming machines are already in operation in a very large number of works. This great success is due to the various advantages of the machines, which lie especially in their reliable operation, their easy adjustment and their very high output.

The bodies may be flanged either at both ends or at one end only and beaded and necked-in at the other. Further, it is possible simultaneously with the seaming to curl the top necked-in edge internally or externally. Upon request, the machines can be supplied for minimum heights of 25 mm. and for minimum diameters of 34 mm.



The bodies are fed automatically by means of carriers with flaps. A controlled holding device allows only one body at a time to drop into the carrier. After flanging, the body rolls automatically into the seaming station in which the bottom is seamed. The finished body is lifted by an ejector and drops into the outlet chute.

The bottoms are fed automatically from the stack. The edge of the bottoms must be slightly curled. When no bottoms are left in the stack, the machine is automatically stopped by a feeler. Seaming of the body on to the chuck is, therefore, impossible. If no body is fed, no damage occurs either. The lid then drops undamaged down out of the machine.

As on all Schuler double-flanging machines, the upper flanging rolls are fixed on separate shafts. They can be quickly and accurately adjusted both vertically and horizontally by means of threaded nuts and threaded bushes. The seaming spindle runs in thrust and roller bearings. The seaming rolls also have roller bearings. The speed of the seaming spindle is particularly high. The bottom is so firmly pressed against the body that slipping cannot occur. Consequently, movement and the resultant damage of the rubber ring or solution is impossible. The machine is engaged and disengaged by a hand lever through a friction clutch. A special carrier, a channel piece and a seaming and a pressure disc are necessary for each size of body. For the height the left-hand bracket is adjusted by means of a hand crank through a threaded spindle.

The M2bf machine can be set up behind the Schuler BAx/0 or BAx/1 soldering machine or behind the Schuler MZt separating machine and connected to these machines by automatic conveyors, this giving continuous production. This plant saves labour and, compared with the fully automatic, is adjustable easily and within wide limits.

Model Code word		M2bf/1 COTOZ	M2bf/2 COTSA
For diameters from	mm.	50—120	50—163
For heights from	mm.	30—260	40—380
For sheet thicknesses up to	mm.	0.4	0.4
Output per minute up to		60	50
Belt pulley diameter and width	mm.	280/75	280/90
Speed of belt pulley	rpm.	500	500
Approximate power required	HP.	2.2	2.5
Speed of motor	rpm.	1500	1500
Approximate case measurements	cm.	185 × 120 × 95	220 × 140 × 100
Approximate space required for machine packed for shipment	cbm.	2.1	3.1
Approximate weight	kg.	750	1150
Price with 1 set of flanging rolls and seaming rolls, without tools			
1 complete set of tools for one size, consisting of: 1 set of carriers 1 channel piece 1 seaming disc and 1 pressure disc Price			
2 lower flanging rolls for one other flange height			
1 pair of spare seaming rolls			
Attachment for internal or external edge curling, with curling head for one size			
Curling head for one other size			
Electric drive, without motor			
Belt guard			

Code word for electric drive, without motor: ZASTI

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