

Technical Bulletin

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Release Date: July 13, 1981 Revision Date: April 1, 1997

SUBJECT: HEM CHANNELS AND HEM ANGLES

REASON: To provide a list of Hem Channels and Hem Angles used in stacks for various package set-ups.

| STACK DESCRIPTION | HEM CHANNEL# | HEM ANGLE RIGHT | HEM ANGLE LEFT |
|------------------------|------------------------|-----------------|----------------|
| 600E | 236,070,380.63 | 236,070,510.03 | 236,070,490.03 |
| 501E | 328,070,010.43 | 609,070,330.03 | 609,070,320.03 |
| 276E | 270,070,010.23 | 270,070,020.13 | 270,070,030.13 |
| 600T | 236,070,380.63 | 236,070,390.53 | 236,070,410.53 |
| 600T Australia Only | 236,070,480.03 | 236,070,510.03 | 236,070,490.03 |
| 501T | 328,070,010.43 | 328,070,020.43 | 328,070,030.43 |
| 501T Australia Only | Not Available at Print | 609,070,330.03 | 609,070,320.03 |
| 440/414 | 267,070,030.33 | 267,070,180.23 | 267,070,190.23 |
| 440/414 Australia Only | 267,070,430.03 | 267,070,440.03 | 267,070,450.03 |
| 440 500 ml PET | 267,070,460.03 | 267,070,470.03 | 267,070,480.03 |
| 368/276 | 270,070,010.23 | 270,070,020.13 | 270,070,030.13 |
| 368/276 Australia Only | 270,070,140.03 | 270,070,150.03 | 270,070,160.03 |
| 368/276 500 ml PET | 270,070,170.03 | 270,070,180.03 | 270,070,190.03 |
| 180/168 | 275,070,010.13 | 275,070,020.13 | 275,070,030.13 |
| 432 Wide Stack | 447,270,010.03 | 447,270,020.03 | 447,270,030.03 |
| 360 Wide Stack | 288,070,030.03 | 288,070,020.03 | 288,070,010.03 |

T-models serialized 0001-6310AP and higher have Channel Caps factory installed.
 1¼ deeper models serialized 0001-2735BI have Channel Caps factory installed.

NOTE: FOR INFORMATION ON CHANNEL CAPS, REFER TO TB 408.

CAUTION: On venders prior to Channel Caps and prior to serial number 0001-2452BF, you may find some sharp edges on top of the hem channels. When loading cans towards the top of a column, a sharp edge can puncture the can. See figure 1 for an illustration on filing the edges and points at the top of the Hem Channels.



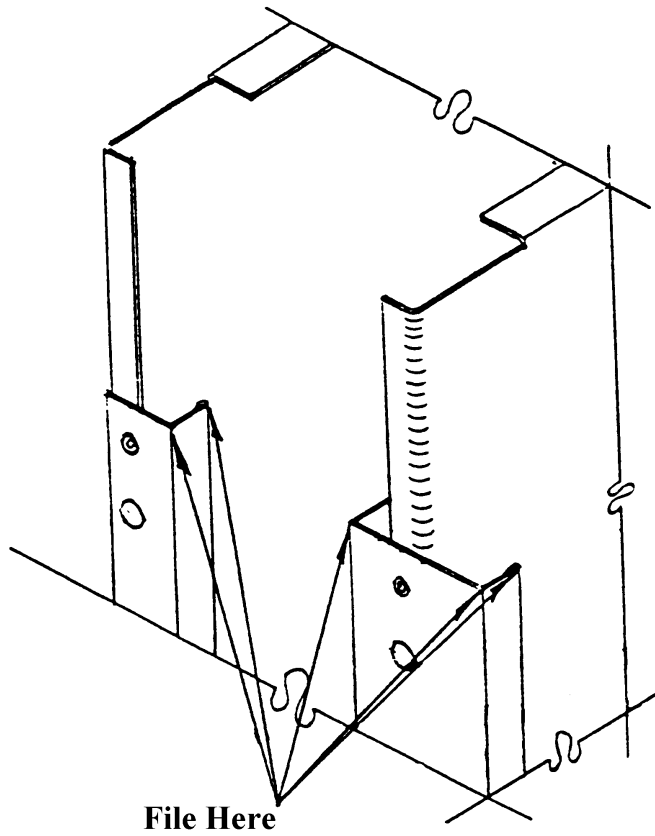


FIGURE 1

FIGURE 2