

## CAP MAKING SYSTEMS

END-O-MAT | CAP-O-MAT

MACHINES  
FOR STAMPING,  
FORMING AND  
LINING OF  
LUG CAPS



Technology that keeps you ahead

**Cantec**  
SOUDRONIC GROUP



## CAP LINER

### END-O-MAT CAP LINER

Rotary cap liner for plastisol with maximized sector for lining

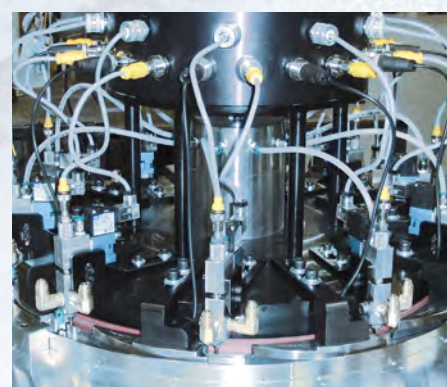
- Capacity between 300 epm and 1200 cpm with 4-, 6-, 8-, or 12-fold tooling, diameter range between 32 mm and 89 mm
- Operator-friendly menus with size-dependent parameter memory (accessed when changing to a different size)
  - ▶ reproducible lined ends
- Fine setting of lining guns (nozzle position) separately in radial and axial direction: In radial direction (diameter setting) by means of a threaded spindle, in axial direction (gun height) by means of a threaded spindle
  - ▶ better compound placement position

#### END-O-MAT CAP LINER

DIA. RANGE	8 GUNS	10 GUNS	12 GUNS
up to 70 mm	up to 600	up to 800	up to 1200
up to 82 mm	up to 500	up to 665	up to 1000
up to 89 mm	up to 450	up to 600	



High-speed rotary liner



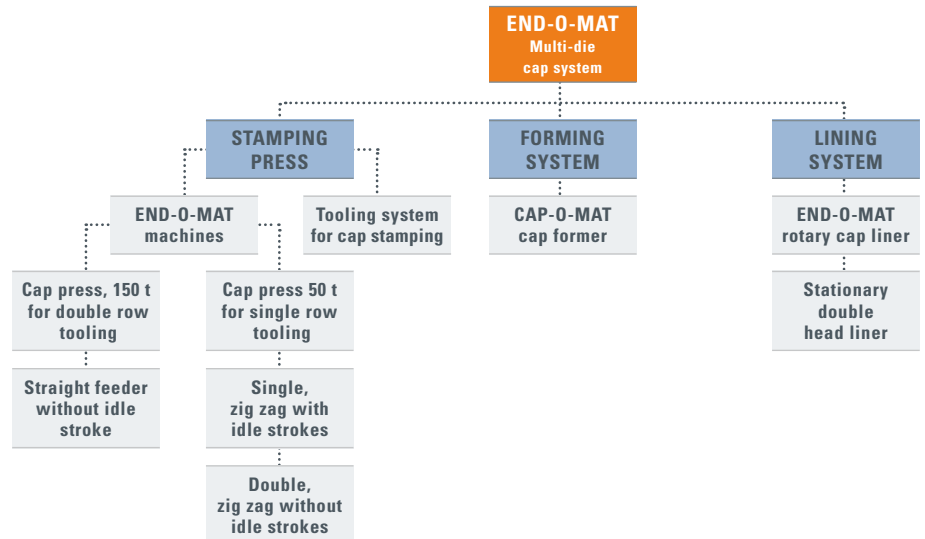
Circular compound distribution system



**TWIST-OFF™ CAP AND PT CAP PRODUCTION WITH END-O-MAT MULTI-DIE CAP SYSTEM**

High-speed production line consisting of:

- Sheet feed stamping press to produce cap shells, type END-O-MAT
- Rotary cap former with pre-curling, curling and lugging, type CAP-O-MAT
- Lacquer hair aspiration with antistatic unit
- Liner for plastisol compound, type END-O-MAT
- Drying and curing unit
- Video inspection
- Packaging
- Conveying



**SHEET FEED SYSTEMS**

**END-O-MAT – THE INNOVATIVE CAPMAKING SYSTEM**

- Quick retooling and quick resetting to different sizes
- Capable of producing caps with dia. from 32 to 89 mm
- Maximum sheet width of 1200 mm (47")
- Excellent material utilisation thanks to minimal web width
- No lubrication above product and die level
- No special foundation due to drive design which provides for balanced weight
- Low maintenance

**Combined strength and precision: the END-O-MAT multi-die stamping presses.**

**Advanced 4-point drive system dispenses with need for slide guiding system.**

**END-O-MAT CAP PRESS WITH 150 T**

- High-speed press for stamping of caps
- Press force 1500 kN
- Capable for operation two row tooling at up to 200 spm with CNC roller straight sheet feeder

**END-O-MAT CAP PRESS WITH 50 T**

- High-speed press for stamping of caps
- Press force 500 kN
- Capable for operation one row tooling at up to 200 spm with CNC zig zag sheet feeder

**END-O-MAT CAP PRESS**

NOMINAL CAP DIA.	NO. OF STROKES STROKES / MIN.	ONE ROW TOOLING		TWO ROW TOOLING	
		NO. OF DIES	CAPACITY CAPS SHELLS / MIN.	NO. OF DIES	CAPACITY CAPS SHELLS / MIN.
		38 mm	up to 200	8	up to 1600
43 mm	up to 200	8	up to 1600	16	up to 3200
53 mm	up to 200	7	up to 1400	14	up to 2800
66 mm	up to 200	6	up to 1200	12	up to 2400
70 mm	up to 200	6	up to 1200	12	up to 2400
82 mm	up to 200	5	up to 1000	10	up to 2000
89 mm	up to 175	4	up to 700	8	up to 1400



**END-O-MAT cap stamping press**



**P4 strip feed press**



## STRIP FEED SYSTEMS

### P4 STRIP STAMPING PRESS

Strip feed press with single and double tooling for stamping and deep drawing of caps

- Strip feed press for cap shells
- Operated with single or double die tooling
- Mechanical strip feed system for automatic feeding with single-scrolled, double-scrolled or straight-sided strips

### P4 STRIP FEED PRESS

SINGLE OR DOUBLE-DIE STAMPING PRESS		ACCESSOIRES
Max. press force	400 kN	Lubricating system
Stroke	75 or 100 mm	
Number of strokes	200 – 300 / min	
Strip length	710 – 1150 mm	
Strip width	70 – 255 mm	

NOMINAL CAP DIA.	NO. OF STROKES	NO. OF DIES	CAPACITY CAPS
STROKES / MIN.		SHELLS / MIN.	
38 mm	up to 300	2	up to 600
43 mm	up to 300	2	up to 600
53 mm	up to 300	2	up to 600
58 mm	up to 300	2	up to 600
70 mm	up to 300	2	up to 600
82 mm	up to 275	2	up to 550
89 mm	up to 250	2	up to 500

**CAP  
FORMER**

**CAP-O-MAT**

The CAP-O-MAT is a mature multi-function system designed to meet the technical and commercial canmaking challenge of the future.

- High level of process capability
- Wide variety of application
- Safety and operator protection

**CAP-O-MAT cap forming toolings (twist off) for 1st, 2nd and 3rd operation (with rail pre-curling)**

The pre-curl station can be equipped with rail pre-curling technology, which reduces the tooling costs

**RAIL PRE-CURLING**

The pre-curl station prepares the cap for curling. The pre-curl geometry takes into account nosing and curl radius. Advantage: Rail pre-curling high production security.

**DIE CURLING**

The curling station prepares the cap for the lugging station. The curl geometry is determined by the lugging station.

**DIE-LUGGING**

The lugging station determines the appearance of the cap. The function and appearance of the lug have been developed with optimum geometry in mind.



CAP-O-MAT



**CAP-O-MAT cap forming toolings (twist off) for 1st, 2nd and 3rd operation (with die pre-curling)**

Alternatively the pre-curl station can be achieved in die pre-curling technology

**DIE PRE-CURLING**

The pre-curl station prepares the cap for curling. The pre-curl geometry takes into account nosing and curl radius.

**DIE CURLING**

The curling station prepares the cap for the lugging station. The curl geometry is determined by the lugging station.

**DIE LUGGING**

The lugging station determines the appearance of the cap. The function and appearance of the lug have been developed with optimum geometry in mind.

**1st operation: Rail pre-curling (option: die pre-curling)**

**2nd operation: Die curling**

**3rd operation: Die lugging**

All die-operating tools are designed with overload protection and as cartridge tools for quick and easy changeover.

**CAP-O-MAT MULTI-FUNCTION SYSTEM**

VERSION	NUMBER OF SPINDLES	DIA. RANGE	CAPACITY CAPS / MIN.
Standard version	4	up to dia. 89 mm	up to 400
	8	up to dia. 82 mm	up to 800
High-speed version	4	up to dia. 89 mm	up to 600
	8	up to dia. 70 mm	up to 1200
	8	up to dia. 82 mm	up to 1000

## TECHNICAL DATAS

### CAP LINE CONFIGURATIONS

#### HIGH-SPEED LINE WITH SHEET FEED STAMPING PRESS (TWO ROW TOOLING) AND ROTARY LINER

END-O-MAT 150 T	2 CAP-O-MAT	2 END-O-MAT	RANGE	CAPACITY
STRAIGHT SHEET FEEDING	HIGH-SPEED VERSION	ROTARY CAP LINER	OF APPLICATION	CAPS/MIN.
10 – 16 out	8-fold tooling	12-fold tooling	up to dia 70 up to dia 82	up to 2400 up to 2000

#### HIGH-SPEED LINE WITH SHEET FEED STAMPING PRESS (ONE-ROW TOOLING) AND ROTARY LINER

END-O-MAT 50 T	CAP-O-MAT	END-O-MAT	RANGE	CAPACITY
ZIG ZAG SHEET FEEDING	HIGH-SPEED VERSION	ROTARY CAP LINER	OF APPLICATION	CAPS/MIN.
5 – 8 out	8-fold tooling	12-fold tooling	up to dia 70 up to dia 82	up to 1200 up to 1000

#### HIGH-SPEED LINE WITH SHEET FEED STAMPING PRESS (ONE ROW TOOLING) AND STATIONARY LINERS

END-O-MAT 50 T	CAP-O-MAT	CAP LINERS	RANGE	CAPACITY
ZIG ZAG SHEET FEEDING	HIGH-SPEED VERSION	STATIONARY, 3 UNITS	OF APPLICATION	CAPS/MIN.
5 – 8 out	8-fold tooling	2-fold tooling each	up to dia 70 up to dia 82	up to 1100 up to 1000

#### MEDIUM-SPEED LINE WITH STRIP FEED STAMPING PRESS AND ROTARY LINER

P4 CAP STAMPING PRESS	CAP-O-MAT	END-O-MAT	RANGE	CAPACITY
STRIP FEEDING	STANDARD VERSION	ROTARY CAP LINER	OF APPLICATION	CAPS/MIN.
2 out	8-fold tooling	8 or 10-fold tooling	up to dia 82	up to 600

#### MEDIUM-SPEED LINE WITH STRIP FEED STAMPING PRESS AND STATIONARY LINERS

P4 CAP STAMPING PRESS	CAP-O-MAT	CAP LINERS	RANGE	CAPACITY
STRIP FEEDING	STANDARD VERSION	STATIONARY, 2 UNITS	OF APPLICATION	CAPS/MIN.
2 out	8-fold tooling	2-fold tooling each	up to dia 82	up to 600