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coating to flow over and adhere to the inner surface of the blank. When the tin coating and solder coating are molten, the blanks are rotated and passed between rolls, one of which will squeeze the blank as the other rolls are moved toward and away from the one roll. If the outer surface of the blank is uncoated, then when the solder coating flows over the uncoated surface, the tin coating which has previously been applied will cool and bond to the solder coating, whereby the tin coating will cling to the solder coating to prevent it from running over the outer surface of the can blank. On the other hand, if the outer surface of the blank is tin plated prior to the application of the solder coating, the solder coating will bond to the tin coating on the outer surface of the can blank 2d92ce491b