



NPCC
VOLUME.....11
NUMBER.....11
MARCH 1985

THE NATIONAL POP CAN COLLECTORS MONTHLY NEWSLETTER

PTL

"BLESSED IS THE MAN WITH A HOBBY, FOR HE LIVES IN TWO WORLDS"

The Pop Can Man will be at the Indianapolis show March 29/30
CAN YOU MAKE IT ????? Contact John Bundy for info 317-776-0553
Special prices on NPCC T-shirts.....see ad in this issue

We must announce that effective March 1 our new subscription rates will be increased to \$12.00 per year, mailed First Class as always.

NPCC TRIVIA

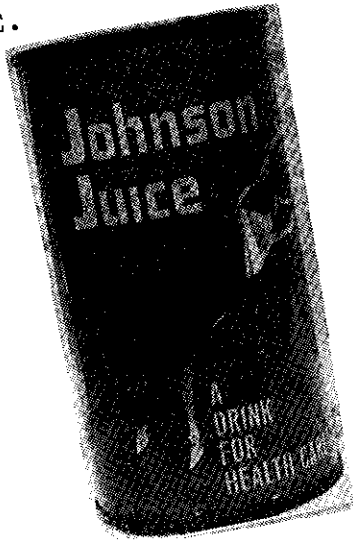
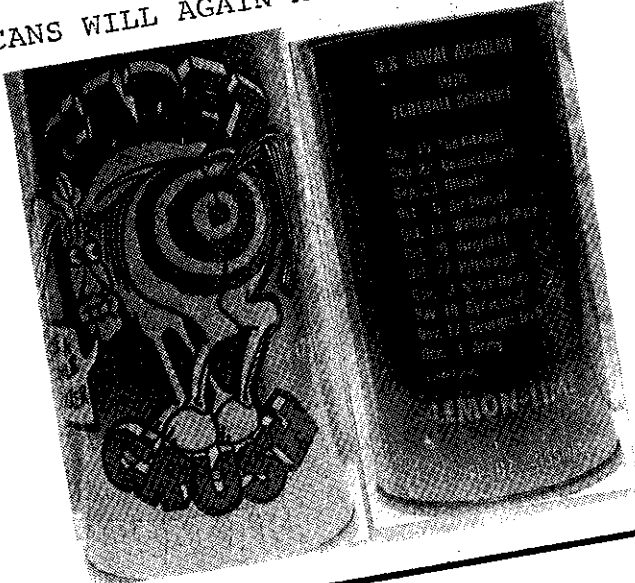
When was the first and only NPCC Commemorative can released?
How many were made? (answer on page 5)

Free ad deadline for April issue is March 21st. Please send in your ads.

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By Warren Hardaker

WAY BACK LAST AUGUST WHEN PAUL AND KAREN BATES WERE OUT WEST FOR THE 1st ANNUAL NPCC CONVENTION, I HAD THE HONOR OF THEIR EXPERTISE WITH A VISIT TO MY HOME. SOME OF THE CANS THAT CAUGHT THEIR EYE WERE THOSE IN THE FOLLOWING PICTURES. PAUL HAD NEVER EVEN SEEN THE OLD DELAWARE PUNCH AND SAID THAT BOTH THE CADET CRUSH 1979 NAVAL ACADEMY FOOTBALL SCHEDULE AND THE JOHNSON JUICE CANS WERE FOUND IN VERY FEW COLLECTIONS. ALTHOUGH I HAVE ONLY A FEW OF MY SODAS ON DISPLAY THESE ALSO ARE A COUPLE OF MY FAVORITES. THINGS HAVE BEEN VERY QUITE ON THE WEST COAST FOR THE PAST FEW MONTHS BUT WITH THE SPRING AND SUMMER SEASONS APPROCHING I AM SURE A LOT OF SPECIAL ISSUE CANS WILL AGAIN MAKE THERE APPEARANCE.



SODA BOTTLE & CAN COLLECTORS - Books listing all known:

Commemorative & Offer Soda Cans (30 + pages)	\$4.00
Commemorative Soda Bottles (20 + pages)	\$5.00
Painted Label Soda Bottles (50 + pages)	\$5.00
Embossed Soda Bottles (25 + pages)	\$5.00
Soda Drinking Glasses (20 + pages)	\$5.00

Soda Mart, Ridgecrest Drive, Goodlettsville, TN 37072



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Soda Mart, Ridgcrest Drive, Goodlettsville, TN 37072

All members are entitled to one free 40 word ad per month. All extra words are 10¢.
Non members rates are 15¢ per word, which includes a copy of the newsletter in which the ad appears.

Display ads....¼ page \$12 ½ page \$20 full page \$35
Black & white photos are acceptable at an extra charge for screening.

Ad deadline is the 21st of each month, any ad received after the 21st will be printed in the following issue unless stated otherwise.

SPECIAL SPRING SALE ON N P C C T-SHIRTS

SEE AD IN THIS ISSUE

WANTED: Grafts;Wisconsin State Fair Aug 9-18 root beer, Lemon Twist, Zep, Milwaukee Open cans Pleezing and Featherweight cans. Interested in most anything made by or for Grafts-must have Grafts name on it, will buy or trade. Also collect glass soda mugs, soda bottle & can openers Dennis Fewless, Route 2 Box 47A, Delavan, Wisconsin 53115

FOR SALE: 2100+ soda can collection. Includes 275 foreign, 57 flats, 8 cones. Also included a good selection of 500+ traders. Will sell all for \$500. plus shipping charge.
John Williams II, 1200 Valentine Drive, Normal, Illinois 61761 tel 309-452-6175

NEW SODA CAN BOOK

Soda Marts Interactive Book Series presents
"Commemorative / Offer / Set Soda Cans" Now illustrated !!

Send \$6.00 plus \$1.50 postage to;

Soda Mart, Ridgecrest Drive, Goodlettsville, Tennessee 37072 1x

FOR SALE; Coca Cola University of Arizona, Coke Super Bowl of Drag Racing and many more pull tabs and flat tops, nothing priced over \$1.00. Send stamp for lists.

William Hill, 2241 North Catalina Avenue, Tucson, Arizona 85712

FOR SALE or TRADE: Soda cans-old & new, flat tops, pull tabs, and a few cones too. Send your want list. We also collect soda bottle caps. "No we are not a farm implement Co." Midwest Combine, 3204 West 143rd, Shawnee Mission, Kansas 66224 tel 913-897-2840

WANTED; old electric Coke & Pepsi signs, will buy or trade.
FOR SALE; Both 7 UP sets, priced at \$50. per set plus postage.

Wally Gilbert, 180 North Upas, Escondido, California 92025 1x

TRADE: Pepsi "Taste the pride of the Carolinas", Food Lion, Kist, A & P, Big K, Big Star, Food Giant, Chek...WANTED; American Dry, Canada Dry "Fall Fiero" contest can and any other new or changed ginger ale cans. ALSO HAVE NEW "PEPSI DAY" FLORIDA FAIR CANS

Ginger Hornsby, P O BOX 91, Marietta, Georgia 30061

FOR SALE or TRADE !!! Soda flats and cones, many Shastas-many generations-many flavors, and most are in excellent condition. Also have other sodas. Will sell very reasonably or I will trade for soda flats or cones. x5

Les Whitman, P O Drawer KK, Westwood, California 96137 tel 916-256-3437

FOR SALE: 1984 Michigan Wolverine and Michigan State Spartan football schedule cans. x3
Only \$7.50 per case, can be mixed.

Rich Johnson, 2870 South Main, Ann Arbor, Michigan 48103

WANTED !!! The following PEPSI COLA bottles; 28 oz no deposit/no return with thin foil or paper type label, 48 oz no deposit/no return thin glass with thin styrofoam label, 48 oz no deposit/no return thick glass with thin foil or paper type label, old embossed bottles-Lord Chesterfield (VA), amber Wilson (NC), Lynchburg (VA) Bottling Works checkerboard effect and many more needed-tell me what you have. x2

Jim South, P O BOX 672, Drexel, North Carolina 28619 tel 704-437-5563

DIFFERENTIAL DEFLECTION OPENS CAN END; PULL TAB IS ELIMINATED

Oil-canning causes high-stress concentrations in coined surface

Brian J. Hogan, Midwest Editor

Greendale, WI—A new can end is made from pre-formed shells or can ends using a two-step process. First, a semi-circular section is drawn from the shell. Next, this section is coined back down upon the original surface. A cross-section taken through the coined area resembles a crushed letter Z. The drawing and coining operations cold-work the metal, and reduce its thickness around the edge of the dome.

Pressure on the dome's uncoined surface, near the center of the can end, causes high-stress concentrations in the coined region. A crack propagates through that part of the

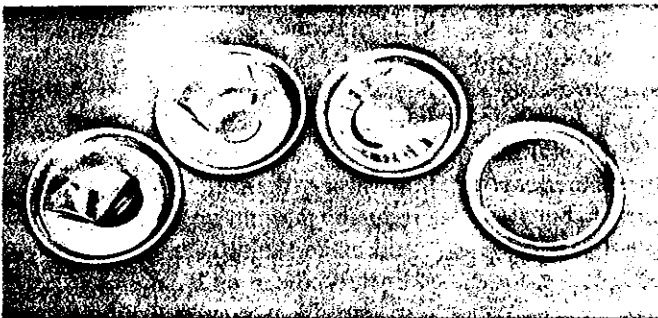
can end. Gas pressure inside the can, combined with deflection resulting from force exerted at the center of the dome, cause the area outlined by the coining operation to rise to an angle of 15- to 20-deg relative to the surface of the can end. A user can then push the projecting tab farther upward using his/her thumb or finger.

James J. Rossetti explains that most conventional can ends have some sort of lever or tab, on which one pulls or pushes. A score on the can end then ruptures, and the part of the can end outlined by the scoring is pushed downward, into the can

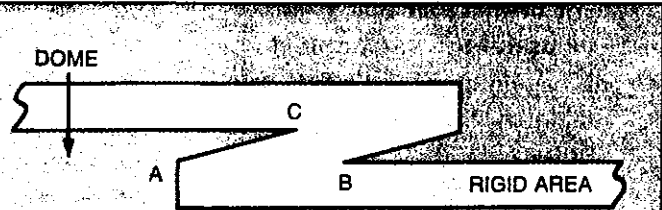
(and the beverage it contains). Other designs eliminate the lever/tab; users press a segment of the can end into the container's interior.

In either case, part of the can end is dunked in the fluid one intends to drink. Filth of various kinds (traces of rat excreta, rat poison, bug sprays, dirt) may be present on that can end. Rossetti points out that it is desirable to avoid inserting any part of a can end in a beverage you intend to consume. By opening upward, his "Top-Pop Lid" allows you to enjoy canned beverages, while minimizing your intake of substances on can end.

Rossetti began working on the



Prototype can end is made using formed lift (right); If flat stock were employed, wrinkles in prototype's surface would disappear. (Design News photo.)



Coining operation folds domed area on "Top-Pop Lid" as shown. When uncoined bubble is depressed, rigid metal around dome deflects less than dome, and point A contacts dome. Dome continues to travel downward, and cracks (initiated at point B or point C) propagate until metal in coined region fails.

Designed by James J. Rossetti and made for him by Toolrite Mfg. Co., New Berlin, WI. "Top-Pop Lid" opens upward, rather than folding down into beverage within can (Design News photo.)

CONTINUED

DIFFERENTIAL DEFLECTION

new can end approximately 3½ years ago, and has recently received a patent on the component. His design employs differential deflection of areas on the can end to create an opening in it.

During manufacture, the domed area previously mentioned is raised about 3/16 inch (max) above the can end's outside edge. Coining follows as described previously. When you press on it, the dome deflects more than the relatively rigid section of the can end that surrounds the dome. The rigid area acts like a fixed edge across which one breaks a stick. Stress risers created during the coining operation cause the coined region to fail. Gas pressure within the can and the mechanical forces generated by pressing on the dome, lift the area outlined by the coining operation. A significant side benefit that results from forming (instead of scoring) the boundary of the part of the can end that lifts upward, is that there are no sharp edges around the opening made in the "Top-Pop Lid".

Crack propagation through the coined metal occurs in two stages. First, force applied to the dome ruptures two severely-folded metal ridges at either end of the coined strip. This action vents some of the gas in the can, allowing you to easily depress the dome. Second, as the dome

travels downward, ruptures propagate through the coined region.

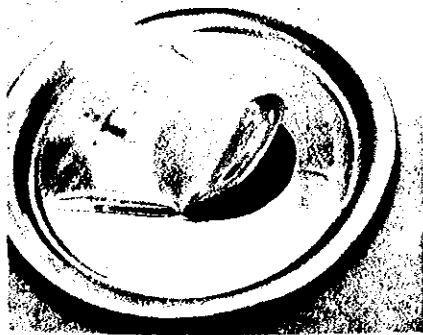
Associate Professor Robert C. Weber of Marquette University, a mechanical engineer, explains that the speed of propagation of the ruptures around the dome determines the final angle of rest of the metal tab created by coining. The propagation speed is related to the manner in which the coining operation is performed. The metal tab can be made to stand up at almost 90-deg to the can end's surface, but a 15-or 20-deg angle is considered most desirable.

Also, by modulating the coining operation, the force necessary to rupture the coined region can be varied. Typically, says Weber, a downward force of between 10 and 15 lb on the dome will open the "Top-Pop Lib". In storage and during pasteurization, the can end contains pressures to 100 psi without opening.

Approximately 65 × 10⁹ can ends are used in the U.S. each year, according to Rossetti. Most of them are made of 5182 H-19 temper aluminum, 11 to 14.5 mils thick. Manufacturing conventional can ends requires progressive die sets having 6 to 12 stations. Tabs/rings require an additional 6 to 19 stations. Rossetti has been making prototype "Top-Pop Lid" can ends in a two-step operation, beginning with formed lids rather than flat stock. He is producing aluminum can ends, but could make them from steel.

Prototype can ends made by Rossetti and his associates exhibit wrinkling caused by the drawing step. If flat stock were employed, control of metal flow would improve and the wrinkles would no longer be a problem. (They are strictly an aesthetic matter, says Rossetti.) In full production, a six-station progressive die will be needed to make the new can ends from flat stock.

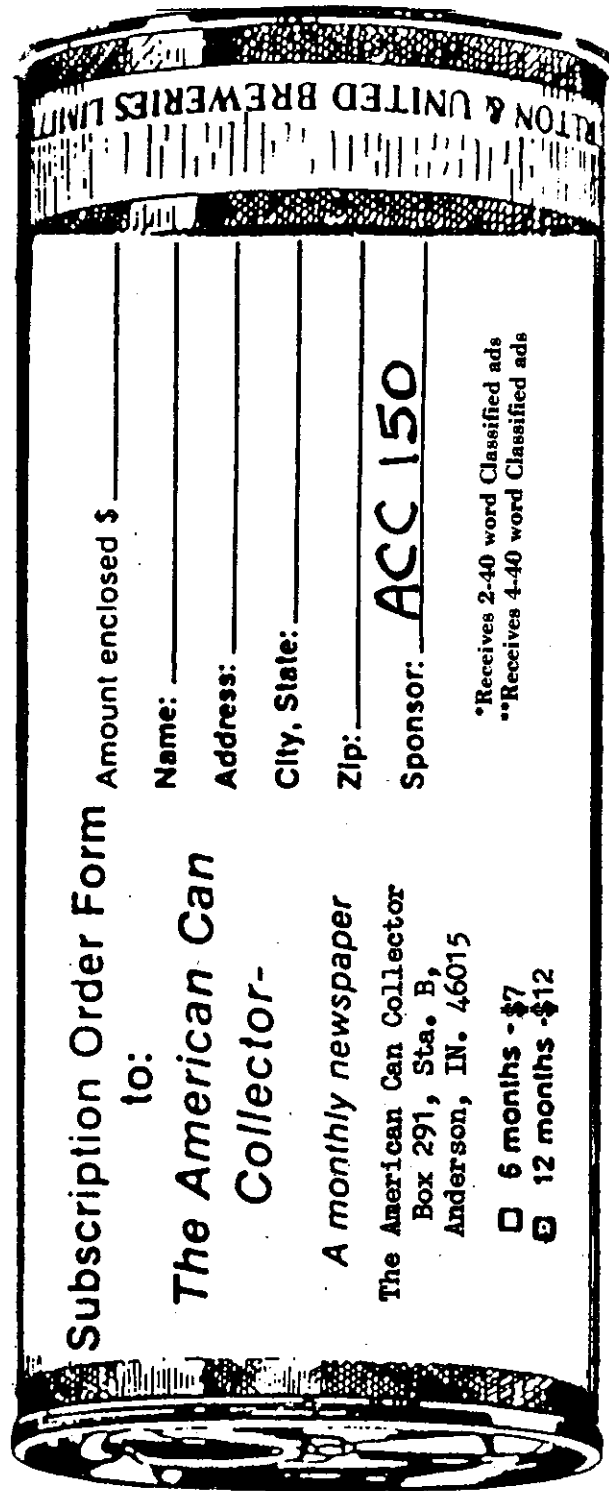
Bottom quarter of domed area on "Top-Pop Lid" is coined as shown; depressing dome causes crack to propagate through coined region. (Design News photo.)



THANK TO BOB RUSSELL
FOR THIS ARTICLE



5-



Subscription Order Form

to:

The American Can
Collector-

A monthly newspaper

The American Can Collector
Box 291, Sta. B,
Anderson, IN. 46015

6 months - \$7
 12 months - \$12

Amount enclosed \$ _____

Name: _____

Address: _____

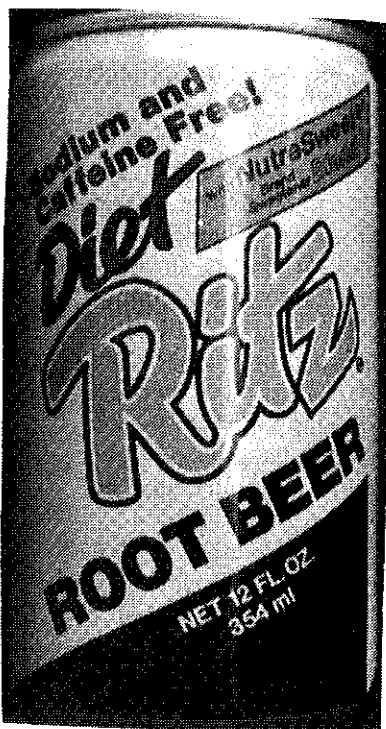
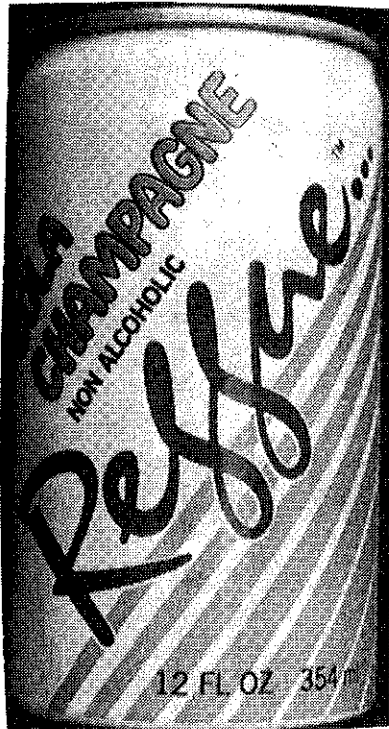
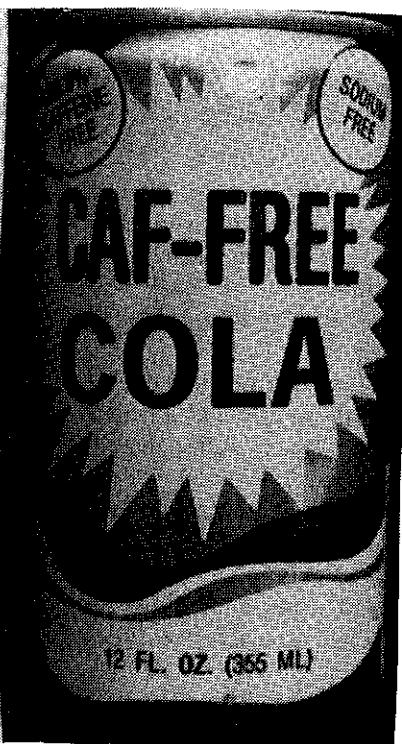
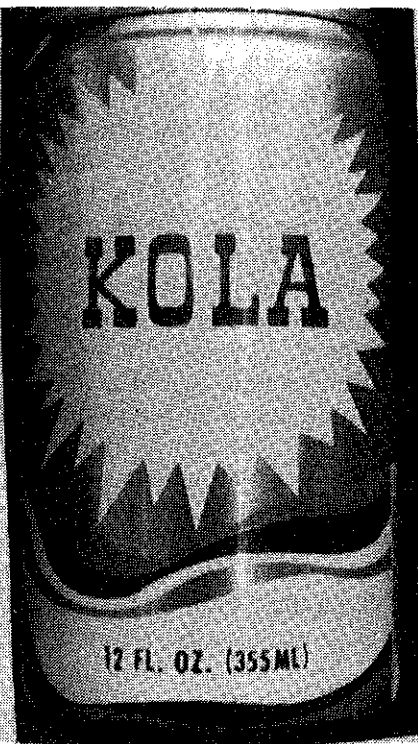
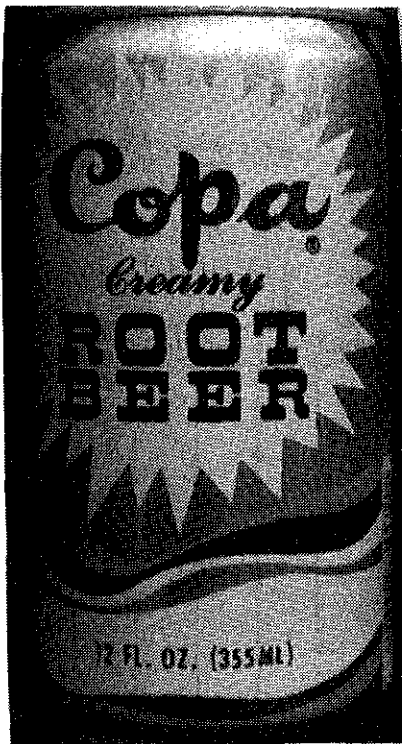
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Sponsor: ACC 150

*Receives 2-40 word Classified ads
**Receives 4-40 word Classified ads

NPCC TRIVIA -
ONLY 500 WERE MADE
ONLY 400 WERE RELEASED
(100 DESTROYED)



New designs for existing products or new products, as introduced in the Miami area.

New-Reggae Cola Champagne by Caw

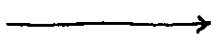
New design Diet Ritz, Caf-Free Cola, & Kola by Beverage Canners of Miami.

note: "Kola" formerly sold as "Copa Cola", can is the same except "Copa" is eliminated.

"Caf-Free" is not identified as Copa brand, but is in similar can, see photo of copa root beer shown for reference.

Our thanks to Robert Cochrane for the above information and photos.

PEPSI COLLECTORS
SEND FOR
INFORMATION



Pepsi-Cola Collectors Club NEWSLETTER

post office box 1275 covina, california 91722

NPCC "T" SHIRTS



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INCLUDES SHIPPING COST

ADULT SIZES S-M-L-XL

CHILD'S SIZES 2-4, 6-8, 10-12, 14-16



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CONTACT DALE ON ANY INQUIRIES YOU MAY HAVE FOR
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PLEASE KEEP US POSTED ON ANY LOCAL
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7

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NAME _____ AGE _____

ADDRESS _____ P O BOX _____

CITY _____ STATE _____ ZIP _____

OCCUPATION _____ TELEPHONE () _____

HOW LONG HAVE YOU BEEN COLLECTING _____ TOTAL CANS IN COLLECTION _____

HOW MANY ARE FLAT TOPS _____ HOW MANY ARE CONE TOPS _____

DO YOU COLLECT ANY CERTAIN FLAVORS, SIZES, TYPES, ETC. _____

DO YOU COLLECT ANY OTHER ASSOCIATED ITEMS (bottles-trays-advertising-etc) _____

MAIL TO : N P C C 3014 SEPTEMBER DRIVE JOLIET, ILLINOIS 60435

PLEASE TELL YOUR FRIENDS AND FELLOW POP CAN COLLECTORS ABOUT N P C C

We feel that there are many pop can collectors who have no idea that there is an organization devoted to their hobby. Please tell your fellow soda can collectors or any interested parties about us.

We will be happy to send application blanks to any of you who would like to set up at any shows, flea markets, antique shows, etc.

FROM
 National Pop Can Collector
 Fred Bogdan-"The Pop Can Man"
 3014 September Drive
 Joliet, Illinois 60435

FIRST CLASS



TO

JERRY POLLACK
 294 AVE B
 BAYONNE, NJ 07002

If a RED stripe appears on your address label--you have 1 more issue coming
 If a blue stripe appears--This is your last issue---Please renew at once