



Belvac Production Machinery Technical Bulletin

Information for Customers Operating & Maintaining Belvac Machines

ISSUE 4, VOLUME 12, APRIL 2009

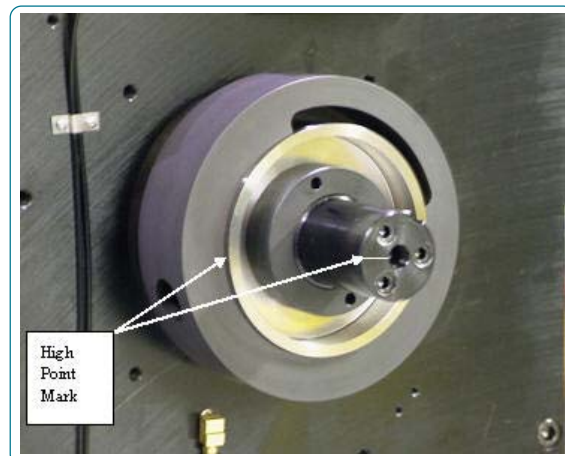
CC92/93/95 VACUUM MANIFOLD ADJUSTMENT PROCEDURE

Adjusting of the trimmer vacuum manifold has been known to be sensitive with regards to the graphite slip ring being damaged. Belvac has addressed this issue with a procedure to eliminate unnecessary slip ring damage.

The recommended method to adjust vacuum timing is:

- Remove the drive bushing/pulley,
- Set the high point of the selector ring at TDC (12:00). If the main shaft does not indicate the high-point of the vacuum selector ring,
 - Indicate the max runnout of the vacuum selector ring,
 - Scribe the end of the main shaft at the max runnout position (TDC).
 - Rotate the turret to the TDC (12:00) position.
- Insert feeler stock (0.0010", 0.0015" or 0.0020") between the vacuum slip ring and the vacuum selector ring.
- Loosen the vacuum manifold assembly clamps
- Advance/retard timing as desired,
- Tighten the vacuum manifold assembly clamps,
- Reinstall the drive bushing/pulley.
- Tension the belt

Determine the max TIR position and mark the end of the main shaft as indicated.





Belvac Production Machinery Technical Bulletin

Information for Customers Operating & Maintaining Belvac Machines

ISSUE 4, VOLUME 12, APRIL 2009



To remove the pulley: release the tensioner, remove the bushing by removing the three screws and jacking the bushing from the pulley.

Upon removal, the vacuum slip ring assembly and selector ring are readily accessed.

This time required to access, reset and secure the vacuum ring is less than 20-min.

Best practice dictates adjusting the turret with the max runout at TDC for the following reason.

If a maintainer does not use feeler stock to set the manifold assembly to the selector ring, the manifold assembly will drop due to gravity within the available running clearance. Upon startup, shaft runout will wedge the selector ring into the graphite ring, potentially cracking the ring.

Belvac recommends feeler stock is used to position the vacuum the graphite ring to the selector ring: other methods may cause damage to the graphite ring.

Please contact Belvac Service with any questions.