



# Belvac Production Machinery Technical Bulletin

Information for Customers Operating & Maintaining Belvac Machines

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## Heavy Duty Cartridge Greasing Modification (Revised)

Belvac's HD Cartridge was designed to be greased and serviced with the cartridge installed on the trimmer. Examination has shown grease applied too liberally or too quickly permeates the shim pack causing the lower arm to move axially. As the grease migrates out from between the shims, the lower arm is allowed to float, causing fluctuation in the knife gap. If the lower arm is greased in a slow, controlled fashion, this condition does not occur.

Belvac's solution to this problem is to remove the re-grease capability of the lower arm on the cartridge. This has been done by removing the grease fitting and its associated channels within the lower knife shaft arm as indicated below. Note that the center shaft grease fittings have not been removed.

Moving forward, re-greasing of this area will be relegated to the tool room during yearly maintenance. The relevant needle bearings will need to be hand packed on this interval, a process which has been successfully used in production for many years.

To facilitate bearing life in production, grease used in the cartridge was changed from Exxon Ronex MP NGLI-II to Mobilith SHC PM460 as used in Belvac's EMC cartridges. This grease is formulated to prevent wash-out, and is more resistant to bodymaker coolants.

