



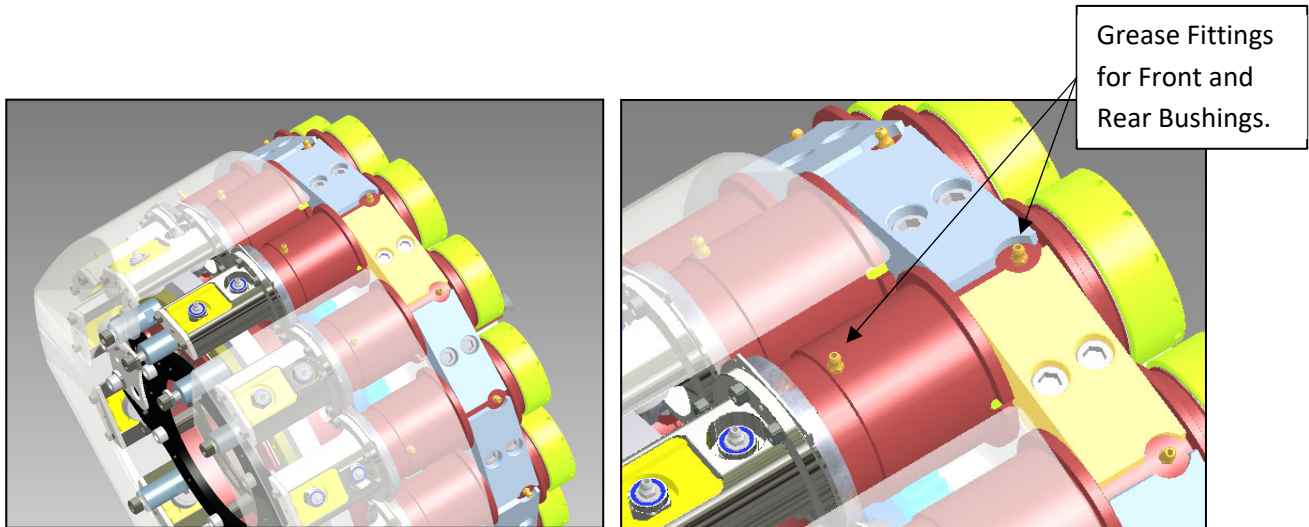
Belvac Production Machinery Technical Bulletin

Information for Customers Operating & Maintaining Belvac Machines

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THE BELVAC (TBN) REFORMER TOOLING CARTRIDGE MANUAL LUBRICATION UPGRADE KIT #8957928



To extend the life of the HyComp bushings and tooling spindle ram, Belvac has provided a manual grease fitting lubrication feature to the Reformer Tooling Cartridge as standard for Reformers issued after September 2017.

Belvac offers a kit to convert earlier Tooling Cartridge Assemblies (8951835, 8951903, 8952201 & 8953831) to this lubricated version under **#8957928**. The conversion kit is on a per-cartridge basis (*i.e. a full turret would require twelve*), consisting of the following:



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Drawing Number	NEW Part Number	Existing Part Number Being Replaced	NEW Part Description	Qty
4924	8955643	8951837	RETAINER, BEARING, H-LINK BASE	1
4939	8955642	8951834 or 8952202	HOUSING, CAM FOLLOWER	1
4969	8955223	8951829	HOUSING, REFORMER SPINDLE, LUBED	1
4976	H18178	N/A	FITTING, GREASE LINCOLN 5175, M6, STRAIGHT, BRASS	2
4699**	8955225	8951780	RETAINER, REFORMER SPINDLE CARTRIDGE	1
↓↓ Common Rebuild Entities ↓↓				
4951	H100147	Same	SCHNORR-BELLEVILLE #002750C	14
4938*	C106187	C101244	CAM FOLLOWER, CFM30BPM, RBC	2
4940	H100165	Same	NUT, LOCK M12X1.5, NYL INS, DIN985	2
5084	8951842-002	Same	SHIM, .002" FOR DUAL CAM FOLLOWER	2
5084	8951842-005	Same	SHIM, .005" FOR DUAL CAM FOLLOWER	1
5084	8951842-010	Same	SHIM, .010" FOR DUAL CAM FOLLOWER	1
↓↓ Reference Information ↓↓				
10	TB36-2N00	Latest Revision	TBN NECKER PART 2 3600	1
20	TB36-C00	Latest Revision	REF/REP APPENDIX C - THE BELVAC 360	1

* Standard Available Cam Follower is RBC.

** If replacing less than a full compliment of (12) Cartridges, one additional retainer must be ordered.

When assembling the kit, finger lube the HyComp bushings with Mobilith SHC 100, then assemble the tooling. As the tooling retains the front HyComp bushing, only lube via grease fitting *after* tooling is installed. Refer to Manual #TB36-2N00 for Manual Lubrication Points and Frequency.

In accordance with the manual (#TB36-C00): "All new and/or rebuilt reformer Cartridge assemblies should be setup to a consistent reform roller bead diameter before they are installed onto The BELVAC reformer turret."

Follow the manual instructions to perform the tooling setup **BEFORE** installation on the production machine. It is critical to ensure all cartridge assemblies provide common bead height and depth specifications.



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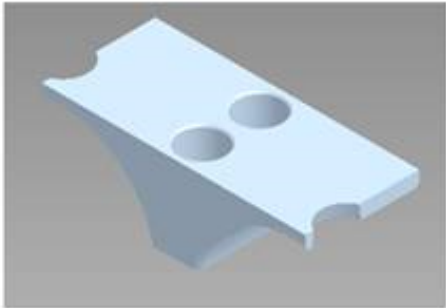
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New direct interchange Reformer Tooling Cartridge Assemblies are also available as follows:

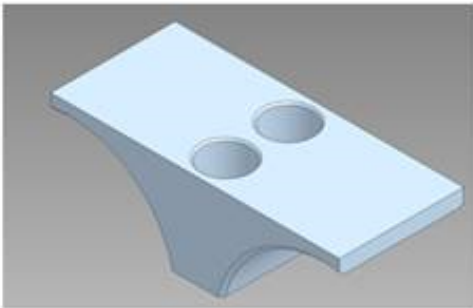
THE Belvac Reformer Tooling Cartridge Assembly	
Existing Obsolete Assembly	New Replacement Assembly
8951835	8956551
8951903	
8952201	



Note: As with the conversion kit, Qty (1) cartridge retainer 8955225 per new assembly will be required, replacing the existing 8951780. If less than a full compliment of (12) cartridges is ordered, one additional retainer #8955225 will be required.



8955225 (New)



8951780 (Existing)