



Belvac Reformer Tooling Wear - Insert Replacement In Both Tool Holders and Receptacles

This Technical Bulletin is being released as an effort to expand on replacement instructions released in Technical Bulletin Issue 30, Volume 1, September, 1997.

The bulletin was originally released as an instruction for customer replacement of the wear-comp bearing inserts (part number 1700360) which allows extended life of both the tool holders and receptacles.

This notice is intended to clarify what is required to make repaired parts ready for re-installation into the reformer turret assembly.

- ✦ Match mark the receptacle or tool holder to its ram assembly prior to removing it from the machine.
- ✦ Worn inserts can be removed by heating the receptacle or tool holder to approximately 250° F (121° C). Take care not to overheat the steel to the point of distorting the original geometry.
- ✦ Cement the new inserts into the components using **Loctite 330** (*Loctite Kit #20251*). This can be purchased from **Belvac** by ordering part number **C44126**. Follow all preparation and application instructions provided in this kit. It covers cleaning, priming and curing for this product.
- ✦ Apply pressure to the components by clamping or placing weight on the insert to ensure the parts are fully seated.
- ✦ Allow parts to fully cure 12 hours with constant pressure applied.
- ✦ Clean any excess adhesive using a razor blade or sharp knife.
- ✦ Inspect parts per dimensions shown below to ensure proper assembly height. This is necessary to ensure both reform roller location and preload in the tooling assembly.
- ✦ In most cases, the components will need to be ground to obtain the dimensions shown. Inserts are designed to ensure a material-off condition exists when the components are initially assembled. The wear-comp material can be ground using standard CBN wheel on an ID grinder.
- ✦ Clean with alcohol and coat with mineral oil.

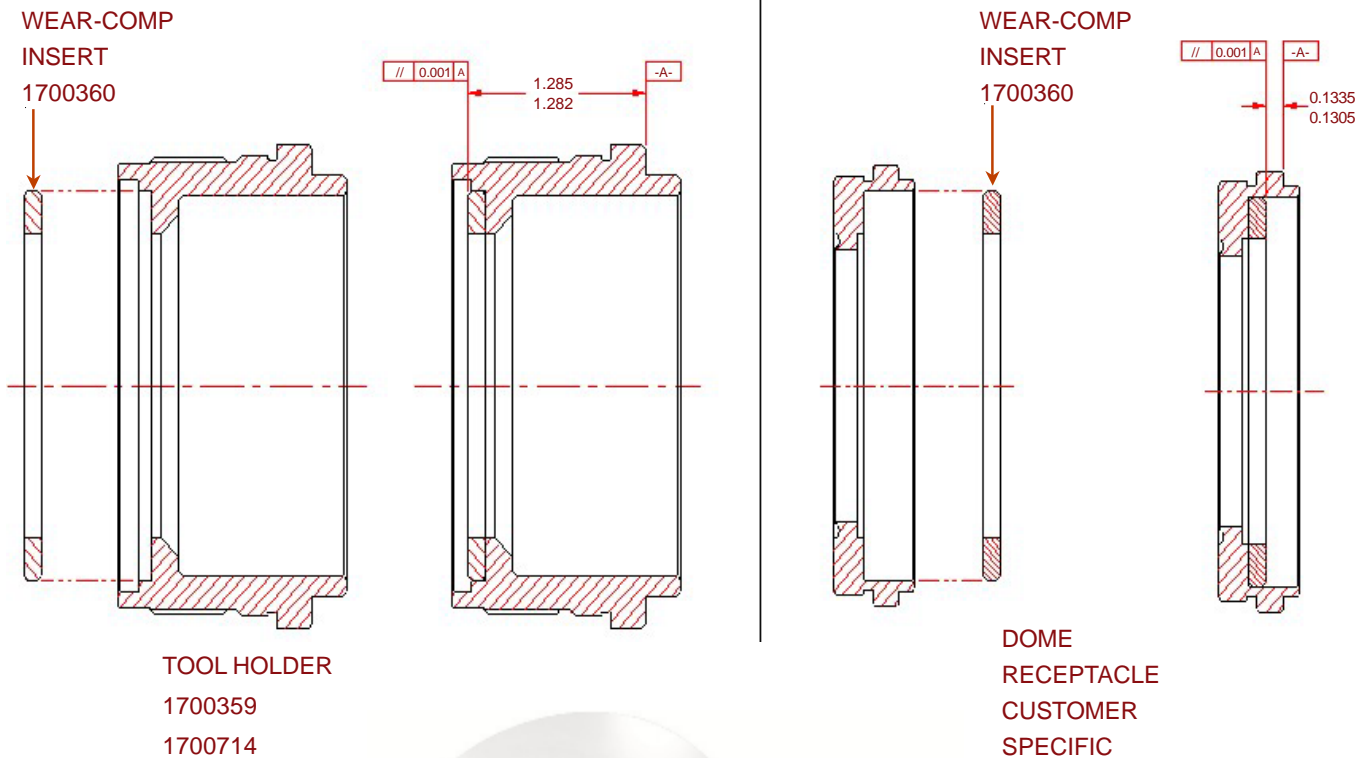
Contact Belvac Sales or Service Representatives for additional information.

Belvac Production Machinery, Inc.

237 Graves Mill Road, Lynchburg, Va. 24502 USA Tel. (434) 239-0358 Fax (434) 239-1964

info@belvac.com

<http://www.belvac.com>



During the replacement procedure, care should be taken to maintain the relationship of the receptacle or tool holder to its specific reformer ram assembly. This allows direct replacement into the assembly without requirement to set up and grind reformer tooling shims.

If the ram/tooling relation is lost in the rework process, refer to Appendix C of the manual for "Reformer Tooling Ram Setup" instructions.

Contact Belvac Sales or Service Representatives for additional information.

Belvac Production Machinery, Inc.

237 Graves Mill Road, Lynchburg, Va. 24502 USA Tel. (434) 239-0358 Fax (434) 239-1964

info@belvac.com

<http://www.belvac.com>