



Belvac Production Machinery Technical Bulletin

Information for Customers Operating & Maintaining Belvac Machines

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All Belvac Necker Systems* Ram Assembly Key Redesign

Technical Bulletin issue 05, volume 03, September 2000, provided notification that all ram assemblies rated up to 2400 CPM would be supplied with a plastic key design instead of the former steel key design. This upgrade bulletin supercedes Technical Bulletin #5 vol. 3, September 2000.

Belvac now supplies as standard the plastic key design on all model ram assemblies installed on new Necker Systems shipped after July 2005, regardless of speed rating. This includes, for example, high speed systems such as 595SK (3000 CPM maximum rated) and 795 (3600 CPM maximum rated).

The plastic keys are directly interchangeable with the steel keys. Installation of the plastic keys is best accomplished with a torque of 15 to 20 in-lbs.

Original Steel Key	NEW PLASTIC KEY	Type/Location	Torque to Tighten Securing SHC Screw
1001172	2752310	Push Ram Assembly	15-20 in-lbs
2001150	2752311	Knockout Ram Assembly	15-20 in-lbs
2001151	2752322	Push Ram Assembly	15-20 in-lbs

All new and rebuilt ram assemblies, either shipped as spares, or on machines manufactured after July 2005, will incorporate the new key material.

**not applicable to 575 and earlier Necker systems.*

Contact Belvac Sales and Service for a quotation.