Belvac Production Machinery
Technical Bulletin
Information for Customers Operating and Maintaining Belvac Machines

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Belvac Reformer/Reprofiler Manuals Information and Setup Revisions

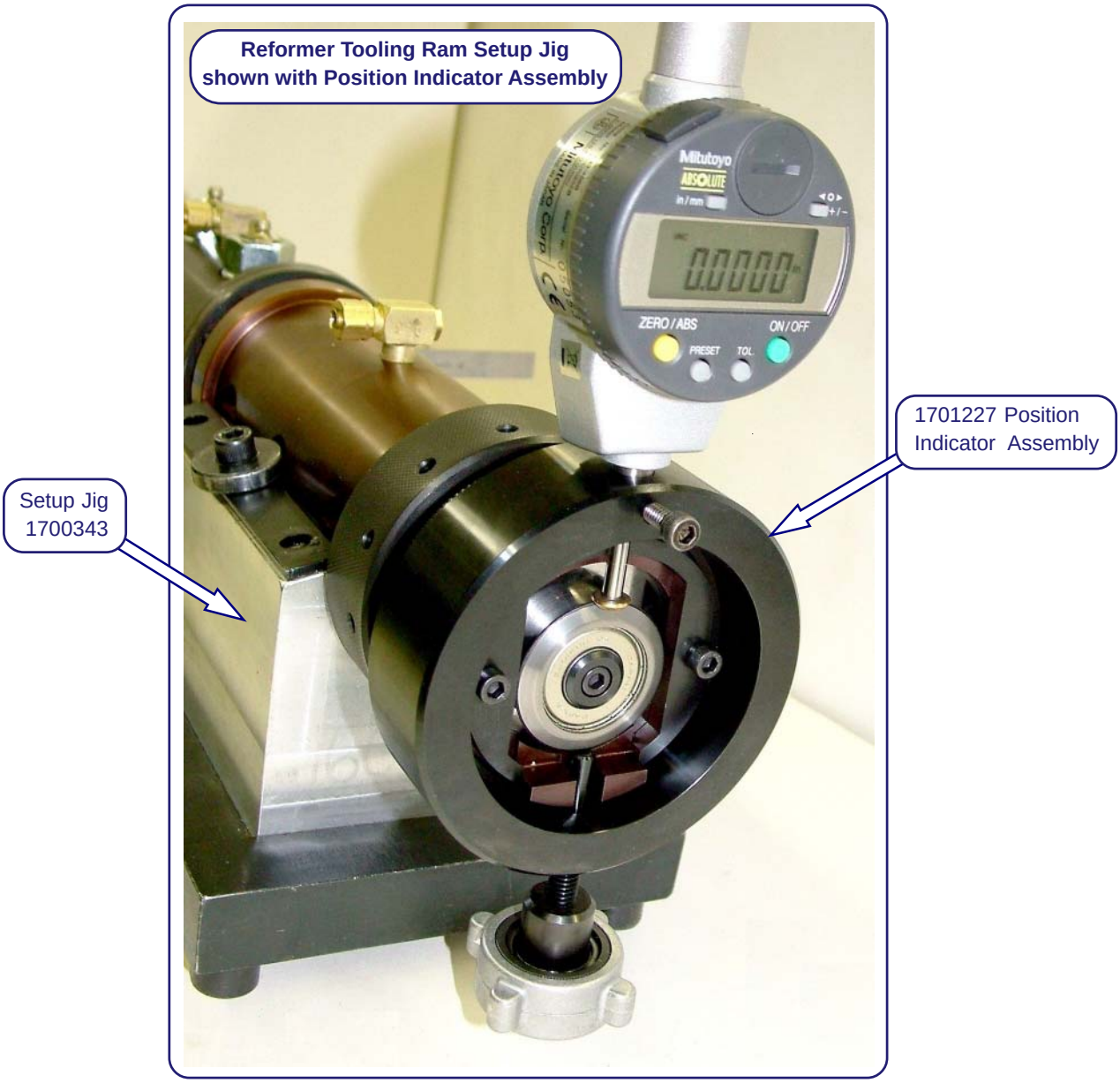
As a result of Belvac's commitment to continuous process improvement, and in response to customer concerns with life expectancy of reformer and reprofiler tooling wear components, new setup procedures were developed to both aid in repeatability from one subassembly to another, one machine to another, and to quantify preload requirements with customer product interface. The new procedures remove subjective references to "feel" in the current setup, as well as improve position of components in the working cycle, as consistent and accurate setup will extend the life of critical bearing components.

The following information has been updated in Appendix C, Base Reformer and Base Reprofiler, of the Operation, Maintenance and Safety Manual for most Belvac Necking systems: This change covers 595K Modular and Fixed Base, 595SK, Quick Change and 810K style necking systems.

Key areas revised include, but are not limited to, the following:

- **Recommended intervals for checking and/or replacement of tooling wear components: H-link bushings (semi-monthly), roller bearings (quarterly) and composite inserts (quarterly).**
  - Inspection intervals were revised to more accurately reflect actual life of components based on production experience.
  - Overall life expectancy is dependent on regular maintenance and proper tooling ram assembly setup.
  - Reference Belvac Technical Bulletin Issue 12, Volume 10, December 2007 for information on change to sealed roller bearings.
  - Belvac recommends coating composite insert surfaces, in contact with the roller flange, with high-temperature lube prior to final assembly. A thin application of lithium complex grease, Mobilith SHC 100 (or a direct equivalent) is recommended on the exposed surfaces of the inserts in both tool holders and receptacles.
- **Reformer tooling ram setup using standard jig 1700343.**
  - With setup procedure change, it's important to ensure existing setup jigs are capable of registering a 0.217 dimension, ram-to-ram bushing, to simulate actual position at TDC. Visit the Belvac website to link directly to a copy of 1700343-REWORK, or see page 4 of this bulletin. This will provide dimensions to rework an existing setup jig for use in the new procedures.
  - Additional setup components, Position Indicator Assembly 1701227, are available for order by contacting Belvac.

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



- **Reprofiler tooling ram setup using standard jig 1700343.**
  - Reprofiler ram assembly setup now allows use of basic 1700343 jig without use of secondary fixture 1700444.
- **Reformer and Reprofiler push pad and turret setup.**
  - Now recommends specific 0.010-0.016 preload on push plates, based on initial flanged can contact, as a starting point.

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To obtain an updated copy of Appendix C relevant to the specific style of your Belvac Reformer/ Reprofiler, log on to the Belvac website. Refer to the following for manual document number required based on necker/reformer style:

595 Fixed Based	595W-C00
595K	595M-C00
595SK	595SK-C00
595K Quick Change	595QC-C00
595SK Quick Change	595SKQC-C00
595 Non-K Quick Change	595QC-NK-C00
810K	810K-C00

Refer to your original machine manual, Appendix C, to verify manual number shown on the first page.

Machines shipping second quarter of 2008 will have the manual updates included.

Contact Belvac Sales or Service Representatives for additional information.

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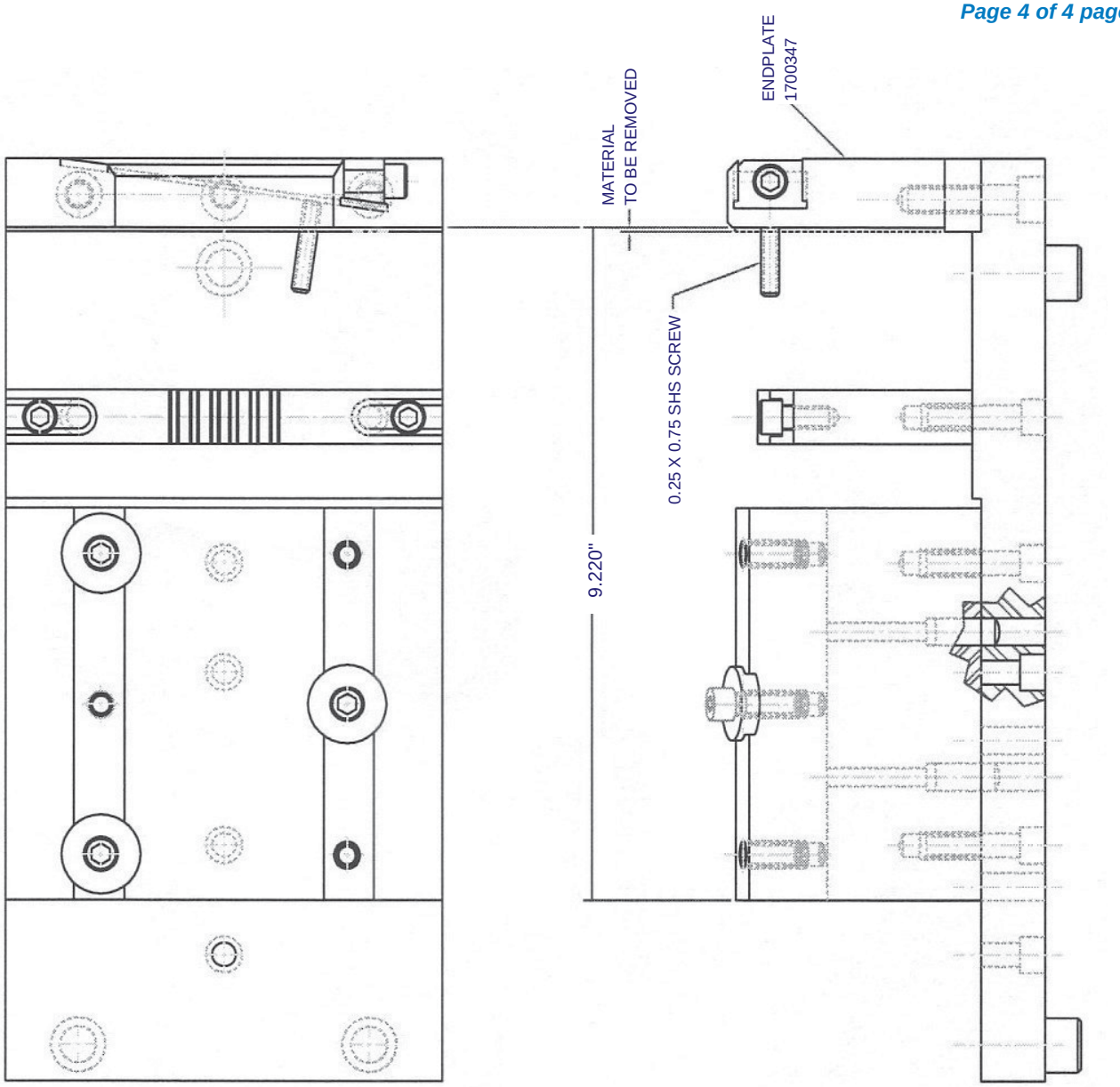
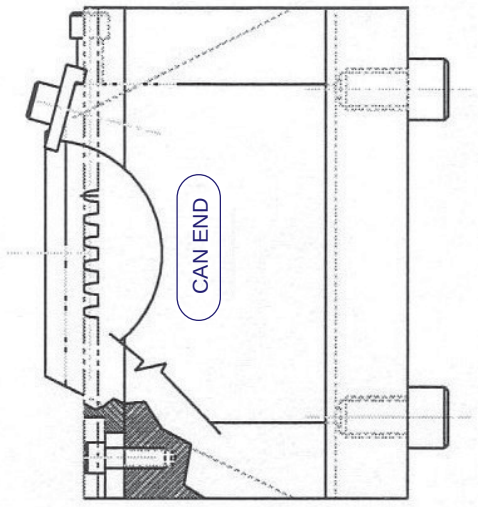


REWORK TO STANDARD SETUP FIXTURE 1700343 IS TO ENSURE ABILITY TO GAIN 0.217" RAM-TO-RAM BUSHING AT SETUP FOR SIMULATED TDC CONDITION.

- MEASURE FOR DIMENSION SHOWN.
- REMOVE .25 X .75 SHS SCREW.
- REMOVE END PLATE 1700347 AND HAVE MATERIAL REMOVED FROM SURFACE SHOWN TO MAINTAIN REQUIRED 9.220".
- RE-ASSEMBLE END PLATE AND VERIFY DIMENSION.
- RE-INSTALL SHS SCREW.



REFERENCE DRAWING NO. 1700343-REWORK

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