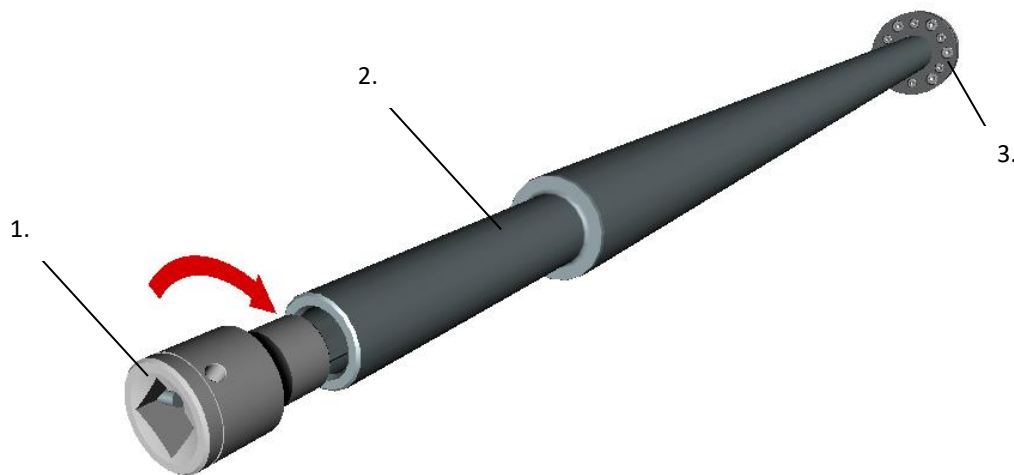


Category: Recommended at the next Ram Assembly installation/ removal

Benefits to Customers:

- Increases Ram Assembly life span.
- Ease of installation and removal of Ram Assembly.

Summary: Based upon feedback and industry experience, an improved method of securing the Ram Assembly to the Ram locator has been introduced to reduce the fastening torque applied to the Ram Assembly. This improved method will increase Ram Assembly life and reduce operator time taken to install and remove from the Bodymaker. This new fastening torque replaces **ALL** existing front loading Ram fastening torques.



1. Ram Fitting Key 2. Ram Assembly 3. Ram Clamp Ring

With the Ram Assembly (2) in position, torque tighten the ram thread to **50 Nm only**, using the Ram Fitting Key (1) and calibrated torque wrench. The clamping force of the Ram Clamp Ring (3) is sufficient to hold the Ram Assembly safely in position.

NOTE: This replaces all previous procedures where 400 Nm of torque was applied at fastening.