



# Technical Bulletin

TB3400-006

Sheet: 1 of 1

ENGINEERING

3400 Neck Forming System

Issue: 09. 12. 2010

## Flanger and Light Tester Improved Vacuum Supply

### CATEGORY: Recommended

**Summary:** CarnaudMetalbox Engineering have introduced an improvement to the adjustability of the Pusher Pad Vacuum in the Flanger and Light Tester stages of the 3400 Die Necker. It has now been fitted as standard from machine serial number 017s

A replacement Baffle is available which now allows low pressure air to be introduced to the Pusher Pad as the can approaches the moment of discharge from the Flanging and Light Testing stages. This enables the Pusher Pad Vacuum to be adjusted without affecting discharge of the can.

In order to complete this upgrade the following items, supplied by CarnaudMetalbox Engineering, are required; Replacement Baffles, additional Regulators, Gauges and fittings.

Copies of the following drawings are also supplied with the upgrade package.

Main Shaft Assembly - Flanger drawing 2398576F sheet 1

Main Shaft Assembly - Light Tester drawing 2398577F sheet 1.

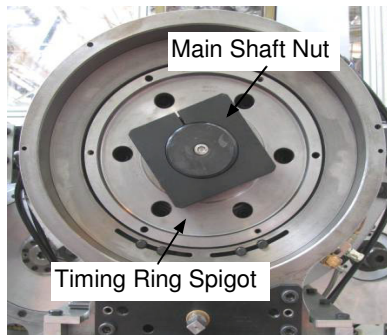
Air and Vacuum Supply drawing ..... (reference drawing)



Pressure Regulators and Gauges

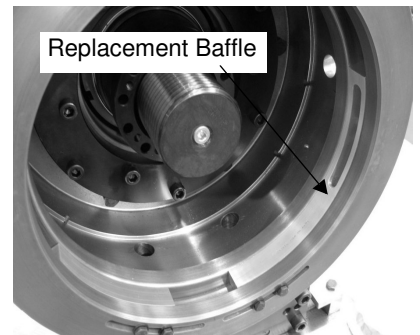
### Replacement Baffle: Fitting Instructions

1. Remove the large square Main Shaft Nut.
2. Remove the Timing Ring Spigot from the main shaft. The existing baffles are now exposed.
3. Replace the Baffle corresponding to the discharge side with the correct new Baffle.
4. Replace the Timing Ring Spigot and Main Shaft Nut. Ensure the Nut is fully tightened and clamped in place by means of the Nut Clamping Screw.
5. Referring to the photograph and the piping assembly drawing provide a feed of air into the final manifold port at 5psi/ 0.4 bar.
6. Adjusting the position of the Baffle will adjust the timing of the introduction of air to the Pusher Pad.



Main Shaft Nut

Timing Ring Spigot



Replacement Baffle

For further information regarding this Technical Bulletin please contact either of the contacts below quoting Technical Bulletin Number **TB3400-006**

Note: a complete Library of Technical Bulletins is accessible on the Company Web Site

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