

CATEGORY: Recommended at next machine maintenance.

Summary: CarnaudMetalBox Engineering Ltd introduces the IBR drive shaft with carbide insert to replace the existing drive shafts, reducing machine downtime and maintenance.

Benefits for Customers:

1. Prolonged component lifespan.
2. Reduced machine maintenance and downtime.
3. Ease of installation.
4. Reduction in the cost of wear items.

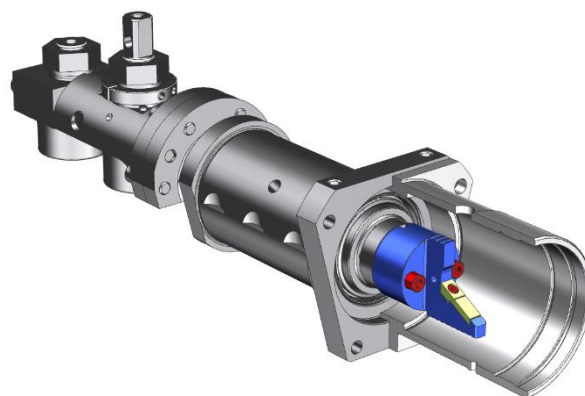


Fig 1. IBR Drive shaft with Carbide Insert

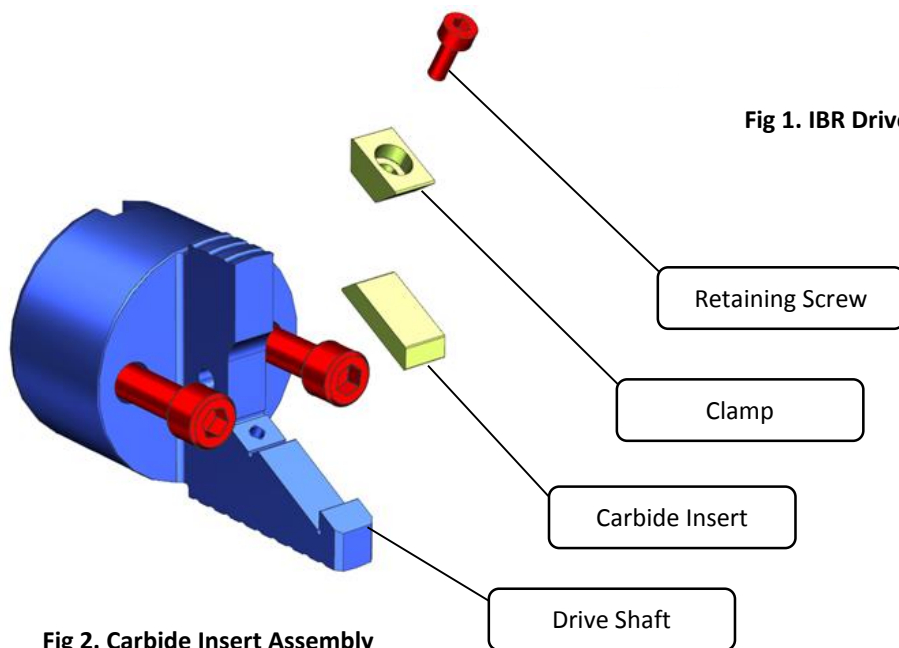


Fig 2. Carbide Insert Assembly

As a result of redesign, CarnaudMetalBox Engineering Ltd has changed the original one piece drive shaft to a new design which incorporates a carbide insert. This improvement will reduce the frequency of machine downtime due to the superior wear resistance of carbide. It will also decrease the maintenance time as only the insert needs to be replaced when worn as opposed to the entire drive shaft. This greatly improves the lifespan of the drive shaft component.

NOTE: For further information regarding this Technical Bulletin please contact either of the contacts below quoting Technical Bulletin number **TB3400-026** and your machine Serial Number. A complete library of technical bulletins is available on the company web site.

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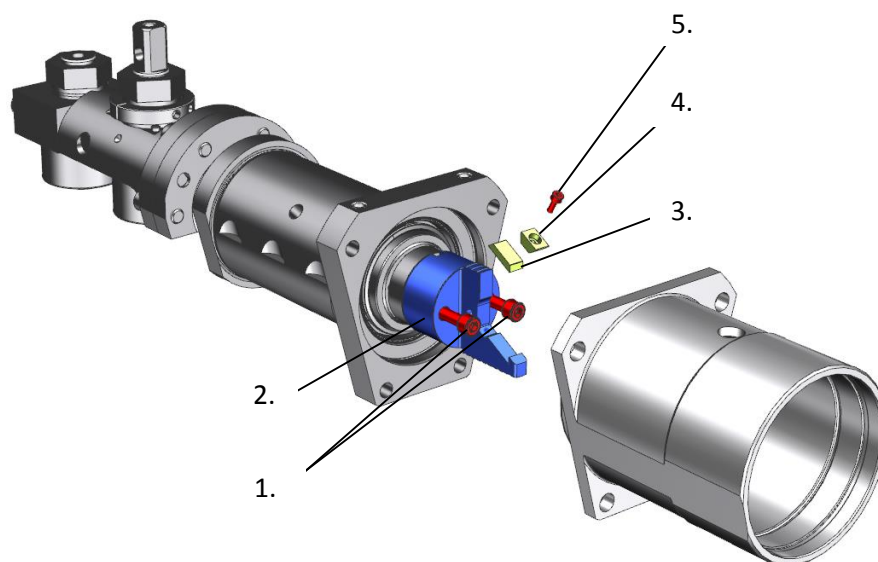


Fig 3. IBR Drive shaft with Carbide Insert Assembly

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|---------------------|-------------------|--------------------|
| 1. Screws, Cap Head | 3. Carbide Insert | 5. Retaining Screw |
| 2. Drive Shaft | 4. Clamp | |

Mechanical Instructions for Customers:

1. Remove the IBR Ram Assembly from the Main Turret and then remove the Head Assembly. (see Section 3 of the Die Necker Operating and Maintenance manual).
2. Remove 2 x cap head screws (1), remove and discard the used Drive Shaft.
3. Fit the replacement Drive Shaft (2), replace the 2 x cap head screws (1), first applying Loctite 222 to the replacement screws (1).
4. Assemble the Carbide Insert (3), central to the drive shaft, with the clamp (4) and retaining screw (5). Apply Loctite 248 to the retaining screw (5) and torque tighten to 2.5Nm (1.84 ft/lbs).
5. Re-assemble all other components.