

## PRIMARY CONNECTING ROD CAP RETAINING SCREWS AND NUTS

### CATEGORY: Mandatory

**SUMMARY:** Investigations into recent failures of the B series Bodymaker Primary Connecting Rod Screws has highlighted that in some instances, there has been some uncertainty as to whether the retaining screws and nut have been replaced with new when connecting rods have been dismantled and reassembled.

The screw and nut used for retaining the Primary Connecting Rod Cap are “one shot” items and should **never be re-used a second time**. It is recommended that, if there is any possibility that the screw and nut have already been used in securing the Primary Connecting Rod Cap in your B series Bodymakers, they should be replaced with new parts.

**Important Note:** Irrespective of whether the Conn Rod Cap has been removed or not, these screws and nuts **MUST** be changed on a regular basis. The designated maximum life of these screws and nuts is **two years**. This life is the designated **maximum life under normal operating conditions**. For a variety of reasons, such as a serious machine crash or jam the life could be significantly shorter than 2 years. It is therefore necessary to check the nut torque settings on a regular

basis. We would recommend that the torque is checked every **month**. Any bolt / nut combination that is found not to be at the specified torque setting, **should be replaced**.

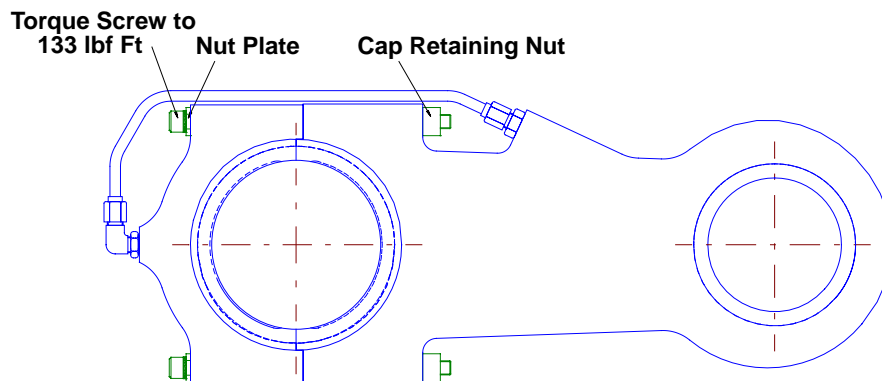
An upgrade kit of parts is now available for all B series Bodymaker Primary Connecting Rods in service. This kit makes use of Nord-Lock vibration proof washers and takes advantage of the Nord-Lock washers superior locking action to that provided by the “Nylock” type nuts currently used. See technical bulletin number **TB-B3/B4-013** for details.

### Machine Manual.

Please find attached latest Primary Connecting Rod Assembly drawing and warning sheet for inclusion in your spares manual.

Implementation of this retrofit kit should take approximately two hours machine stoppage time.

For further information about the Primary Connecting Rod Cap Retaining Screws and Nuts please contact either of the references at CarnaudMetalbox Engineering detailed below, quoting the technical bulletin number **TB-B3/B4-005**.



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