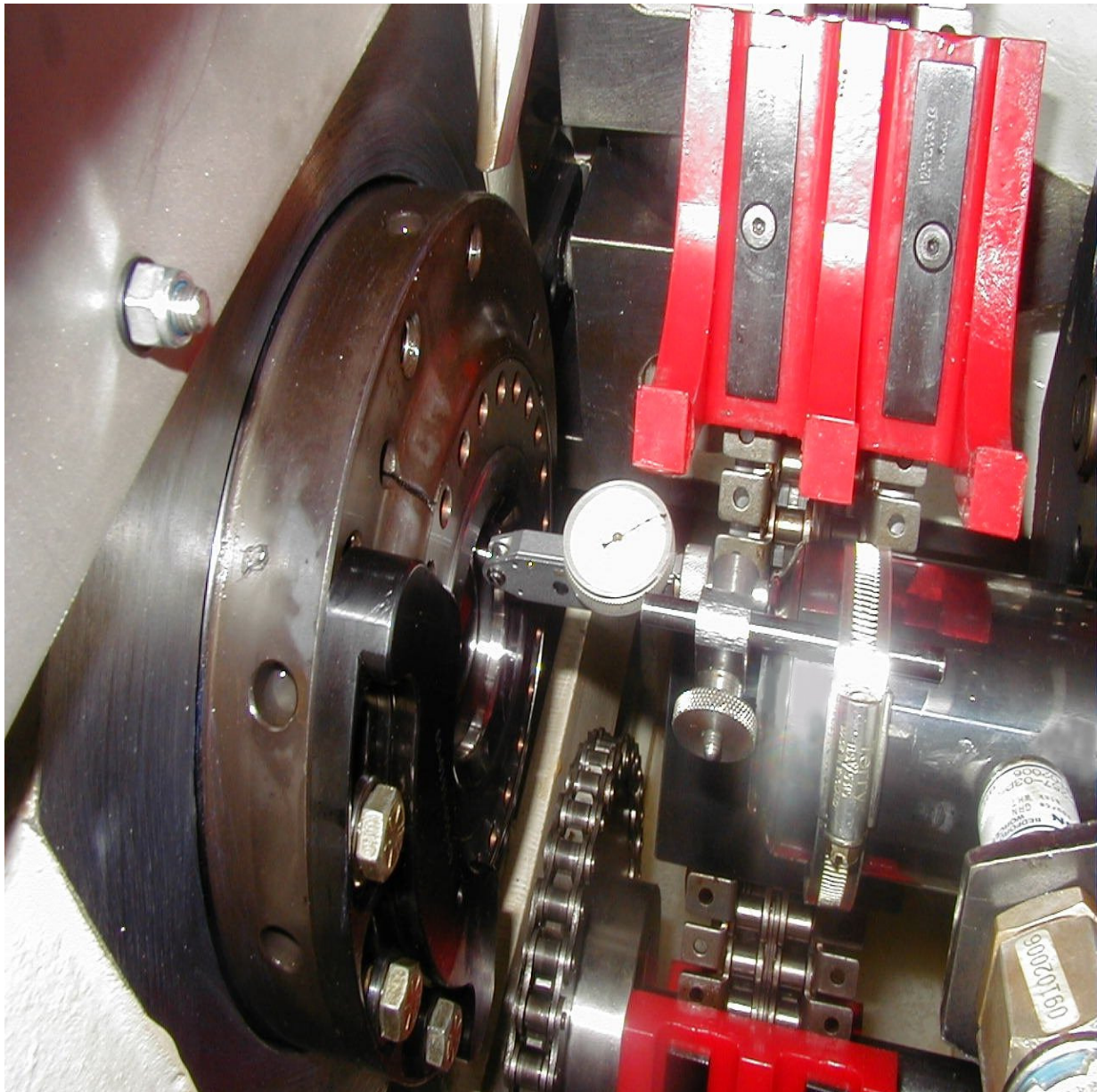


Dome Station Setting Procedure

The Dome Die should be set from the punch. (Illustration Refers)



Refer to sheet two for Setting Procedure.

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Dome Station Setting Procedure

With the Ram fitted and the oil running the machine **MUST** be up to operating temperature of 40°C - 45°C before setting can commence.

To centralize the dome tooling:

- a. Tools required:
 - i D.T.I clock, 0.0005"
 - ii Clamp and Bar for D.T.I
 - iii Clip to Clamp D.T.I to Punch
 - iv Old Punch (Recommended)
- b. Fit the Dome Assembly to the Dome Door.
- c. On machines fitted with Discharge Conveyor Chain remove two Unloader Pockets. On machines fitted with Turret Discharge remove the Turret.
- d. Fit the Punch on to the Ram, or if the Punch is already fitted slacken the Punch Nose so that the Punch Sleeve can be rotated.
- e. Bar the machine until the Punch Nose is about 100mm (4") from the Dome Station.
- f. Attach a Dial Indicator to the Punch Sleeve in a position that it can be swept around the Dome Die checking that the Dome Assembly is concentric to the Punch within 0.025 / 0.05mm (0.001" / 0.002") TIR within 0.025mm (0.001") above the centre line of the Punch. Adjust the Dome Assembly using four adjusting screws on the Dome and torque tighten to the required torque.
- g. Re-check that the Dome Die has retained the required setting.
- h. Remove the Dial Indicator.
- i. Re-tighten the Punch Nose or remove the Punch as required and replace the Unloader Pockets / Turret.

Recommended

For further information about the Dome Station Setting Procedure, please contact either of the references at CarnaudMetalbox Engineering detailed below quoting the Technical Bulletin number **TB5000-024**