



# Technical Bulletin

**TB3400-018**

Sheet: 1 of 3

ENGINEERING

**3400 Neck Forming System**

Issue: 20. 05. 2014

## Improved Transfer Turret Vacuum Supply Package

**CATEGORY:** Advised at next maintenance

**Summary:** CarnaudMetalbox Engineering introduces an improved vacuum supply package for transfer turrets on Necker, Flanger, IBR, Intermediate Infeed and Intermediate Discharge stages.

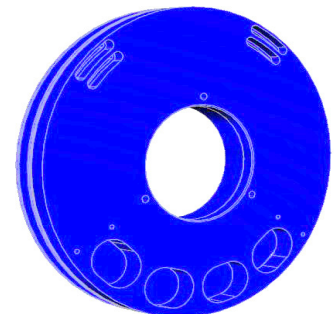
**NOTE:** This technical bulletin **DOES NOT** apply to the Light Tester and Vision stages.

### Benefits for Customers

1. 50% increase in ducting diameter improves transfer turret and vacuum system flow and improves can handling at higher speeds.
2. 5 fold increase in surface area from the 4 slot design vacuum manifold produces a more even and constant air flow. **See Fig. 1 (below right) and Fig. 4**
3. Re-designed vacuum manifold port allows maximum vacuum pressure to the transfer turret pockets. Current machine set-up restrictions are reduced leading to improved main vacuum fan efficiency.

### Recommended Action For Customers

1. Purchase improved transfer turret vacuum supply kit from CarnaudMetalbox Engineering quoting **BOM No. 2298-001**.
2. Remove Old Transfer Turret Vacuum Supply Package as shown on page 2 **Fig. 2**
3. Fit New Transfer Turret Vacuum Supply Package as shown on page 3 **Fig. 3**



**New Vacuum Manifold Transfer**

**Fig. 1**

Continued...

CarnaudMetalbox Engineering Limited,  
Dockfield Road, Shipley,  
West Yorkshire, BD17 7AY, UK  
Tel: +44 1274 846200, Fax: +44 1274 846201  
email: [sales@CMBEcanmaking.com](mailto:sales@CMBEcanmaking.com)

CarnaudMetalbox Engineering Limited,  
79 Rockland Road, Norwalk,  
Connecticut 06854, USA  
Tel: +1 203 853 7325, Fax: +1 203 866 7627  
email: [sales@CMBEcanmaking.com](mailto:sales@CMBEcanmaking.com)

## Improved Transfer Turret Vacuum Supply Package

### Mechanical Instructions for Customers

#### Removing Old Transfer Turret Vacuum Supply Package. See Fig.2

1. Remove 3 off 1/4" UNC x 5/8" screws
2. Remove Manifold Flange and Vacuum Hose
3. Slacken 4 off 5/16" UNC screws
4. Remove 1 off Guide, LH Sub Assy
5. Remove 1 off Guide, Extended, RH Sub Assy
6. Remove 3 off 1/2" UNC x 1" Hex screws
7. Remove Transfer Turret
8. Slacken 8 off Tollock Locking Bush M8 screws
9. Remove Tollock Locking Bush
10. Remove Hub Transfer Turret
11. Remove 3 off 5/16" UNC x 2" screws
12. Remove Vacuum Manifold Transfer

**NOTE:** Remove front section **ONLY**



**Warning!** Risk of Entrapment  
Trained Personnel **ONLY**  
Isolate & Lock Out Machine

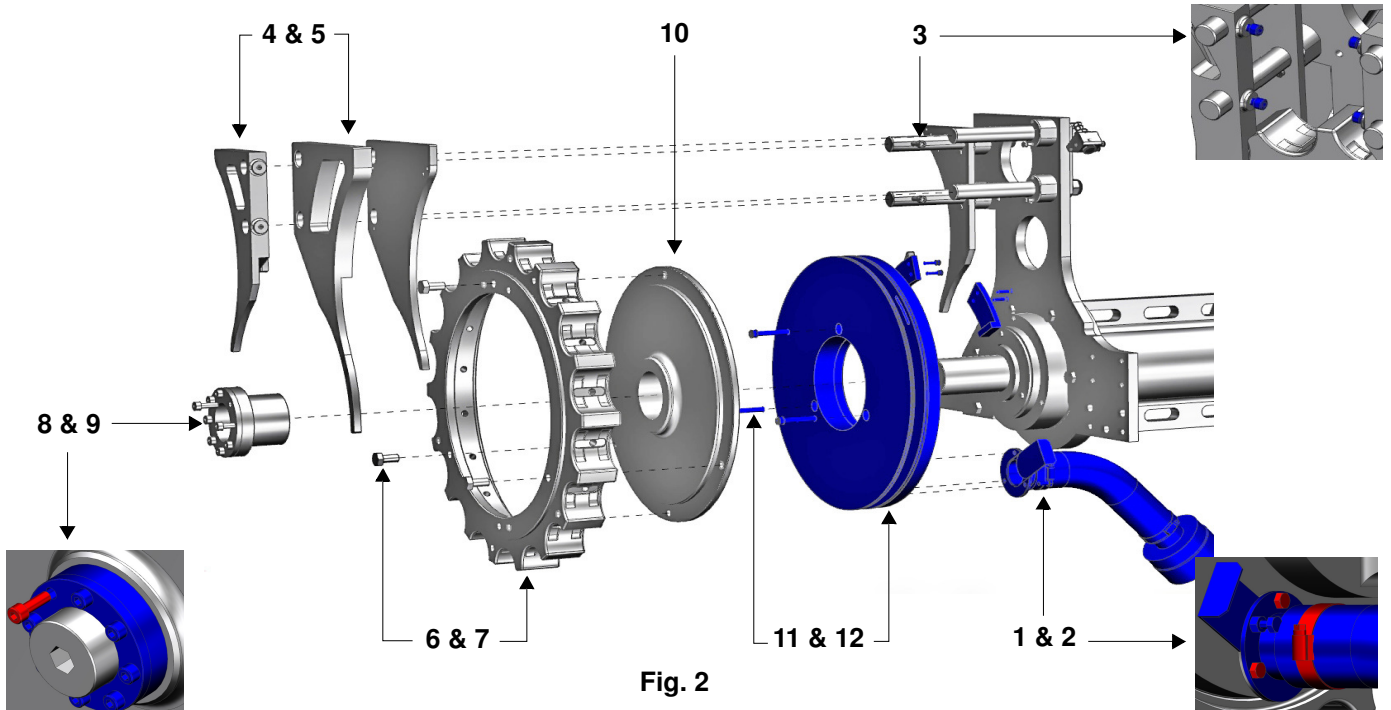


Fig. 2

Continued...

CarnaudMetalbox Engineering Limited,  
Dockfield Road, Shipley,  
West Yorkshire, BD17 7AY, UK  
Tel: +44 1274 846200, Fax: +44 1274 846201  
email: [sales@CMBEcanmaking.com](mailto:sales@CMBEcanmaking.com)

CarnaudMetalbox Engineering Limited,  
79 Rockland Road, Norwalk,  
Connecticut 06854, USA  
Tel: +1 203 853 7325, Fax: +1 203 866 7627  
email: [sales@CMBEcanmaking.com](mailto:sales@CMBEcanmaking.com)

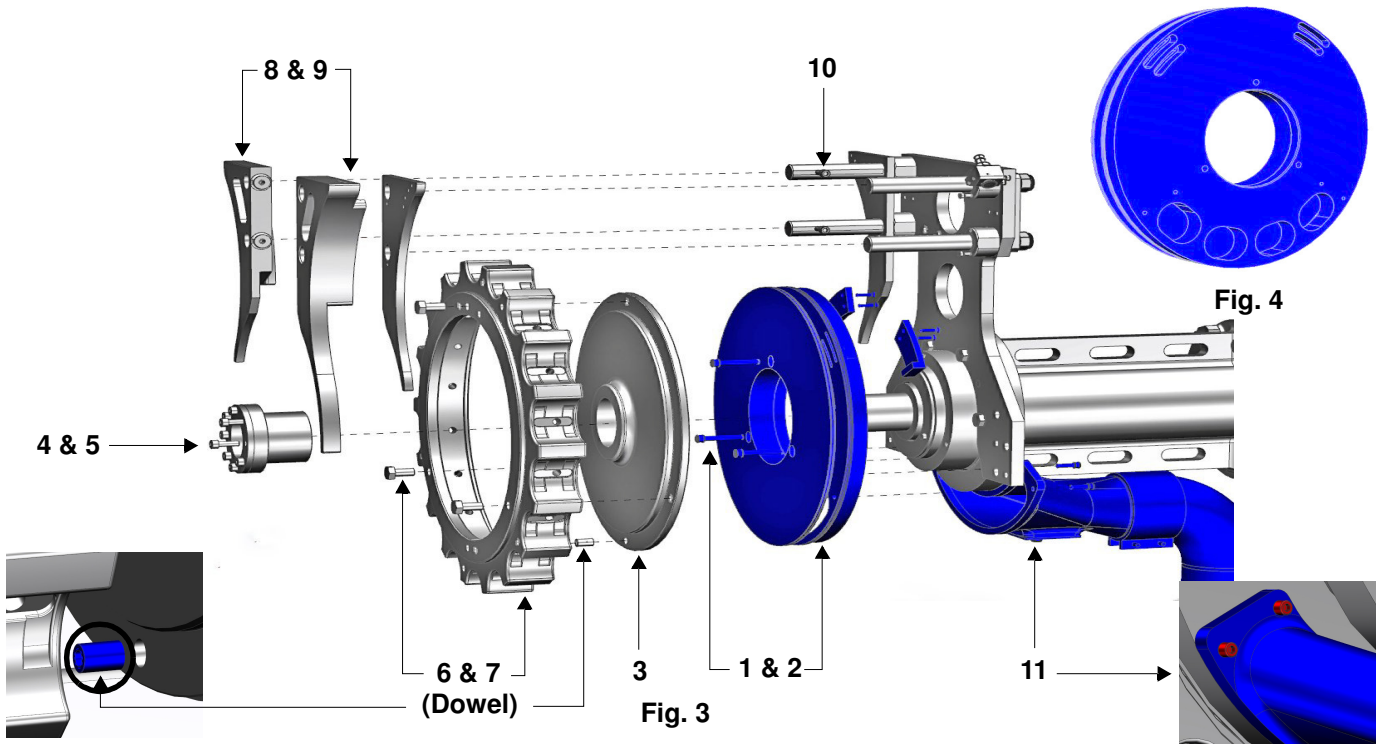
## Improved Transfer Turret Vacuum Supply Package

### Fitting New Transfer Turret Vacuum Supply Package. See Fig. 3

1. Fit Vacuum Manifold Transfer
2. Secure 3 off 5/16" UNC x 2" screws. **NOTE:** Position of 4 off slots as shown in **Fig. 4**
3. Fit Hub Transfer Turret
4. Fit Tollock Locking Bush to shaft
5. Secure 8 off Tollock Locking Bush M8 screws and **Torque to 41Nm.**
6. Fit Transfer Turret. **NOTE: Position of Dowel**
7. Fit 3 off 1/2" UNC x 1" Hex Screws
8. Fit 1 off Guide, LH Sub Assy on Guide Posts. Position as required
9. Fit 1 off Guide, Extended, RH Sub Assy on Guide Posts (**FRONT GUIDE ONLY**). Position as required
10. Secure 4 off 5/16" UNC screws
11. Fit ducting to rear of Vacuum Manifold Transfer and secure 4 off 1/4" UNC x 7/8" screws. **See Fig. 3**



**Warning!** Risk of Entrapment  
Trained Personnel **ONLY**  
Isolate & Lock Out Machine



For further information regarding this Technical Bulletin please contact either of the contacts below quoting Technical Bulletin Number **TB3400-018** and your machine Serial Number

**Note:** A complete Library of Technical Bulletins is accessible on the Company Web Site.

CarnaudMetalbox Engineering Limited,  
Dockfield Road, Shipley,  
West Yorkshire, BD17 7AY, UK  
Tel: +44 1274 846200, Fax: +44 1274 846201  
email: [sales@CMBEcanmaking.com](mailto:sales@CMBEcanmaking.com)

CarnaudMetalbox Engineering Limited,  
79 Rockland Road, Norwalk,  
Connecticut 06854, USA  
Tel: +1 203 853 7325, Fax: +1 203 866 7627  
email: [sales@CMBEcanmaking.com](mailto:sales@CMBEcanmaking.com)