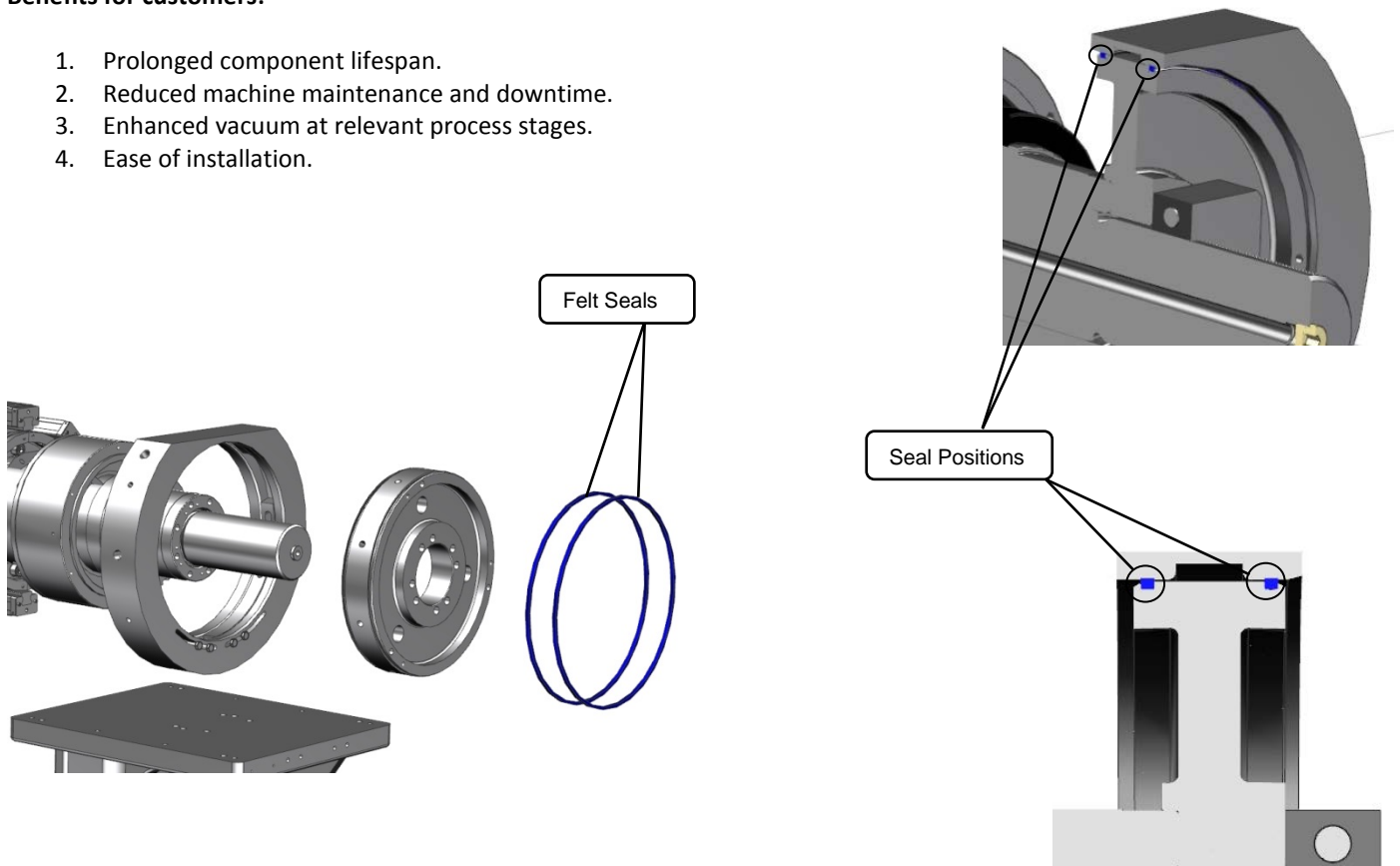


**CATEGORY:** Recommended at next maintenance for all Flanger and Light Tester stages applicable to Serial Numbers 001s – 052s.

**Summary:** Carnaud Metalbox Engineering introduces felt seals to replace the existing energised spring seal on the Flanger and Light Tester vacuum manifolds for the 3400 Die Necker, reducing machine downtime and maintenance.

**Benefits for customers:**

1. Prolonged component lifespan.
2. Reduced machine maintenance and downtime.
3. Enhanced vacuum at relevant process stages.
4. Ease of installation.



As a result of redesign, Carnaud Metalbox Engineering has changed the original energised spring seals to felt seals (Part No. 23183402). This type of seal offers an improved and lasting closure resulting in a prolonged vacuum supply to the Flanger and Light Tester process stages on the 3400 Die Necker. Through enhanced durability the new felt seals require less maintenance than the previous energised spring seal.

**NOTE:** For further information regarding this Technical Bulletin please contact either of the contacts below quoting Technical Bulletin number **TB3400-023** and your machine Serial Number. A complete library of technical bulletins are available on the company web site.

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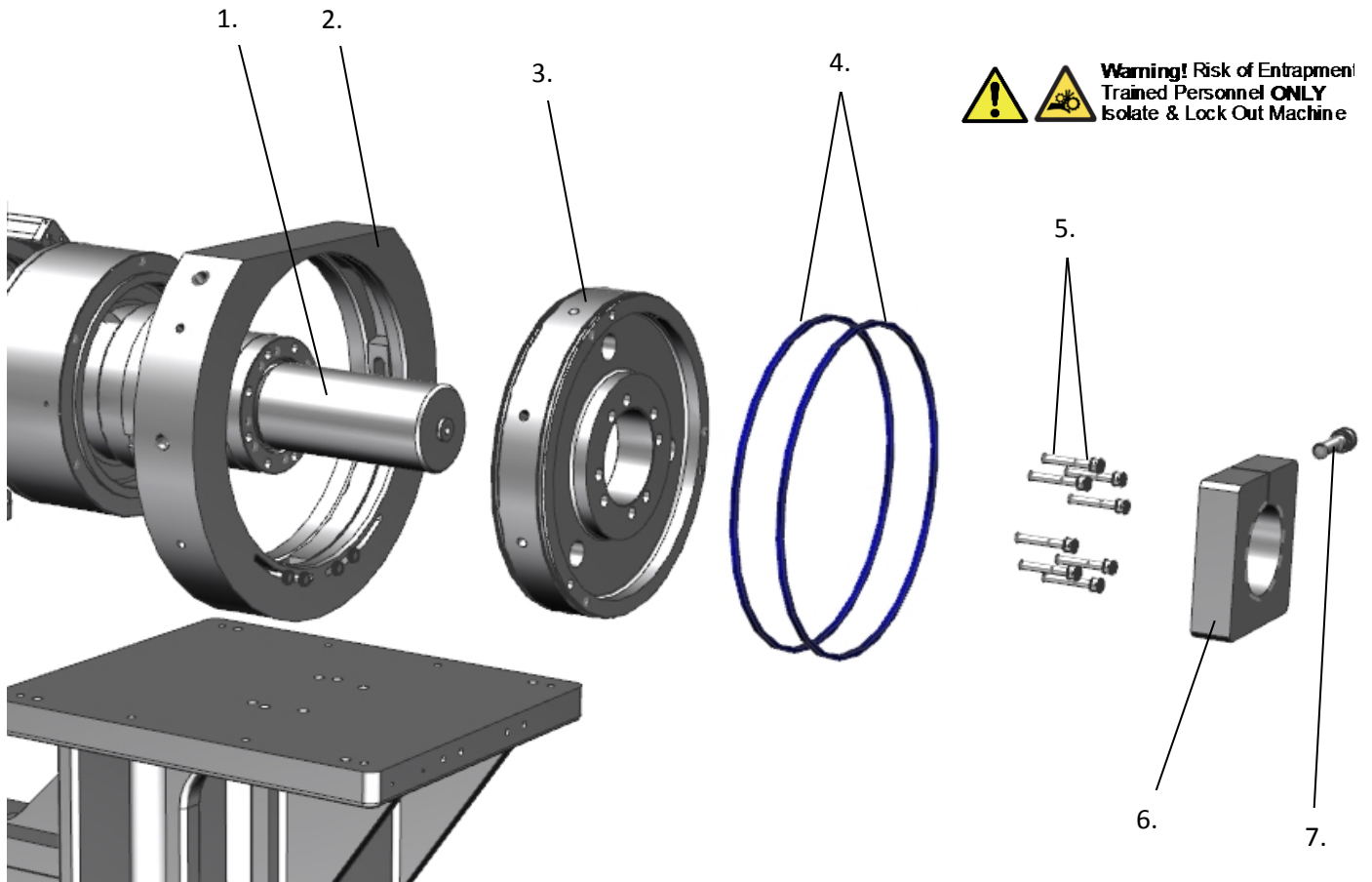


Figure 1

- |                      |                       |                    |               |
|----------------------|-----------------------|--------------------|---------------|
| 1. Main Shaft        | 3. Spigot Timing Ring | 5. Screws, Cap hd  | 7. Pinch Bolt |
| 2. Outer Timing Ring | 4. Felt Seals         | 6. Securing Collar |               |

### To remove the existing seals and replace with new seals:-

- Remove the end cover from the rear of the Flanger/ Light Tester station (see Section 3 of the 3400 Die Necker Operating and Maintenance manual).
- Loosen the pinch bolt (Figure 1(7)) securing the collar (6) around the main shaft (1). Remove the collar.
- Remove 8 x cap head screws (5) securing the spigot timing ring (3) in position. Carefully remove the spigot timing ring, complete with used seals.
- Remove then discard the used seals before inspecting the spigot timing ring for signs of damage/ wear, cleaning as necessary.
- Clean the seal grooves around the outer edge of the spigot timing ring, making sure they are free of any burr or debris.
- Fit the replacement seals into the seal grooves, first applying Loctite 431 adhesive all the way around the circumference of the groove to secure the seals in position.
- Re-assemble all components making sure that the spigot timing ring is correctly orientated inside the outer timing ring (2) before securing in position.