

Category: Recommended on all Die Necker serial numbers between 001-S – 100-S.

Benefits to Customers:

- To the longevity/ lifespan of the rotary union seals.

Summary: Rotary unions subjected to a combination of high pressure and high speed simultaneously are more prone to failure/ leakage. In order to mitigate this effect, Carnaud Metalbox Engineering Ltd have modified the Die Necker PLC program to improve the grease cycle. These changes to the PLC will make the following alterations to the grease cycle:

- Once the cycle starts, either automatically or manually, the Die Necker speed will be checked and reduced to 900 Cans Per Minute (CPM).
- When the Die Necker speed is less than 920 CPM, the grease solenoid will energise.
- Once the grease cycle has completed, the Die Necker will run at 900 CPM for a further 15 seconds to allow for the pressure to decay to a suitable level. This timer pre-set can be adjusted to suit the actual pressure decay – TMR023 – 15000 mSec.
- The Die Necker will require 'zeroing', once, after the modified program has been downloaded to the PLC.

CarnaudMetalbox Engineering Ltd ask that all requests for this PLC upgrade be directed to the electrical department at Shipley, Electrical-GBR-shIPLEY@eur.crowncork.com.



For further information regarding this Technical Bulletin, please contact either of the contacts below quoting Technical Bulletin number TB3400-034 and your machine Serial Number. A complete library of Technical Bulletins is available on the company web site.