

PRIMARY CONNECTING ROD CAP RETENTION

CATEGORY: Mandatory

Summary: CarnaudMetalbox Engineering have further improved the method of retaining the Primary Connecting Rod Cap on their latest series 5000 Bodymakers

Improvement is by means of a one piece Bolt Retaining Plate used in conjunction with Nordlock vibration proof Washers.

The Bolt Retaining Plate engages with the hexagon head of the Bolts to prevent Bolt rotation.

The caming action of the Nordlock Washers, under the Nuts, make the joint virtually vibration proof.

An upgrade kit of the relevant parts is now available to enable all 5000 Primary Connecting Rods in service to take advantage of the latest design

The upgrade kit is available for all 5000 Bodymakers built prior to machine serial number 209s and the complete package should take approximately two hours to fit.

Important Fitting Instruction:

The kit comprises the following new parts:

- Primary Conn Rod Bolts
- Primary Conn Rod Nuts
- Nordlock Washers
- Bolt Retaining Plates
- Nut Plates

It is essential that all these parts are used and that all existing Bolts and Nuts are discarded.

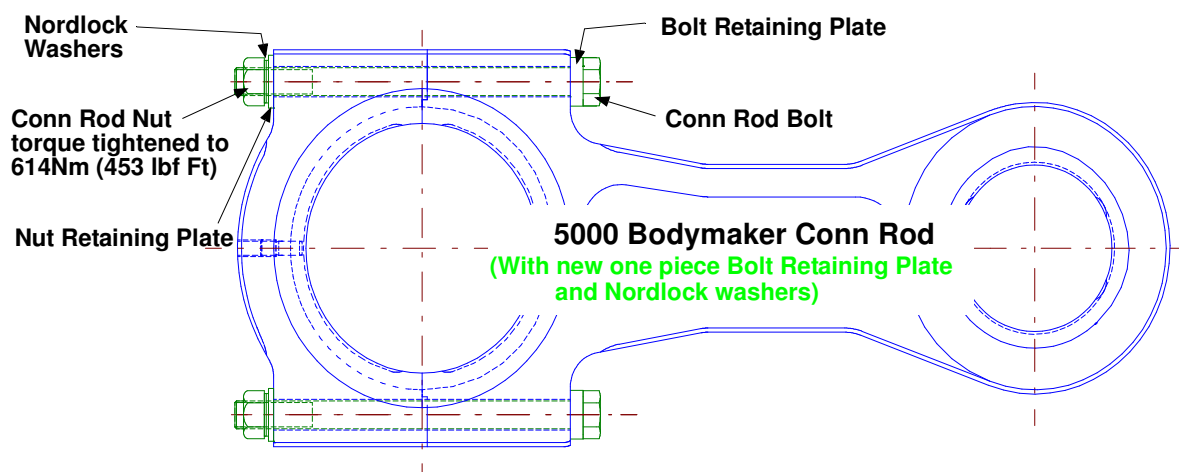
Note: the torque setting for the replacement Nuts is 614Nm (453 lbf Ft).

IMPORTANT The Bolts and nuts used for retaining the Primary Connecting Rod Cap are "one shot" items and should never be re-used.

Machine Manual:

Included with this bulletin are revised Primary Connecting Rod drawing/parts list page and warning sheet for inclusion in existing machine manuals.

For further information please contact either of the references at CarnaudMetalbox Engineering detailed below, quoting the technical bulletin number **TB5000-033**.



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5000 Bodymaker Operating and Spares Manual

Note:

It is extremely important that the following note is included in all your copies of 5000 Bodymaker Operating and Spares Manuals.

IMPORTANT WARNING NOTE

PRIMARY CONNECTING ROD CAP RETENTION

IT IS IMPERATIVE THAT THE CAP RETAINING PRIMARY CONN ROD BOLTS AND NUTS **MUST NOT** BE RE-USED ONCE THEY HAVE BEEN TORQUED TIGHTENED. THEY **MUST** ALWAYS BE REPLACED WITH NEW PARTS WHEN REMOVING/REPLACING THE CONN ROD CAP.

THESE BOLTS, NUTS AND NORDLOCK WASHERS **MUST** ALSO BE CHANGED ON A REGULAR BASIS. WHILE THEIR DESIGNATED **MAXIMUM** LIFE IS **TWO YEARS** IT IS RECOMMENDED THAT THESE PARTS ARE REPLACED EVERY 12 MONTHS AT ANNUAL OVERHAUL.

NOTE:

THE TORQUE SETTING FOR THE 5000 BODYMAKER CONN ROD LATEST STYLE NORDLOCK WASHER ARRANGEMENT IS 614Nm (453 lbf Ft)



5000

Machine : 5000 Bodymaker

Machine Code : 015043

Sheet : 6

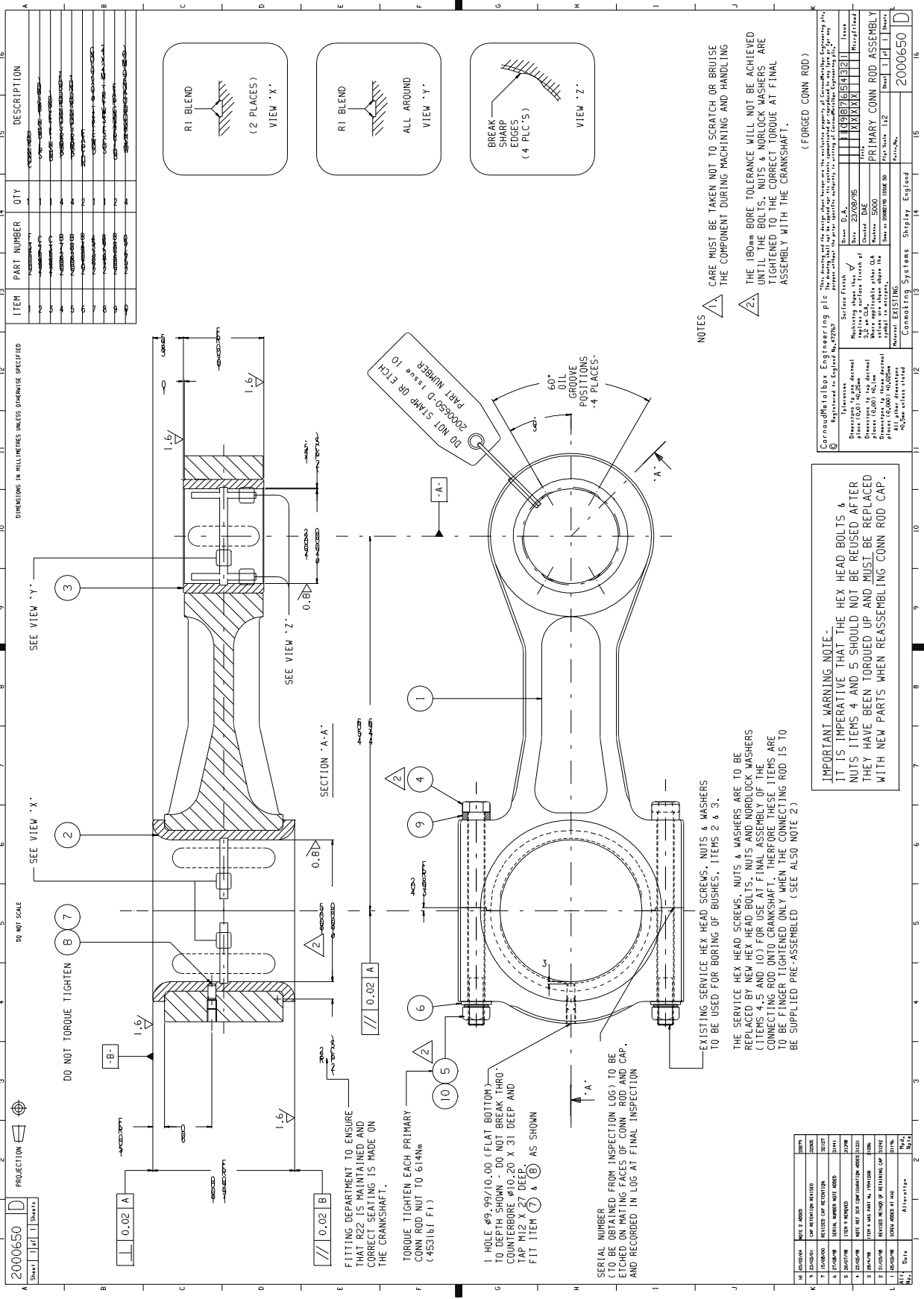


Assembly : PRIMARY CONN ROD ASSEMBLY

Drawing No : 2000650D


BOM No : 5002-006

Issue : 14.12.2004



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5000	<i>Machine :</i> 5000 Bodymaker	<i>Machine Code :</i> 015043	<i>Sheet :</i> 6
	<i>Assembly :</i> PRIMARY CONN ROD ASSEMBLY		
	<i>Drawing No :</i> 2000650D	<i>BOM No :</i> 5002-006	<i>Issue :</i> 26.03.2001

Item	Part No.	Description	Qty.
	2000650D	PRIMARY CONN ROD ASSEMBLY (COMPLETE)	1

NOTE: THE PRIMARY CONN ROD SHOULD BE PURCHASED AS A COMPLETE COMPONENT COMPRISING THE FOLLOWING ITEMS:-

1	2000643F	CONN ROD SEMI-FINISHED	1
2	1299562C	SPLIT BUSH	1
3	1299563C	BUSH - CONN ROD	1
4	2008217B	PRIMARY CONN ROD BOLT	4
5	2008218B	PRIMARY CONN ROD NUT	4
6	2010094B	NUT PLATE	2
7	27683354	DOWEL EXTRACTOR 10MM X 20	1
8	27182268	SCREW, SOC SET CUP PT, S/LOC, M12 X 12	1
9	2008208B	BOLT RETAINING PLATE	2
10	27576750	WASHER, NORDLOCK, PRIMATRONIC GLUED PAIRS. NL20 (M20)	4

IMPORTANT

ITEMS 4 & 5 SHOULD NOT BE REUSED AFTER THEY HAVE BEEN TORQUE TIGHTENED AND MUST BE REPLACED WITH NEW PARTS IF RE ASSEMBLING THE CON ROD CAP.