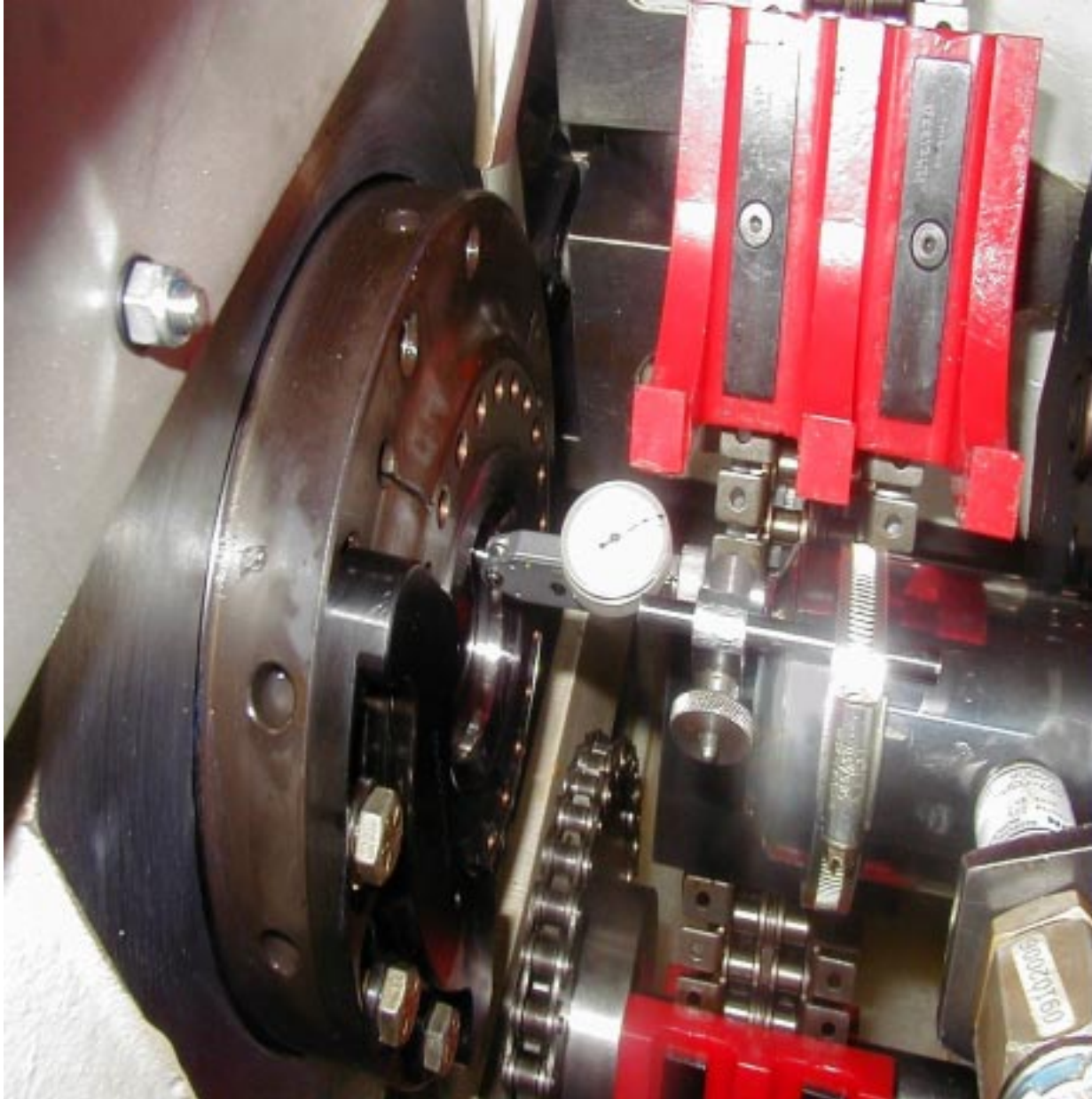


Dome Station Setting Procedure

CATEGORY: Recommended

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. Remove two Unloader Pockets from the Discharge Conveyor.
- 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 Conveyor Unloader Pockets.

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 **TB-B3/B4-007**.

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

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