



Belvac Production Machinery Technical Bulletin

Information for Customers Operating & Maintaining Belvac Machines

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595 MODULAR INTERMEDIATE INFEEED VACUUM VALVE

In November 2005 Belvac introduced the Intermediate Infeed (II) feature for modular necking systems. This feature allows a machine to process multiple can diameters and necks without idle thru kits, by feeding cans into the system following a pre-selected number of process turrets. This feature has successfully produced cans since its inception while reducing floor space requirements, utility requirements, and machine idle time for Belvac customers.

Recent testing of the Intermediate Infeed system has produced data indicating all II systems may not be operating with the nominal amount of vacuum at the takeaway point between the Intermediate Infeed starwheel and the transfer starwheel beneath. Vacuum valves for the lower transfer starwheel utilized from November 2005 until January 2011 (reference part number 2753959 revision 03 and similar) may not be properly ducting sufficient vacuum to the upper 1/3 of the transfer starwheel.

Belvac recommends that these valves be replaced by the latest revision in each application should insufficient performance be found in this area during production.

Since part numbers are dependant on can height range and machine rotation, and may differ throughout the machine, Belvac Sales and Service should be contacted to ensure the correct vacuum valve is supplied for each specific machine.



Intermediate Infeed



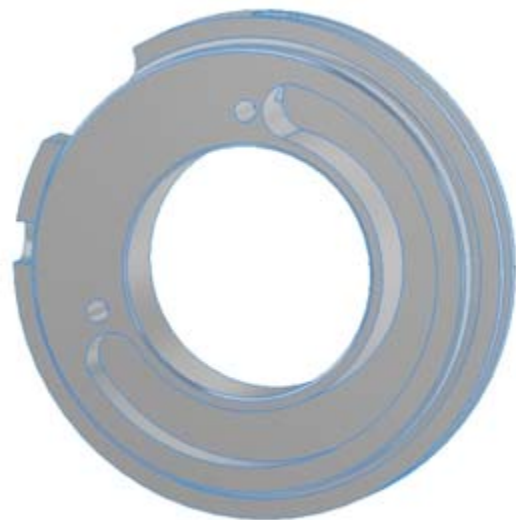
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Original vacuum valve (small opening).



Latest vacuum valve (large opening).

Installation of the new vacuum valve requires approximately 20 minutes. As this valve is only used when the II is active, a convenient time to replace the valve would be during a changeover to the II mode. No modifications to the machine are required as the new valve is a direct replacement for the old.

The latest vacuum valve design is standard on all new Modular 595K, 595SK, and 590 Necking system machinery shipped after January 1, 2011.