



Belvac Production Machinery Technical Bulletin

Information for Customers Operating & Maintaining Belvac Machines

ISSUE 01 VOL. 8 MAY 2005

595K and SK Rotary Union System Revision to Pressure Requirements

This bulletin announces the revision of lubricant system pressure requirements and the pressure relief valve recommendation, based on customer experience with the High Pressure Rotary Union on all Belvac 595 Modular and Fixed Base (595K and 595SK) Necker systems (necking and flanging turrets only).

This bulletin supercedes Technical Bulletin #4, vol. 6, dated April 2003.

The high pressure rotary union (Part No. C48517) used on the gear end of necker and flanger turrets, is the vehicle to supply high pressure lubrication from the pump to the injectors. With this component located in the gearcase, it is important to get maximum life, and to prevent grease from leaking into the gearcase oil.

There are three pressure sensitive processes involved in Belvac's necker systems:

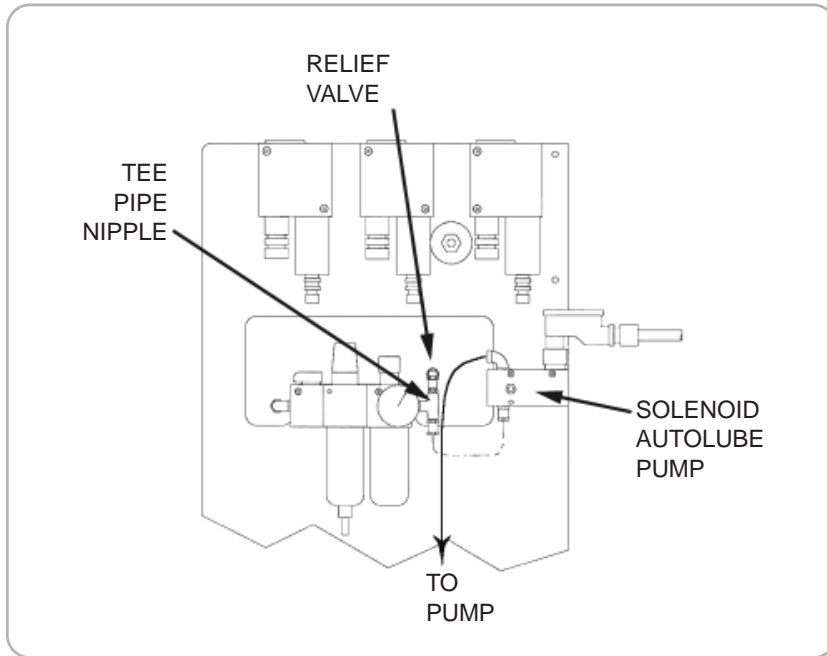
- ◆ 1200 PSI minimum pressure to activate all injectors
- ◆ 3000 PSI maximum pressure rating of the autolube pump
- ◆ 2000 PSI maximum pressure rating of the rotary union

Belvac's rotary union is rated at 250 RPM and 2000 PSI; however the manufacturer does not recommend both conditions exist simultaneously.

To satisfy both the Necking system requirements as well as the manufacturer's requirements, Belvac now offers a 45 PSI pressure relief valve #C44617, to be plumbed in line with the supply pressure to a 40:1 autolube pump, resulting in a maximum system pressure of 1800 PSI. The addition of this component ensures sufficient pressure to activate the injectors while maintaining greater life expectancy for the rotary union.

The following illustration indicates the pressure relief valve and its location relative to the pump system, on a modular machine:

(continued next page)



It takes approximately 20 minutes to install the new relief valve per machine.

To order the relief valve and associated mounting hardware, specify the following:

Pressure Relief Valve Kit #2752940

This component and circuitry is standard on all new Modular 595K and 595SK Necking system machinery shipped after January 1, 2005.

Contact Belvac Sales/Service for more information.