



Belvac Production Machinery Technical Bulletin

Information for Customers Operating & Maintaining Belvac Machines

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Rotary Union System Upgrade - Fixed Base (595K) and Modular Systems (595K & SK)

The rotary union 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 in the gearcase, it is important to get maximum life to prevent grease from leaking into the gearcase oil.

Customer feedback on Belvac's high pressure rotary union #C48517 prompted Belvac to review the root cause of the problem and consider practical solutions.

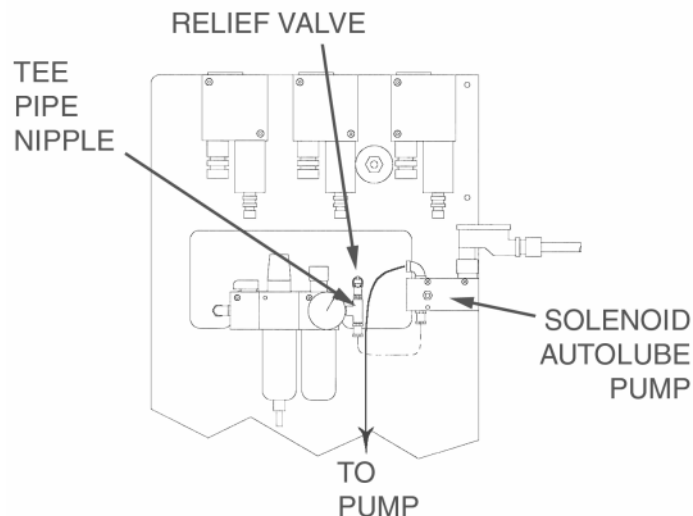
There are three pressure sensitive processes in the Necker system:

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

Belvac's rotary union is rated at 250 RPM and 2000 PSIG; 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 offers a 40 PSIG pressure relief valve #C44419 to be plumbed in line with the supply pressure to the 40:1 autolube pump resulting in a maximum system pressure of 1600 PSIG. The addition of this component ensures sufficient pressure is available to activate the injectors, as well as maintain 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:



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It takes approximately 20 minutes to install 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, effective January 2003.

Contact Belvac Sales or Service Representatives for ordering information.

All Technical Bulletins may be viewed on Belvac's web site, www.belvac.com.