

3 Mandrel Wheel Part Upgrades

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Technical Bulletin 2502-5 for Stolle Concord 24MRT Decorators

Stolle has upgraded 3 parts for the mandrel wheel of Concord 24MRT (24 Mandrel Rotary Trip) Decorators that will make adjustments and maintenance faster and easier.

1. Improved ball plungers

Stolle has introduced a new design ball plunger that has a hex broach instead of a slot. This ball plunger holds the rest shaft in position as the machine is running. The new design allows for easier adjustment and removal of the ball plunger.

Previously, the ball plunger was difficult to adjust and remove. Using a flat head screw driver did not allow for the torque required to break the ball plunger free. The new design features a hex broach and allows use of a 7/32" Allen wrench for adjustments.

In addition, a new blow-off air supply block is required for this retrofit. This is necessary because the ball plunger is longer and will contact the existing block. Two sets of mounting screws to attach the block are also provided. In addition, a longer fitting is provided for easier access to disconnect the air supply without having to remove the block. This makes it much faster and easier to work in that area of the carrier manifold.

The new design can be retrofitted on 24MRT machines. Purchase part number 222350244, which includes all parts needed including 24 ball plungers. This new design is standard for all new OEM machines and Rotary Trip retrofits.

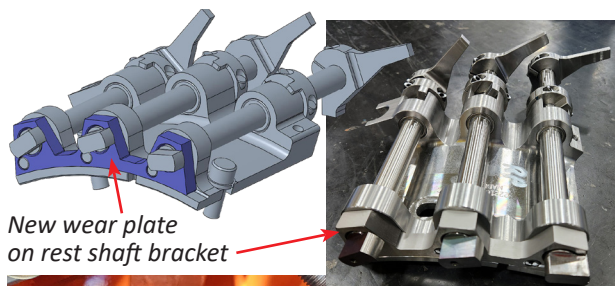
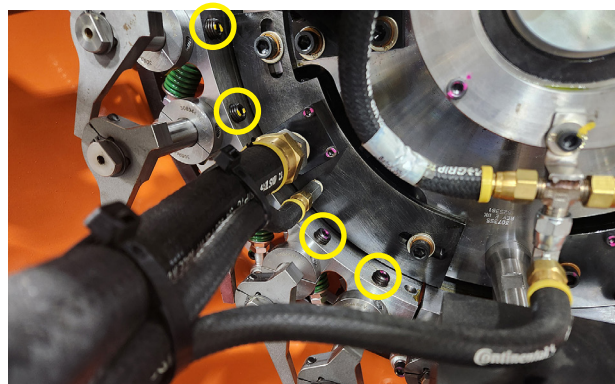
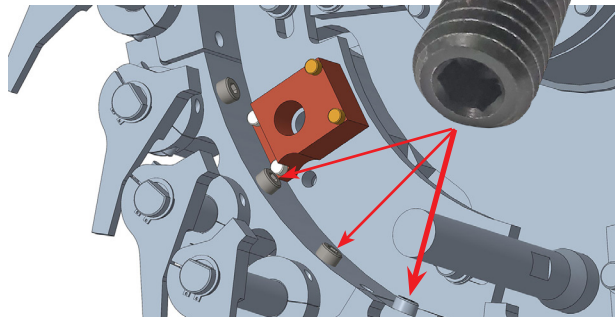
2. Wear plates for rest shaft brackets

24MRT machines can now use a wear plate to increase the life of the rest shaft brackets. This wear plate is located where the trip arm shoe makes contact when the mandrel is tripped. The new design allows for replacement of a wear part instead of replacing the entire rest shaft bracket.

Previously, the trip arm shoe would contact the rest shaft bracket right above the bronze bushing or needle bearing.

Continued on next page

New ball plunger has a hex broach that uses an Allen wrench for easier adjustments and removal



New wear plate on rest shaft bracket



New wear plate design allows replacement of a wear part instead of the entire rest shaft bracket



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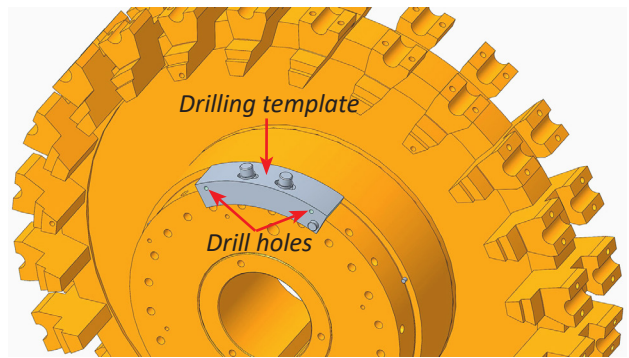
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This surface was very thin and would wear away causing missed trips and mandrel circle errors. Using the wear plate provides much longer life. The wear plate is made from hardened steel and can be replaced with only three screws.

The new design can be retrofitted on all 24MRT machines. Purchase part number 222108669 in a quantity of 8 to retrofit your machine. Please note this new part is not interchangeable with older designs, a full set of 8 is required for a retrofit. This new design is standard for all new Concord 24MRT Decorators and Rotary Trip Retrofits.

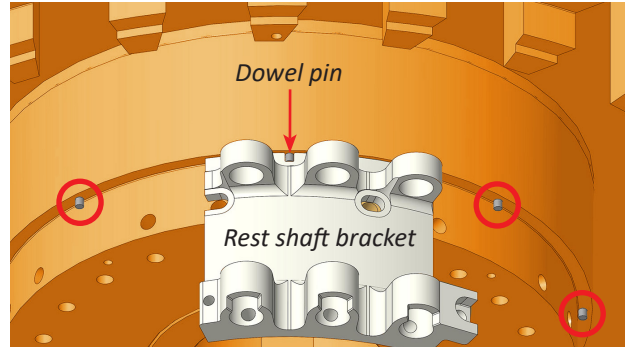


Drilling template mounted on the mandrel turret wheel

3. Dowel pins for rest shaft brackets

24MRT machines can now be retrofitted with dowel pins to help locate rest shaft brackets. This rest shaft assembly is part of the mechanism that retracts one mandrel if a can is not loaded. The new design allows for replacement of bracket assemblies quicker and more accurately.

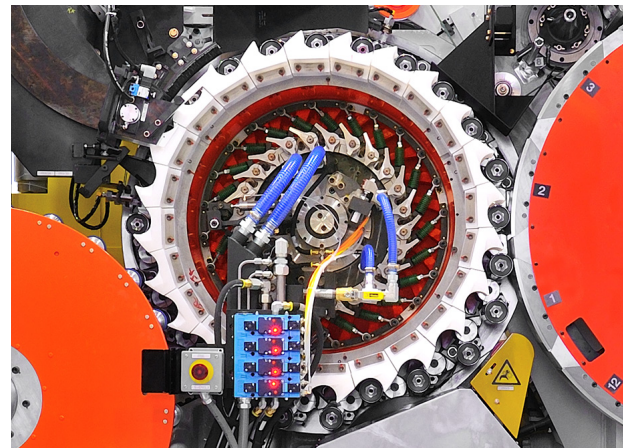
Previously, replacing rest shaft bracket assemblies would require several measurements to ensure there was enough travel for retract. This was because the brackets could be clocked up to .20 out of nominal position. The dowel pin retrofit assists in correctly positioning the rest shaft brackets during installation. Now, resetting the mandrel circle is the only task required after replacing rest shaft brackets.



Rest shaft bracket mounted on turret wheel with a locating dowel pin

To drill the dowel holes in the mandrel turret wheel, Stolle provides a drilling template that installs with 3 screws (one shoulder screw in the front face, two screws on the radius). A supplied drill bit is used in the template holes to drill the dowel holes in the small lip on the turret wheel, and the dowel pins are installed in these holes.

Dowel pins can be retrofitted on all Concord 24MRT machines that have rest shaft brackets with slots in them to accept the pins. These include all brackets manufactured after 2014 with part number 309290 with revision C, or all brackets with part number 222109426. If the brackets on your machine do not have dowel pin slots, you can order a set of 8 new ones – all new rest shaft brackets include slots. The dowel pin retrofit kit (part number 222174655) includes the drilling template, drill bit and dowel pins. The dowel pin design is standard for all new OEM machines and Rotary Trip retrofits.



Mandrel wheel on Concord 24MRT Decorator



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