

Mandatory Goizper Clutch-Brake Upgrade

for Stolle B6 / B7 Standun Bodymakers



Stolle
Standun Bodymaker
Technical Update 1510-1
Rev. 2

Recent upgrades of performance indicate an immediate, mandatory requirement to re-program the PLC of the bodymaker for clutch speed initiation. Please make an immediate change to the PLC program such that the clutch engagement revolutions per minute are below 270 rpm. *This is an immediate requirement to prevent premature failure, and excessive wear and tear on equipment.*

Secondly, Stolle Machinery advises visual and physical verification of all bolts on the assembly of the clutch-brake friction plates and engagement pins. Figure 1 on the right shows all the properly torqued screws and their locations.

Bill of Materials Item #6 from Goizper must be torqued using Loctite 243 (or equivalent) must be applied to the hex head screws and verified for the correct torque of 410 N-m (300 ft-lb).

Bill of Materials Item #17 must be torqued using Loctite 243 (or equivalent) must be applied to the hex head screws and verified for the correct torque of 210 N-m (155 ft-lb).

Bill of Materials Item #56 must be torqued using Loctite 270 (or equivalent) must be applied to the socket head screws and verified for the correct torque of 410 N-m (300 ft-lb).

Bill of Materials Item #57 must be torqued using Loctite 270 (or equivalent) must be applied to the socket head screws and verified for the correct torque of 410 N-m (300 ft-lb).

BOM ITEM	QTY	ITEM DESCRIPTION	LOCTITE (OR EQUIVALENT)	TORQUE SPECIFICATION
6	12	M20 X 60 DIN 931 – 8.8; HHCS	243	410 N*m (300 ft-lb)
17	8	M16 X 40 DIN 933 – 8.8; HHCS	243	210 N*m (155 ft-lb)
56	4	M20 X 90 DIN 912 – 8.8; SHCS	270	410 N*m (300 ft-lb)
57	4	M20 X 110 DIN 912 – 8.8; SHCS	270	410 N*m (300 ft-lb)

Any loose hardware needs to be immediately replaced with new and proper mounting hardware. In addition, the proper torque needs to be applied according to the Goizper Operations Manual. Drawings from this manual are attached to this document for reference (see Figures 3 and 4 on the following pages).

When servicing flywheel assembly equipment, always replace the Nordlock washers anytime the screws are loosened or removed.

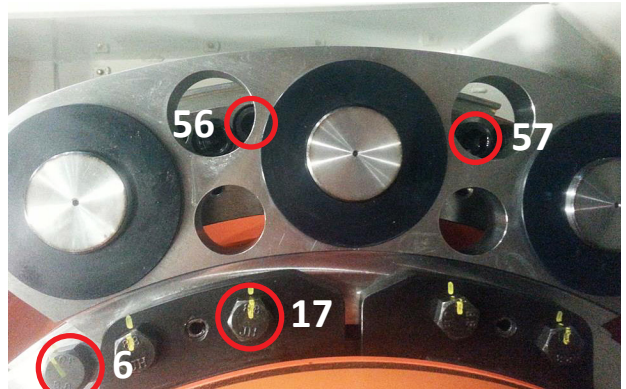


Figure 1: Torqued screws - Visual verification and placement of screws. Note the yellow paint markers visually verifying the screws are torqued and have not come loose.

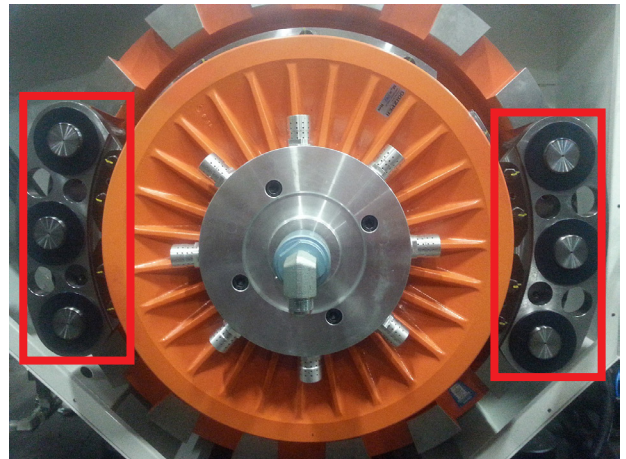


Figure 2: Front view of the flywheel and clutch assembly with screw locations

A complete hardware replacement is required for any and all screws that have been loosened or removed. Do not re-use hardware for risk of failure and loss of torque hold.

The Flywheel Assembly is Stolle part number 095690, and the Goizper part number is 5.83.76.1186.AB.

For more information about the mandatory Goizper Clutch-Brake upgrade for Standun Bodymakers, please contact Stolle Centennial at +1 303-708-9044.



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