



Stolle Machinery Company, LLC

Stolle Advanced Technology Operations (SATO)

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Necker (E-NCKR) Light Test Seal Puck Body

Serial Numbers Affected:

This bulletin applies to all Stolle Die Neckers with a Light Test Module

1.1 Overview

The Necker Light Test Module contains 12 Seal Pucks, each held in place with two Seal Puck Lock Blocks. The Seal Puck Lock Block is fixed in place with a #10-24UNC socket head cap screw. This bulletin outlines the intended installation and verification procedure of the Seal Puck and Seal Puck Lock Block.

1.2 Issue

If the socket head cap screw used to fix the Seal Puck Lock Block in place is improperly installed or insufficiently tightened the Lock Block can become loose. This allows movement of the Seal Puck to the point it can fall outward into the process turret while it is in operation. The Starwheel or Guide may be seriously damaged.

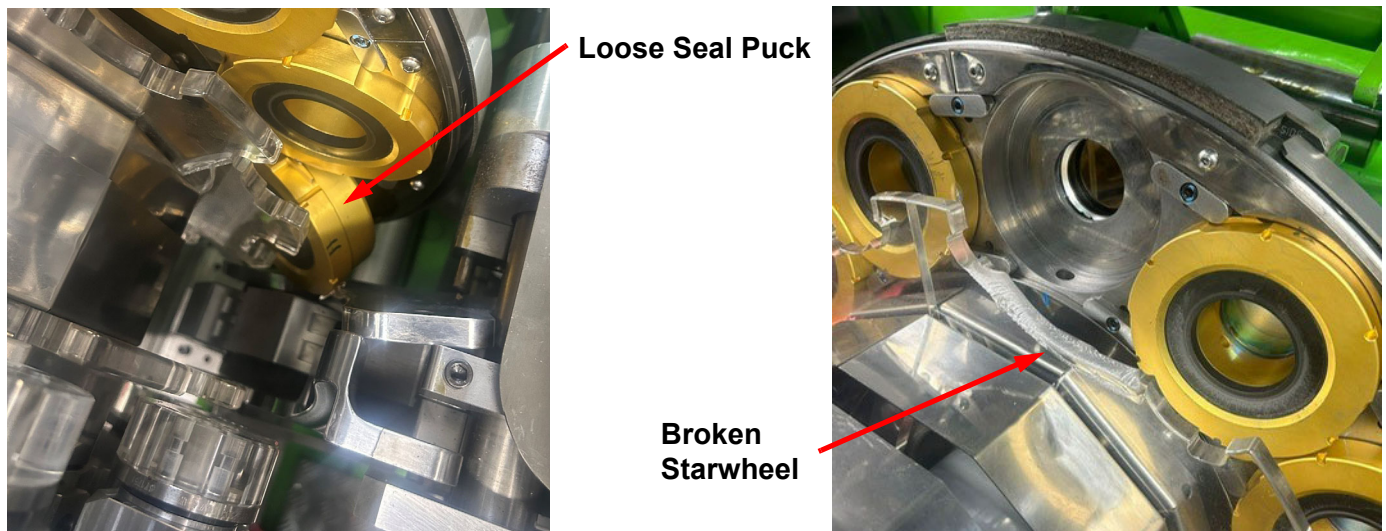


Figure 1-1. Light Test Damage

1.3 Correction

To properly place and tighten the Seal Puck Lock Blocks use the following procedure:

1. Insert the Seal Puck Lock Block in place and secure with the #10-24UNC socket head cap screw.
2. Torque the cap screw to 5.8 ft-lbs (8 Nm).
3. Insert the Seal Puck aligning the puck insertion slot with the end of the Lock Block.
4. Turn the Seal Puck clockwise with the Stolle Puck Tool until the puck body wedges against the Seal Puck Lock Block at the point of contact. There are two points of contact on each Seal Puck (left and right side).

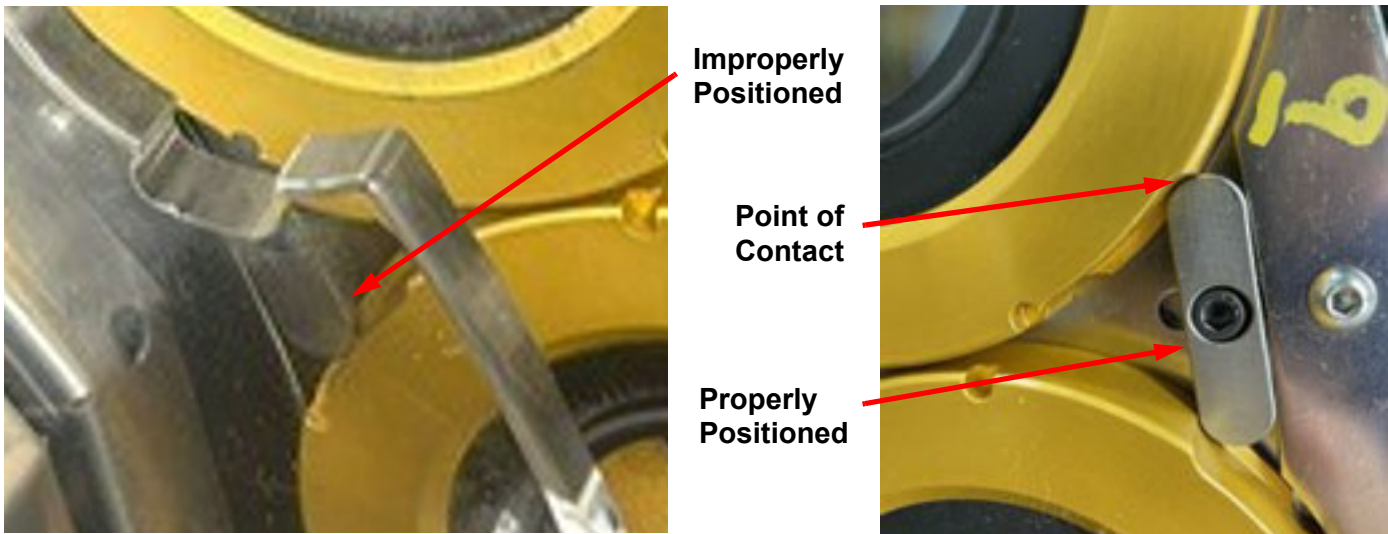


Figure 1-2. Improperly and Properly Positioned Seal Puck Lock Block

5. Make sure there is no gap between the Seal Puck Lock Block body and the Seal Puck body.

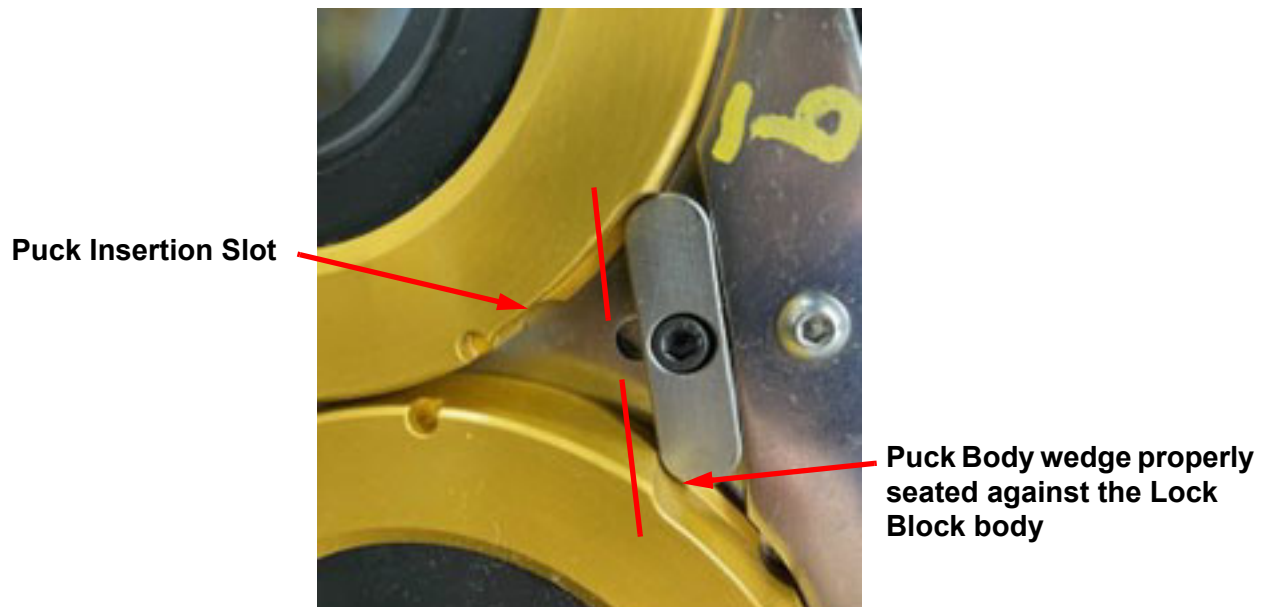


Figure 1-3. Properly Seated Seal Puck Body

To prevent any slippages in the future from leading to machine damage, it is recommended to stop the machine at least once per hour during operation to check the position of the pucks. To aid in monitoring movement place a mark on each Seal Puck body aligning with a mark on the turret. If any movement is detected re-torque the socket head cap screw and re-position the Seal Puck Body.