



Stolle Machinery Company, LLC

Stolle Advanced Technology Operations (SATO)

Technical Bulletin Number: 004

August 2023

Necker (E-NCKR) Pneumatic and Lube Fittings and Tubing Replacement

Part Numbers Affected:

222202261, 222188873, 222209740, 222188874, 222279807, 222279808, 222279809, and 222279810

1.1 Overview

The Die Necker operates as intended when the Rams are properly lubricated, and the correct amount of air and vacuum are supplied to the outboard assembly. This bulletin outlines the intended maintenance procedure and interval to ensure proper operation of the Die Necker.

1.2 Issue

There are two issues addressed in this bulletin: failure of pneumatic, vacuum, and lubrication fittings, and the failure of the tubing connecting the sources of these to their target destination.

1.3 Correction

To properly maintain the Necker pneumatic, vacuum and lubrication tubing and fittings, perform the following procedures every month:

1. Remove the grease covers from all modules.
2. Check the condition of all flexible lubrication, vacuum, and pneumatic tubing checking for excessive stiffness, cracking, deterioration or breakage. Replace the tubing if any of these conditions are noted. The necessary length for each tube is listed below:
 - The Necker Module Pusher Ram is 230mm
 - The Necker Module Knockout Ram is 215mm
 - The Light Tester Pusher Ram is 230mm
 - The Reformer Pusher Ram is 265mm
 - The Flanger Pusher Ram is 265mm
 - Outboard Assembly vacuum lines are 144cm
 - Cut the tubing length from a roll of the tubing specified in the appropriate drawing for the module you are working on.

3. Check the condition of all flexible lubrication, vacuum, and pneumatic hose connection fittings for worn swivel joints, loose threads, release ring, or damaged internals. Replace the fitting if any of these conditions are noted.

NOTE: Tighten the fittings to finger tight, and then turn 2-3 more times. If using a Crowsfoot and torque wrench the reading should be 2.5 ft/lbs (3.4 Nm) maximum torque.

1.4 Design and Part Update

From Q2 of 2023 replacement fittings are available for order from Stolle Machinery. Part number 222206621 has been replaced by 222279807, part number 222188873 has been replaced by 222279808, part number 222209740 has been replaced by 222279809, and part number 222188874 has been replaced by 222279810.

The parts can be located on your ram assembly drawings and vacuum assembly drawings.



Figure 1-1. Current Parts

Inquiries for spare part orders should be submitted to the Necker Senior Product Director:
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