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Issue

Excess breakage and decreased service life of Can Guide Hinges, Springs, and Spring Clips.

If the Can guide hinges are mounted in their higher position, although they appear to contain the cans well, when resting at the pushers before loading, they cause more violent action of the hinge & springs. This leads to a greatly decreased life, and is counter-productive to proper can orientation, and smooth case loading.

Recommendation

Correctly mount the can guide hinge below the "spacer" plate, rather than using the spacer plate as a clamping plate. This is key to getting the most life out of the parts, as well as smooth operation and case loading.

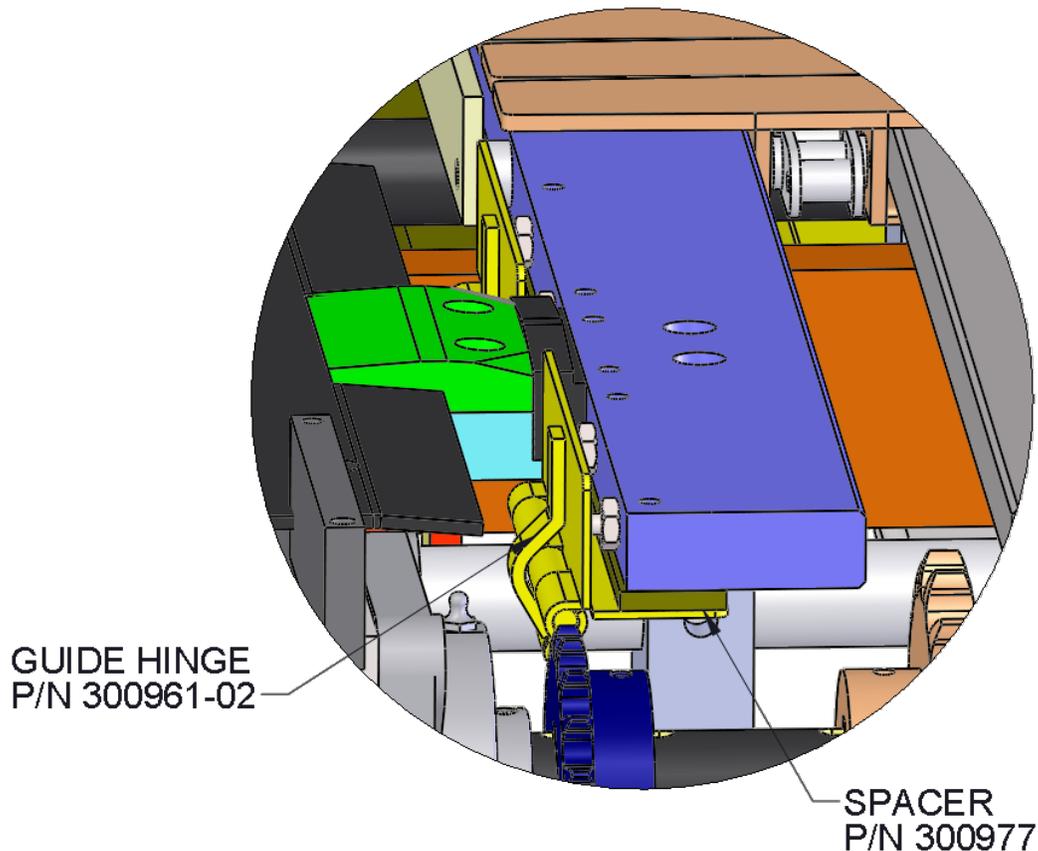


FIGURE 1

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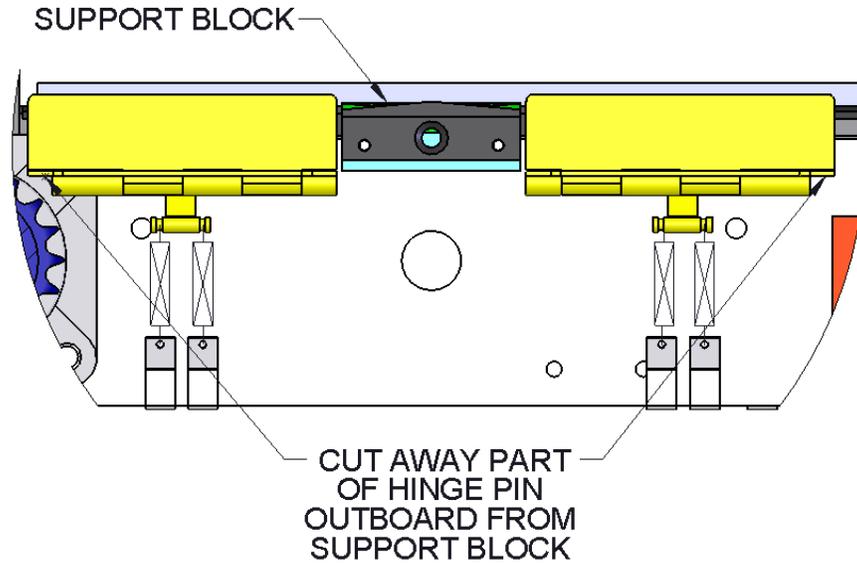


FIGURE 2

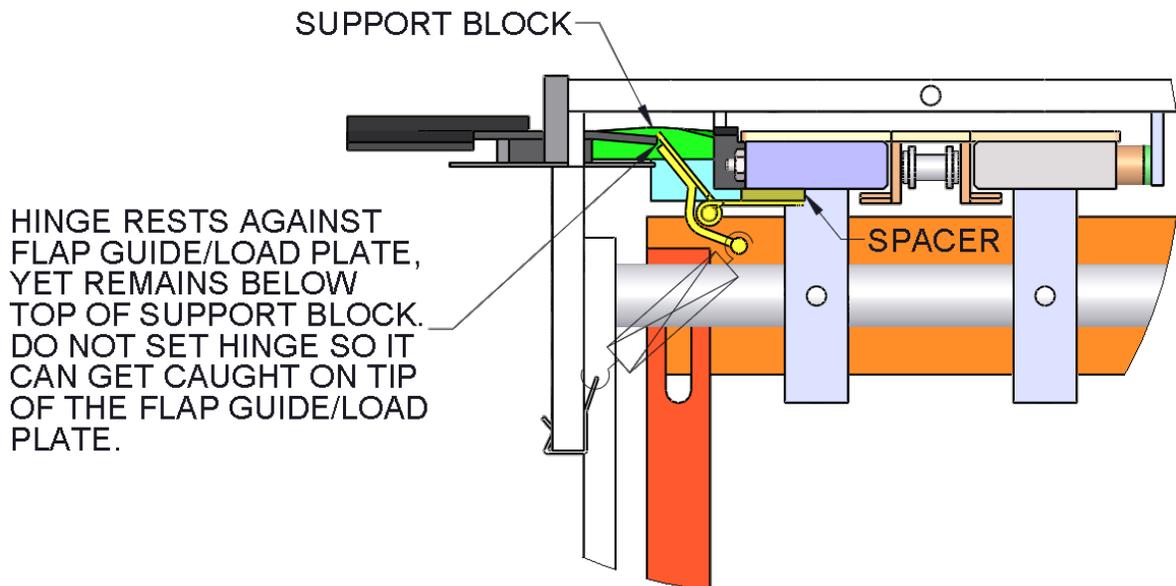
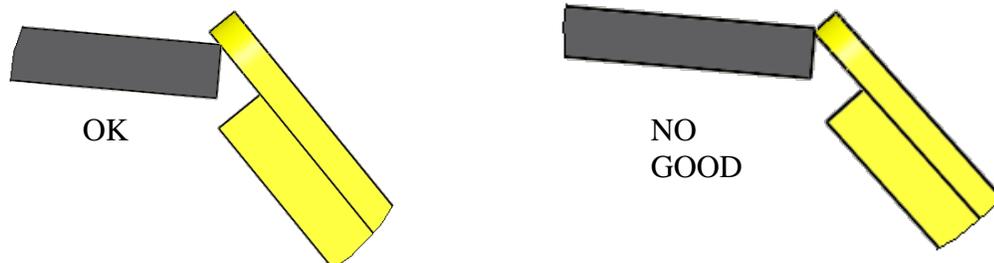


FIGURE 3



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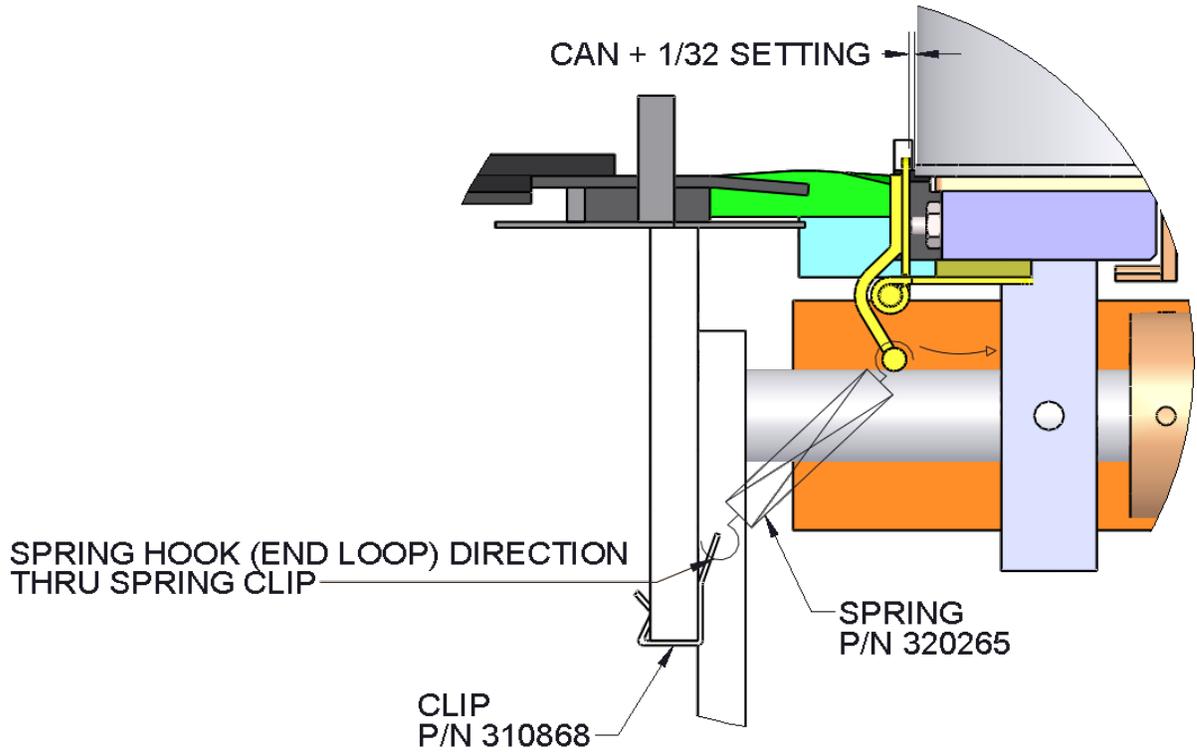


FIGURE 4

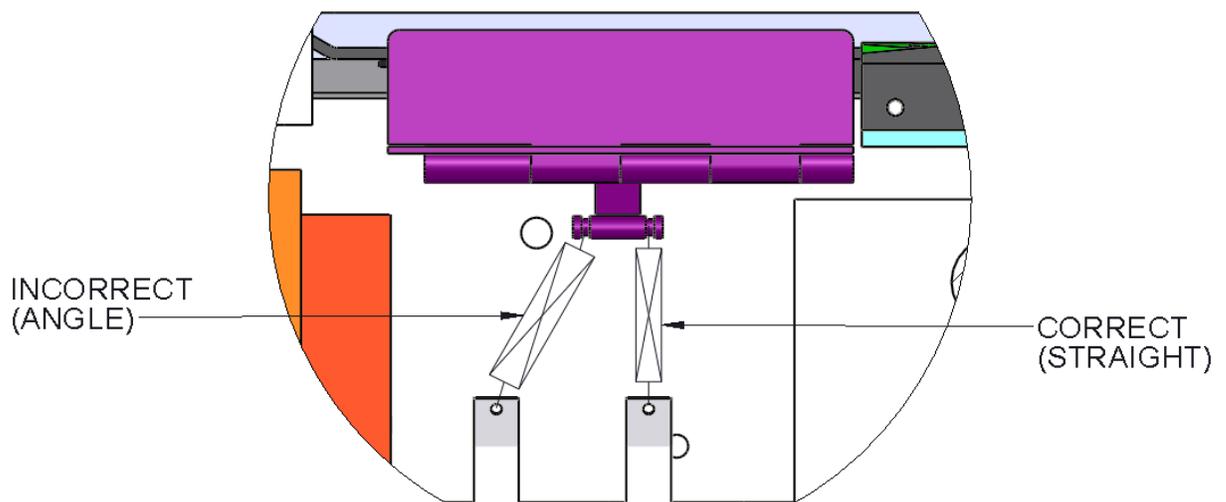


FIGURE 5

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Setup Criteria:

1. The guide hinges must be mounted with the cut-away part of the hinge pin facing outboard, away from the support block that is mounted between the 2 hinges (See Figure 2).
2. Position the can guide hinge so the vertical plate is as straight up and down as possible, at "Can + 1/32" from the outer can guide rail. This is when the hinge is relaxed against the adjuster set screw (See Figure 4).
3. The guide hinge must come to rest against the lower flap guide, or loading plate. The hinge plate must not be able to get caught on the load plate, yet must stay below the Support Block when actuated fully over against the load plate (See Figure 3).
4. The spring clips must be mounted in a position so the springs are in a straight line vertically from the clips. They should not cause the spring to be angled sideways (See Figure 5).
5. The spring's end-loop or hook, should enter the spring clip hole in the direction that causes the spring to move deeper onto the clip, as the hinge is actuated down by the can loading. This will help prevent the end-loops from fatiguing open further (See Figure 4).
6. The welded tab holding the spring posts on the vertical part of the guide hinges, may become fatigued or bent. This can decrease, or increase the spring tension of the hinge return.
 - A. If the hinge returns too violently, then the spring tension is too great. The spring-post end of the tab needs to be bent slightly further away from the barrel of the hinge, and toward the spring clip.
 - B. If the hinge does not have enough spring tension to return well, and hold a can in position, then the spring tension is insufficient. The spring-post end of the tab needs to be bent slightly in toward the barrel of the hinge, and away from the spring clip.

Note: Once the hinge tab is positioned correctly, whenever a new spring is put on, the spring tension should remain the same as it was when the last new spring was put on.