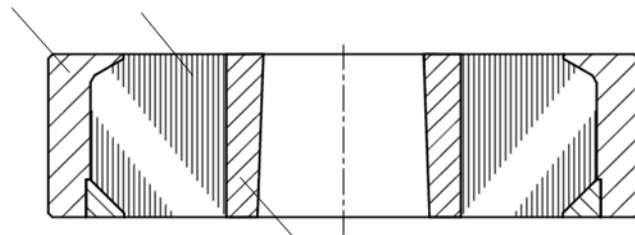


**Assembly and disassembly instructions for
STRECON® SC 200 / SC 400
STRECON® E+ Containers: SC 200+ / SC 400+**

Principle design of a STRECON® container

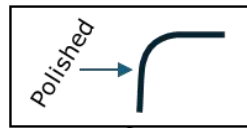
casing stripwinding



Winding ring with conical bore
SC200 / SC400: Tool steel
SC200+ / SC400+: Tungsten carbide

Check the die before assembly

- Are the dimensions correct? Check the outer diameter, conical angle, height
- Are the outer edges rounded and free of burrs?
- Is the transition from the radius to the taper polished?
- Is the outer surface ground ($R_a < 0.4$) and free of scratches, grooves, or other defects? Is the outer surface free of PVD/CVD coating?



! Insufficient die quality may cause damage to the container

Assembly of a die in a STRECON® SC/SC E+

1 Cleaning

- Use a degreasing solvent, e.g. ethanol
- Clean the outer surface of the die
- Clean the inner surface of the STRECON container



! Fitting of the die without cleaning may cause it to shoot out!

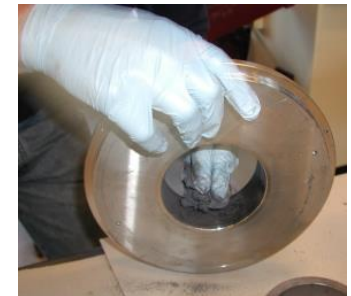


2 Lubrication

- Dub a thin layer of MoS₂ powder (e.g. Molykote) evenly on the contact surfaces
- Avoid local accumulations of lubricant and wipe off surplus



! Excessive lubrication may cause the die to shoot out!



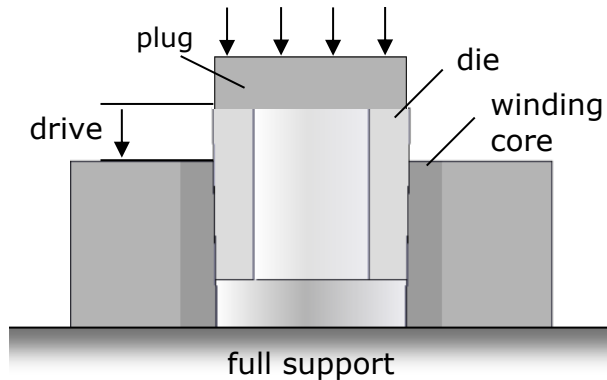
3 Positioning

- Place the STRECON container on the press table, the larger bore diameter on the top
- Place the die in the STRECON container
- Put a plug on the top of the die (not illustrated here)



Press fitting

- Make sure that the STRECON container is fully supported during the press fitting
- A slow-running hydraulic press is recommended.

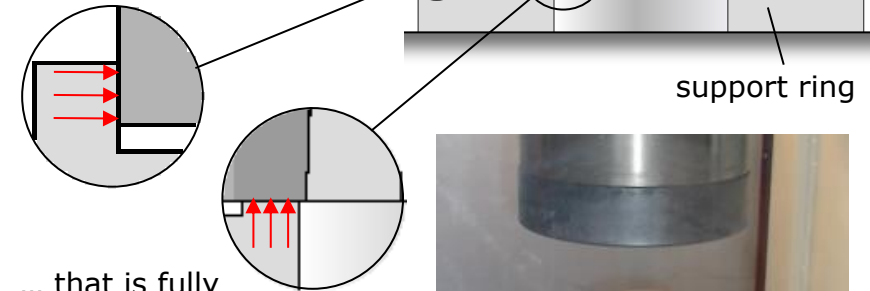


In case of large dies or a limited capacity of the press, it can be beneficial to perform the press fitting in two or more operations. For further advice, please check out our instruction videos (<https://strecon.com/instruction-videos>) or contact STRECON A/S.

Disassembly of a die in a STRECON® SC / SC E+

1 Positioning

- Place the STRECON container on a support ring ...
- ... that is centering the STRECON container



... that is fully supporting the winding ring

- Place a plug on the die insert



2 Disassembly

- Press out the die in the press by pressing down the plug

Technical Support

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