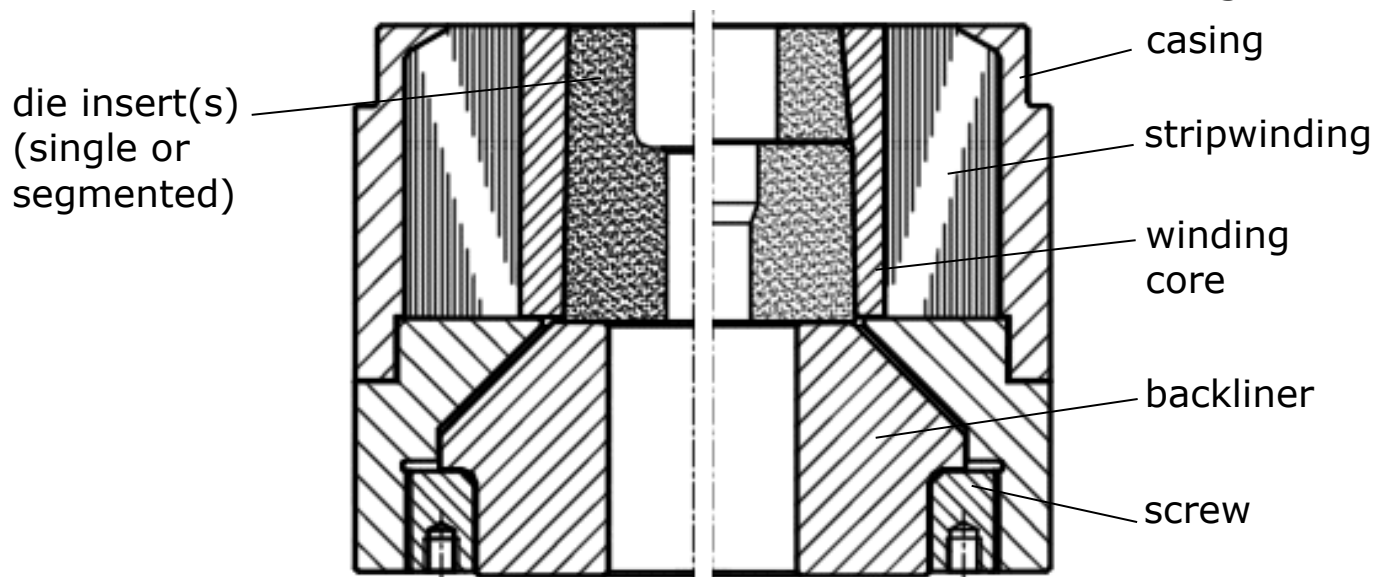


Assembly instructions for STRECON® AXI-FIT prestressed containers with a conical angle $\leq 1.5^\circ$ or a double cone¹

Principle design of a STRECON® AXI-FIT container

Continuous conical
angle $\leq 1.5^\circ$

double cone
with one angle $\leq 1.5^\circ$
and the other angle $> 1.5^\circ$



Check die insert(s) and tool elements 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 angle polished?
- Are the outer contact surfaces of the die ground ($R_a < 0.4$), free of scratches or grooves, and free of surface coating?

¹ Remark: For these conical angles and in case of appropriate cleaning and lubrication, there is no risk of uncontrolled shooting-out of the die during assembly. For larger conical angles, see STRECON instruction 4407.

Assembly of die inserts in a STRECON® AXI-FIT

1 Cleaning

- Use a degreasing solvent
- Clean the outer surface of the die and the inner bore 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, wipe off surplus



! Excessive lubrication may cause the die to shoot out!

3 Positioning of die insert(s)

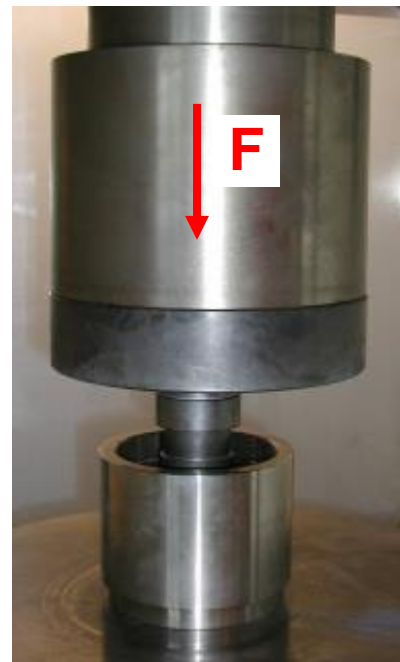
- Place the STRECON container on the press table, the larger bore diameter on the top
- Place the die insert(s) in the STRECON container
- Make sure that the orientation and position of the die insert(s) is correct
- Put a plug with sufficient height on the top of the die



! If the die is divided into **two or more inserts**, they **must be pressed in together**. Otherwise, the insert may shoot out, or the inner bore may get damaged by an uneven press fit.

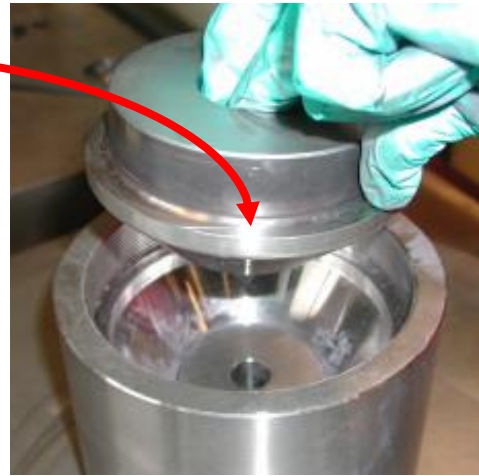
4 Press fitting of die insert(s)

- A slow-running hydraulic press is recommended.
- Make sure that the container is fully supported.
- Press down the plug and the die insert(s)
- Note the force **F** required for the press fitting.
- Relieve the press



5 Positioning of backliner and screw

- Insert the backliner



- Apply the screw (loosely, not finally tightened)

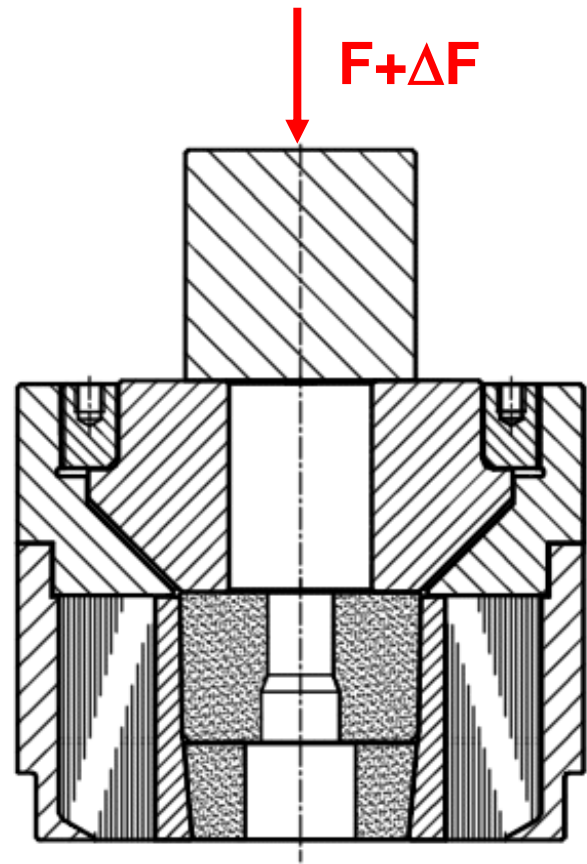


- Put a plug onto the back of the backliner (not onto the screw!)
- Place the whole assembly in the press



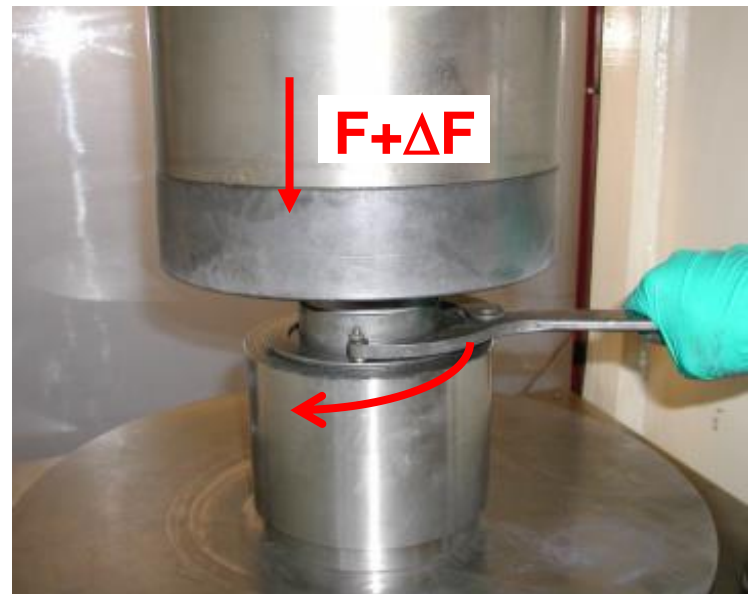
6 Axial prestressing

- Press down the backliner by the assembly force F that has been applied to the die inserts in step 4
- Apply an additional force ΔF in order to adjust the axial prestressing



- Tighten the screw while the press force is applied
- Release the press

The assembly is READY.



Please also pay attention to the following instructions for disassembly.

1 Loosening the screw under press force

! The screw may (and can) only be loosened while the backliner is loaded in the press!

- Place a plug on the backliner (not on the screw!)
- Place the assembly in the press
- Press down the backliner by

the assembly force F

plus

the additional force ΔF
for axial prestressing

plus

an additional force
(approx. 20%)

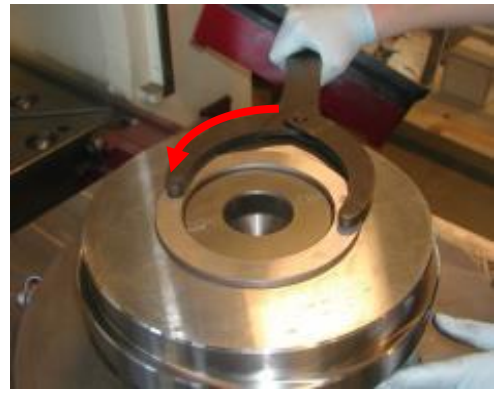
(see notes from assembly)

- Loosen the screw by a few turns (not completely!)
- Release the press



2 Take out screw and backliner

- Loosen the screw outside the press and take it out



- Take out the backliner



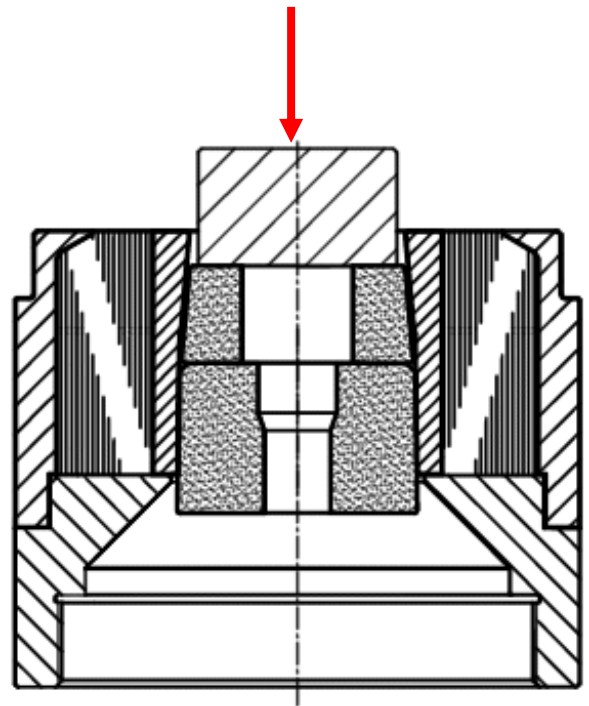
3 Turn the container round

- Put some rags into the cavity of the container (where the backliner was placed) in order to absorb the die inserts when pressing them out
- Turn the container around and place it on the press table (*see drawing on the following page*)



4 Press out the die insert(s)

- Put plugs onto the die and press down the die insert(s) slowly in the press
- Lift the AXI-FIT container carefully, take care that the die inserts do not fall off sideways



The disassembly is READY.

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