



Dixie Canner Company

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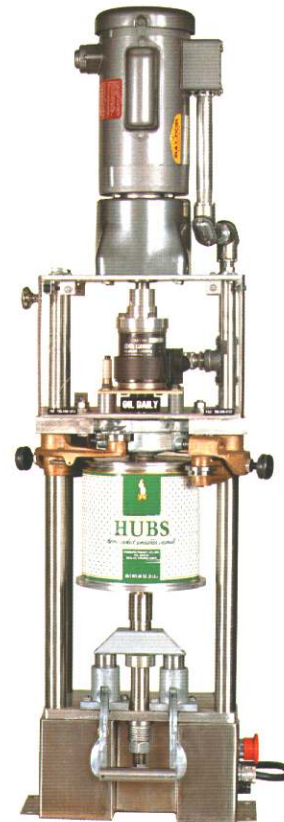
Worldwide Dependability ————— Can Packaging & Processing Equipment

OPERATOR'S MANUAL DIRECT DRIVE DIXIE DOUBLE SEAMER Model 10D

OIL DAILY:

- A. Gears inside gear housing through oil groove in gear housing at cut surface of chuck shaft. (Oil through #517 gear housing cover plate where indicated.)
- B. Seam rolls and cam rolls (Oil cam rolls through #517 gear housing cover plate where indicated.)
- C. Seam roll levers through gear housing arms.
- D. Base plate stem and plunger.
- E. Can lift lever and wear plate.

Wipe off excess. Experience will help you determine the correct amount of oil to use.



If you are not experienced with your machine, please read and understand this manual before operating the machine. If you have a question discuss it with your supervisor or contact Dixie Canner Company.

INTRODUCTION

Dixie Model 10D double seamers are adaptable for containers up from 4-5/16" to 6-3/16" diameters and up to 7" tall. They may be fabricated for containers taller than 7".

OPERATION

With base plate in lower position, place filled can with top in place on the baseplate. Lower the hand lever to raise can into position with the chuck and to engage the start switch. The machine seals the can automatically then stops. Remove the can and repeat the operation.

CAUTION

Before operating your Dixie Double Seamer, review this manual and make certain that:

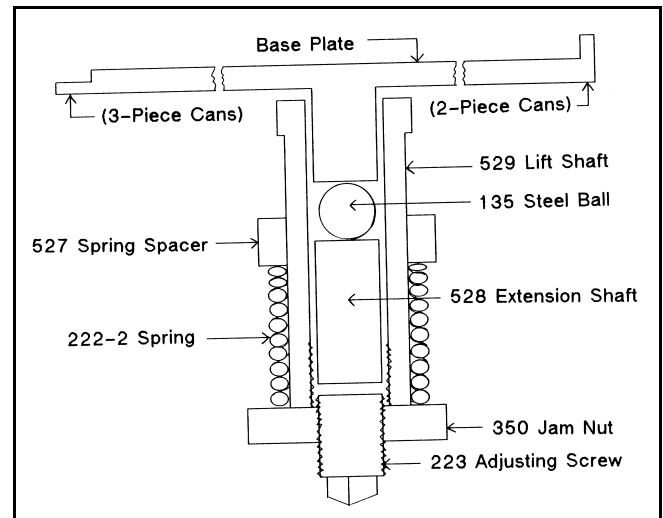
1. The machine is bolted securely to your table or counter top and is properly connected to your electrical supply.
2. All moving parts are oiled and operate freely.
3. The machine is properly adjusted.
4. If this machine is used occasionally or is inactive for more than a few days, give special attention to servicing before and after storage.

BASE PLATE PRESSURE ADJUSTMENTS

Proper base plate pressure is required to produce essential body hook and to prevent the can from slipping during the seaming cycle.

To make minute adjustments or to change to cans shorter than 6" proceed as follows:

Cans 6" to 7" tall do not require a height spacer. Base plate pressure adjustments are made by turning the adjusting screw (223) after loosening jam nut (350) at the lower end of base plate lift shaft (529).



SECTIONAL VIEW OF BASE PLATE ASSEMBLY

With a can and top locked into position with the seaming chuck, adjust the screw (223) "snugly" and then tighten the jam nut (350). After making seam roll adjustments and closing a test can, final adjustments are made to produce the proper hooks.

The steel ball (135) and the extension shaft (528) must be cleaned and oiled periodically; to remove them, first remove the adjusting screw. After making adjustments, tighten jam nuts or set screw.

NEUTRAL POSITION

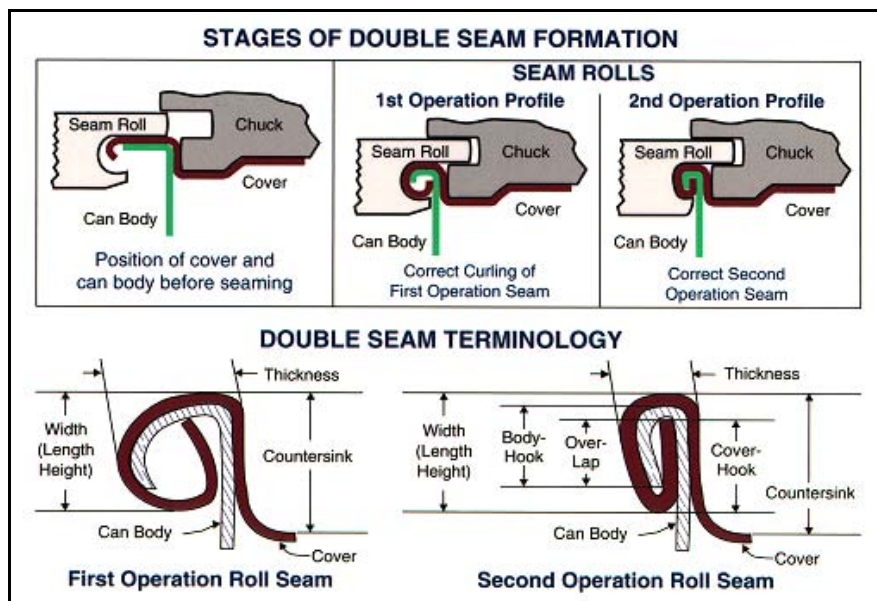
The machine is in a neutral position when both cam rolls (20) are in their innermost position and both seaming rolls are in their outermost position.

SEAMING ROLL ADJUSTMENTS:

There are ten (10) revolutions per seaming cycle, five (5) for each seaming roll. The function of the first operation seam roll is to curl the cover hook and body hook into proper position. The function of the second operation seam roll is to complete the sealing of the can.

FIRST OPERATION

The seamer must be in neutral position (both cam rolls [20] are at their innermost position and both seam rolls (1st and 2nd) are at their outermost position).



1. Turn machine OFF. Loosen lock nuts [16] and turn seam roll set screws [17-A] backwards until both seam rolls are moved back as far as they will go.
2. Turn power ON. Press and release the actuator on the clutch/brake assembly [502-1] FOUR times. Turn machine OFF. Press actuator once to release the clutch brake. Grasping the aluminum collar [508], manually turn the clutch/brake clockwise ONE HALF revolution. These 4½ revolutions of the clutch/brake assembly places the first operation seam roll in its innermost position with the chuck.

3. Place large diameter gauge wire [40] in groove of first operation seam roll and adjust the seam roll set screw [17-A] until the gauge wire fits snugly between the seam roll and chuck lip. (Do not place gauge wire in groove of chuck.) Tighten lock nut [16] while holding the seam roll set screw [17-A] with socket head wrench. There should be sufficient friction to turn the seam roll as the gauge wire is moved back and forth. Remove gauge wire.
4. Turn machine ON. This completes the 5th revolution. Press the can raising lever [23] down and hold in place. The seamer will return to neutral position.
5. Close a container and inspect the first operation seam. Measure the seam thickness and adjust the first operation seam roll as needed to meet seam specifications.

SECOND OPERATION

1. Turn machine ON. Release the actuator on the clutch/brake [502-1] NINE times. This places the second operation seam roll into its innermost position with the chuck.
2. Place small diameter gauge wire [41] in groove of second operation seam roll and adjust the seam roll set screw [17-A] until the gauge wire fits snugly between the seam roll and chuck lip. Tighten lock nut [16] while holding the seam roll set screw [17-A] with socket head wrench. Remove gauge wire.
3. Turn machine ON. Press the can raising lever [23] down and hold in place. The seamer will return to neutral position.
4. Close a container and inspect the second operation seam. Make any final adjustments required to produce seam specifications recommended by the can manufacturer or to ensure a hermetic seam.

If you are unable to obtain the essential measurements recommended or a hermetically sealed container, you may need seam rolls with different profiles.

CHANGING FROM ONE SIZE CAN TO ANOTHER:

Change parts consisting of a chuck, a base plate and a height spacer may be required for each different can diameter, top or style. Also, a different set of seaming rolls may be required for each. Your can manufacturer or supplier may recommend the seam roll profiles for your cans. Dixie stocks or may be able to furnish the seam roll profile needed. Therefore, make sure you have the correct change parts available when changing your machine from one can size to another, then proceed as follows:

1. Put seam rolls in neutral position.
2. Loosen lock nuts (16) and set screws (17-A) until both seaming roll levers (122) are back as far as they will go. If needed, change seaming rolls.
3. Change chucks. Make certain that the new chuck is properly tightened into position against the shoulder of the chuck shaft. **CAUTION:** Follow directions below to prevent damage to the clutch/brake assembly.

To remove the chuck, hold the chuck shaft with a 5/8" wrench on the cut side of the shaft, located above the top support plate above the gear housing. Then place the two pins of the D-44 chuck wrench (provided with your seamer) into two of the four holes located on the bottom of the chuck. [The pins of the chuck wrench will fit into either diagonal or adjacent holes depending on the diameter of the chuck.] To loosen, turn the chuck to the left. Finish removing the chuck by hand.

To install a new chuck, hold the chuck shaft with a 5/8" wrench, as described above, while using your hand to thread the chuck onto the lower end of the chuck shaft. Turn to the right to thread the chuck onto the chuck shaft. Use the chuck wrench, as described above, to tighten snugly.

4. Install the proper base plate and height spacer for the can to be closed. Adjust the base pressure and seaming rolls as outlined above.

TIMING THE MACHINE

The machine is properly timed when both cam rolls (20) are at their innermost position and both seaming rolls (1st and 2nd) are at their outermost position. If the seamer has been inadvertently stopped in mid-seaming cycle, simply engage the start lever by pressing the can raising lever (523-2) to finish the seaming cycle and place the seamer back into time.

If the seamer is out of time for any other reason, press the actuator of the clutch/brake/solenoid assembly (502), one revolution at a time, until the cam rolls are in their innermost positions and the seaming rolls are in their outermost position. The seamer may be timed by using an open end wrench to turn the chuck shaft until the cam rolls are at their innermost position and the seam rolls are at their outermost position.

CLUTCH/BRAKE/SOLENOID ASSEMBLY

CAUTION: The clutch/brake/solenoid assembly (502) is very complex. If the clutch/brake/solenoid assembly fails to operate, Dixie recommends replacing it with a new assembly. You may return the malfunctioning unit for factory repairs for future use as spare. Factory service/repair may require 4-6 weeks. *Please be careful if attempting repairs on this unit to avoid irreparably damaging the unit.*

CHANGE PARTS AND REPAIR PARTS

Photographs of parts, assemblies, machine sections, base plates and height spacers with the corresponding part number are shown on other pages. A Parts/Price List is furnished separately. When ordering parts, always furnish both the part number and the name of the part. When ordering change parts for cans, always send six (6) loose tops and can bodies of the size can(s) to be closed.

REPAIR PARTS AND REBUILDING SERVICE

A complete stock of parts is maintained by Dixie Canner Company. Parts may be ordered as needed to replace worn or damaged parts.

Your Dixie Double Seamer may be returned to Athens, Georgia for complete rebuilding at a nominal service charge, plus the cost of parts needed. When returning the machine for the rebuilding service, please observe the following:

1. Return the complete machine and include several cans and tops of the exact size and type closed. Properly crate the machine and cans for safe delivery and return shipment, and prepay the shipping cost.
2. Write a letter authorizing the rebuilding service and mention any problem with the machine. Also mention particular instructions concerning return shipment, urgency, and other pertinent instructions.

HELPFUL HINTS – TROUBLESHOOTING

Until the operator is familiar with the mechanics of your can closing machine and learns to recognize irregularities in the essential requirements of the double seam, the outline below is intended to help notice obvious defects and list some causes that may serve as a guide in correcting minor troubles.

MECHANICAL DEFECTS AND COMMON CAUSES

- A. Can slips during seaming operation
 1. Damage or lack of oil in the base plate, lift shaft, height spacer or steel ball
 2. Insufficient base plate pressure
 3. Worn or wrong size chuck
 4. Seaming rolls binding on pins
- B. Machine operates with undue noise or "locks"
 1. Machine not properly timed
- C. Unusually loose seaming rolls
 1. Seaming roll or pins worn
- D. Seaming rolls do not return to neutral position
 1. Seaming roll levers binding
 2. Seaming lever spring weak or broken
 3. Machine not properly timed

- E. Machine seems to "labor" or freeze tight
 1. Needs oil.
 2. Too much base plate pressure
 3. Seaming rolls too tight
 4. Misalignment of moving parts

DOUBLE SEAM DEFECTS and COMMON CAUSES

- A. Cut over. Unusually sharp edge at top inside edge of seam
 1. 1st or 2nd operation seam roll set too tight
 2. Worn seam rolls or worn chuck
- B. Cut or fractured seam
 1. Seam rolls set too tight
- C. Droop or lap in double seam at or near can body side seam
 1. Too much base pressure
 2. 1st operation seam roll set too loose
 3. Worn 1st operation seam roll
- D. Excessive countersink depth
 1. Too much base pressure
 2. 1st operation seam roll set too loose
 3. Chuck not properly seated in can top
 4. Chuck groove worn
- E. False seam. Body hook and cover hook do not overlap
 1. Can top not properly seated on can
 2. Damaged can flange or can top curl
- F. Long body hook
 1. Too much base pressure
- G. Long cover hook
 1. 1st operation seam roll set too tight
- H. Short body hook
 1. Insufficient base pressure
 2. 1st operation seam roll set too tight
 3. 2nd operation seam roll set too loose
- I. Short cover hook
 1. Too much base pressure
 2. 1st operation seam roll set too loose
 3. Worn 1st operation seam roll
 4. Excessive countersink depth
- J. Cover hook or body hook not uniform
 1. Base plate or plunger worn
 2. Chuck or seam rolls out of alignment
- K. Droops, vees, wrinkles
 1. Excessive base pressure
 2. 1st operation seam roll too loose or worn
 3. 2nd operation seam roll too tight
 4. Defects in can body or top
 5. Incorrect seam roll profiles

