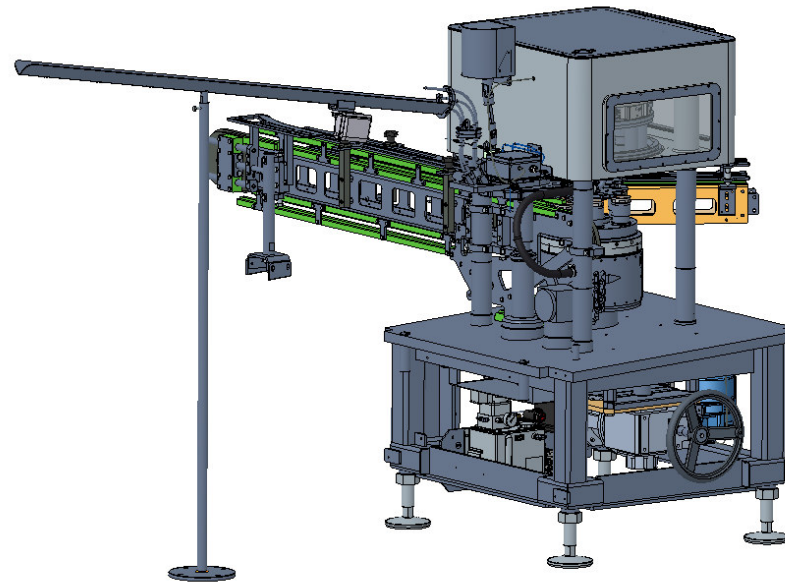
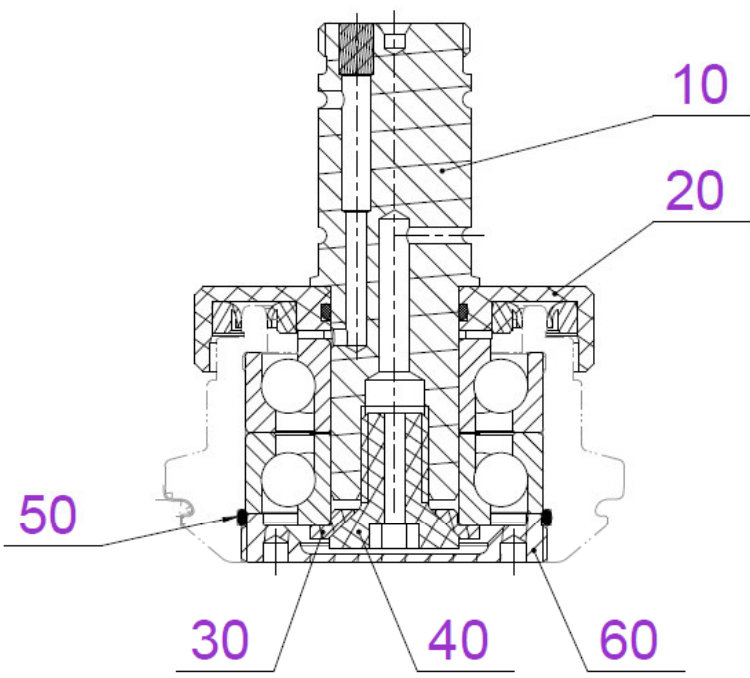


U.S. Seamer Machine Set Up



2

85013118S001.ASM	10
85013120S001.ASM	20
301024013210.PRT	50
85013023S001.PRT	30
85013028S001.PRT	40
85013119S001.PRT	60



- Montageverfahren:
1. Platz # 10 Pin-up-side-down in der Halterung
 2. Zwischenzeitliche Abstandshalter von # 20 zwischen Lippendichtungen entfernen
 3. Packung 1 ccm Fuchs Cassida RLS0 Fett zwischen 2 Lippendichtungen
 4. Klüber Unisilikon L200 auf # 20 O-Ring und Install # 20 als Show anwenden
 5. die Nahtrollenbaugruppe 850XXXXX als Show-Position installieren
 6. Loctite 243 (Blau) auf # 40 anbringen, um # 30 mit Drehmoment 19-20 Nm zu
 7. O-Ring Nr. 50 anbringen, indem du einen leichten Mantel aus Fuchs Cassida
 8. installieren Sie # 60, indem Sie Loctite 243 (Blau) mit Drehmoment 10-12 Nm
 9. Halten Sie die Welle Nr. 10 und drehen Sie die Rollenordnung. bestätige und keine Schaukelbewegung zwischen Rolle und # 10
- Assembly Procedures:
1. place #10 Pin up-side-down in the fixture
 2. remove temporary spacer from #20 between lip seals
 3. pack 1 cc of Fuchs Cassida RLS0 grease between 2 lip seals
 4. apply Klüber Unisilikon L200 on #20 O-ring and Install #20 as show
 5. install seaming roll assembly 850XXXXX as show position
 6. apply Loctite 243 (Blue) on #40 to install #30 with torque 19-20 Nm
 7. install O-ring #50 by applying light coat of Fuchs Cassida RLS0 grease
 8. install #60 by applying Loctite 243 (Blue) with torque 10-12 Nm
 9. hold #10 shaft and spin the roller assembly. confirm free spinning and no rocking movement between roll and #10

installieren
RLS0-Fett einsetzt
anwenden
das freie Spinnen

85013121S001	0.185
NAME	MASS (kg)

General Tolerances Machining: ISO 2768-mk Laser cutting: ISO 9013-231 Flame cutting: ISO 9013-332 Welding: EN ISO 13920-BE undefined Edges: ISO 13715	Language	EN	Projection		Created by	LeeC	Created on	2017-05-10	Format	A3
	Version	1.1	Exchange Format		Changed by		Changed on	-	Scale	2:1
	Reference				Checked by	LEECHA	Checked on	2018-09-18	Sheet No. of	1/1
	Denomination	Befestigungsteil Falzrolle komplett Mounting part Seaming Roll komplett								
		Drawing No.	85013121		EC-Number	0		EC-index	0	

Item	ICt	Component	Component description	Quantity
0010	L	85027201S001	Seaming Roll_Second op...	1
0020	L	85023050S001	Bearing_Pair__	1
0030	L	85023066S127	Shim_Seaming Roll__	1
0040	L	85013121S001	Mounting part_Seaming ...	1

Montagehinweise

1. Platz # 10 Nahtrolle auf den Tisch drücken
2. eine leichte Schicht Fuchs Cassida RLS0 Fett auf ID von # 10 auftragen
3. Ausrichtung 1. # 20 Lager offene Seite nach unten von Gewinde Ende von # 10
4. Verwenden Sie ein? N? 30 ID x? N? 34.5 OD Stahlrohr als Presswerkzeug
5. Mit Presswerkzeug das erste Lager gegen die Nahtrollenleiste drücken
6. Ausrichtung 2nd # 20 Lager offene Seite nach oben vom Gewindeende von Seaming Roll
7. durch Presswerkzeug 2. Lager gegen 1. Lageraußenring drücken
8. Halten Sie auf beiden Seiten der Lager-ID, überprüfen Sie die Rolle, die sich frei dreht
9. Sichtprüfung der Lagerung ist in "Doppel-Back-to-Back" (DB) Montage Assembly Procedure

1. place #10 Seaming Roll upside down on the press table

2. apply a light coat of Fuchs Cassida RLS0 grease to ID of #10

3. align 1st #20 bearing open side down from threaded end of #10

4. use 85035014S001 press 1st bearing against Seaming Roll ledge

5. Place a proper thickness shim 85023066Sxxx on 1st bearing

6. align 2nd #20 bearing open side up from threaded end of Seaming Roll

7. through Press Tool, press 2nd bearing against 1st bearing outer race

8. Hold on both sides of bearing ID, check roll is turning freely

9. visual check the bearing is in "double back-to-back" (DB) mounting

85027301S003	Heat treat RC58-62	0.431
85027301S002	None	0.431
85027301S001	TiN	0.431
Teilenummer	TREATMENT	MASSE

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General Tolerances	Language	Projection	Created by	Created on	Format
Machining: ISO 2768-mK-E	EN		LeeC	2017-05-11	A3
Laser cutting: ISO 9013-231	Version	WIS Guideline	Changed by	Changed on	Scale
Flame cutting: ISO 9013-332	6.1	K0360	Xiong	2021-06-23	2:1
Welding: EN ISO 13920-BE	Similar to		Checked by	Checked on	Sheet No./of
undefined Edges: ISO 13715			Ding	2021-06-23	1/1
	Denomination	Falzrolle Zweitformung komplett Seaming Roll Second operation komplett			
	Drawing No.	85027301	EC-Number	921830	EC-index
					2

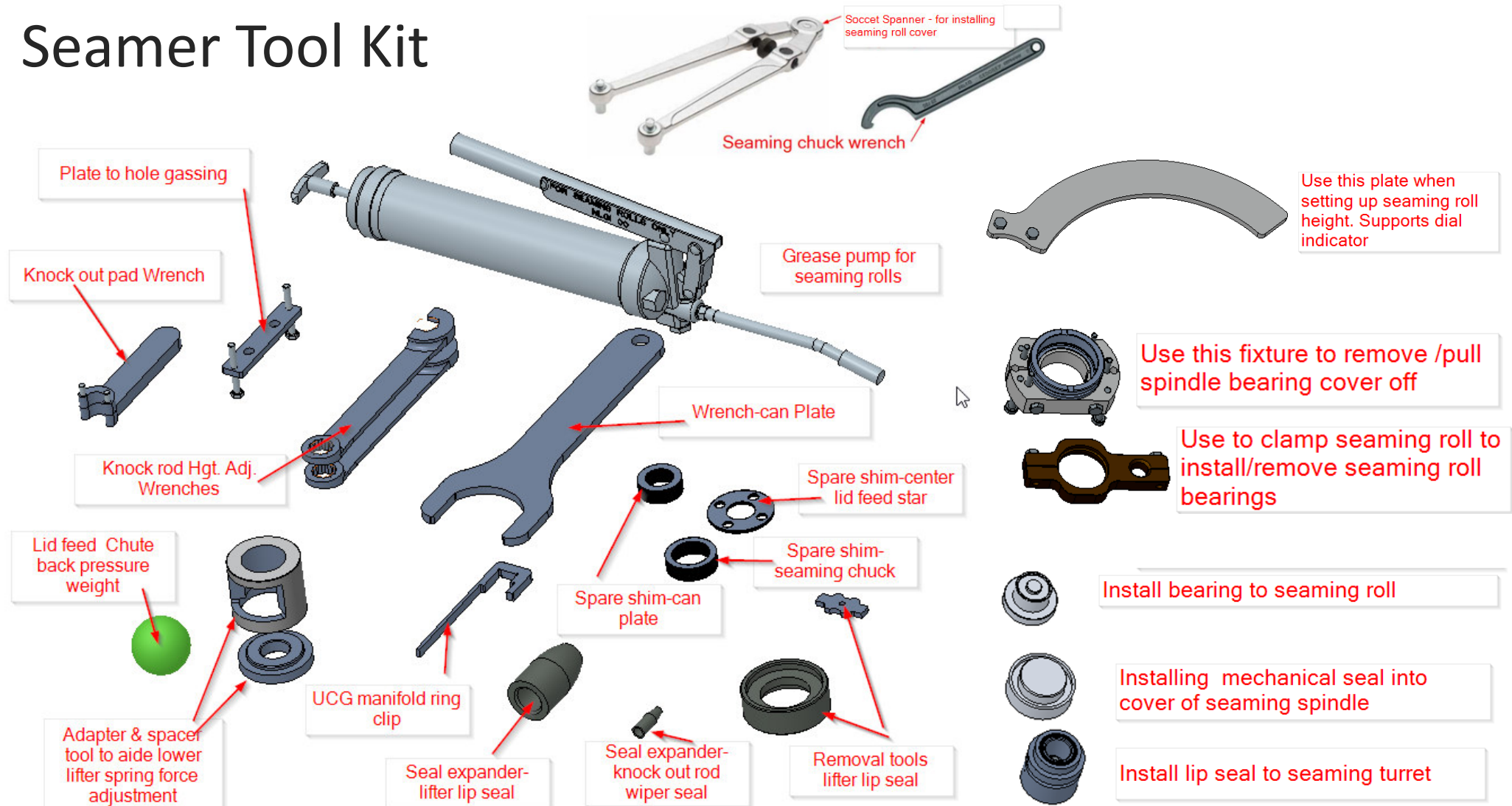
Seamer Mechanical Inspection Check List

WAUKESHA PLANT		Mechanical Inspection Check List			
Haskel Co. (E&J Gallo)		Entity # : 6960-11-834A		Doc Name: Seamer_mechanical-rev0	
Model # : TK250-6 Seamer		Serial # : 85000014S001		Revision Level: 0	
				Prepared by: Chane Lee	
				Approved by: Kyle Nielsen	
Notes: All measurement units in inch except noted				Station #	
Description					
1 Plane Seaming Chucks within		202 →		1 2 3 4 5 6 7 8	
0.05 mm / 0.002" between chucks		200 →		+ .001 .000 .000 + .001 .000 + .001	
0.1 to 0.15 mm / 0.004" to 0.006" below Centering Bell				X X	
2 Plane Can Plates				.000 -.001 -.001 .000 .000 -.000 X X	
within 0.03 mm / 0.001" between each plate					
3 Seaming Cam Levers Vertical End Play				.005 .005 .005 .005 .005 .005 X X	
0.05 - 0.13 mm / 0.002 - 0.005"					
4 Drop-off from Filler to Infeed Conveyor				.006"	
0.25 mm / 0.01"					
5 Drop-off of infeed conveyor to can plates				.008"	
0.25 mm / 0.01"					
6 Drop-off from Can Plates to Discharge Wear Plate				.007"	
0.25 mm / 0.01"					

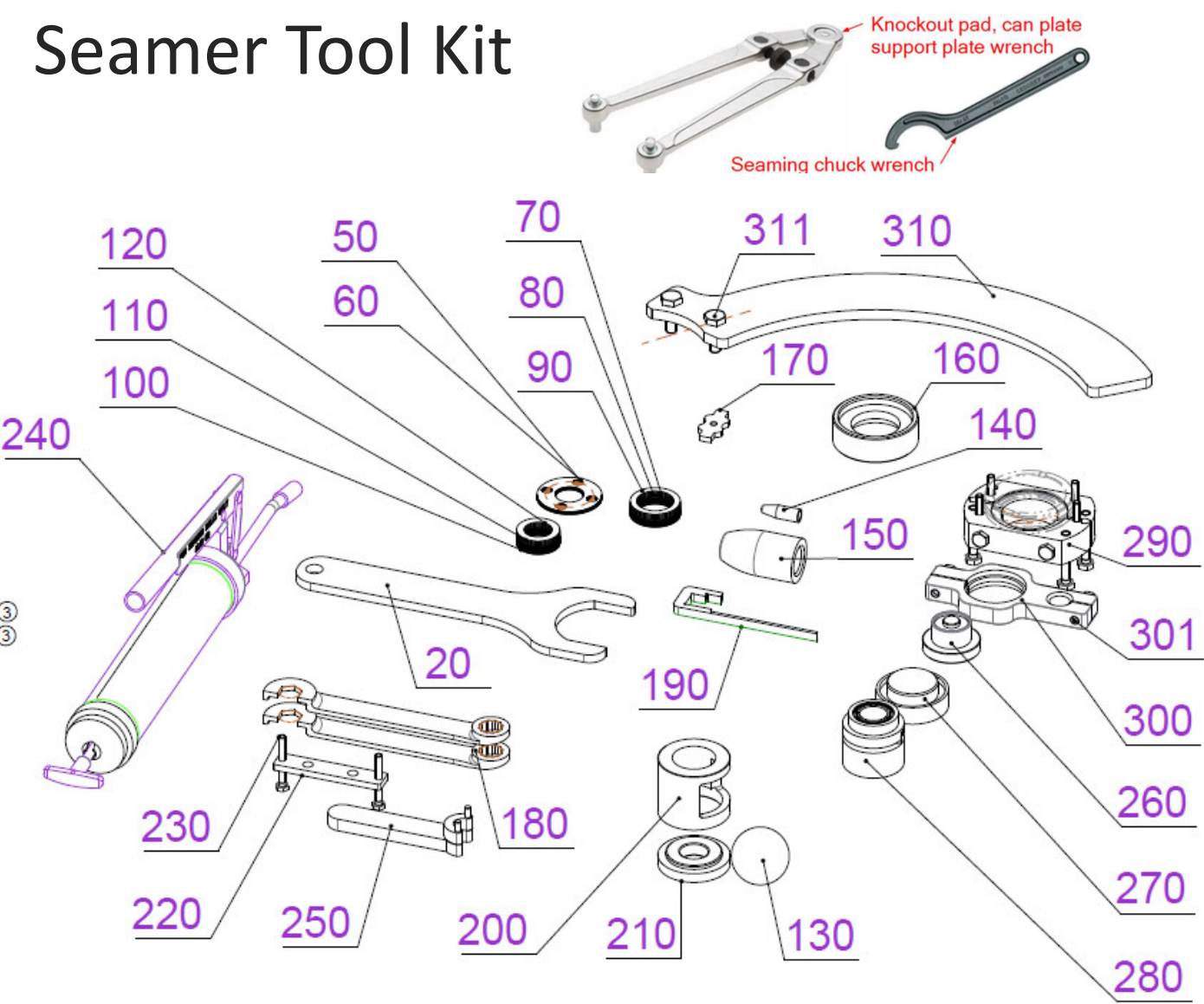
Seamer Mechanical Inspection Check List

7 Can Guides Running Clearance 0.15 to 0.25 mm / 0.006 to 0.010"	<u>.010"</u>		
8 Can Feed Turret to Lid Guide Vertical Clearance 0.8 to 1.5 mm / 0.032 to 0.060"	<u>1.5"</u>		
9 Can Feed Turret (UCG Turret) Timing in time with seaming star		Y ☒	N ☐
10 Can Feed Chain Tension 8 to 10 mm / 5/16 to 3/8" slag at filler end with 200 N / 45 Lbs force	<u>9mm</u>		
11 Can Feed Chain timing to Can/Lid Feed Turret 3 mm / 0.12" at the center line of star		Y ☒	N ☐
12 Discharge Turret Timing in time with seaming star		Y ☒	N ☐
13 Knock Out Pad height at all stations K.O. Pad touch lid panel at 90°	☒	Y ☒	N ☐
14 Knock Out Cam Timing 0.8 mm / 0.031"		Y ☒	N ☐
15 Pin Gauge Height Per calculation	Can size: <u>66</u> <u>57</u> <u>53</u>	☒	
	Height: <u> </u> <u> </u> <u> </u>	☒	
16 Can Plate Spring pressure Per can mfg industry standard	<u>100</u> <u>100</u> <u>100</u> <u>95</u> <u>100</u> <u>100</u>	☒ ☒	

Seamer Tool Kit



Seamer Tool Kit



Item	Part Number	Description	Qty
10	304999950047	Tool case	1
20	85035002s001	Pipe wrench	1
30	304999950046	Socket spanner Face stake	1
40	X07000754	Hook Spanner	1
50	85018140S010	SHIM, CAN INFEE STAR, 0.10 mm	6
60	85018140S020	SHIM, CAN INFEE STAR, 0.20 mm	4
70	85013113S010	Shim, Seaming Chuck, 0.10 mm	8
80	85013113S025	Shim, Seaming Chuck, 0.25 mm	4
90	85013113S040	Shim, Seaming Chuck, 0.40 mm	4
100	85013172S010	Shim, Can plate, 0.10 mm	8
110	85013172S020	Shim, Can plate, 0.20 mm	8
120	85013172S080	Shim, Can plate, 0.80 mm	4
130	85035037S051	Ball- Lid feed	1
140	85035024S001	K.O. Rodod seal assembly aid	1
150	85035025S001	Lifting station seal assembly aid	1
160	85035044S001	Lifting station seal removal aid	1
170	85035045S001	Lifting station seal removal aid	1
180	85035127S001	Wrench, knock out rod adjustment	2
190	85035042S001	Retaining clip, gassing manifold	1
200	85035107S001	Can plate, adapter Tool	1
210	85035120S001	Spacer ring	1
220	85035050S001	Plate	1
230	301132171190	Hexagon head cap screw, M6x50	2
240	85035126S001	Grease Gun High-Out-put Lever	1
250	85035124S001	Spanner	1
260	85035014s001	Assembly aid_	1
270	85035015S001	Assembly aid_	1
280	85035020S001	Assembly aid_	1
290	85035131S001	Tool_Cover seal	1
300	85035132S001	Fixing clamp_ Seaming Roll_	1
301	301132171720	Hexagon head cap screw_ Thread to head	2
310	85035133S001	Support plate_ Dial indicator_	1
311	301132172370	Hexagon head cap screw_ Thread to head	2

85035003S001

Rv

WIW

SEAMER, TOOL KIT

Lo

WIW

On Hand

0

--Current STD Costs--

Order Cust

0

Mat

446.0435

Order Purch

0

Lab

423.6343

Order Mfg

4

Out

226.2500

Order Sched

0

OH1-Va

369.0736

Order Req

0

OH2-Fix

608.3023

In QC

0

Acq

0.0000

Rejected

0

Tot

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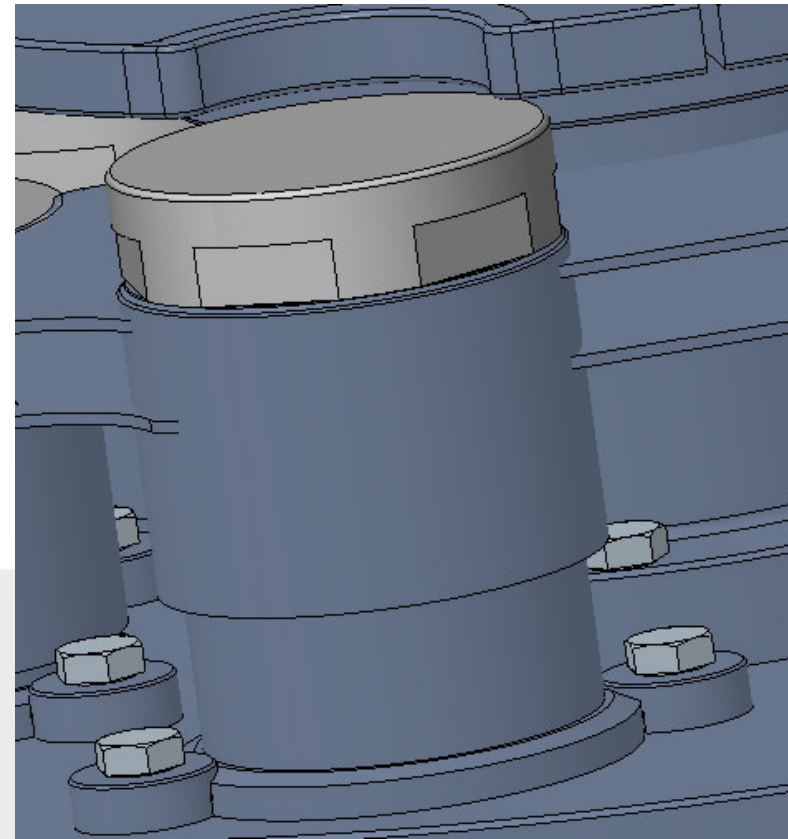
Days

0

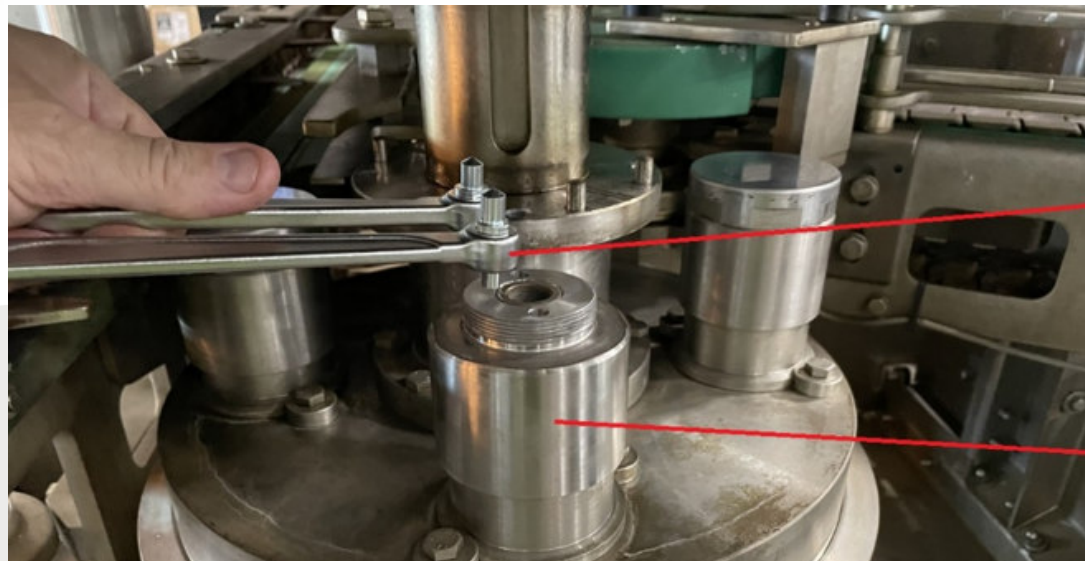
Pipe Wrenches



85035002s001



Socket Spanner Wrench



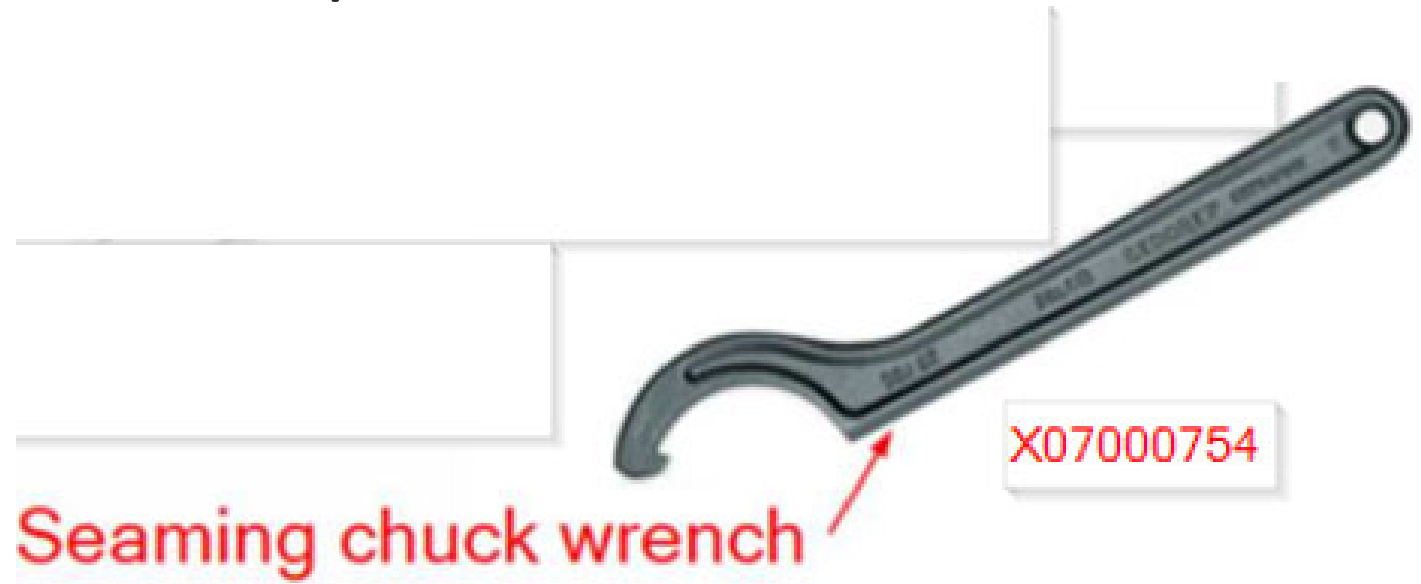
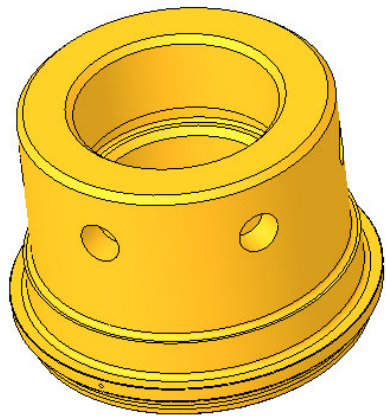
If support plate does not come off easily use this tool in the seamer tool kit.

Remember this is reverse threads so clockwise is loosening

Support plate



Hook Spanner Wrench

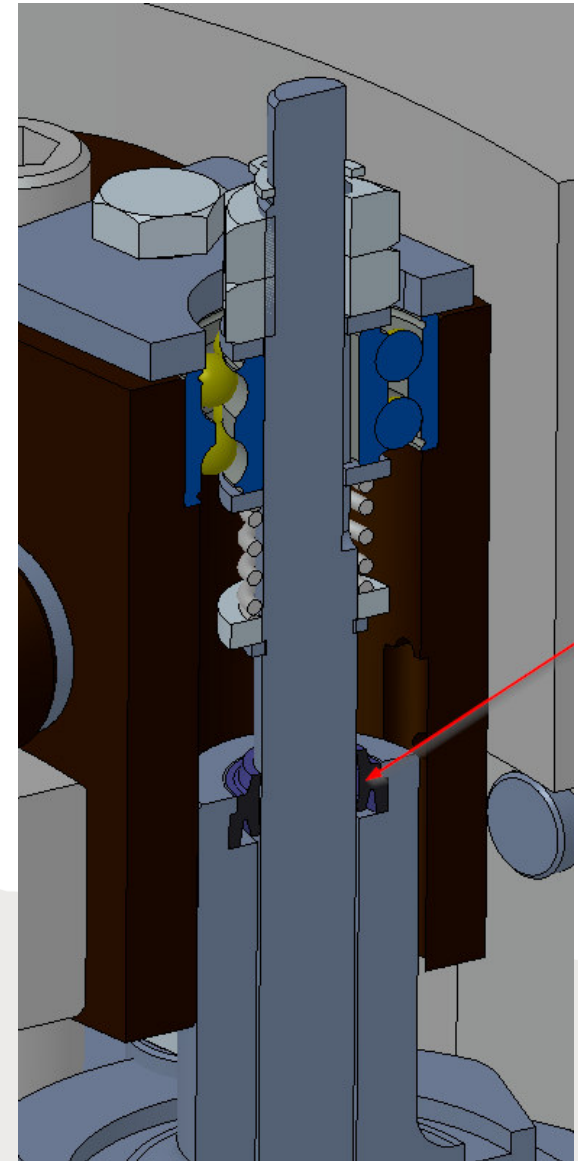
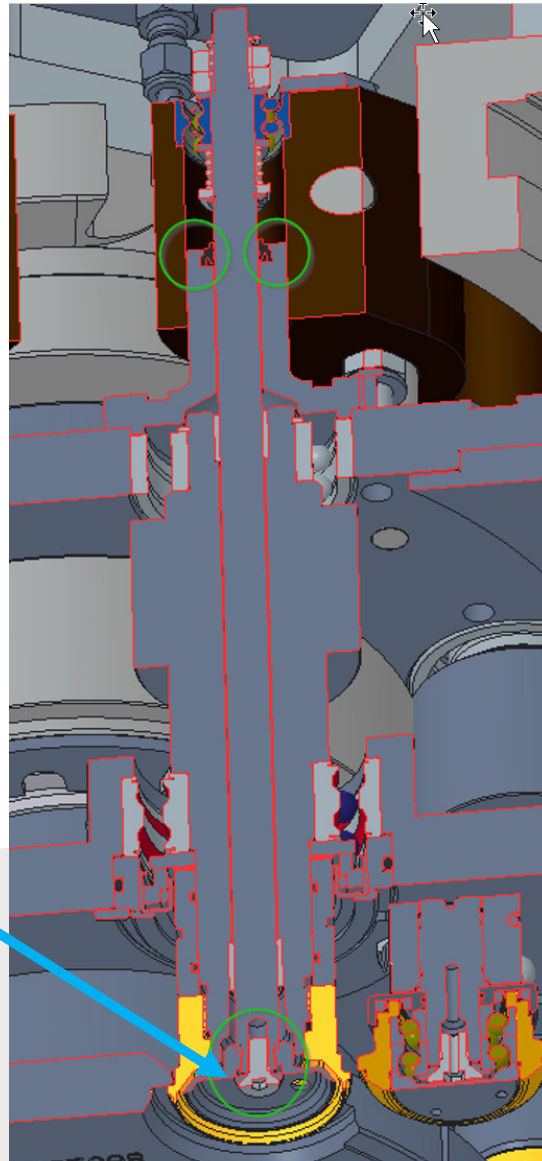


Seaming chuck wrench

X07000754

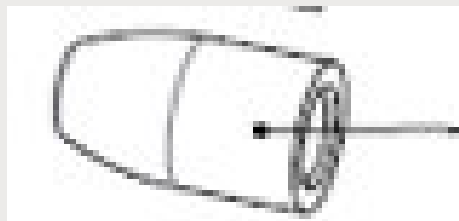
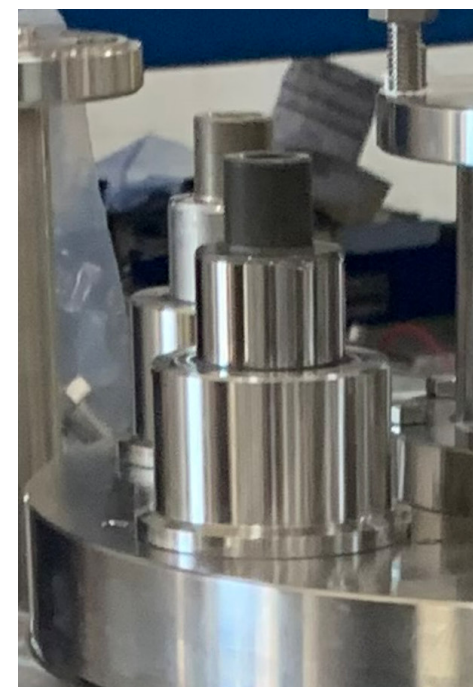
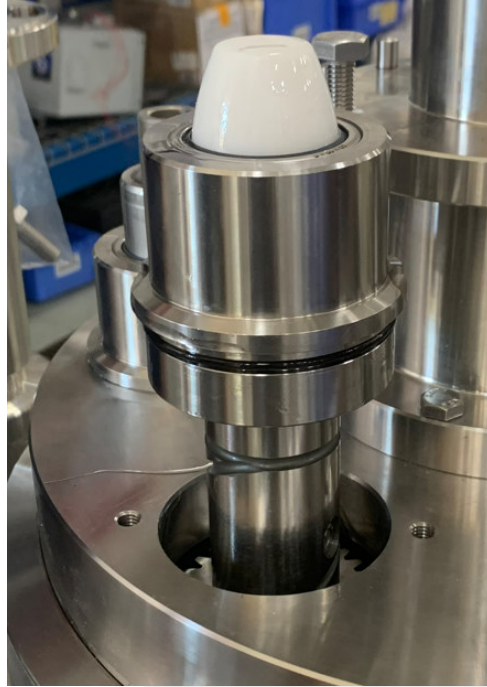
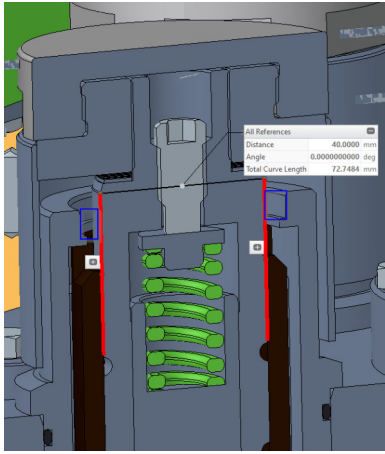
Knock Out rod seal
Assembly Aid

85035024s001
To protect damage to
seal by red arrow



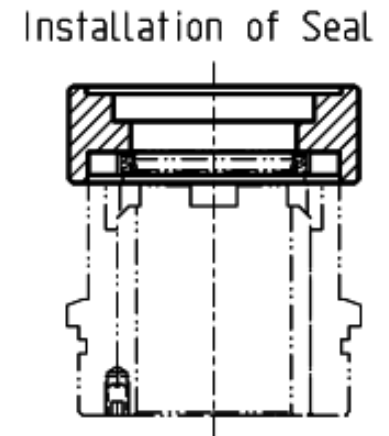
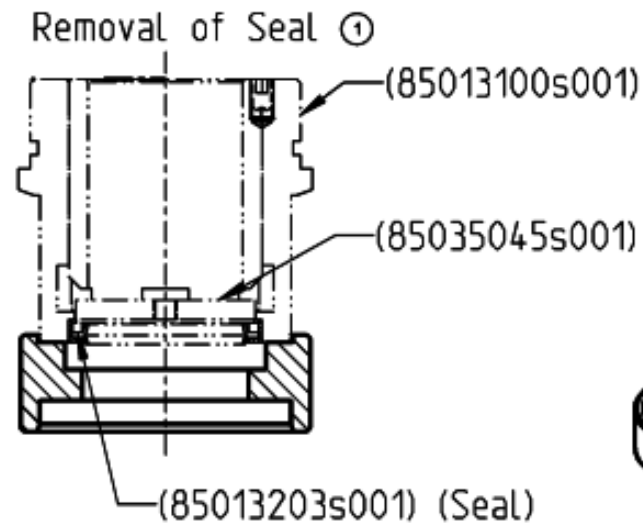
Seal

Seal Expander Lifter lip seal Assembly Aid



85035025s001

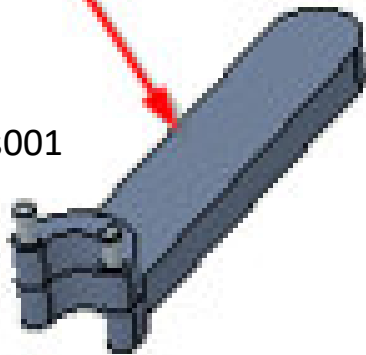
85035044s001 & 85035045s001 Install / Removal of Lower Lifter lip seal



Knock out pad Wrench & Knock out rod Hgt. Adjust Wrench

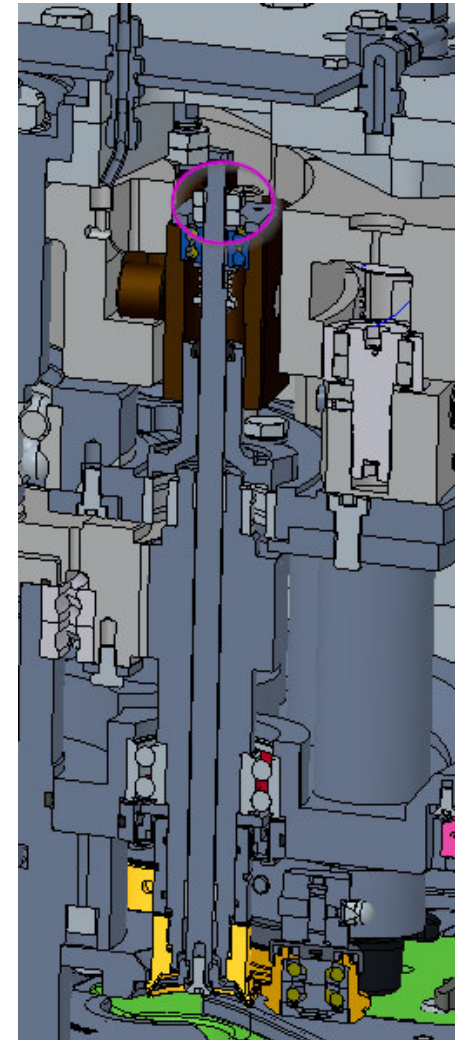
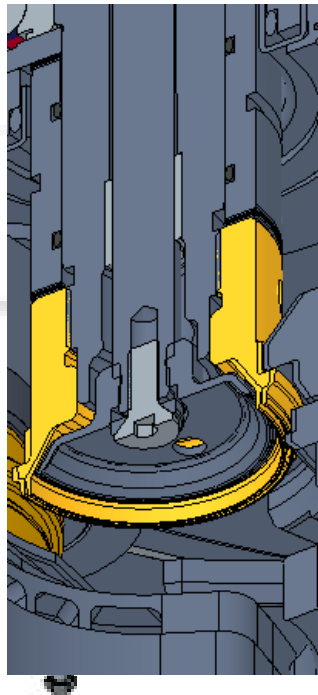
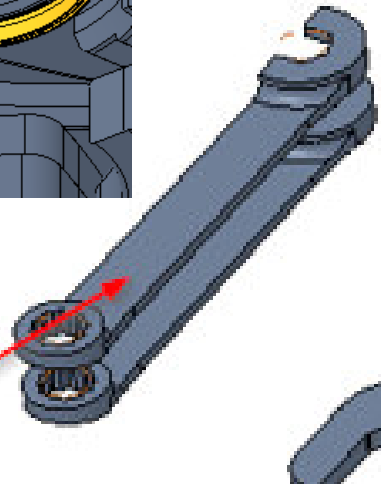
Knock out pad Wrench

85035124s001

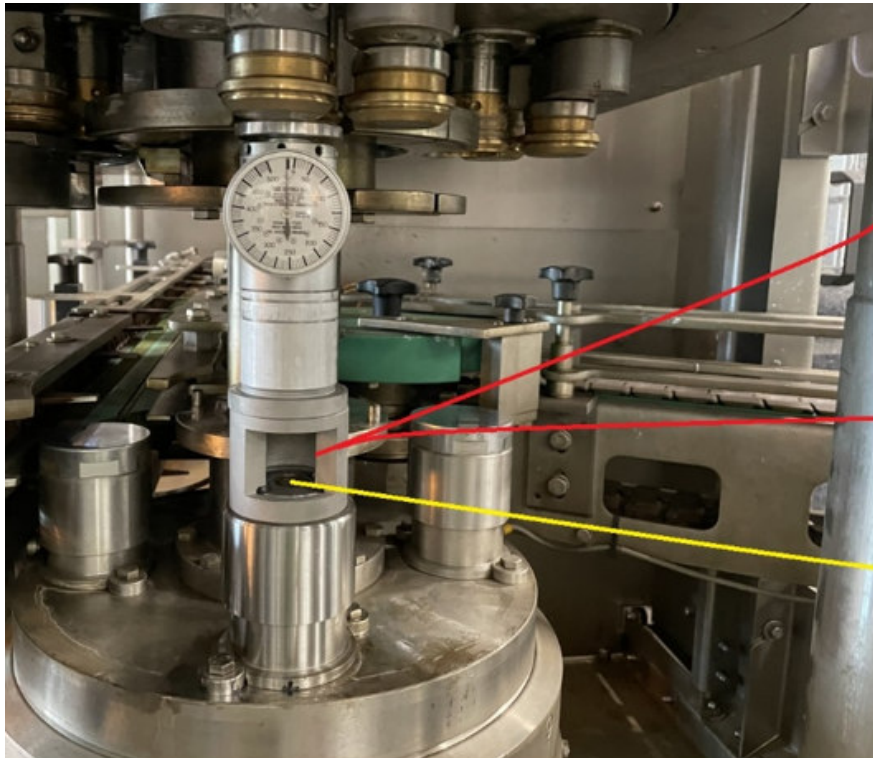
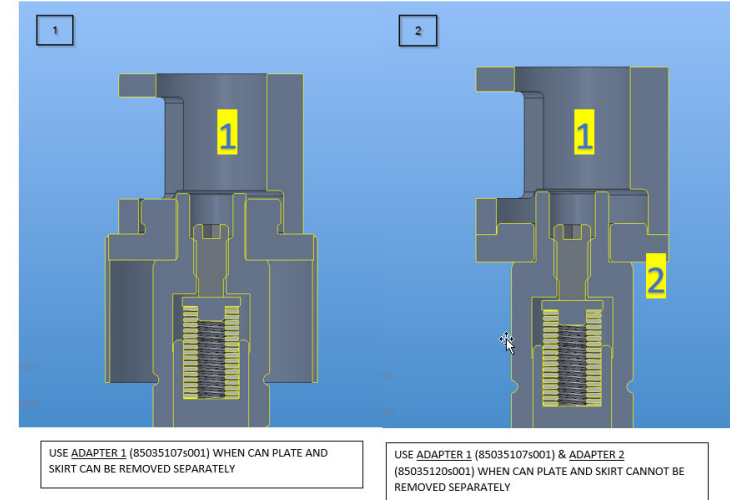


Knock rod Hgt. Adj.
Wrenches

85035127s001



Adapter & Spacer to aid Lower lifter spring force Adjustment



Adjust spring pressure

Check the last know good one or the manufactures sheet to get the correct spring pressure needed.

If you have this spacer assembly for the pressure gauge you will not need to install the can plate. If not, you will need to install the can plate, check your pressure, remove can plate and adjust then recheck your spring pressure etc and so on until you get the correct spring pressure.

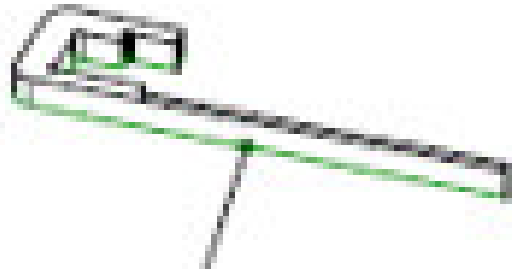
This assembly can be purchased from KHS if wanted.

With the lower piece you can get to the set screw that adjusts spring pressure. It saves a bunch of time.

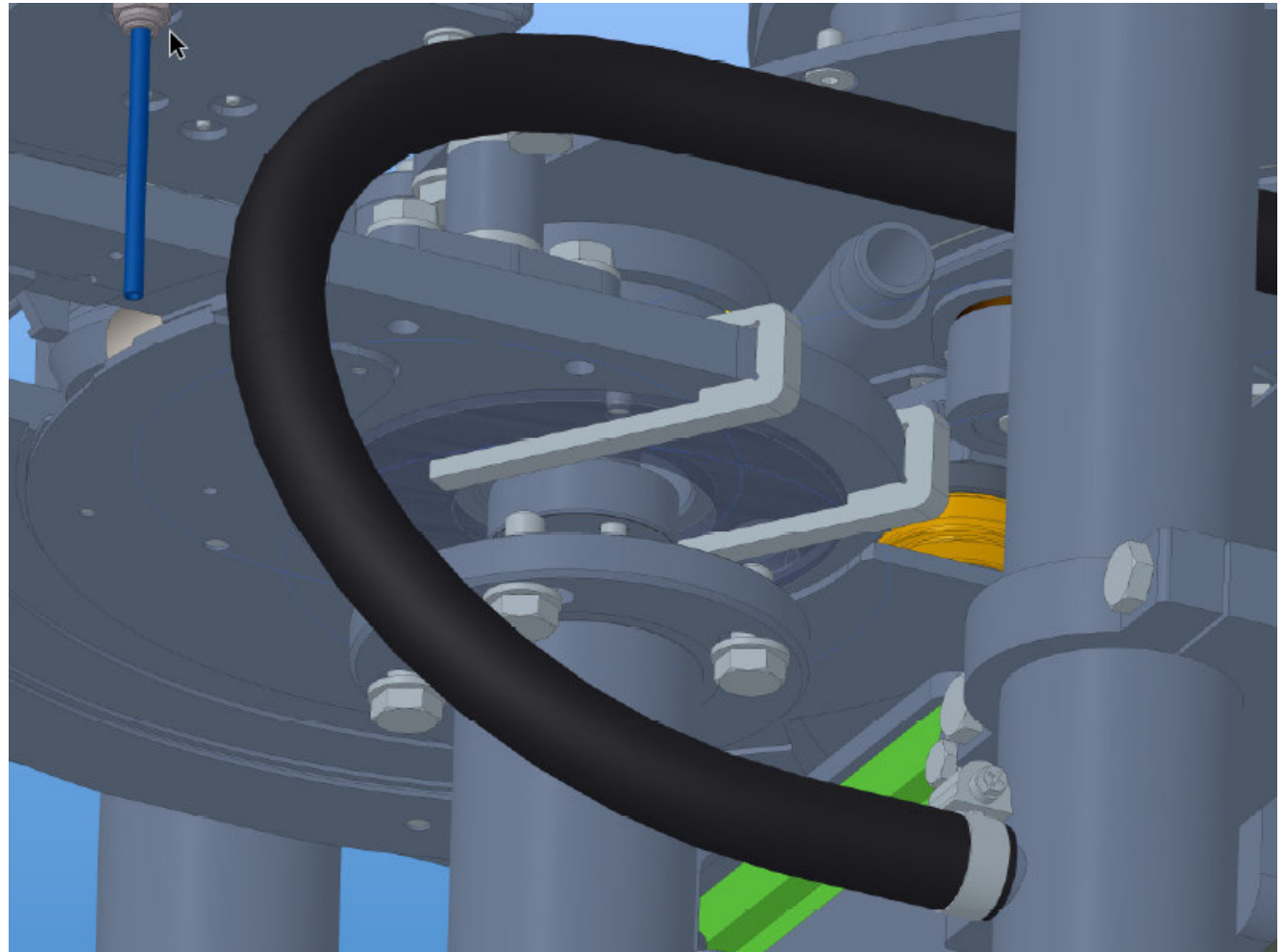
1- 85035107s001

2- 85035120s001

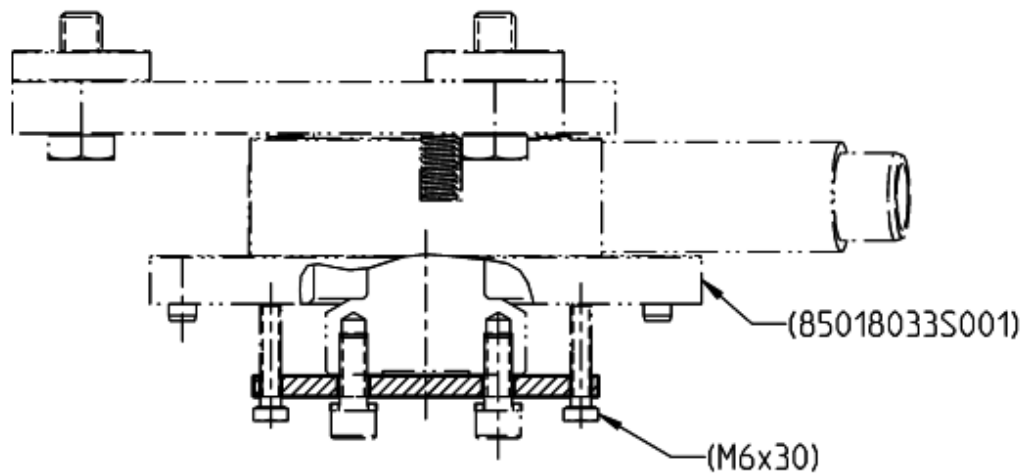
Under Cover Gassing ring clip



85035042s001



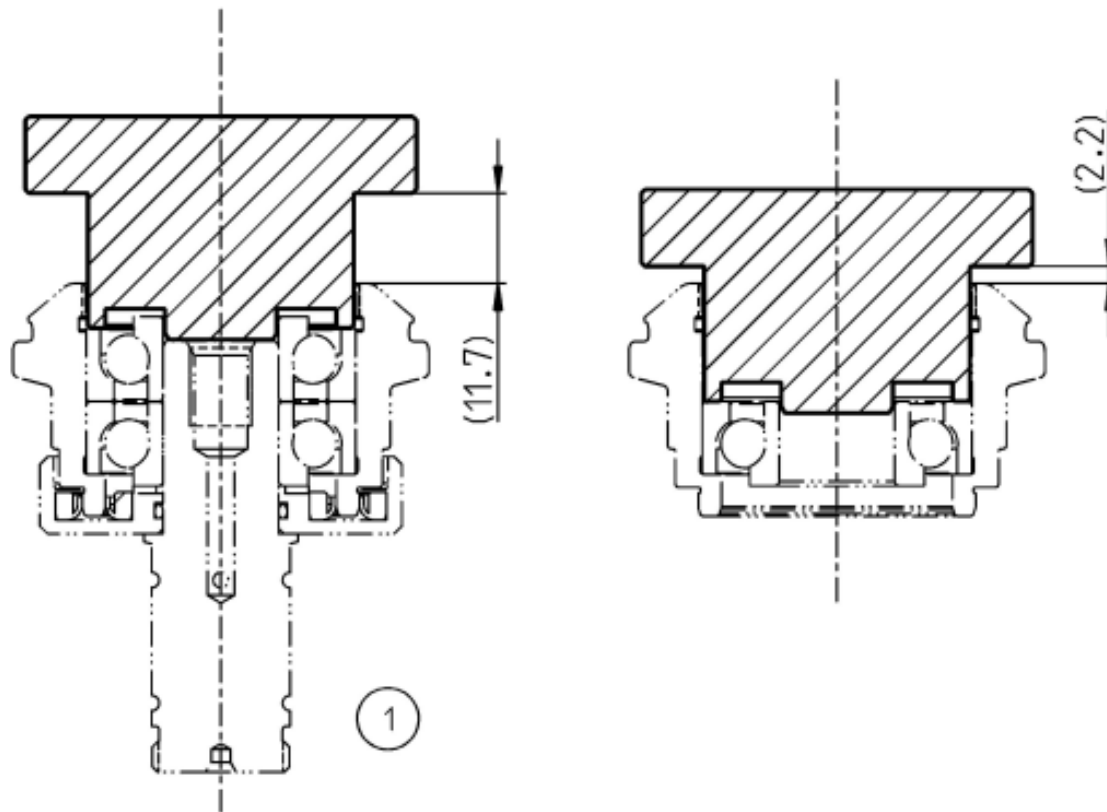
Under Cover Gassing support plate 85035050s001



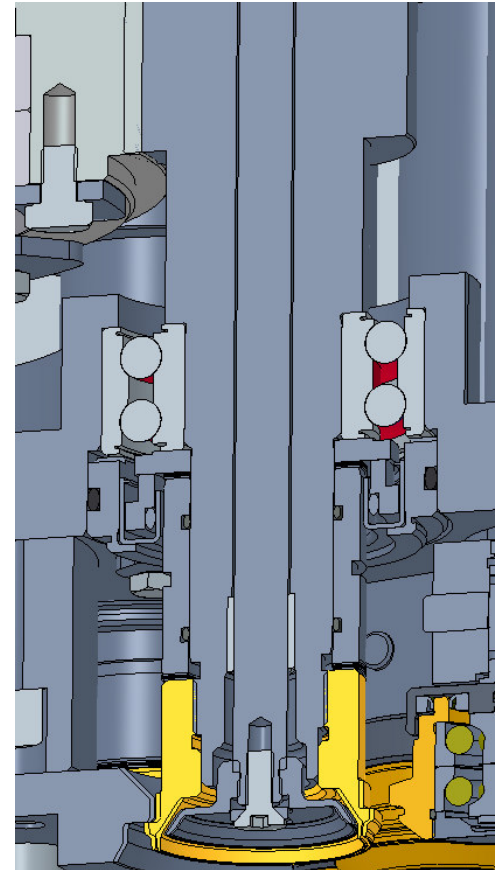
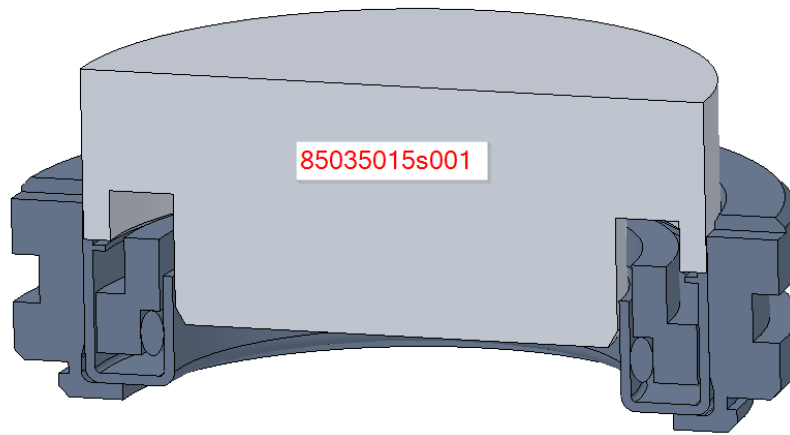
Used to support 85018033s001) during installation



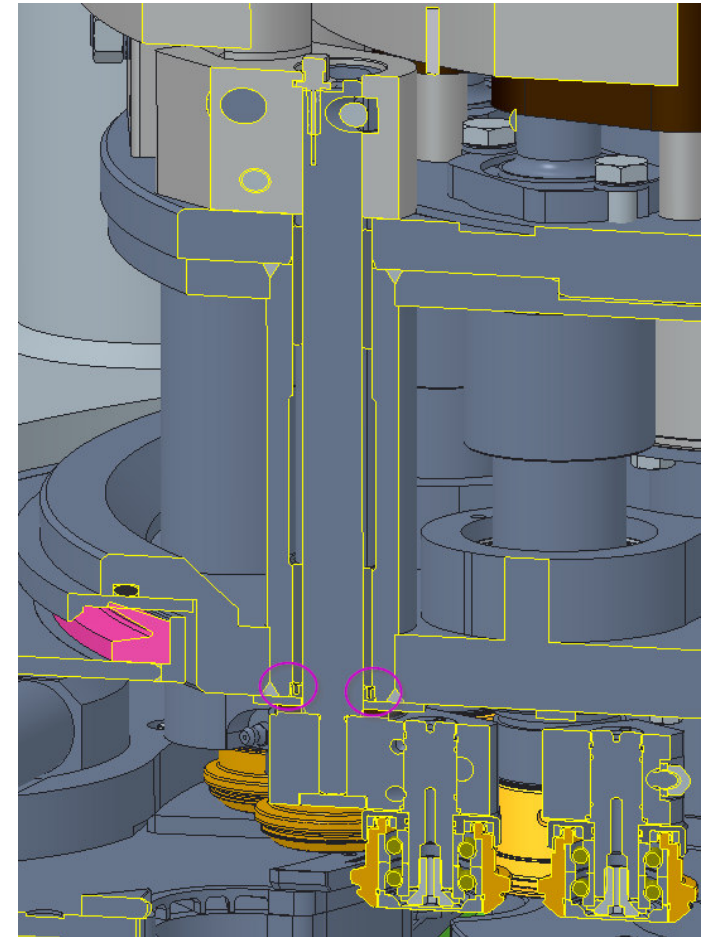
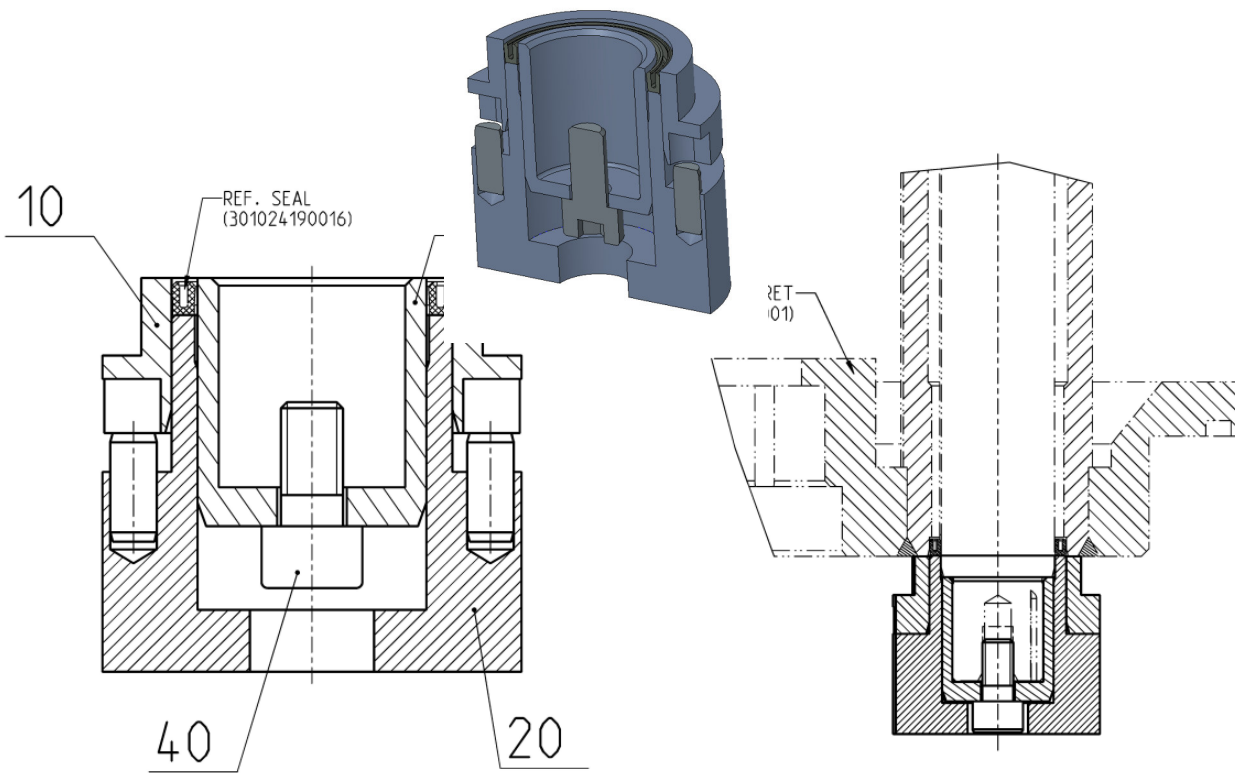
85035014S001 Assembly aid – Install bearing to seaming roll



85035015S001 Assembly aid – Installing mechanical seal into cover

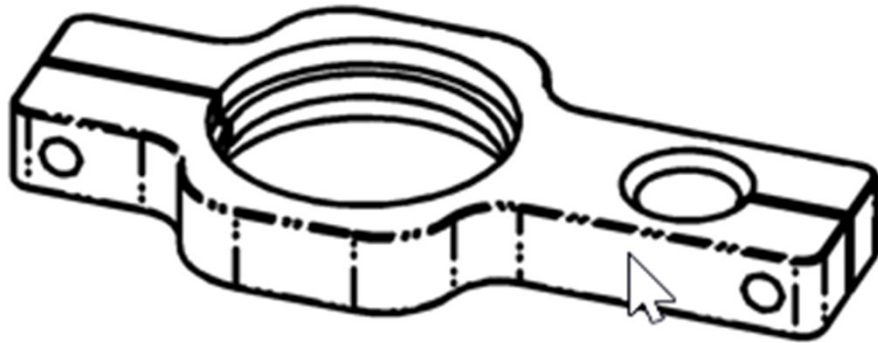


85035020S001 Assembly aid – Install lip seal to seaming turret



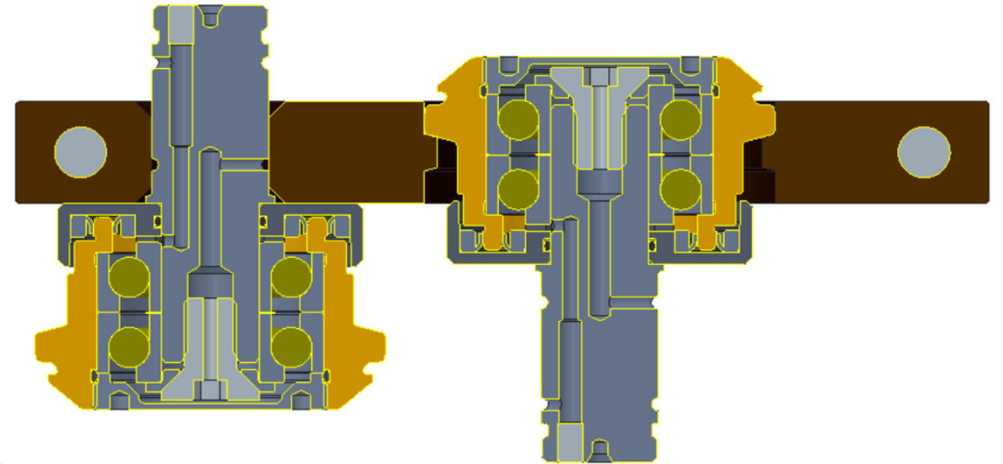
Seaming Roll Clamp

85035132s001



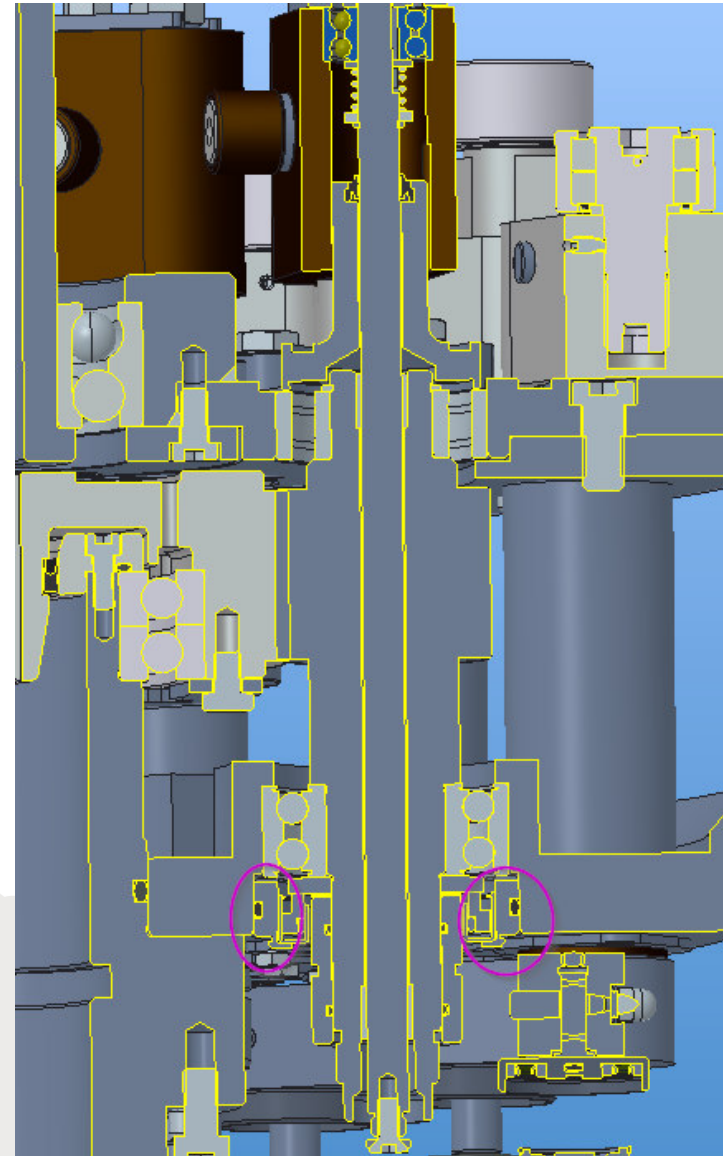
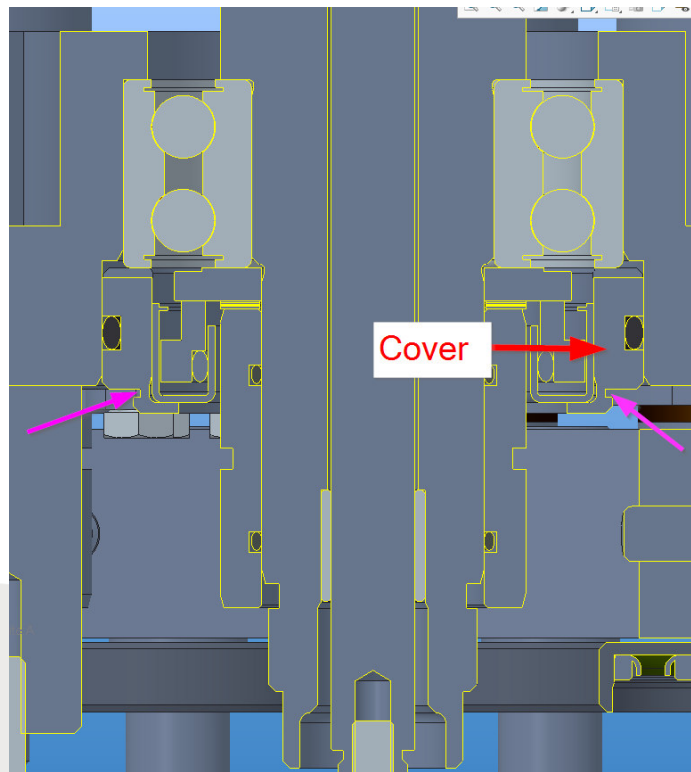
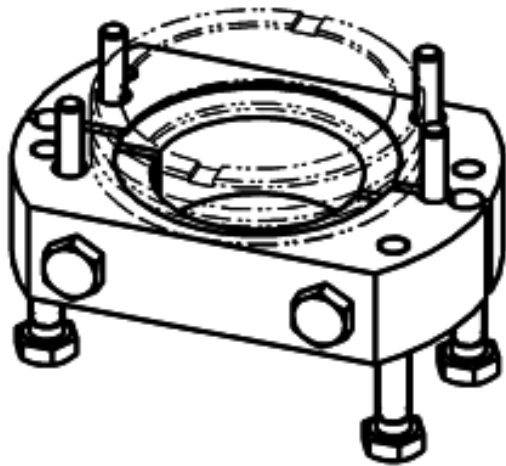
1:2

0002



Tool Cover Seal

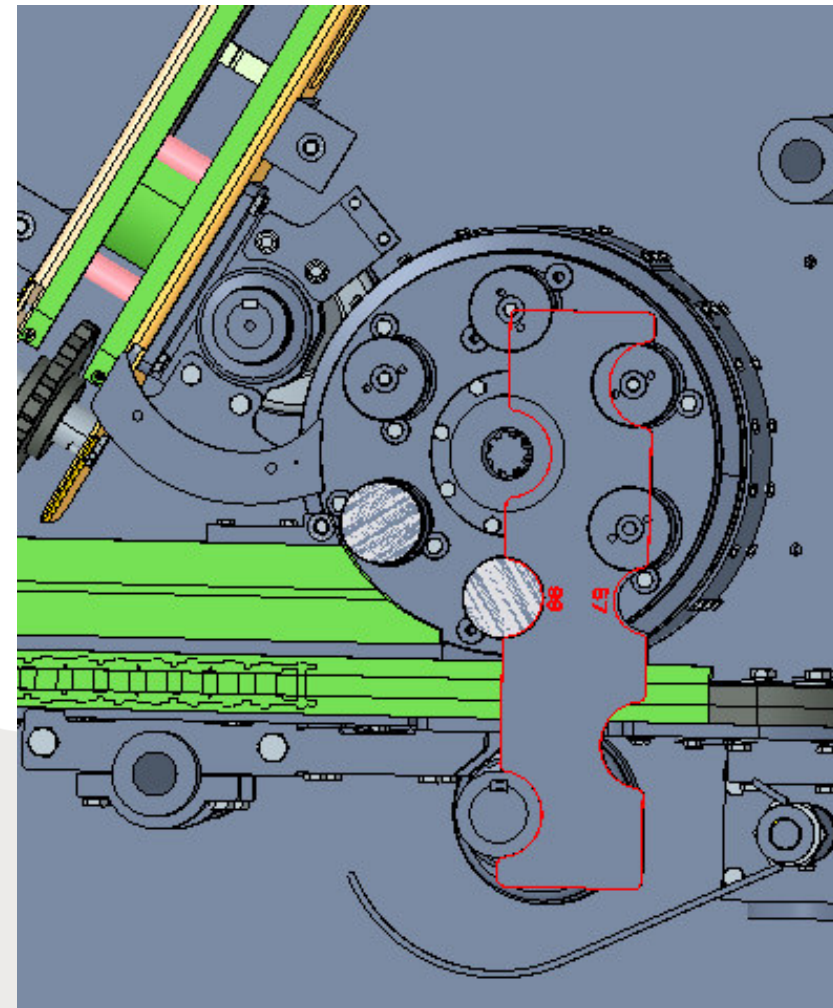
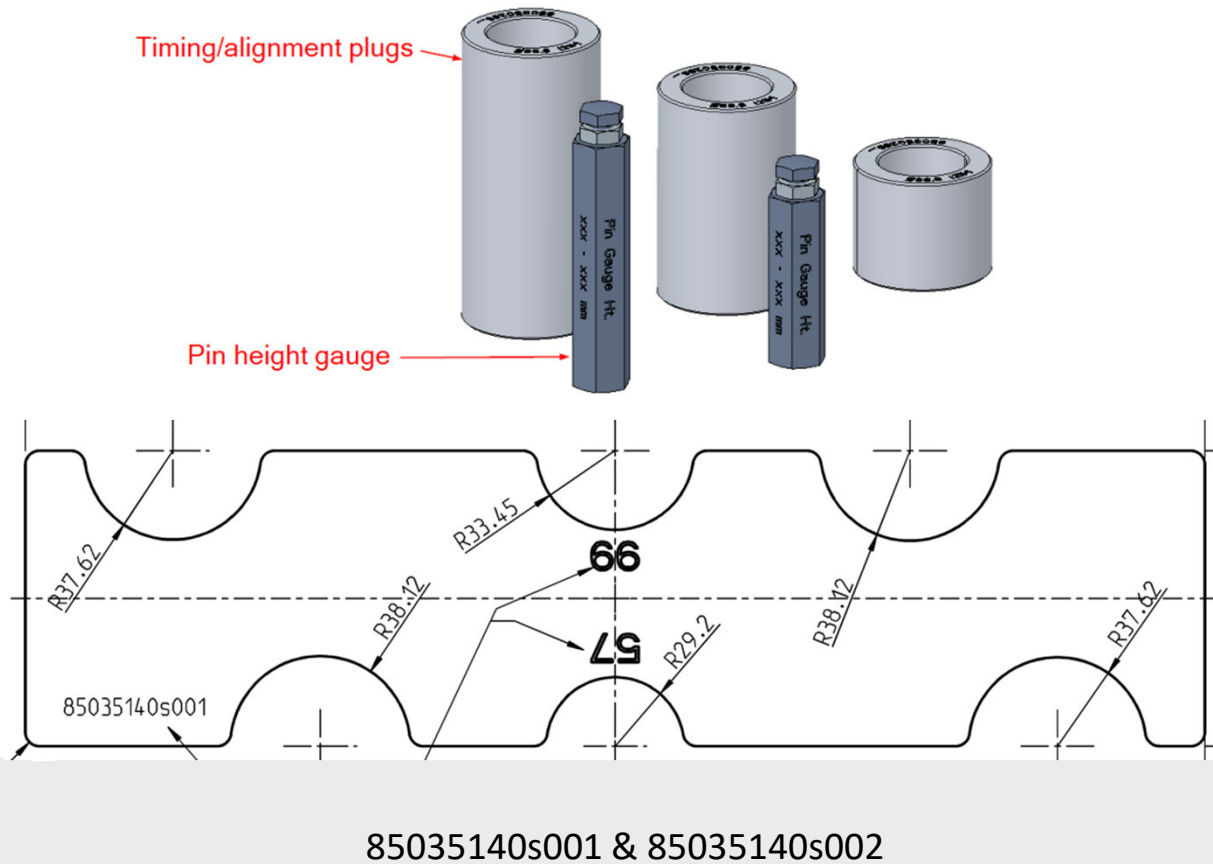
85035131s001



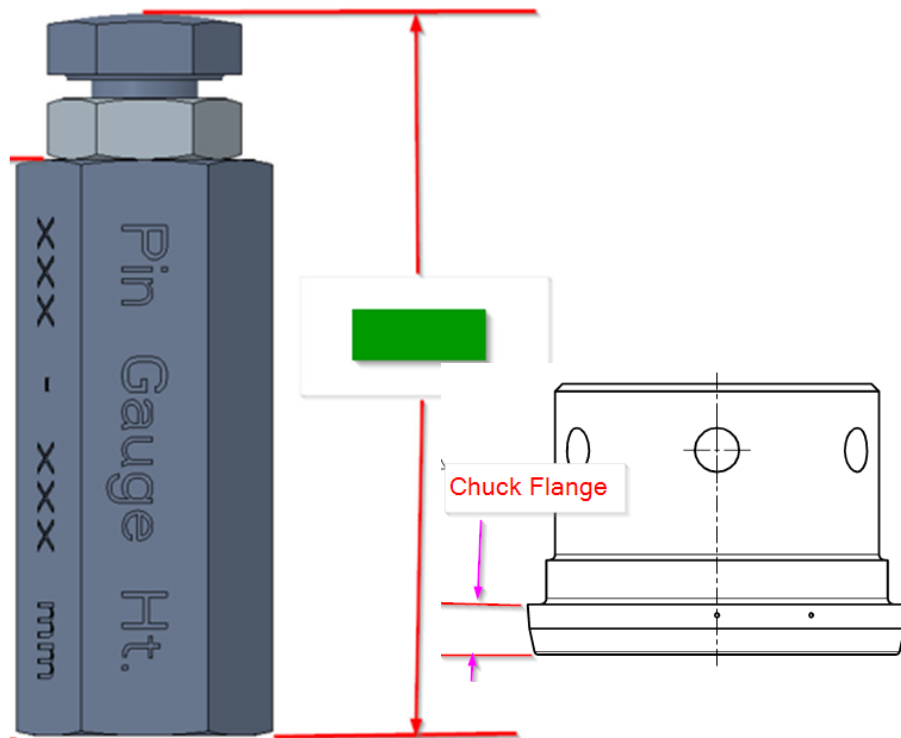
Use Dial Indicator Plate To / set up Hgt. of Seaming rolls



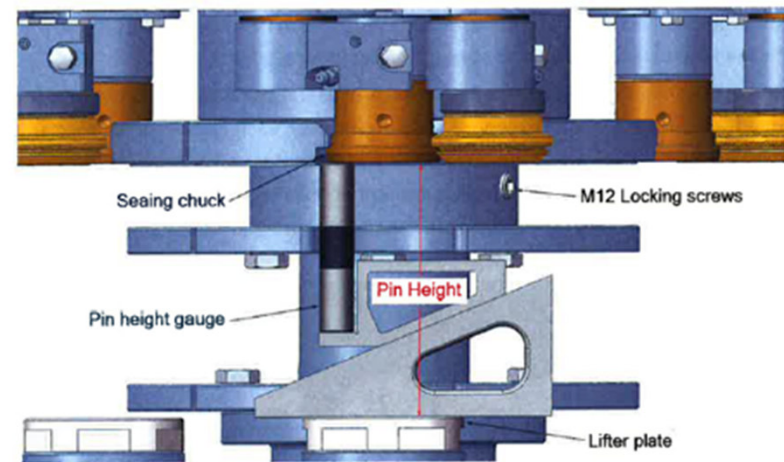
Seamer Alignment tools & Pin Hgt. Gauges



Pin Height Set-Up



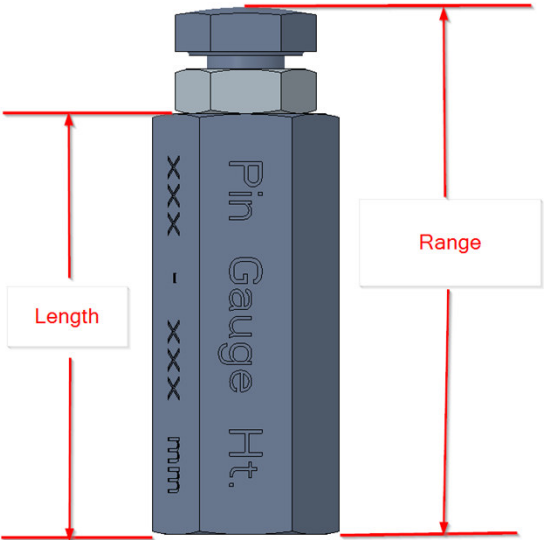
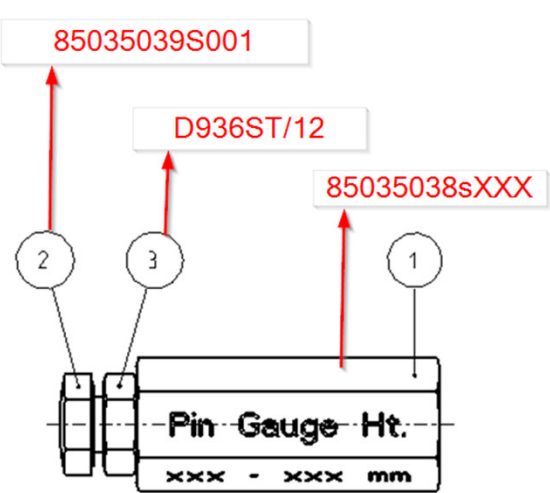
	Metric	Inch
Seaming Chuck Flange Thickness	6.86 mm	0.270"
+ Lifter Spring Deflection	+ 0.56 mm	+ 0.022"
+ Can Height Lost in Seaming	+ 0.53 mm	+ 0.021"
= Total Number	7.95 mm	0.312"
Can Height	122.23 mm	4.812"
- Total Number	- 7.95 mm	- 0.312"
= Pin Gauge Height	114.28 mm	4.500"



85035040 Pin Height Gauges

Assembly #	Range				Base Part#
	Inch		mm		
85035040S080	3.071	3.937	78	100	85035038S065
85035040S100	3.858	4.724	98	120	85035038S085
85035040S120	4.646	5.512	118	140	85035038S105
85035040S140	5.433	6.299	138	160	85035038S125
85035040S160	6.220	7.087	158	180	85035038S145
85035040S180	7.008	7.874	178	200	85035038S165
85035040S200	7.795	8.661	198	220	85035038S185

Length	
Inch	mm
2.559	65
3.346	85
4.134	105
4.921	125
5.709	145
6.496	165
7.283	185

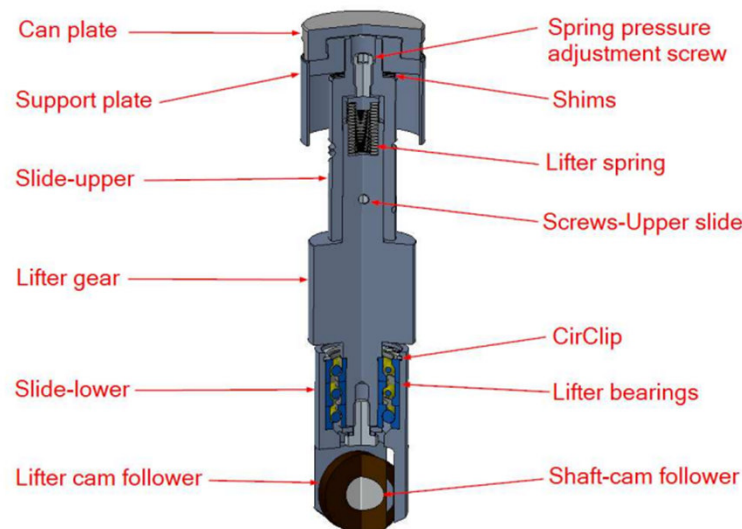


Level Can Plates



The Can Plates elevation is adjustable by adding or subtracting shims under the Support Plate to raise or lower the Can Plates elevation to achieve the level of all can plates within ± 0.025 mm (± 0.001 ").

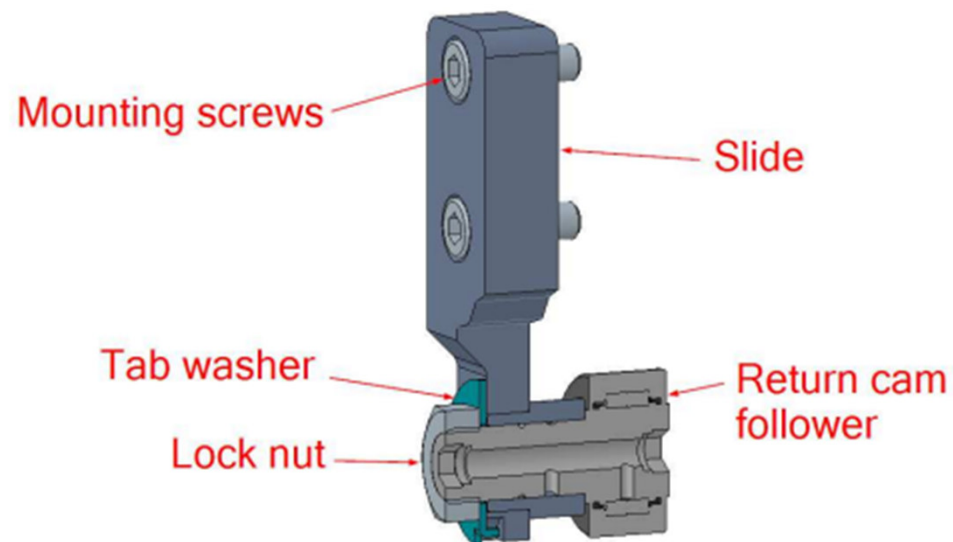
This adjustment must be completed before setting the drop-off, 0.25 mm or 0.010" from the seamer infeed conveyor.



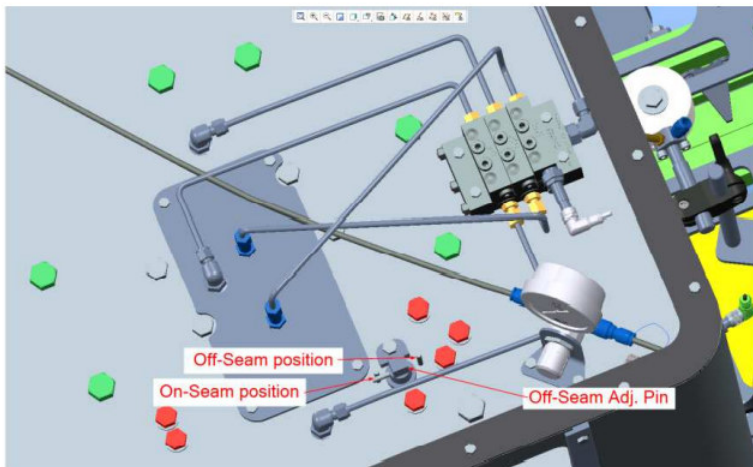
Return Cam Followers



Each Return Cam Follower assembly must be individually adjusted to provide 0.1 to 0.15 mm (0.004 to 0.006") running clearance between the Roller Lifter Cam and Lifting/Returning Cams.

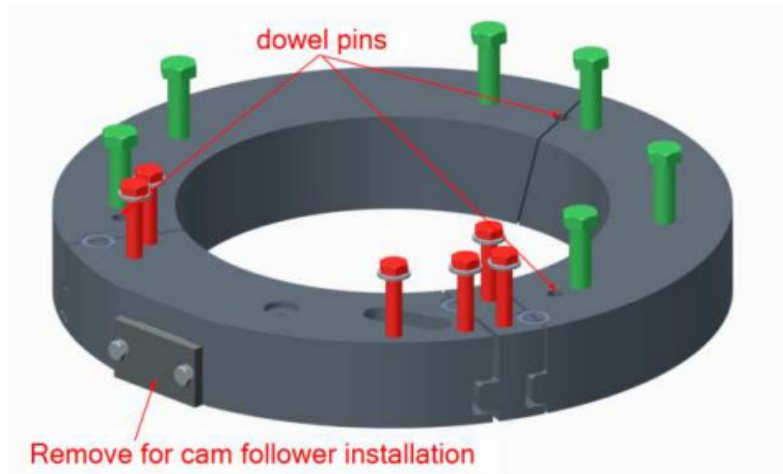


Seaming Cam 1st Operation Seam test

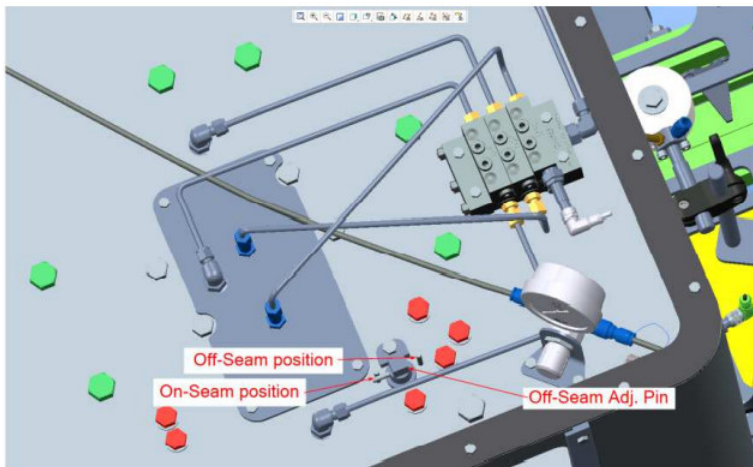


To perform a 1st operation seam test, the seamer needs to be set to 2nd operation Off-Seam mode (Off-Seam in short).

1. Loosen 6 bolts in red color
2. Rotate the Off-Seam adjustment pin half turn counterclockwise
3. Re-fasten 6 bolts.
4. Run the machine in the jog speed only to perform the Off-Seam test.
5. Reset back to On-Seam setting after the test before running the seamer in normal speed.



Seaming Cam 1st Operation Seam test



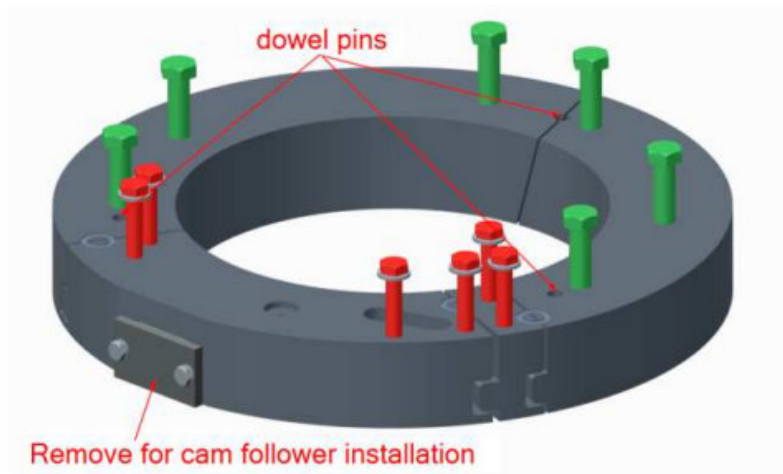
From Nick Brunette / Bill Good: The offseam does not work properly

2nd op. Rolls are normally set at 0.010-0.012" [.25-.3 mm] from chuck & 1st op. are normally set at 0.021" – 0.022" [0.53-.55 mm] from chuck

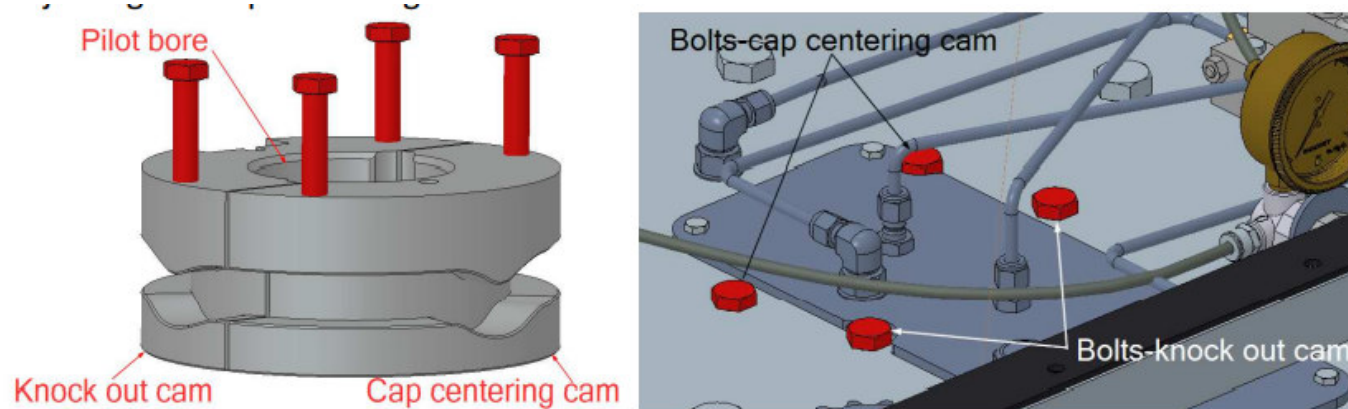
Note: CDL+ & CDL-W 2nd op. are normally set at 0.013" [0.33 mm] (might work)

Problem:

If 2nd op is set 0.012 " [0.25 mm] or less, there are contact on the 1st operation seam check. Resulting in inaccurate 1st op seam check



Knockout/Cap Centering Cam Adjustment



In order to remove or install the K.O. Cam, the seaming Cam must be removed.

Rotate the cam counterclockwise to advance the Knockout Pads movement and rotate the cam clockwise to delay the movement.

Adjust the K.O. Cam radially until there is about 0.8 mm (0.031") clearance between cover and Knockout Pad at discharge

Height Adjustment of Knockout Rods should be made before adjusting the Cap Centering and Knockout Cam.

Seaming Chucks Set-Up



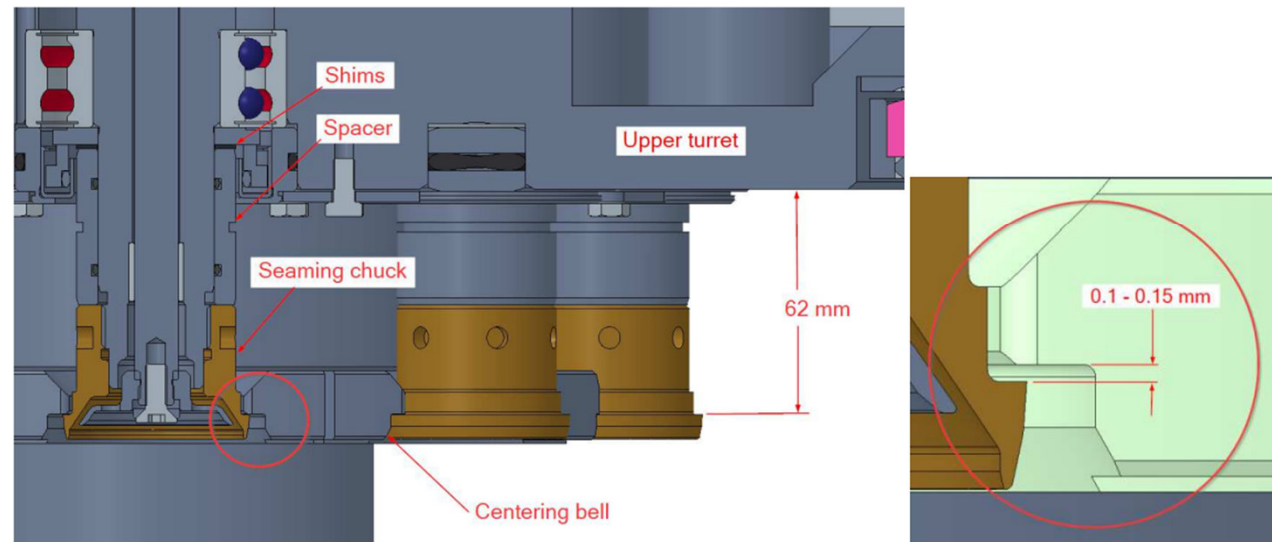
All seaming chucks must be planed within 0.05 mm (0.002") height relative to each other. Adjust the number of the shims to achieve this consistent Seaming Chuck elevation.

Chuck flange also needs to be set at 0.1 to 0.15 mm (0.004-0.006") below the Centering Ring

The total amount of shim thickness should be around **1.68 mm or 0.066"**. The number of shims is determined by the accumulated machining tolerance of all components

Do not install shims between the Seaming Spindle Spacer and the Seaming Chuck.

Turret and the flange of Seaming Chucks should be 62 ± 0.1 mm when chucks are properly shimmed.



Seaming Lever Shaft axial Clearance & Seam Thickness Adjustments



The Running Clearance Adjustment Screw sets the Seaming Lever to the correct axial clearance that allows the Seaming Lever Shaft to turn freely without excessive axial end play.

The seam thickness could be adjusted by loosening the Clamping screw, then turning two Seam Thickness Adjustment Screws in opposite direction evenly.

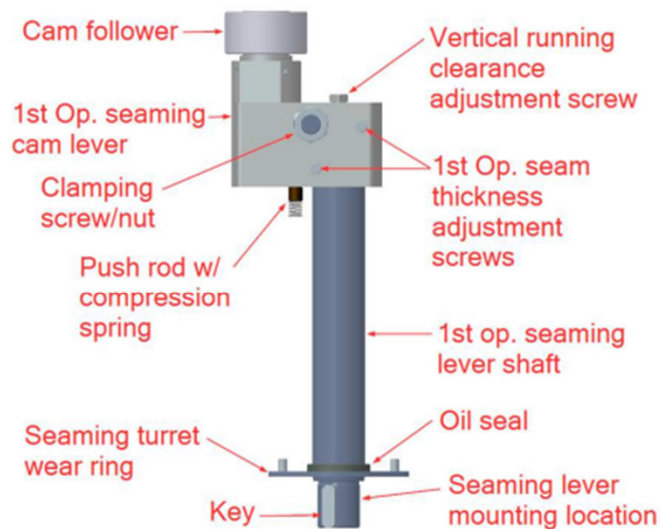


Figure 5-24: 1st Op seaming lever shaft



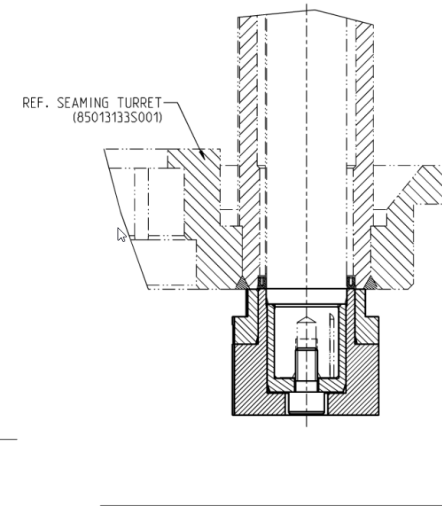
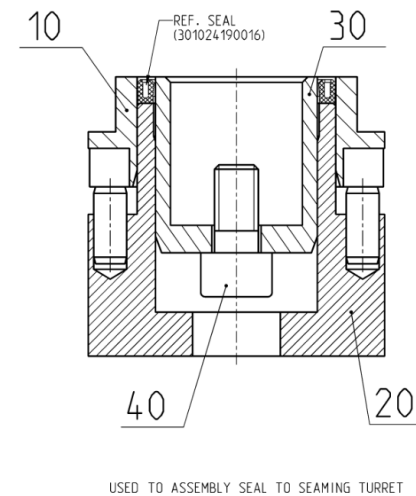
Figure 5-25: 2nd Op seaming lever shaft

Seaming Lever Shaft axial Clearance & Seam Thickness Adjustments Needs to be rework



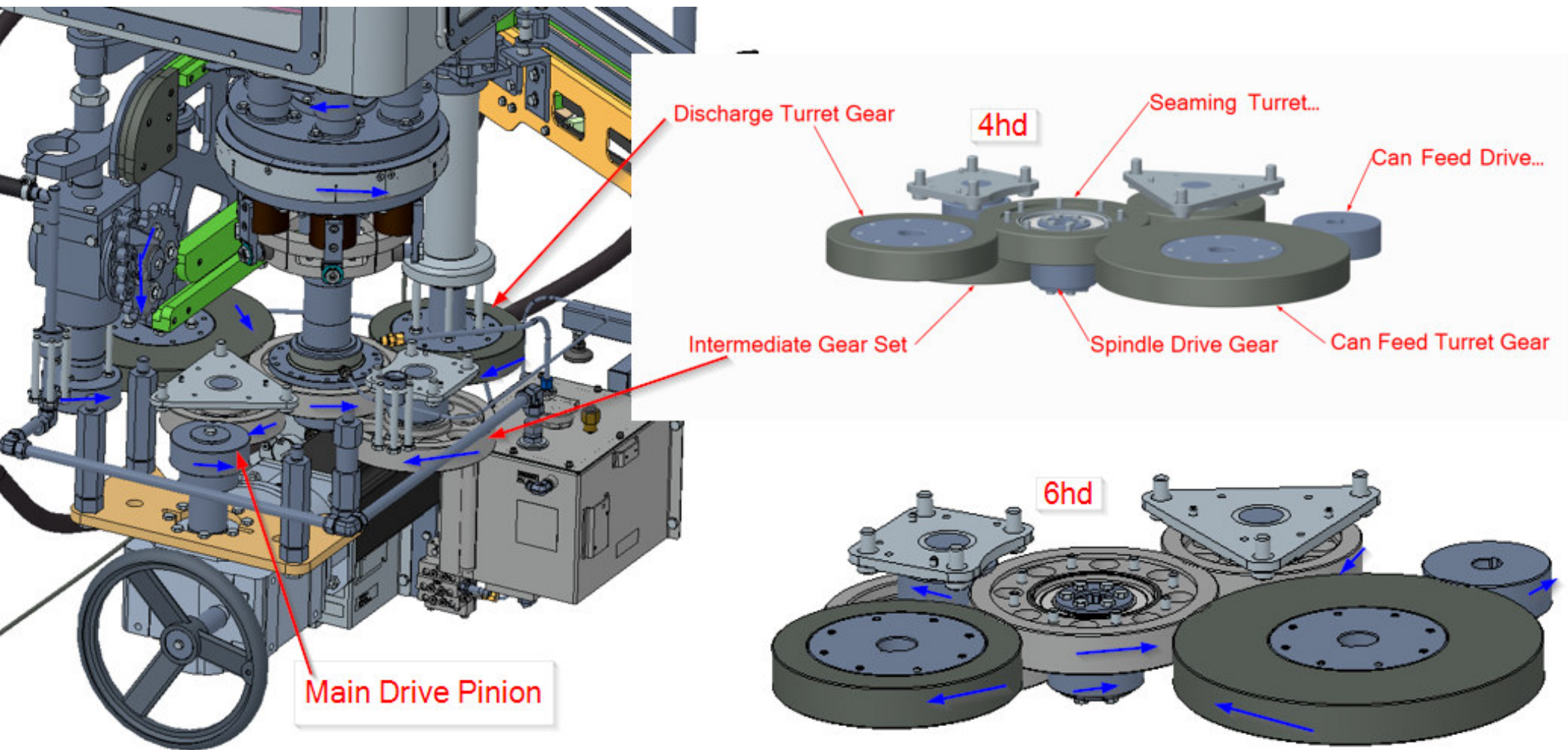
Tools Required

- 1) 4 mm hex keys
- 2) 8 mm open wrench
- 3) 19 mm twelve-point box wrench
- 4) Feeler gauge
- 5) Indicator (0.02 mm/0.001")
- 6) Loctite® 243, anti-seize.,
- 7) 85035020S001 Seal installation tool kit
(Contains 85035021S001, 85035022S001, and 85035106S001)



Setting up Gear Train Backlash

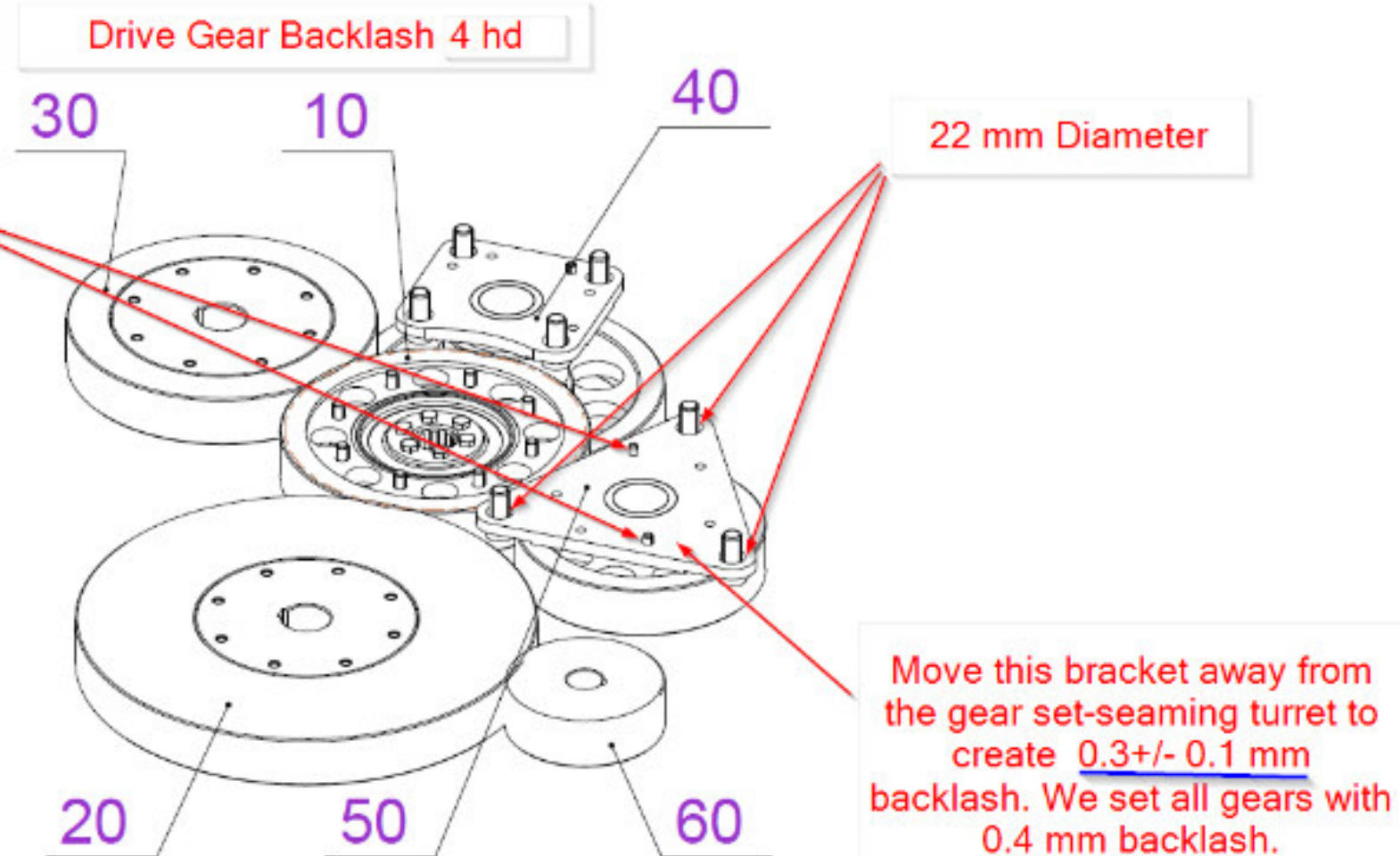
ferrum



Setting up Gear Train Backlash



These two pins were not installed. Bracket should be able to move outward once (3) M16 bolts are loosen. The clearance holes for M16 bolts are 22 mm diameter. So you should be able to only adjust the #50 idler to create 0.3 ± 0.1 mm backlash between Main drive pinion #50 idler and #10 gear without moving the main drive.



Drive Gear Backlash 6 hd

30 10 40

20 50 60

This diagram shows an exploded view of a gearbox assembly. The components are numbered as follows: 30 (top cover), 10 (input shaft), 40 (output shaft), 20 (bottom cover), 50 (output gear), and 60 (input gear). Red arrows indicate the assembly sequence and alignment of the parts.

22 mm Diameter

Move this bracket away from the gear set-seaming turret to create 0.2 mm backlash. We set all gears with 0.2 mm backlash.

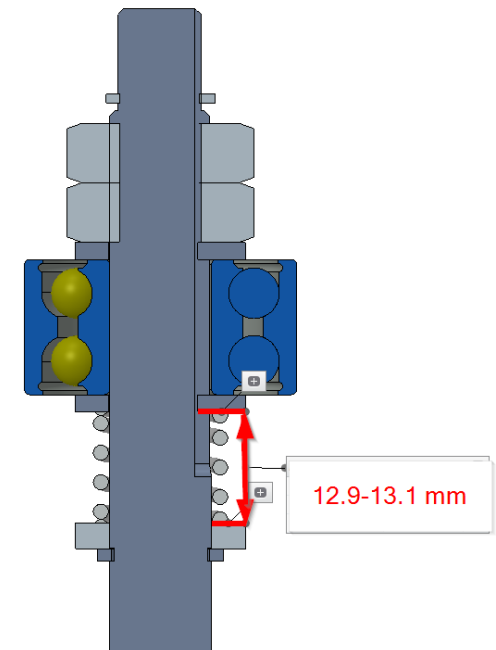
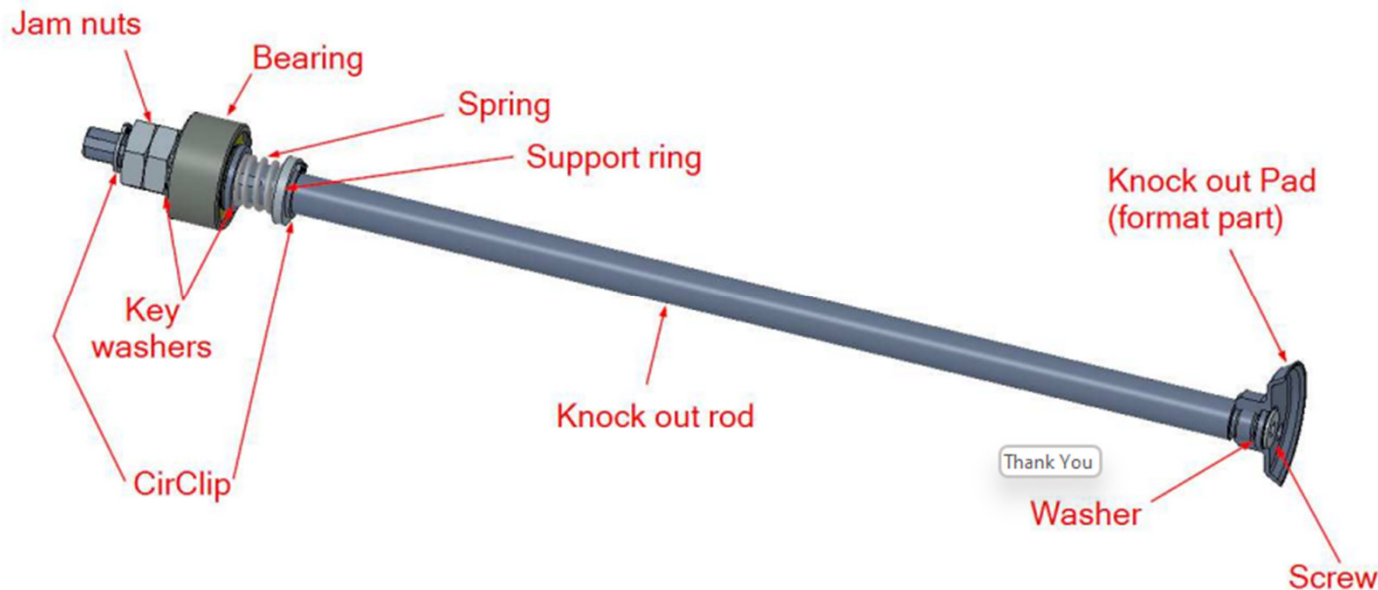
Knock Out Pad Height Adjustment



The Knockout Pad height is adjusted by turning two jam nuts at the top of the rod.
(Between lower key washer and top support ring) 12.9-13.1 mm – gives correct travel of knock out pad

Height Adjustment of Knockout Rods should be made before adjusting the Cap Centering and Knockout Cam.

Adjust the K.O. Cam radially until there is about 0.8 mm (0.031") clearance between cover and Knockout Pad at discharge



Setting Internal Positive Pressure



The control pressure should be set at **1 kPa or 4"** of H₂O initially. Do not exceed 1.2 kPa or 5" of H₂O maximum at the pressure regulator for any reason. (Excessive pressure can cause oil leak or possible seal damage)

This pressure must remain on all the time when the seamer is in the normal operation, wash down, CIP, or even when the seamer is completely shut down with power off.



Figure 5-41: Seamer internal positive pressure control

Under cover Gassing Pressure



The initial pressure should be set at 2.5 kPa. Adjust the pressure up or down to optimize the TPO and CO₂ consumption. See Filler Service Module manual for more details.

Bubble Breaker Pressure

The Bubble Breaker Control is integrated into the Filler Service Module. It is also integrating the wash-in-place function. The initial pressure should be set at 180 kPa. Adjust the pressure up or down to optimize the TPO and CO₂ consumption.

Seaming roll lubrication



The re-lube window is 72 hours of operation or after washing down, whichever occurred first. One shot of suggested lubricant by using the standard duty manual grease gun for each seaming roll.

Apply grease gently manual grease gun with NLGI 00 or 0 food grade grease to lubricate the Seaming Rolls at the grease fitting on the Seaming Lever. (Cassida grease)

Clean up the excessive grease and the used grease discharged from relief port. Rotate the seaming roll by hand after charging the grease to distribute grease evenly and verify the seaming roll is not locked by over pressured grease. I

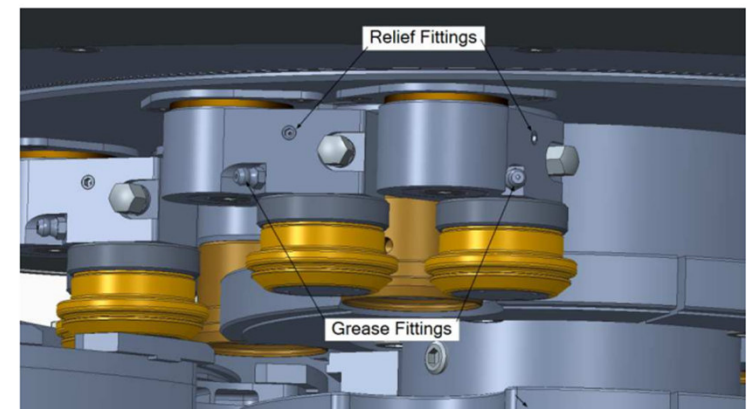
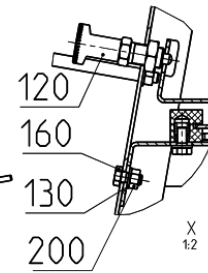
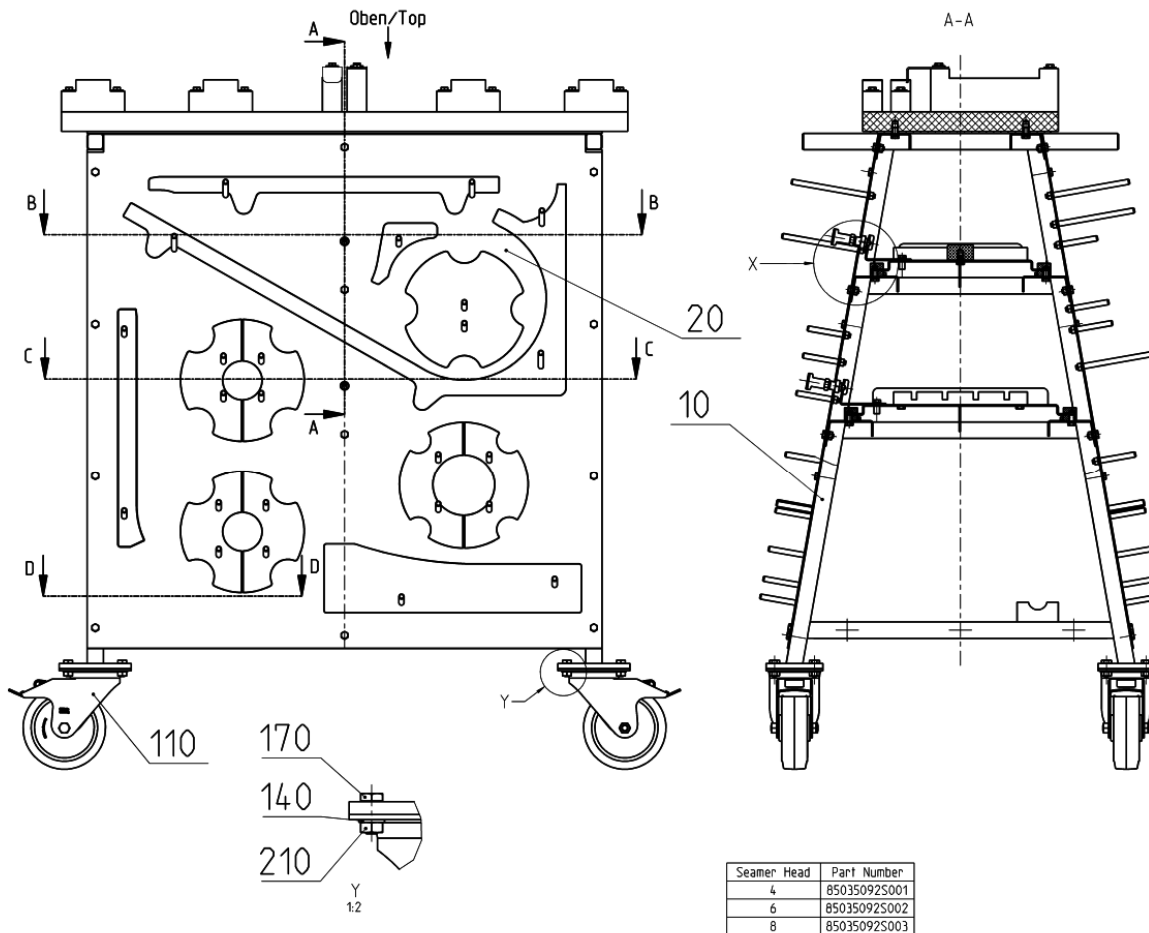


Figure 5-48: Seaming roll lubrication

Service Format Parts Cart



85035092S002 Rv

WIW

SERVICE CART, FORMAT PARTS Lo WIW

1	On Hand	0	--Current STD Costs--
P	Order Cust	0	Mat 12,911.0000
140	Order Purch	0	Lab 0.0000
70	Order Mfg	0	Out 0.0000
602	Order Sched	0	OH1-Va 131.6900
PCE	Order Req	0	OH2-Fix 47.7700
0	In QC	0	Acq 0.0000
0	Rejected	0	Tot 13,090.4600
1/8/2020 3:29:15 F	Scrapped	0	--Current LVL Costs--
1/10/2020 3:29:15	Allocated	0	Mat 12,911.0000
0	Reserved	0	Lab 0.0000
0	Backordered	0	Out 0.0000
1600	Planned	0	OH1-Va 131.6900
85	Short	0	OH2-Fix 47.7700
OUT	Avail Issue	0	Acq 0.0000
W-CPSMF	Avail Plan	0	Tot 13,090.4600
3/23/2022 3:41:47	LY Service	0	Sale Price 20787.66
N Not Frozen			

Thank You