



OPERATOR'S MANUAL
MODEL 225F
CAN SEALER



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INTRODUCTION

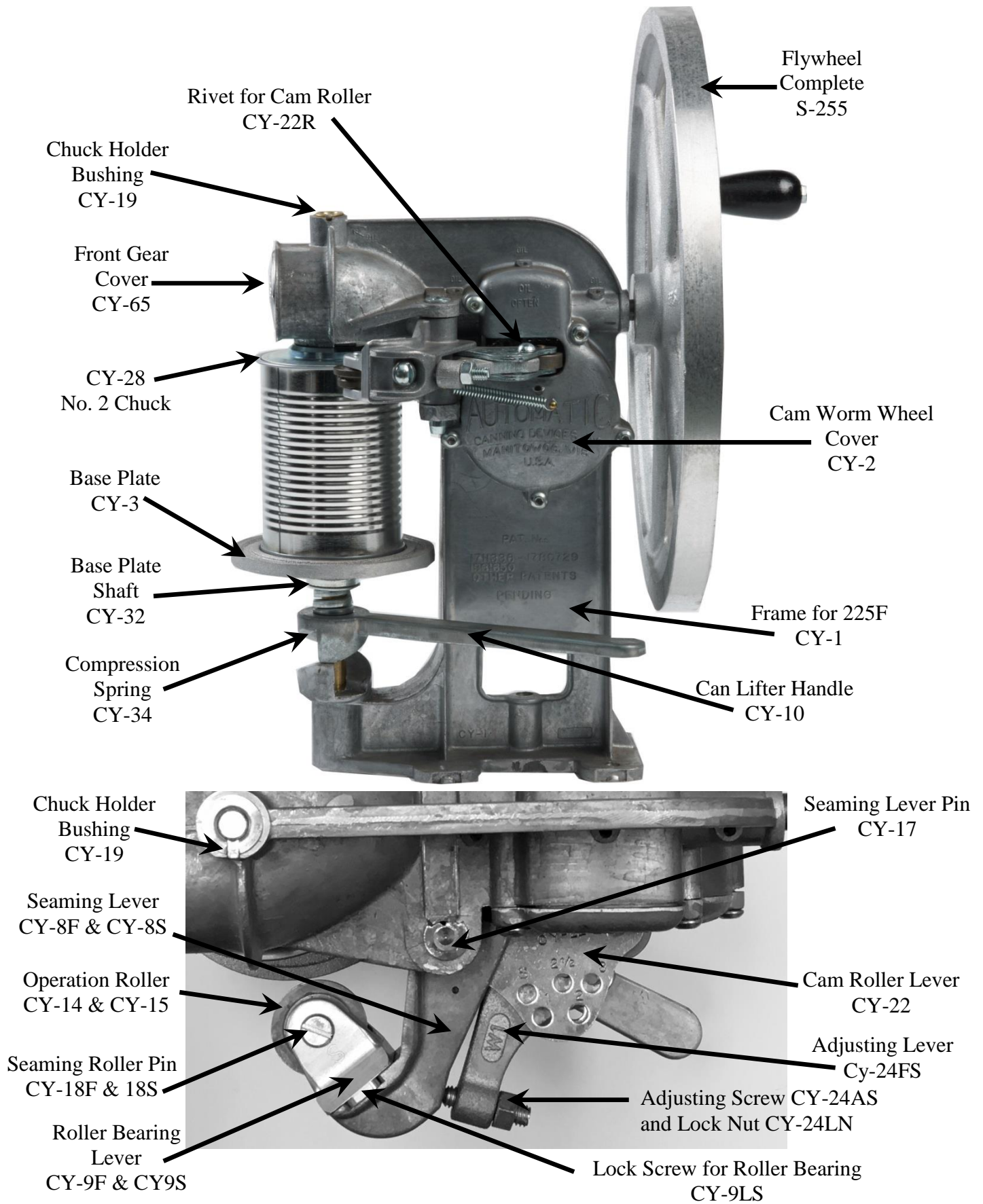
This can sealer was thoroughly inspected and tested at the factory before shipment. Immediately upon receipt, carefully check the can sealer for damage before using it. Do not operate the can sealer if it is damaged; call (920)-682-8627 for further instruction.

The 225F comes with either the CY-28 No. 2 Chuck or the CY-27 No. 3 chuck and the CY-3 Base Plate. These are designed and set up to seal a No. 2 or No. 3 can. A sample can was used to set up the machine and was locked in place during shipping to help protect the machine. Prior to removing the container, lower and raise the base plate by turning the Can Lifter Handle as far as possible to the left and then back to the right a few times. Pay attention to the amount of pressure you have to apply to the Lifter Handle when locking the can into place. It is good to develop a feel for the amount of base plate pressure required to properly seal a can. Cans with a bigger or smaller diameter will require a different size Chuck and Base Plate. Height adjustment with spacers is necessary before attempting to seal other size cans.

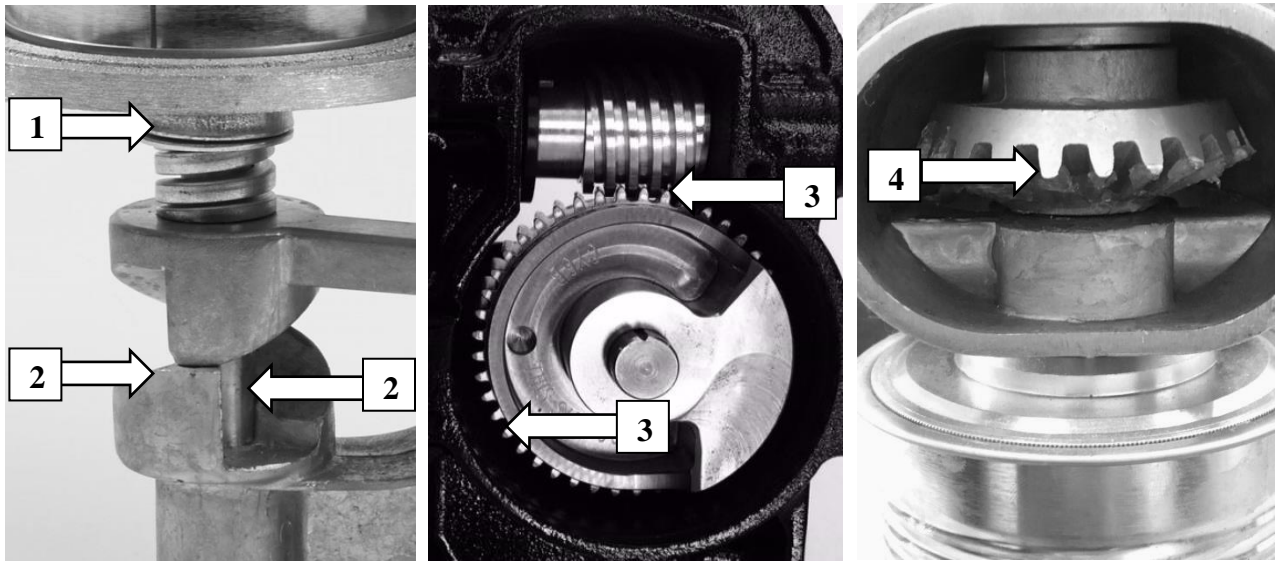
GETTING STARTED

1. The sealer can be firmly attached to a table or bar using the four bolt holes (cast into sealer base) to bolt down the sealer. If that isn't possible, you can use a C-clamp to attach the sealer to a bench top.
2. For operation, the seaming lever rivets (CY-22R) should be in the number 2 or the size you are sealing hole of the cam roller arms (CY-9F & CY-9S).
3. Lower the Base Plate (CY-3) by turning the Can Lifter Handle (CY-10) as far as possible to the left.
4. Place lid on filled can and set can on Base Plate (CY-3).
5. Raise can until it is clamped firmly between the Base Plate and Chuck by turning Can Lifter Handle (CY-10) as far as possible to the right until handle locks itself against the Frame (CY-1). The can is now ready to be sealed.
6. Turn the Flywheel (S-255) until the first operation roller touches the can, continue to turn until the first operation roller pulls away from the can. This hooks the lid to the can. Keep turning the Flywheel until the second operation roller touches the can; continue to turn until the second operation roller pulls away from the can. This finishes the seal. (You will turn the Flywheel a total of 18 times).
7. When both arms are away from the can, pull can lifter handle toward you and remove can.
8. Wipe down the machine frequently to prevent buildup of foreign material.

PARTS DIAGRAM



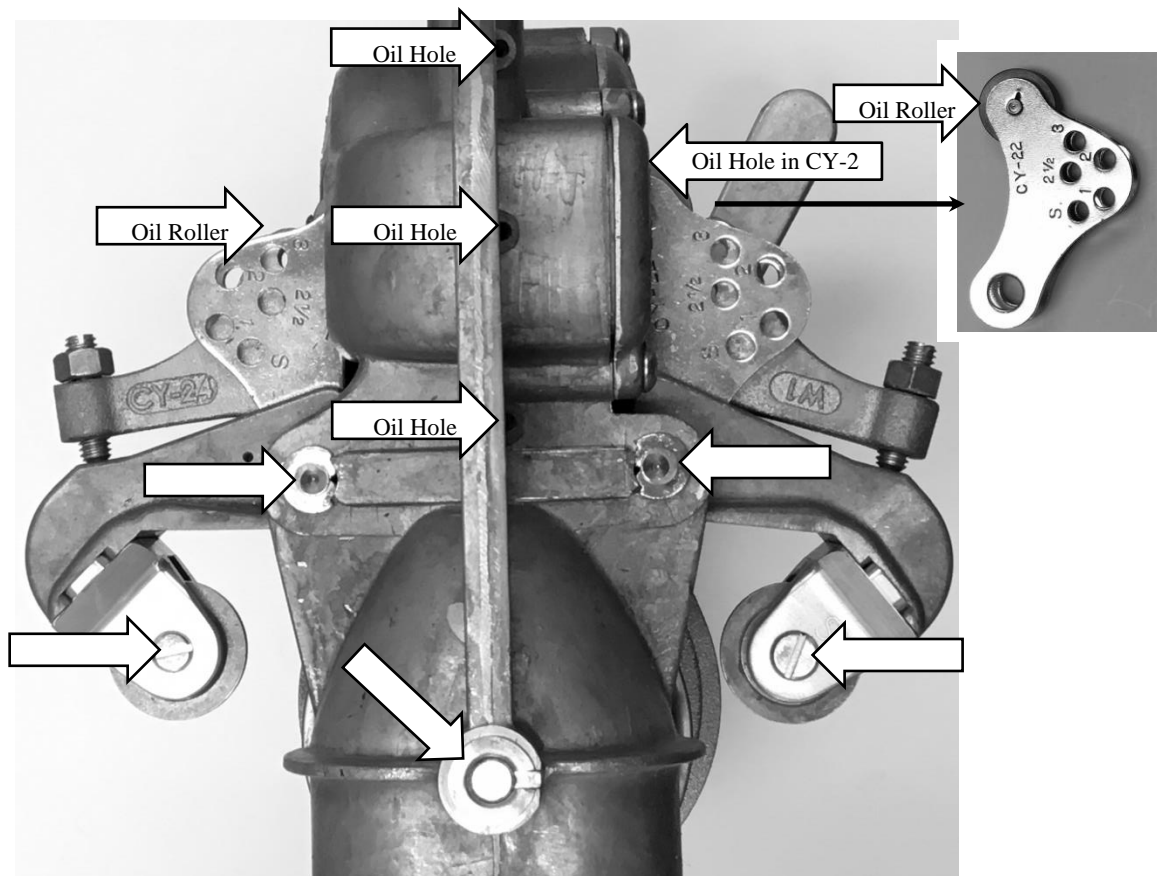
MAINTENANCE



Quarterly Maintenance Schedule

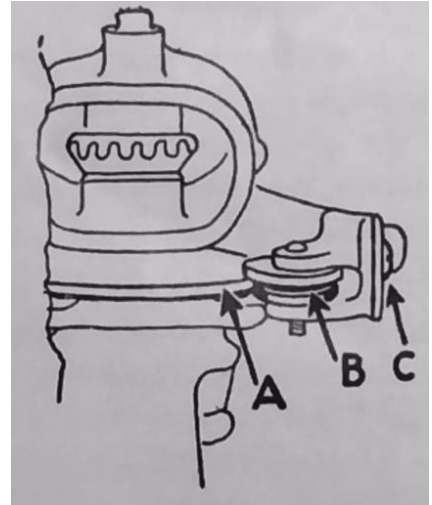
1. Remove Base Plate and oil the CY-32 Baseplate Shaft on the underside with food grade lube oil.
2. Remove Can Lifter Handle; oil brass stem and where Handle comes in contact with Frame. (Use food grade oil)
3. Put food grade white petrolatum on all of the teeth of the Cam Worm Wheel located behind the Cam Worm Wheel Cover.
4. Put food grade white petrolatum on the teeth of the Bevel Gear located behind the Front Gear Cover.

Daily Maintenance Schedule: Use food grade lube oil at each arrow below.



ADJUSTMENTS & SEAM GAUGE

Check the adjustment of the Seaming Rolls occasionally. First check the height adjustment as follows: When Chuck (A in sketch) is held up tightly against the Brass Bushing (CY-1BER), the underside of the top flange on the Seaming Roll (B in sketch) must fit closely on top of Chuck (A). To make adjustments, push the Adjusting Lever (CY-24) toward Chuck until Seaming Roll touches the Chuck. Slightly loosen Screw (CY-9LS) which is "C" in sketch, push down on Roller Bearing Lever that contains Seaming Roll (B) until top flange of Seaming Roll (B) rests on top of Chuck (A). Now tighten Screw (CY-9LS) which is "C" in sketch **as tight as possible**.



This adjustment should be made on both 1st and 2nd Operation Rolls. After height adjustment has been made, use the Seam Gauge which is for checking the seam on any standard size can.

Use the seam gauge as follows: Remove the Rivet (CY-22R) on the Second Operation Cam Roller Lever (CY-22). The second operation is on the right side if you are facing the front of the machine. Run an empty can in the machine to seal the First Operation. Remove the can and slip the Gauge over the seam. The groove marked "1st" should slide over seam on can. The seam will not fill the entire length of the groove but the Gauge should slip on far enough so that it touches the can cover. If groove in Gauge will not slip over seam, tighten First Operation Roller (CY-14) by loosening Lock Nut (CY-24LN) and turning Adjusting Screw (CY-24AS) not more than a quarter turn to the right. If the groove in Gauge is loose on the seam, turn the Adjusting Screw to the left. Repeat above operation with another empty can until Seam Gauge fits over seam correctly. When first operation seam is correct, change the Rivet (CY-22R) from the First Operation Levers to the Second Operation Levers and adjust the Second Operation Roller in the same manner as the First Operation Roller using the can that has a proper first operation roll seam. The groove in the Seam Gauge marked "2nd" is used when adjusting the Second Operation Roller (CY-15). **Be sure to tighten the Lock Nuts (CY-24LN) after adjusting each roller.**

If it is necessary to operate sealer without a can in place, remove Chuck (CY-28) to prevent damage to it and Seaming Rolls.

TROUBLE SHOOTING

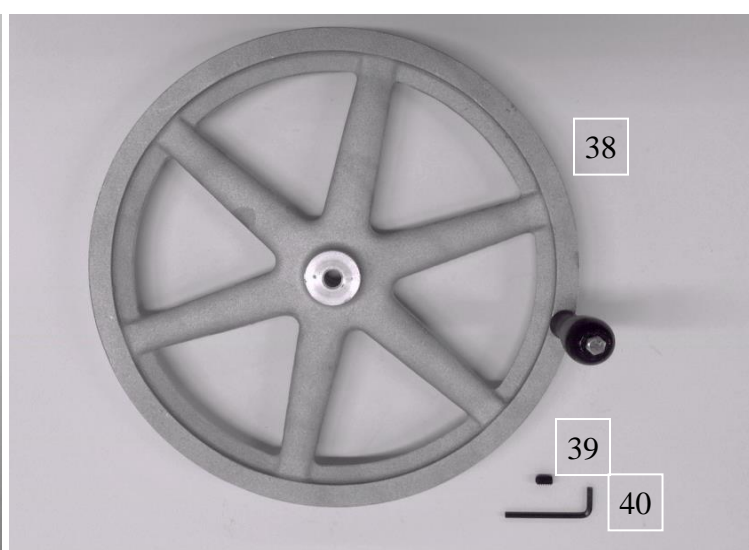
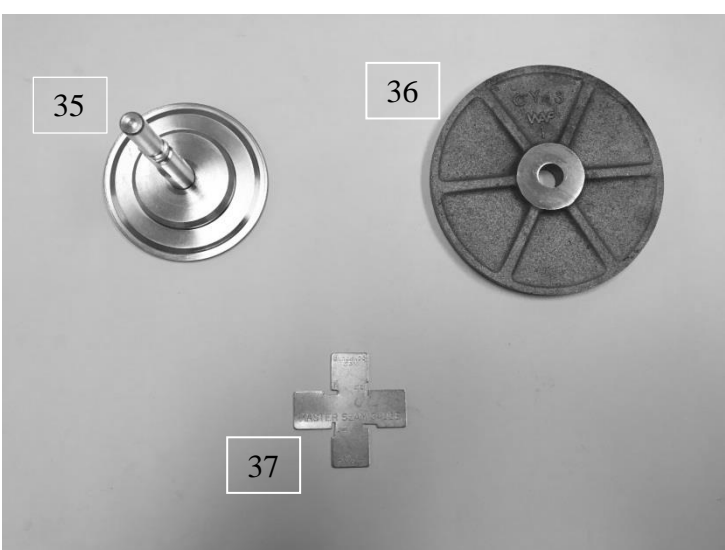
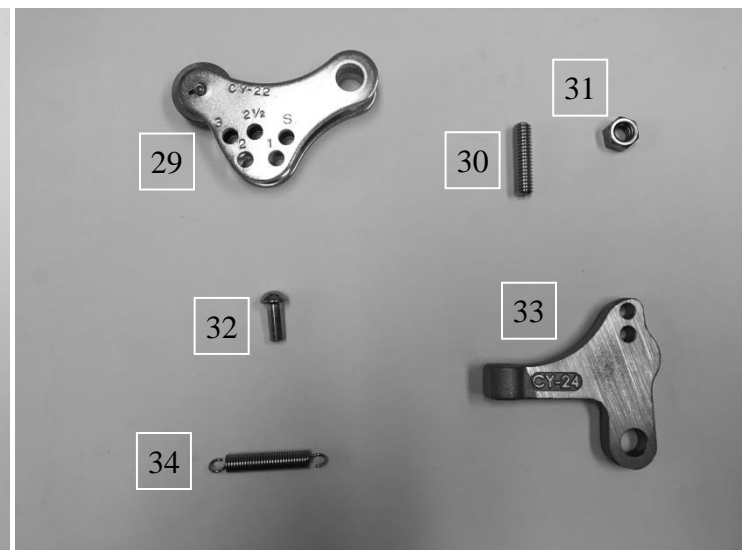
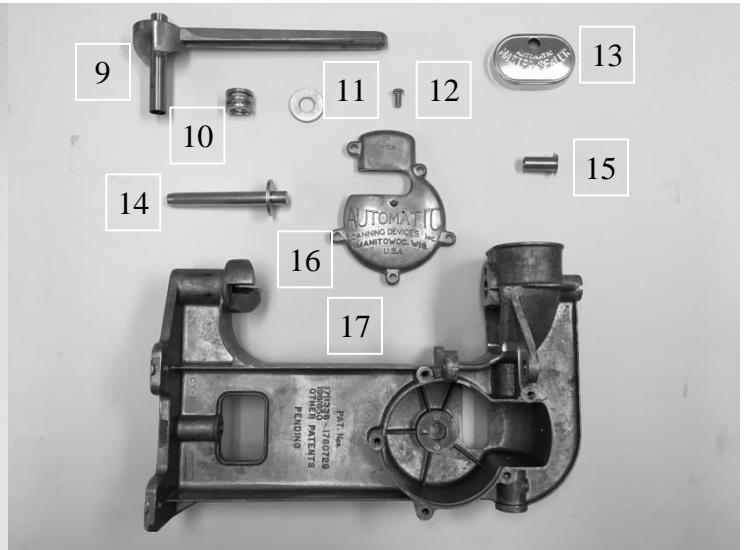
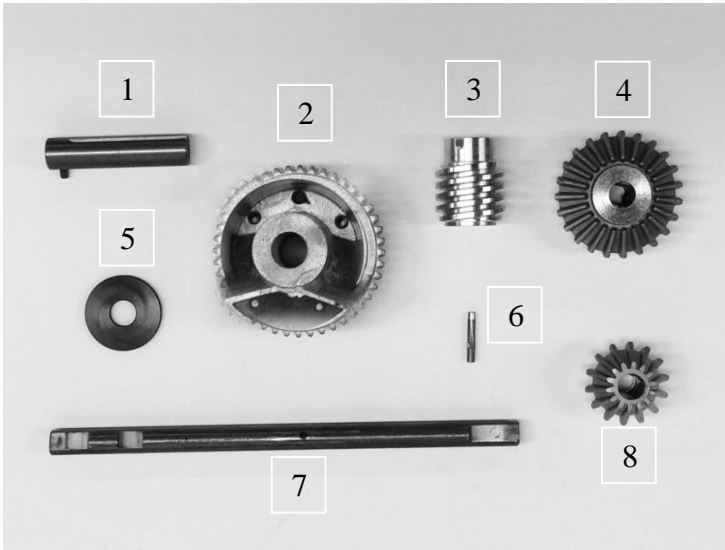
Can isn't spinning properly:

1. Increase belt tension as follows: Loosen lock nut on the tensioning bolt, then turn tensioning bolt to the right to increase tension. After adjustment, tighten the lock nut.

Operation rollers aren't spinning properly:

1. If the rollers aren't kept clean, over time buildup from certain liquids can form and lock the roller into place. Remove the Roller Bearing Lever and soak assembly in warm soap and water for 10 minutes to loosen buildup. Rinse clean and dry. Install Roller Bearing Lever, adjust and oil with food grade lube oil.

PARTS PICTURE LIST



PARTS LIST

<u>PICTURE Number</u>	<u>PART Number</u>	<u>DESCRIPTION</u>
1	CY-26	Worm Wheel Shaft
2	CY-6	Cam Worm Wheel/225 & 225F
3	CY-7	Worm Gear
4	CY-4	Bevel Gear w/ Ball Lock
5	CY-25W	Worm Shaft Fiber Washer
6	CY-25D	Pin for Worm Shaft
7	CY-25	Worm Shaft
8	CY-5	Bevel Pin Gear
9	CY-10	Can Lifter Handle
10	CY-34	Compression Spring
11	HW	Various Height Washer (s)
12	CY-2S	Cover Plate Screw
13	CY-6S	Front Gear Cover
14	CY-32	Base Plate Shaft
15	CY-19	Chuck Holding Bushing (Top)
16	CY-2	Worm Wheel Cover
17	CY-1	Frame for 225 and 225F
18	CY-9LS	Lock Screw for Roller Bearing
19	CY-9F	Roller Bearing Lever-First
20	CY-18F	Seaming Roller Pin-Second
21	CY-14	First Operational Roll
22	CY-9LW	Lock Washer for Lock Screw
23	CY-9S	Roller Bearing Lever-Second
24	CY-18S	Seaming Roller Pin-Second
25	CY-15	Second Operation Roll for Can Sealer
26	CY-8F or CY-8S	Seaming Lever-First or Second
27	CY-17	Seaming Lever Pin
28	CY-1E	Escutcheon Pin
29	CY-22	Cam Roller Lever
30	CY-24AS	Adjusting Screw for Adjusting Lever
31	CY-24LN	Lock Nuts (2) for Adjusting Screw
32	CY-22R	Rivet for Cam Roller & Adjusting Levers
33	CY-24FS	1-Adjusting Lever
34	CY-35	Seaming Lever Spring
35	CY-28	Chuck for No. 2 Cans
36	CY-3	Base Plate
37	CY-83	Seam Gauge
38	S-255	Flywheel Complete
39	S-255S	Flywheel Set Screw
40	S-255SW	Set Screw Wretch

**To order parts, please call Wisconsin Aluminum Foundry Co. at 920-682-8627
or e-mail customerrelations@wafco.com**

ALL AMERICAN AUTOMATIC MASTER CAN SEALER LIMITED WARRANTY

This quality Automatic Master Can Sealer is designed and manufactured to provide many years of satisfactory performance under normal use. Wisconsin Aluminum Foundry guarantees to the original owner that should there be any defects in material or workmanship during the first ninety (90) days after purchase, we will repair or replace it, at our option. This warranty does not apply to damage caused by shipping. To obtain service under the warranty, please do the following:

- 1) Call the Customer Service Department to obtain a Return Authorization (RA) Number. Items returned without a Return Authorization Number will be refused.
- 2) Return can sealer, shipping prepaid with sales receipt, RA Number and a description of the claimed defect to:

**WISCONSIN ALUMINUM FOUNDRY CO., INC.
CONSUMER PRODUCTS DIVISION
1931 SOUTH 14th STREET / PO BOX 246
MANITOWOC, WI 54220**

PHONE: 920-682-8627 FAX: 920-682-4090

Return transportation will be prepaid on all can sealers under warranty. Repairs made after the warranty has expired will be billed at the current repair costs.

We want you to obtain maximum enjoyment from using this quality can sealer and we ask that you take the time to read and follow the operating instructions. Failure to follow instructions, damage caused by improper replacement parts, abuse, or misuse will void this warranty.

This warranty gives you specific legal rights, and you may also have other rights which vary from state to state. This is Wisconsin Aluminum Foundry's guarantee to you and is being made in place of all other express warranties.

Important - please read: Any alterations, modifications or changes of any type made to the can sealer or to any component thereof will void this warranty.