Cannular Compact Semi-Auto Canning Machine

Seaming Start/End Point Alignment

KegLand Distribution PTY LTD

The Semi-Automatic Compact Cannular Canning Machine actuates the first operation and second operation rollers automatically ensuring a consistent seam on every can.

This unit relies on a rotating cam contacting a microswitch to indicate when the machine has reached the endpoint of the seaming rotation and hence the start point of the next seaming rotation. The activation of this microswitch results in the motor turning off.

The motor should be turned off when the second operation roller has moved away from the chuck and before the first operation roller begins moving towards the chuck. Therefore, the motor should turn off when the second operation roller has finished compressing the seam and both the first and second operation rollers are at the furthest point away from the chuck.

If you notice that your rollers stop at the wrong position then this instruction manual will guide you through how to adjust the Cannular such that rollers are at their correct position when the microswitch is activated.
**Step 1.** Loosen the two grub screws which hold the lower cam (situated behind the chuck) to the camshaft.

![Lower Cam](image)

**Step 2.** Inch the machine until the upper cam (situated below the blue cog) is contacting the spring-loaded lever of the microswitch (this can be identified by an audible click)

![Microswitch](image)
Step 4. You will notice two red lines on the lower cam (each line is situated 180 degrees from each other). One red line has the grub screw to its left, the other has the grub screw to its right.

Align the lower cam such that the red line which has the grub screw on its right is lined up with the left arrow on the cannular body, as shown below. This ensures that the entire second operation seaming process is completed and the micro switch is activated as the second operation roller begins moving away from the chuck.

Note: you may need to hold the 2nd operation roller towards the chuck while aligning the cam to prevent the 2nd operation roller from rotating the cam.

Step 5. Tighten both grub screws on the lower cam and confirm the motor is stopping with the rollers in their correct final positions.