



# Dixie Canner Company

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Worldwide Dependability

Can Packaging & Processing Equipment

## OPERATOR'S MANUAL

### DIRECT DRIVE DIXIE DOUBLE SEAMER

Model 25D



## CLEANING INSTRUCTIONS

Do not hose down your seamer. **Your Model 25D Seamer is not waterproof.** We sent a spray bottle and a sample of non-rinse brewery cleaner (Star San is a popular brand). To clean:

- 1- Spray the seamer with the non-rinse brewery cleaner and thoroughly wipe off all the beer and foreign matter daily. Beer will act like a glue if left to harden on the seamer
- 2- Lubricate daily (see page 3 of your manual)
- 3- Place a little dab of grease on the end of the baseplate adjustment screw daily, and oil the stem with the food grade oil
- 4- Once a week, remove the seam rolls one at a time (they are different and must be returned to the proper seam roll arm)
- 5- Clean the seam rolls, seam roll bushings, seam roll pins, and seam roll arms once a week (see page 2 of your manual for the schematic)
- 6- Remember, the seam roll pins (screws) are reverse threaded so you will need to turn them clockwise to loosen and counterclockwise to tighten

# OPERATOR'S MANUAL

## DIRECT DRIVE DIXIE DOUBLE SEAMER

### MODEL 25D

### INTRODUCTION

#### DESCRIPTION

Dixie Model 25D series of double seamers are adaptable for containers up to 4 1/4" diameter and 6" tall. At the time of fabrication, extension posts may be used to accommodate containers taller than 6".

#### OPERATION

With the machine turned on and the baseplate in the lower position, place filled container with lid in place on the baseplate. Lower the hand lever to the locked position; this raises the container into position with the chuck. The machine automatically seals the container and stops. Raise hand lever, remove the can and repeat the operation.

Upon opening the box your seamer arrives in, compare the contents of the box with the attached packing slip. **NOTE: Two gauge wires (1st operation wire and 2nd operation wire) and a Chuck Wrench are provided with each new Model 25D. They are attached to the seamer's rear post. Remove and store in a safe location. These proprietary tools are required for the care and adjustment of the machine.** Additional tools are required for maintenance and adjustment of your seamer (if it is an item we stock, the part number is provided.)

- 5/8 open end wrench (176-A)
- 1/4" ratchet driver (176-C)
- oiler (177-B)
- 3/16 allen wrench (176-B)
- 8" flat head driver w/ 3/16 tip (176-D)
- 11/16 open end or crescent wrench (43)

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## QUICK START

(read and follow these procedures prior to operation of Model 25D)

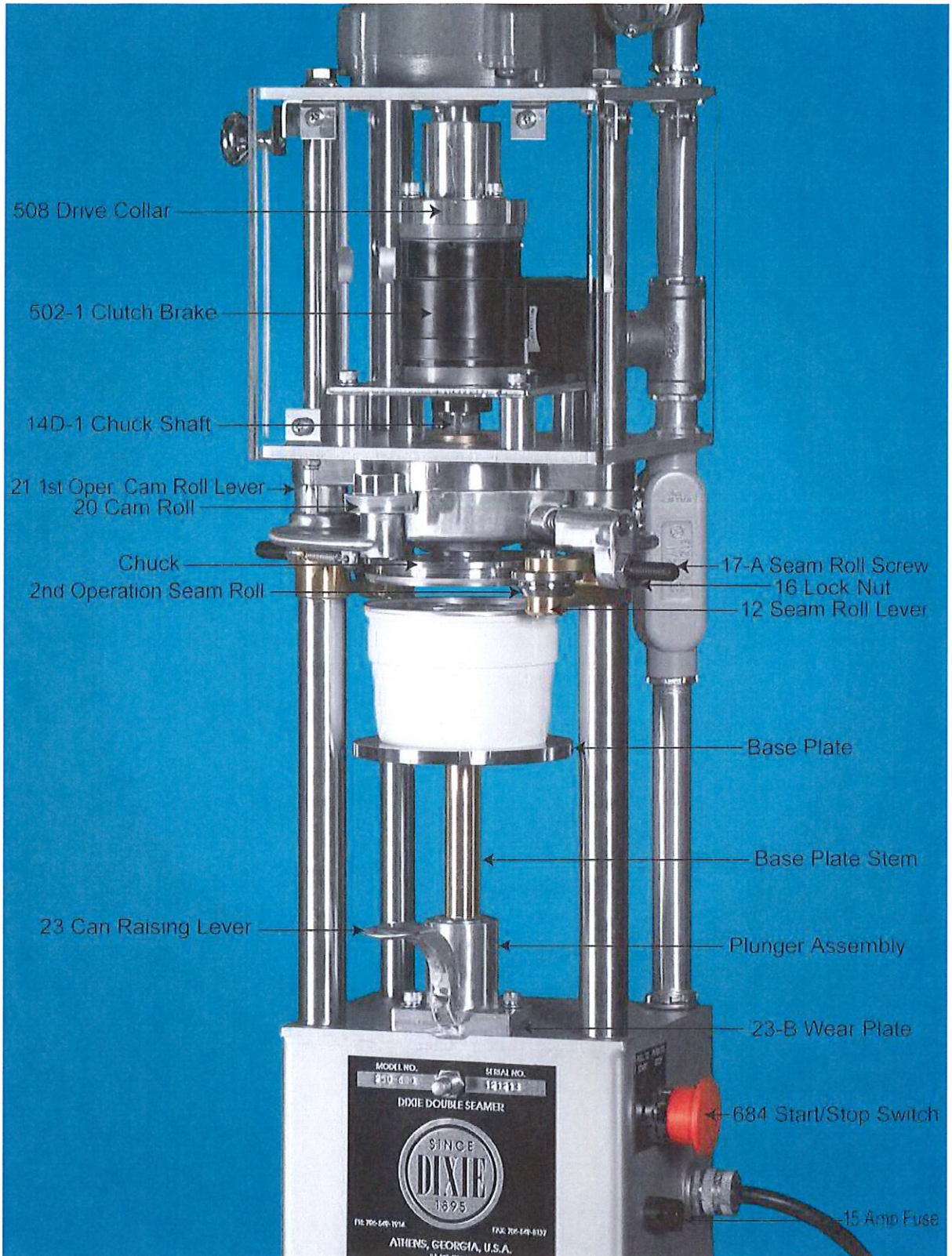
You've opened the box, compared the contents to the packing list, located and stored the **gauge wires** and **chuck wrench** (they're attached to the rear post). Securely bolt your seamer to your counter top or table and properly connect it to your electrical supply. Now turn to page 2-Schematic. Using the schematic, carefully examine your seamer and identify all of the parts. This quick review will help you familiarize yourself with the machine. This step is important, the more familiar you are with the machine the easier it will be to understand the information that follows.

Your Model 25D seamer was set up and adjusted to close your container within the **specifications (spec sheet) you provided** to Dixie Canner Company prior to leaving the factory. It is likely that the last sample container (provided by you) sealed at the factory is still mounted on the machine. Prior to removing the container, lower and raise the base plate (by operating the hand lever a few times. Pay particular attention to the amount of pressure you have to apply to the hand lever when locking the container into position with the chuck. You want to develop a feel for the amount of **base plate pressure** required to properly seal your container. This will be helpful in making periodic adjustments due to wear or when installing change parts for a different sized container. Remove the sample can from the machine.

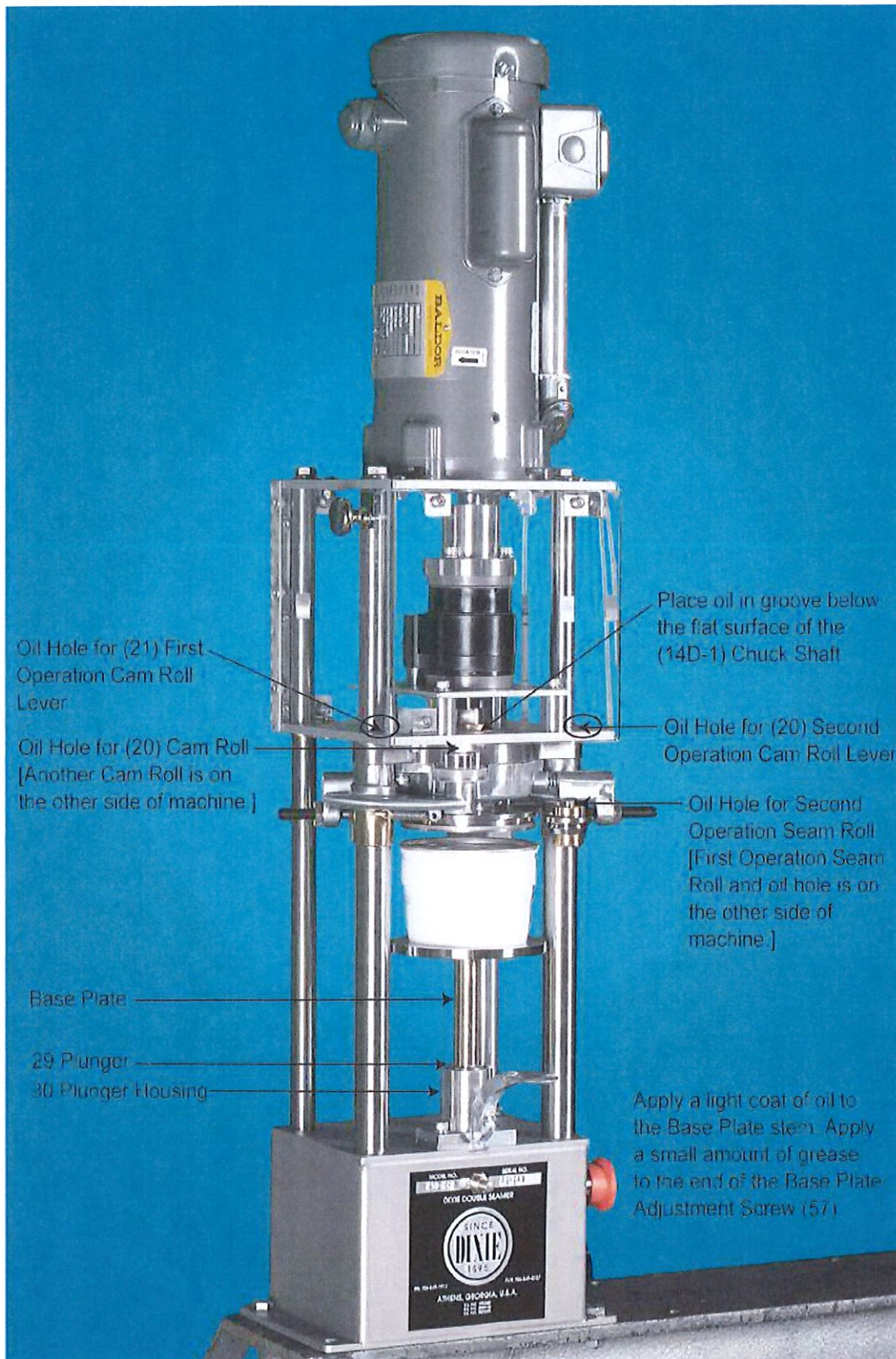
Grab your oiler and turn to page 3. Examine the picture on page 3. The captions and directional arrows demonstrate the areas that need to be lubricated. Apply several drops of oil at each location. Use a paper towel to wipe off any excess oil. Your Model 25D is designed to have a long service life with proper care and maintenance. Prior to operating your machine each day, lubrication needs to be applied. If the machine will be out of service for a day or more, lubricate it before storing and again prior to placing it back in service. Take time to wipe down the machine at the end of each use. Accumulated dust, dirt, debris, excess oil and other viscous fluids organic to your operations can combine to form ( for lack of a better word) gunk. "Gunk" can act as a grinding paste which can cause excessive wear of metal parts.

Turn the machine on. Seal two or three test containers. Break the double seams down and evaluate them according to your/company procedure. **Body hook, cover hook, seam height,** and **seam tightness** can all be fine tuned within the parameters for which your container and end were designed. Your container manufacturer should provide you a **specification sheet** (which you provide to Dixie Canner Company with your samples when ordering) for your container and end. Container design is a complex field. There is no such thing as a "standard" size. Similarly sized containers may be made with materials of different weights, etc. which has a direct bearing on the optimum double seam dimensions required for any particular container.

# SCHEMATIC



## DAILY LUBRICATION ILLUSTRATION



# CHANGE PARTS SET UP AND ADJUSTMENT FOR THE MODEL 25D

Due to friction, pressure, and other forces applied to the various parts of your Model 25D during operation a certain amount of wear to the parts of your machine (as with all machines) will occur. Your Model 25D has been designed to compensate for this. Proper care and maintenance and daily lubrication can minimize wear. While following your/company's double seam evaluation procedure you may notice a variance in optimal seam dimensions due to machine wear. Or you may be installing change parts you have purchased for a different sized container and have to set up the machine from scratch. Regardless, the procedures and the order in which they are followed are the same. In the following pages detailed instructions for performing each of the following procedures are provided.

## **1) Base Plate Pressure adjustments:**

Base plate pressure adjustments are performed to;

- a) prevent container from slipping or turning during the seaming cycle
- b) increase or decrease body hook

## **2) First Operation adjustments:**

First operation adjustments are performed to;

- a) increase or decrease cover hook
- b) can influence seam height, thickness and countersink depth

## **3) Second Operation adjustments:**

Second operation adjustments are performed to;

- a) increase or decrease seam thickness
- b) increase or decrease seam height

## **4) Installing or Removing Chuck:**

Use a 5/8" open end wrench to hold the drive shaft to prevent the shaft from turning when installing or removing a chuck. Open the Lexan Guard Door to access the drive shaft and apply the wrench to the square flats of the chuck shaft located below the clutch/brake.

Use the Chuck Wrench (provided with the seamer) to remove or install the chuck. Depending on the size of your chuck, insert the pins of the chuck wrench into adjacent or diagonal holes in the surface of the chuck.

**To remove** (loosen) the chuck, turn the chuck counterclockwise (towards the left).

**To install** (tighten) the chuck, turn the chuck clockwise (towards the right). Always insure the chuck is fully tightened with the bottom of the chuck shaft flush with the top of the chuck.



## BASE PLATE PRESSURE ADJUSTMENTS (FOR PROPER CHUCK ENGAGEMENT AND +/- BODY HOOK)

In order to perform base plate pressure adjustments you will need a long, slender flat head screw driver with a narrow (3/16") tip. **Caution: insure Start/ Stop Switch is in the stop position and the machine is not running.**

Step 1. Remove base plate from plunger (29) by simply lifting it out.

Step 2. While holding the base plate by base plate stem, look into the hole in the center of the base plate. You will see the slotted end of the set screw (56). Inspect the metal disc(46) and disc retainer spring (59) inside the (bottom of) Plunger (29) for excessive wear or breakage.

Step 3. Insert screw driver into the hole in the center of the base plate and loosen (turn counter clockwise) the Set Screw (56) several turns so that the Adjusting Screw (57) can be screwed in and out freely.

Step 4. Replace the base plate in the plunger, press the base plate firmly downwards to insure it is fully seated.

**NOTE: To increase base plate pressure remove base plate and turn the Adjusting Screw (57) counterclockwise increasing the length of the screw protruding from the base plate stem, to decrease base plate pressure turn the Adjusting Screw (57) clockwise reducing the length of the screw protruding from the base plate stem.**

Step 5. Place container and end on base plate. Depress can raising lever positioning the container end on the chuck. One of three things will happen;

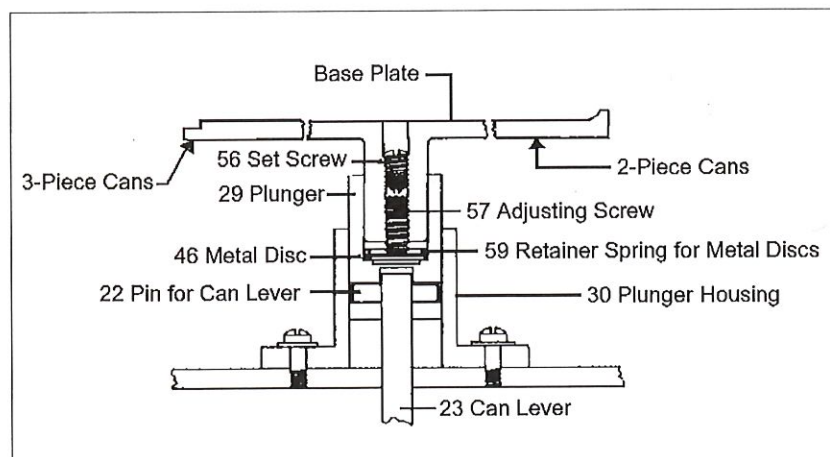
a) The container end will be fully seated onto the chuck and the base plate is in the locked position (you cannot push it down), this is good.

b) The container end is fully seated on the chuck but the base plate will not lock in place. You need to gradually decrease the base plate pressure until the base plate locks in place with the end and chuck properly positioned.

c) The container end is not fully seated on the chuck and the base plate is in the locked position. You need to increase base plate pressure until the end is properly seated on the chuck and the base plate is in the locked position.

Step 6. With container properly positioned on chuck and base plate locked, grasp the container and attempt to turn it. If the chuck allows it to slip and turn you need to gradually increase base plate pressure until the container is firmly in place. If the Container doesn't slip and turn, gradually decrease base plate pressure until slight movement (slip/ turn) of the container is possible. Then slightly increase pressure until container is firmly in place.

The base plate pressure is set. After adjusting the first operation, seal a container and inspect the seam. You can increase body hook by increasing base plate pressure. You can decrease body hook by decreasing base plate pressure.



SECTIONAL VIEW OF BASE PLATE ASSEMBLY

## NEUTRAL POSITION/TIMING THE MACHINE

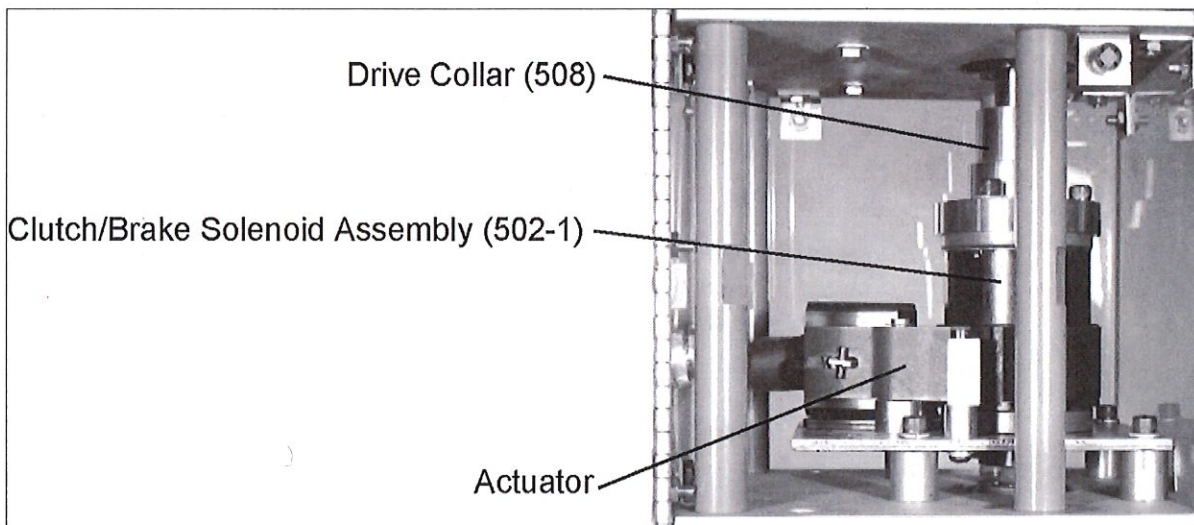
Your Model 25D was in the neutral position (properly timed) when you removed it from the shipping carton. The machine is in the neutral position when both **Cam Rolls (20)** are in their innermost position and both **Seaming Rolls (1st and second operations)** are in their outermost position.

Timing the machine. For some reason a seaming cycle was interrupted (power outage, etc.) and now the machine is out of time ( Not in neutral at the beginning of the seaming cycle). This is easily corrected.

**Step 1-** Power to the machine should be on.

**Step 2-** Depress the container raising lever (23) and allow the seamer to complete its cycle. It will complete the cycle and stop in neutral.

**Note:** On pages 8 and 9 you will find instructions for adjusting the 1st and 2nd operation seaming rolls. It will be necessary to advance the machine from neutral to a specific rotation in the seaming cycle. This is necessary so that the seaming roll that you are adjusting is at its innermost position in relation to the chuck. This is easily accomplished by pressing and releasing the clutch/brake actuator (displayed in the picture below). Each time you press and release the actuator, the clutch/brake advances one (1) rotation.



## GAUGE WIRES, USE AND PROPER POSITIONING

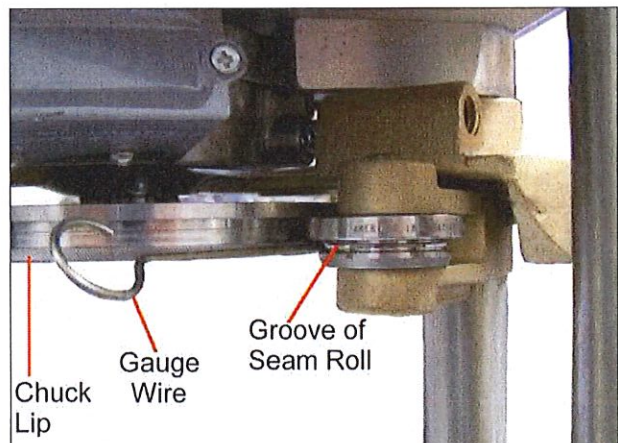
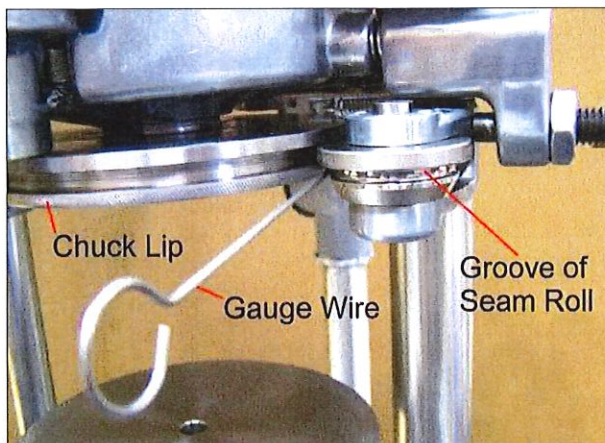
Two gauge wires are provided with your Model 25D seamer. They were attached along with the chuck wrench to the rear post of your machine when you received it. The gauge wires are used as a starting point for adjusting the seaming rolls. Final adjustments will be required to obtain specific seam dimensions recommended by your can supplier or manufacturer. The first operation gauge wire is the approximate thickness of your first operation seam. The second operation gauge wire is the approximate thickness of your second operation seam.

### Gauge Wire Sizes

<u>Dixie Part No.</u>		<u>Thickness</u>
40	1st Operation	0.062
41	2nd Operation	0.031
40-C	1st Operation	0.080
41-C	2nd Operation	0.050
40-P	1st Operation	0.090
41-P	2nd Operation	0.075

### CORRECT POSITIONING OF GAUGE WIRE

Gauge wires should be positioned in the groove of the seaming roll and against the lip of the chuck.



## FIRST OPERATION SEAM ROLL ADJUSTMENT

There are ten (10) revolutions per seaming cycle, four and a half (4 1/2) revolutions per seaming roll (the tenth revolution is the neutral position). The function of the first operation seam roll is to curl the cover hook and body hook into proper position.

**Step 1-** Insure the machine is in neutral. Remove the second operation seaming roll and set aside. Or loosen the lock nut and turn set screw counter clockwise insuring 2nd operation seaming roll cannot contact chuck.

**Step 2 -** With power on press and release the actuator on the clutch/brake assembly four (4) times. Turn the machine off. Then press the actuator one (1) more time to release the clutch brake. While manually turning the clutch one half turn in a clockwise direction. You can either grasp the Collar(508) and turn by hand or use a 5/8" wrench to turn the chuck shaft. These 4 1/2 revolutions of the clutch/brake assembly place the first operation seam roll at its innermost position with the chuck

**Step 3-** While the power to the machine remains off , loosen the lock nut (16) and place the first operation gauge wire in the proper position (see photograph on Page 6). Adjust set screw (17-A) until the first operation seam roll is snugly in position with the chuck. You should still be able to move the gauge wire back and forth between the seam roll and chuck. You want to achieve a firm fit. If you cannot remove the gauge wire with a firm but smooth resistance the adjustment is too tight.

**Step 4-** Turn power to the machine on which will automatically complete the fifth revolution.

**Step 5-** depress the actuator on the clutch/brake assembly four (4) times to put machine back in neutral.

**Step 6-** Seal a container. Inspect the seam according to your/company's recommended procedure.

**Step 7-** Fine tune your adjustments to achieve your container supplier's or manufacturer's recommended first operation cover hook and body hook.

- a) To increase body hook, increase base plate pressure.
- b) To decrease body hook, decrease base plate pressure.
- c) To increase cover hook, tighten first operation seaming roll.
- d) To decrease cover hook, loosen first operation seaming roll.

## SECOND OPERATION SEAM ROLL ADJUSTMENT

The function of the second operation seaming roll is to complete the sealing of the container.

**Step 1-** Re-install the second operation seaming roll (you removed it so it would be out of the way while you adjusted the first operation).

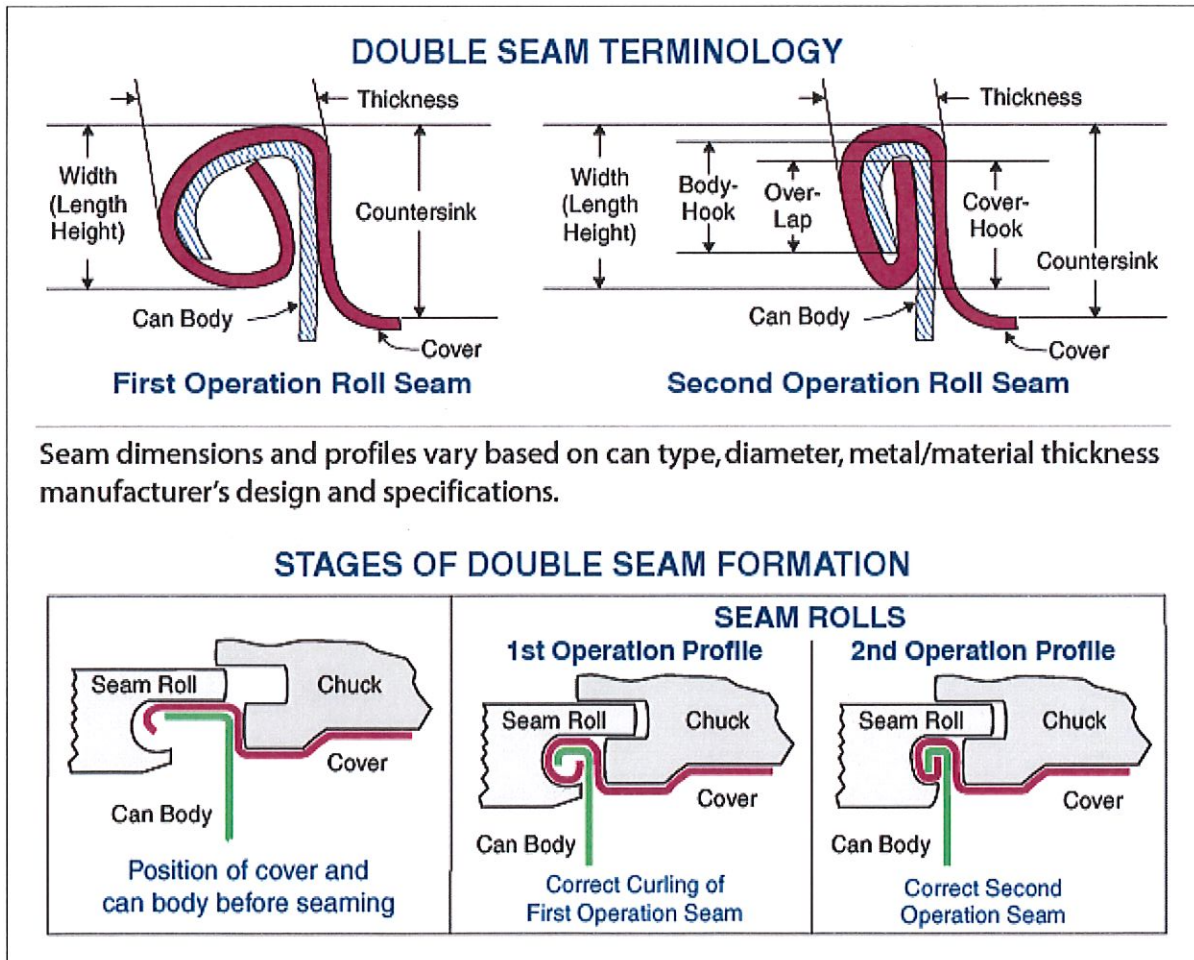
**Step 2-** With power on depress the container raising lever (23) and allow the machine to perform one seaming cycle.

**Step 3-** With power on depress the actuator on the clutch/brake assembly nine (9) times, placing the second operation seaming roll in its innermost position. Switch power OFF.

**Step 4-** Using the second operation gauge wire adjust the second operation seaming roll in the same manner in which you adjusted the first operation seaming roll (page 8).

**Step 5-** Turn power to machine on, depress container raising lever (23), to complete tenth revolution and cycle, returning machine to neutral.

**Step 6-** Seal a container, inspect the seam, make any final adjustments necessary.



# 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 following outline intended to help notice obvious defects and list some causes that may serve as a guide in correcting minor problems.

## NOTE:

Should the clutch/brake assembly continue to turn without stopping in the neutral position, check the position of switch (632) located directly behind the cam roll (20) on the rear of the machine. The switch (632) should be positioned close enough to the cam roll so that the cam roll can push the bronze prong of the switch (632) sufficiently to fully activate switch. With the machine on, the switch will produce an audible click when the switch (632) is correctly positioned, and the clutch assembly will stop in the neutral position. If the switch (632) cannot be adjusted properly or is visibly damaged it needs to be replaced.

## MECHANICAL DEFECTS AND COMMON CAUSES

- a) Container slips or will not turn during seaming operation.
  - 1. Damage or lack of oil in the base plate, height spacer or plunger assembly.
  - 2. Missing or broken metal discs/retainer spring in the plunger.
  - 3. Insufficient base plate pressure.
  - 4. Worn or wrong size chuck.
  - 5. Seaming rolls binding on pins.
  - 6. Wear plate worn.
  
- b) Machine operates with undue noise or locks.
  - 1. machine not properly timed.
  
- c) Unusually loose seaming rolls.
  - 1. Seaming rolls or pins worn.
  - 2. Bushings are worn. Replace bushings or entire seaming roll(s).
  
- d) Seaming rolls do not return to the neutral position.
  - 1. Seaming roll levers are 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.

## **TROUBLE SHOOTING**

### **DOUBLE SEAM DEFECTS AND COMMON CAUSES**

- a) Cut over. Unusually sharp edge at top inside edge of seam.
  - 1. 1st or second operation seaming roll set to tight.
  - 2. Worn seaming rolls or worn chuck.
  - 3. Excessive base plate pressure.
  
- b) Cut or fractured seam.
  - 1. Seaming rolls set to tight.
  - 2. Seaming rolls damaged.
  - 3. excessive base plate pressure.
  
- c) Droop or lap in double seam at or near the can body side seam.
  - 1. Excessive base plate pressure.
  - 2. 1st operation seaming roll set to loose.
  - 3. Worn 1st operation seaming roll.
  
- d) Excessive countersink depth.
  - 1. Too much base plate pressure
  - 2. 1st operation seaming 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. Container top not properly seated on container.
  - 2. Damaged container flange or container top curl.
  - 3. Not enough base plate pressure.
  - 4. Seaming rolls set too loose.
  
- f) Long body hook.
  - 1. Too much base plate pressure.
  - 2. Seaming rolls set too tight.
  
- g) Long cover hook.
  - 1. 1st operation seaming roll set too tight.
  
- h) Short body hook.
  - 1. Insufficient base plate pressure.
  - 2. 1st operation seaming roll set too tight.
  - 3. 2nd operation seaming roll set too loose.

# TROUBLE SHOOTING

## DOUBLE SEAM DEFECTS AND COMMON CAUSES

(CONTINUED)

i) Short cover hook.

1. Too much base plate pressure.
2. 1st operation seaming roll set too loose.
3. Worn 1st operation seaming roll.
4. Excessive countersink depth.

j) Cover hook and body hook not uniform.

1. Base plate or plunger worn.
2. Chuck or seam rolls out of alignment.

k) Droops, Vees, or wrinkles.

1. Excessive base plate pressure.
2. 1st operation seaming roll too loose or worn.
3. 2nd operation seaming roll too tight.
4. Defects in can body or top.
5. Incorrect seaming roll profiles.



# **CHANGE PARTS, REPAIR PARTS AND SERVICE**

## **CHANGE PARTS**

Change parts, consisting of a chuck, base plate, and a height spacer may be required for each different container diameter, height, top, or style. Also a different set of seaming rolls may be required for each container. Your container manufacturer or supplier will recommend the seam roll profiles for your containers. Dixie Canner Company stocks or may be able to furnish the seaming roll profile needed.

- **Always insure you have the proper change parts available when changing your machine from one container size to another.**
- **When ordering change parts always send us six (6) loose ends and six (6) container bodies of the container size(s) to be closed.**

## **REPAIR PARTS**

When ordering parts always provide the part name and part number. A complete stock of parts is maintained by Dixie Canner Company. Parts may be ordered as needed to replace worn or damaged parts.

## **REPAIR OR SERVICE**

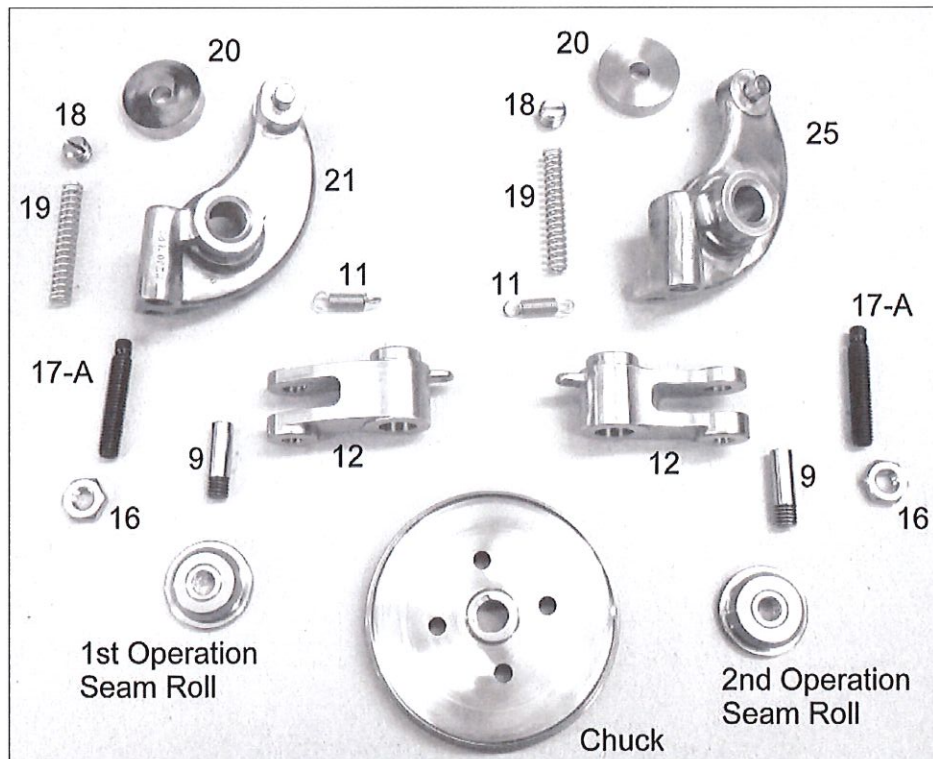
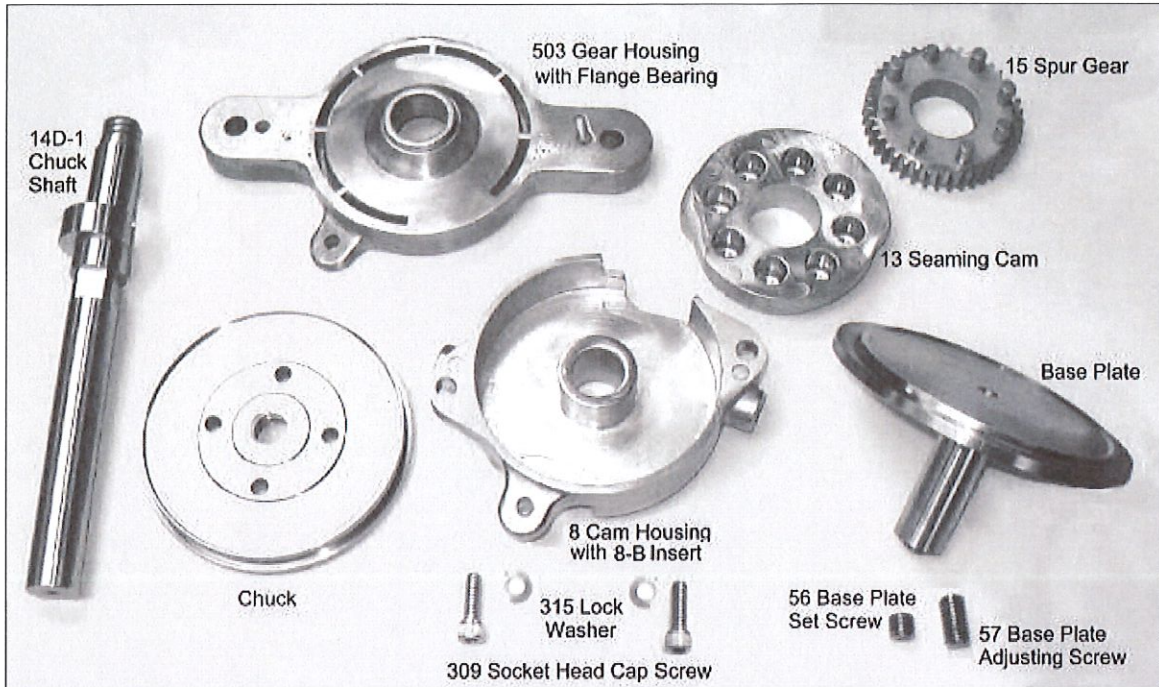
Repair or service is provided for the cost of labor plus parts needed. For factory repair or service, ship the seamer prepaid to:

**Dixie Canner Company  
326 Commerce Blvd.  
Athens, GA 30606 USA**

When returning a seamer for repair or service please observe the following:

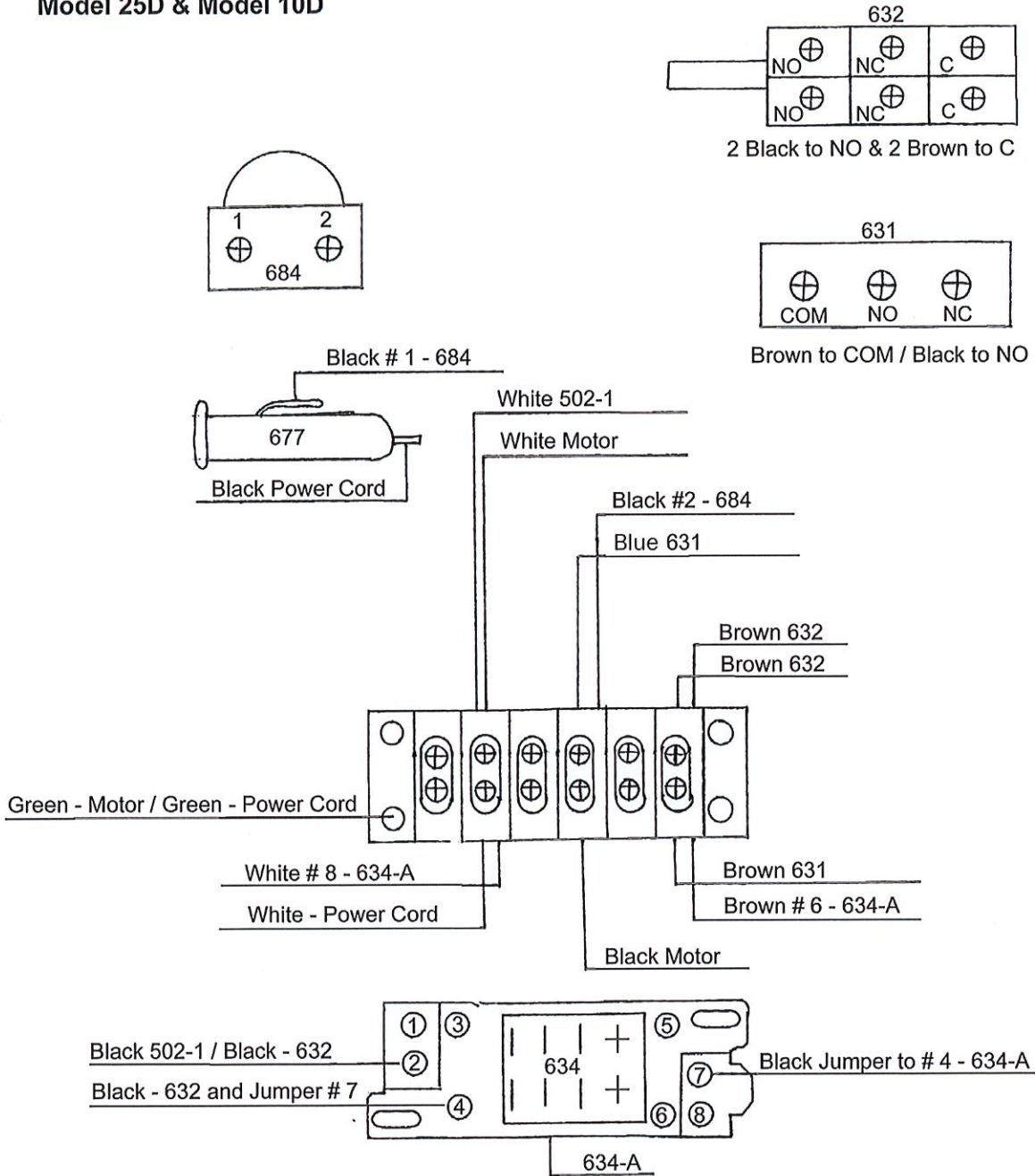
1. **Send the complete seamer with change parts and six (6) containers and ends of the exact size to be closed. Package the machine and containers/ends for safe delivery.**
2. **Enclose a letter authorizing repair or specifying if an estimate is required prior to repair. Mention any particular problem with the seamer. Provide contact information and instructions regarding shipment, urgency and other relevant information.**

# CHANGE/REPAIR PARTS, NAMES AND NUMBERS



# WIRING DIAGRAM

**Wiring Diagram  
Model 25D & Model 10D**



06/09/16



# Dixie Canner Company

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## DIXIE MODEL 25D - PARTS

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### PART NO. DESCRIPTION

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8	Cam Housing with 8-B Insert
8-B	Insert for Cam Housing
9	Seam Roll Screw
11	Seam Roll Lever Spring
12	Seam Roll Lever
13	Seaming Cam
14D-1	Chuck Shaft
15	Spur Gear
16	Lock Nut
17-A	Seam Roll Set Screw, swivel pad
18	Cam Roll Lever Set Screw
19	Cam Roll Lever Spring
20	Cam Roll
21	1st Operation Cam Roll Lever
22	Pin for Can Raising Lever
23	Can Raising Lever
23-B	Wear Plate
25	2nd Operation Cam Roll Lever
29	Plunger
30	Plunger Housing
40	1st Operation Gauge Wire (Specify container type)
41	2nd Operation Gauge Wire (Specify container type)
44	Chuck Wrench
46	Metal Disc for Base Plate
56	Base Plate Set Screw
57	Base Plate adjusting Screw
59	Retainer Spring for Metal Disc
308	1/4-28 x 3/4 Hex Head Cap Screw
309	1/4-20 x 3/4 Socket Head Cap Screw
315	1/4 Lock Washer
330	3/8-16 x 3/4 Hex Head Cap Screw
331	3/8 x 1" Hex Head Cap Screw
334	3/8 Flat Washer
335	3/8 Lock Washer
366	6-32 Hex Nut
369	6-32 x 1-1/4 Machine Screw
372	10-32 x 1/2 Machine Screw
374	1/4-20 x 1-1/2 Socket Head Cap Screw
374-1	Modified 374
375	8-32 x 1/2 Machine Screw

<b>PART NO.</b>	<b>DESCRIPTION</b>
427	1/2" Tee
501-6	Motor
501-7	Motor
501-FCBA	Fan Cover
501-MCBA	Motor Capacitor
502-1	Clutch/Brake/Solenoid Assembly
503	Gear Housing With Flange Bearing
503-A	Flange Bearing
504	Gear Housing Cover Plate
505-1	Spacer
506	Motor Platform
507	Frame Post for Motor Platform
508	Drive Collar
511	Woodruff Key
519	Face Plate 25D/10D
520-1	Conduit Box (Base) for 25D
520-3	Gasket for 520-1 Base
521	Seam & Cam Roll Post, 25D
521-F	Front Frame Post
522-R	Rear Frame Post
571	Clutch/Brake Guard
573-1	Magnet for Clutch/Brake Guard
573-2	Magnet Plate for Clutch/Brake Guard
573-3	Knob for Clutch/Brake Guard
573-4	Guard Mounting Bracket
573-5	3/16 x 1/4 Aluminum Rivet
573-7	3/16 Rivet Washer
598	53 x 19 x 16 Shipping Box
601-B	6 Strip Terminal
601-C	Motor Cord
604	Terminal Cap
605-1	Cord Connector, 1850
605-2	Cord Connector, 3150
606	1/2" Straight "C" Condulet, modified
608	Pull Elbow, 1/2"
609	Lock Nut, 1/2"
607-A	Condulet Gasket & Cover
612-1-1/2	1/2" x 1-1/2" Nipple
612-2	1/2" x 2" Nipple
612-5	1/2" x 5" Nipple
612-8	1/2" x 8" Nipple
612-9	1/2" x 9" Nipple
612-11	1/2" x 11" Nipple
612-15	1/2" x 15" Nipple
614	Sealing Ring
631	Clutch Start Switch
632	Clutch Stop Switch
633	Enclosure for Clutch Stop Switch
634	Relay Switch
634-A	Base for Relay Switch
634-B	Clip for Relay Switch Base
677	Inline Fuse Holder
684	Start/Stop Switch with Contact Block 684-1
684-2	Pull/Start, Push/Stop Legend Plate
689	15 Amp Fuse MDA-15 Time Delay Ceramic Tube

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<b>PART NO.</b>	<b>DESCRIPTION</b>
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CHANGE PARTS

Seam Rolls  
Seam Roll Bushing

Chucks                    108 to 404 diameter  
Add for Special

Base Plates              108 to 404 diameter  
For Caulking  
Add for Modified Base Plate

Height Spacer

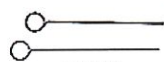
<b>SPK/25D Model 25D Spare Parts Kit</b>		
4	11	Seam Roll Lever Spring
1	23-B	Wear Plate
2	46	Metal Disc for Base Plate
1	59	Retainer Spring for Metal Disc
1	631	Clutch Start Switch
1	632	Clutch Stop Switch
1	677	Inline Fuse Holder
6	689	15-Amp Fuse

<b>HEAD-25D-10D Head Assembly (assembled)</b>		
1	8	Cam Housing with 8-B Insert
1	13	Seaming Cam
1	15	Spur Gear
1	14D-1	Chuck Shaft
2	309	1/4"-20 x 3/4" Socket Head Cap Screw
2	315	1/4 Lock Washer
1	503	Gear Housing with Flange Bearing

## CUSTOMIZED CHANGE PARTS

		PRICE EACH
<b>CHUCKS:</b>	108 to 404 diameters	Request Price
	405 to 603 diameters	Request Price
	604 to 610 diameters	Request Price
	Add for Magnets in chuck	Request Price
	Add for Special	Request Price
<b>SEAMING ROLLS:</b>		Request Price
<b>BASE PLATES:</b>	108 to 404 diameters	Request Price
	For Caulking Tubes	Request Price
	405 to 603 diameters	Request Price
	604 to 610 diameters	Request Price
	Add for Modified Base Plate	Request Price
<b>HEIGHT SPACERS:</b>		Request Price

### TOOLS FOR USE WITH DIXIE DOUBLE SEAMERS



40/41



43



44



176-A



176-B



176-C



176-D

<b>40</b>	<b>Gauge Wire, First Operation</b> – For gauging initial seam roll settings	Request Price
<b>41</b>	<b>Gauge Wire, Second Operation</b> – For gauging initial seam roll settings	Request Price
<b>43</b>	<b>Adjustable Wrench</b> – For loosening or tightening seam roll lock nut	Request Price
<b>44</b>	<b>Chuck Wrench</b> – For removing or installing chuck	Request Price
<b>176</b>	<b>Set Tools (176-A, 176-B, 176-C, 176-D)</b>	Request Price
<b>176-A</b>	<b>Chuck Shaft Wrench</b> – For holding chuck shaft while removing or installing chuck	Request Price
<b>176-B</b>	<b>Allen Set Screw Wrench</b> – For adjusting seam roll set screws	Request Price
<b>176-C</b>	<b>Adjustable Screwdriver</b> – For removing or installing seam roll screws	Request Price
<b>176-D</b>	<b>Screwdriver, 8"</b> – For adjusting base plate pressure	Request Price

### LUBRICANTS & LUBRICATION EQUIPMENT



177-B



177-C



177-D



178

<b>177</b>	<b>Set Lubricants &amp; Lubrication Equipment (177-B, 177-C, 177-D)</b>	Request Price
<b>177-B</b>	<b>Oiler, 1 pt. capacity, with flexible spout</b>	Request Price
<b>177-C</b>	<b>Oil, Food Grade, Light Duty, pint</b>	Request Price
<b>177-D</b>	<b>Grease, Food Grade, 14.1 ounce tube</b>	Request Price
<b>178</b>	<b>Busch R-580 Vacuum Pump Oil, quart</b> – Vacuum Seamers Only	Request Price

## DIXIE DOUBLE SEAM INSPECTION TOOLS

173-A



### Can Opener

For cutting hole in steel/tin top. Made of stainless steel with wood handle.

Note: A fine rasp file may be used to cut through the top (cover) of the double seam to expose cover hook and body hook for measuring.



### 173-B End Cutting Nipper

For cutting and tearing steel/tin top from double seam. Made of steel with vinyl coated handles.

#### PURPOSE:

Dixie's can seam test kit includes the tools needed in the process of can double seam inspection. The disc-cutter type can opener has an adjustable, heavy duty blade which allows you to cut a disc from the can cover without damaging the double seam. The end cutting nipper has perfectly matched hardened jaws to allow cutting through the seam to expose the cover hook, over-lap, and body hook. The can seam micrometers are graduated in thousandths of an inch (or hundredths of a mm) for measuring seam thickness and height. 173-C and 173-C-Metric micrometers feature a depth gauge for measuring countersink.

### 173 Can Seam Test Kit, 3 Parts

Includes Can Opener, Nippers and your choice of Micrometers. (If not otherwise specified, 173-C Micrometer will be included.)



### Can Seam Micrometers

Measures seam thickness, seam height, and countersink.

### 173-C Can Seam Micrometer

Graduations: 0.001 inch

Range: 0 to 0.375" thickness and width;  
0 to 0.200" countersink.

### 173-C-Metric Can Seam Micrometer

Graduations: 0.01 mm

Range: 0 to 9.5 mm thickness and width;  
0 to 0.200" countersink.



### Snub Nose

### Can Seam Micrometers

For multi-necked beverage or aerosol cans. Measures seam thickness and seam height.

### 173-C-SN Can Seam Micrometer

Graduations: 0.001 inch

Range: 0 to 0.375" thickness and width

### 173-C-SN-Metric Can Seam Micrometer

Graduations: 0.01 mm

Range: 0 to 9.5 mm thickness and width

## VACUUM ONLY TEST GAUGE

for Cans and Jars

Easy to use. A quick firm stroke forces the pointed needle through the top and the soft rubber gasket material around the needle prevents air from entering the container while you read the gauge. Easy to read 1" graduations in "Hg inside a 2" diameter brass case.



### M-135-A Vacuum Only Test Gauge

30" Hg ("Hg x 25 = mm)





## WARRANTY

ALL DIXIE EQUIPMENT IS GUARANTEED AGAINST DEFECTIVE MATERIALS AND WORKMANSHIP FOR A PERIOD OF UP TO TWELVE MONTHS FROM DATE OF SHIPMENT FROM ATHENS, GEORGIA U.S.A. TO THE ORIGINAL CUSTOMER. DIXIE CANNER WILL REPAIR OR REPLACE AT OUR OPTION, EQUIPMENT WHICH PROVES TO BE DEFECTIVE. THE EQUIPMENT MUST BE RETURNED FREIGHT PREPAID FOR OUR INSPECTION. THE GUARANTEE DOES NOT INCLUDE REPAIR OR REPLACEMENT PARTS REQUIRED BECAUSE OF MISUSE, ABUSE, OR NORMAL WEAR AND TEAR. REPAIRS MADE BY OTHER THAN THE FACTORY, TERMINATES DIXIE CANNER COMPANY'S LIABILITY UNDER THIS GUARANTEE. THIS GUARANTEE IS MADE EXPRESSLY IN PLACE OF ALL OTHER GUARANTEES OR WARRANTIES, EXPRESSED OR IMPLIED, WITH RESPECT TO QUALITY OR FITNESS FOR A PARTICULAR PURPOSE.

300 DOUBLE SEAM

RECOMMENDED DOUBLE SEAM SPECIFICATIONS


	<u>CCC</u>	<u>ANGELUS</u>
SEAMING CHUCK	1366656	95L836
FIRST OPERATION ROLL	SRG126	R-6J
SECOND OPERATION	SRG224	S-41G

MACHINE SET UP SPECIFICATIONS (NOTE 1)	<u>US STANDARD</u>	<u>METRIC</u>
PIN HEIGHT (IN) 300/307 X 603	5.845 ± 0.010	148,46 ± 0,25
300/307 X 710	7.265 ± 0.010	184,53 ± 0,25
BASE PLATE LOAD (LBS)	250 ± 20	113.40 ± 9.07

<u>PRODUCT SPECIFICATIONS DIMENSIONS AND PARAMETERS</u>	<u>SET UP SPECIFICATION</u>		<u>OPERATING SPECIFICATION</u>	
	(IN)	(METRIC)	(IN)	(METRIC)
FIRST OPERATION SEAM THICKNESS	0.108 ± 0.004	2,743 ± 0,102		
FIRST OPERATON COUNTERSINK DEPTH	0.298 ± 0.003	7,569 ± 0,076		
SECOND OPERATION SEAM THICKNESS	0.066 ± 0.002	1,676 ± 0,051	0.064 – 0.068	1,626 – 1,727
SECOND OPERATION COUNTERSINK DEPTH	0.298 ± 0.003	7.569 ± 0,076	0.298 ± 0.005	7,569 ± 0,127
SEAM HEIGHT	0.120 – 0.126	3,048 – 3,200	0.118 – 0.128	2,997 – 3,251
BODY HOOK LENGTH	0.080 ± 0.005	2,032 ± 0,127	0.080 ± 0.008	2,032 ± 0,203
COVER HOOK LENGTH	0.080 ± 0.005	2,032 ± 0,127	0.065 MIN	1,651 MIN
TIGHTNESS RATING	100%	100%	90%	90%
ACTUAL OVERLAP	0.040 MIN	1,016 MIN	0.035 MIN	0,889 MIN

NOTE 1: Machine set up specifications are for initial setting only. Adjustments from these settings should be made as needed to achieve product specification requirements

NOTE 2 Double seam quality is the responsibility of the customer.

Date: 4/2/04	Approved: R RAYBURN	Product:  300 END (.0142")		Metal Beverage Container Operations 9300 W. 108th Circle, Westminster, CO 80021-3682 P.O. Box 589 Broomfield, Co 80038-0589	
Drawn: N ZANETELL	Approved: T NGUYEN			DOUBLE SEAM ALUMINUM CAN US STANDARD & METRIC	THE DESIGNS, INFORMATION AND DATA CONTAINED HEREIN ARE PROPRIETARY AND ARE SUBMITTED IN CONFIDENCE, AND SHALL NOT BE DISCLOSED, USED OR DUPLICATED IN WHOLE OR IN PART, FOR ANY PURPOSES WHATSOEVER WITHOUT THE PRIOR WRITTEN PERMISSION OF BALL CORPORATION. RECEIPT OF THIS DOCUMENT SHALL BE DEEMED TO BE AN ACCEPTANCE OF THE CONDITIONS SPECIFIED HEREIN.
Checked: ZANETELL	Approved:	PRODUCT STANDARD	REV.		
Approved: R MCCAULEY	Approved:	300/307 X 603 300/307 X 710	SEAM-309		A