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Worldwide Dependability — Can Packaging & Processing Equipment

Model UVGMD-ALCC VACUUM/GAS/MULTIFLUSH SEAMER OPERATORS MANUAL



Model UVGMD-ALCC

INTRODUCTION

The Dixie R&D Model UVGMD-ALCC offers your choice of atmospheric, vacuum only, vacuum then gas, or multiflush double seaming.

RANGE: 1½" to 6¼" diameter, up to 7" tall.

Change parts are required for each size can.

CAPACITY: 8 Cans Per Minute - Atmospheric

6 Cans Per Minute - Vacuum

5 Cans Per Minute - Vacuum and Gas

2 Cans Per Minute - Multiflush

For other than atmospheric mode, averages are based on 15" vacuum and, in the multiflush mode, 3 sequences of vacuum then gas flush.

CAUTION

BEFORE OPERATING YOUR DIXIE DOUBLE SEAMER REVIEW THIS MANUAL and supplementary information pertaining to the Vacuum Pump and other accessory items, if any. Also make certain that:

1. The machine is properly connected to your electrical supply.
2. Auxiliary and accessory items are properly attached.
3. Oil filling port on the vacuum pump is filled to recommended levels.
IMPORTANT Use only SAE 20 motor oil. Capacity is 0.5 quart.
4. All moving parts are oiled. These parts will require periodical oiling to prevent unnecessary wear.
5. The machine is properly adjusted for the cans to be closed. Inspect machine adjustments periodically to assure proper results.
6. The machine is cleaned and oiled as needed. Give special attention to servicing before and after a period of inactivity or storage.

OPERATION

Pull red ON/OFF switch to supply power to the machine. The Command Center will initialize and perform self-test. The Command Center screen will display the currently selected Operating Mode. Select or change the Operating Mode as follows.

Refer to separate sections in this manual for identification or location of change parts and how to use the 201-5 Can Top Retainers, if needed.

ATMOSPHERIC:

Press the F1 function key **F1** to select ATMOSPHERIC Mode. Position lid and container. Press the ENTER key **↵** or simply close the chamber door to start the seaming cycle. When machine stops, remove can. The chamber door remains open if the ENTER key **↵** is used.

VACUUM ONLY:

Press the F2 key **F2** to select VACUUM ONLY mode. Position lid on chuck and container on base plate; close door. The preset vacuum value is performed; the can is lifted and double seamed automatically then stops turning; remaining chamber vacuum is released. Operator opens door, removes can and repeats the operation.

Preset desired vacuum value (P1) as per instructions on page 3 for the Digital Vacuum and Gas Programmer (648).

VACUUM THEN GAS:

Press the F3 key **F3** to select VACUUM THEN GAS mode. Position lid on chuck and container on base plate; close door. The preset vacuum and gas values are performed; the can is lifted and double seamed automatically then stops turning; remaining chamber vacuum is released. Operator opens door, removes can and repeats the operation.

Preset desired vacuum and gas values (P1 + P2) as per instructions on page 3 for the Digital Vacuum and Gas Programmer (648). Also, refer to any instructions provided with your gas regulator [Gas regulator and tank are not provided by Dixie Canner Company].

MULTIFLUSH:

Press the F4 key **F4** to select MULTIFLUSH mode. Position lid on chuck and container on base plate; close door. The preset sequences of vacuum and gas values are performed; the can is lifted and double seamed automatically then stops turning; remaining chamber vacuum is released. Operator opens door, removes can and repeats the operation.

Preset desired vacuum and gas values (P1 + P2 and P3 + P4) as per instructions on page 3 for the Digital Vacuum and Gas Programmer (648). Also, refer to any instructions provided with your gas regulator [Gas regulator and tank are not provided by Dixie Canner]. The factory has preset the "hold" time for both vacuum and gas values at 0.1 second, unless otherwise specified at time of order; (i.e., the vacuum value(s) will be held for 0.1 second before another operation is performed and/or the gas value(s) will be held for 0.1 second before another operation is performed or the container is double seamed. The "hold" time for vacuum and gas values may be changed in 0.1 increments up to 9.9 seconds as outlined on the following page. The maximum number of possible multiflushes is 10.

When selecting the number of multiflushes you wish to perform, please follow the guidelines outlined in the following charts as examples. As notated, if the desired number of times selected to perform the vacuum and gas values is an ODD number, then P3 can not be a greater value than P1. [The values for P1 and P3 are set with the 648 Digital Programmer].

Important considerations when choosing the number of multiflushes and preset vacuum/gas values are:

- When in the Multiflush mode, the Model UVGMD-ALCC will only close after either a P3 or P4 value is performed.
- If you desire to pull vacuum one time then close your container, select the Vacuum Only operating mode – only P1 is performed.
- If you desire to pull vacuum one time then gas flush one time, select the Vacuum Then Gas operating mode – only P1 and P2 are performed.
- P3 and P4 values are only effective in the Multiflush mode.

Note: If the seamer should continue to pull vacuum or attempt to close the container repetitively, turn the power to the machine off and on two or three times in rapid succession to stop the repetitive action. Before resuming seaming functions, check the preset values on the 648 Digital Programmer and/or the number of times selected to perform P1 + P2 on the Command Center screen.

EXAMPLES OF MULTIFLUSH OPERATIONS WHEN NUMBER OF TIMES TO PERFORM P1 + P2 IS SET AT AN ODD VALUE

No. of Times to Perform Set Values		Vacuum then Gas Sequences	Closes After	Sequence of Vacuum and Gas Values
P1 + P2*	P3 + P4			
1	1	VAC → GAS	GAS	P1, P4
1	2	VAC → GAS → VAC	VAC	P1, P2, P3
1	3	VAC → GAS → VAC → GAS	GAS	P1, P2, P3, P4
1	4	VAC → GAS → VAC → GAS → VAC	VAC	P1, P2, P3, P2, P3
1	5	VAC → GAS → VAC → GAS → VAC → GAS	GAS	P1, P2, P3, P2, P3, P4
1	up to 10	... etc.	... etc.	... etc.
3	1	VAC → GAS → VAC → GAS	GAS	P1, P2, P1, P4
3	2	VAC → GAS → VAC → GAS → VAC	VAC	P1, P2, P1, P2, P3
3	3	VAC → GAS → VAC → GAS → VAC → GAS	GAS	P1, P2, P1, P2, P3, P4
3	up to 10	... etc.	... etc.	... etc.

* When "Number of Times to Perform P1+P2" is an *odd* number [value set on Command Center Screen], then P3 can not be greater than P1 [values set with 648 Digital Programmer].

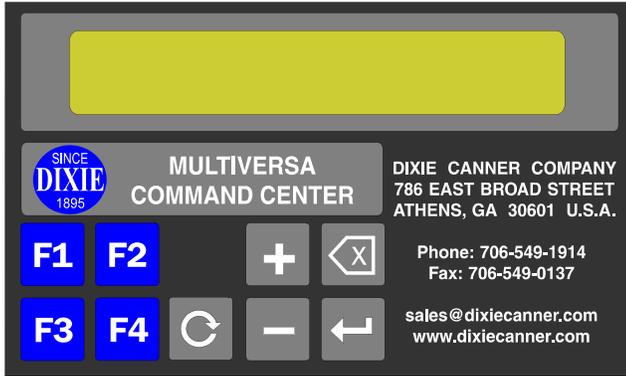
EXAMPLES OF MULTIFLUSH OPERATIONS WHEN NUMBER OF TIMES TO PERFORM P1 + P2 IS SET AT AN EVEN VALUE

No. of Times to Perform Set Values		Vacuum then Gas Sequences	Closes After	Sequence of Vacuum and Gas Values
P1 + P2*	P3 + P4			
2	1	VAC → GAS → VAC	VAC	P1, P2, P3
2	2	VAC → GAS → VAC → GAS	GAS	P1, P2, P3, P4
2	3	VAC → GAS → VAC → GAS → VAC	VAC	P1, P2, P3, P4, P3
2	4	VAC → GAS → VAC → GAS → VAC → GAS	GAS	P1, P2, P3, P4, P3, P4
2	up to 10	... etc.	... etc.	... etc.
4	3	VAC → GAS → VAC → GAS → VAC → GAS → VAC	VAC	P1, P2, P1, P2, P3, P4, P3
4	4	VAC → GAS → VAC → GAS → VAC → GAS → VAC → GAS	GAS	P1, P2, P1, P2, P3, P4, P3, P4
4	5	VAC → GAS → VAC → GAS → VAC → GAS → VAC → GAS → VAC	VAC	P1, P2, P1, P2, P3, P4, P3, P4, P3
4	up to 10	... etc.	... etc.	... etc.

* When "Number of Times to Perform P1+P2" is an *even* number [value set on Command Center Screen], then P3 can be greater than, less than, or equal to P1 [values set with 648 Digital Programmer].

THE MULTIVERSA COMMAND CENTER (650-2)

The Multiversa Command Center is used to select the operating mode and to reprogram the number of operations for vacuum/gas flushes or to change the "hold" time for vacuum and/or gas values. This unit will display the current operating mode, then change to advise what function is currently being performed during the seaming cycle. The following section describes the functions of the Command Center keys.



FUNCTIONS OF THE COMMAND CENTER KEYS

F1, F2, F3, F4: These keys are used to select the Operating Mode as described under Operations.

☺: The Selection key allow the operator to view the total number of cans seamed in each mode. Continue to press the Selection key **☺** to view all menu totals. This will display the total number of cans seamed during each mode, and provide a grand total of cans seamed since the totals were last cleared. All mode totals may be cleared by pressing the Clear key **ⓧ**. Pressing the Enter key **↵** to return to the current Operating Mode.

☺: Press the Dixie Logo key **☺** twice to enter PROGRAM MODE. The screen will display the current settings for the number of vacuum/gas flushes for the preset P1 + P2 and/or P3 + P4 vacuum and gas values, and the programed delay for holding vacuum or gas. Use the Selection key **☺** to display these menu settings, then use the Plus **+** or Minus **-** keys to increase or decrease the setting. Save the new settings by pressing the Enter key **↵**. NOTE: Vacuum (P1 and P3) and gas values (P2 and P4) are set with the Digital Programmer (648) as described under the following heading on this page.

↵: The Enter key **↵** is use to store or save settings. In Atmospheric Mode pressing the Enter key **↵** activates the seaming cycle.

ⓧ: The Clear key **ⓧ** is used to clear counts of cans closed all operating mode, or to reset the Command Center as described below.

The Command Center is programed to advise pause operation each time 5,000 cans have been closed. The Command Center screen will display the message "Press **ⓧ** to Clear." This should remind the operator to "CLEAN AND OIL MACHINE." When the message "Press **ⓧ** to Clear" is displayed, the operator should perform necessary maintenance before clearing the message and resetting the Command Center.

NOTE: The machine will not operate while the "Press **ⓧ** to Clear" message is being displayed; the Command Center must be reset to resume operation. To reset, press the Clear Key **ⓧ**; turn power to machine off and then back on. Turning power off before pressing the Clear key **ⓧ** will not reset the Command Center.

DIGITAL VACUUM AND GAS PROGRAMER (648)

The 648 Digital Vacuum and Gas Programer reads in inches of Hg. Calibrations are in increments of 0.2" Hg. The vacuum pump is rated 29.8" Hg; the maximum recommended vacuum value which may be entered is 29.8" Hg. The lowest recommended value for setting vacuum or gas is 1" Hg. [The 648 Digital Vacuum and Gas Programer is rated $\pm 0.5\%$ accuracy.] Use your finger to set a desired value in the program as explained below.

1. Press the SET button until **F-1** is indicated (within 1 sec.) NOTE: Release the SET button immediately once **F-1** has appeared to avoid changing the factory programming.

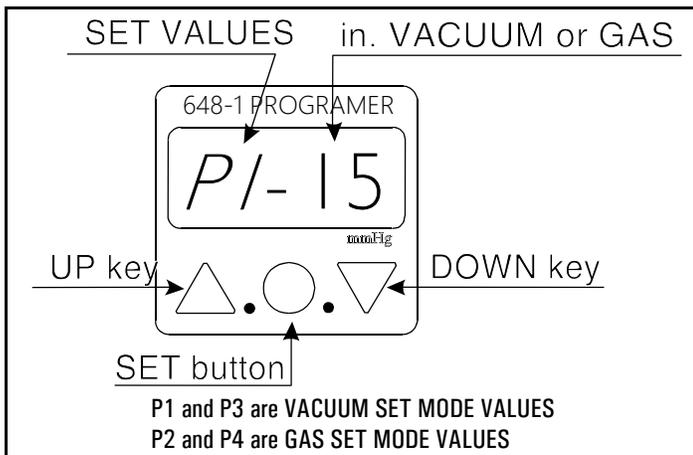
2. Press the SET button until P1 appears on the display followed by the current P1 value. (In the diagram above, 15 represents the current setting for the P1 mode). Release the SET button.

Proceed to Step 3 if you do not want to change the current setting for P1.

Press the Δ key to increase the vacuum value for P1, or press the ∇ key to decrease the vacuum value for P1.

3. Press the SET button until P2 appears on the display followed by the current P2 value. Release the SET button.

Proceed to Step 4 if you do not want to change the current setting for P2.



Press the Δ key to increase the gas value for P2, or press the ∇ key to decrease the gas value for P2.

4. Press the SET button until P3 appears on the display followed by the current P3 value. Release the SET button.

Proceed to Step 5 if you do not want to change the current setting for P3.

Press the Δ key to increase the vacuum value for P3, or press the ∇ key to decrease the vacuum value for P3.

5. Press the SET button until P4 appears on the display followed by the current P4 value. Release the SET button.

Proceed to Step 6 if you do not want to change the current setting for P4.

Press the Δ key to increase the gas value for P4, or press the ∇ key

to decrease the gas value for P4.

6. Press the SET button again. The display will show "0." The vacuum and gas values selected in the previous steps are now programmed into memory and the procedure is complete.

Example - Vacuum Only:

A. Set the digital programer to stop the vacuum pump at 18" Hg by setting the P1 mode at 18.

B. See OPERATION for seaming instructions.

Example - Vacuum Then Gas:

A. Set the digital programer to stop the vacuum pump at 20" Hg by setting the P1 mode at 20.

B. Set the digital programer to replace vacuum (with gas) to 5" Hg by setting the P2 mode at 5.

C. See OPERATION for seaming instructions.

Example - Multiflush:

A. Set the digital programer to stop the vacuum pump at 25" Hg by setting the P1 mode at 25.

B. Set the digital programer to replace vacuum (with gas) to 5" Hg by setting the P2 mode at 5.

C. Set the digital programer to stop the vacuum pump at 20" Hg by setting the P3 mode at 20.

D. Set the digital programer to replace vacuum (with gas) to 5" Hg by setting the P4 mode at 5.

E. See OPERATION for seaming instructions.

NOTE: The number of times the P1 + P2 and P3 + P4 vacuum and gas values will be performed (i.e., number of flushes) is set with the Command Center.

NOTE: The 648 Digital Vacuum/Gas Programer should display "0" when the machine is turned on under atmospheric conditions. If the display fails to read "0," reset by pressing the Δ and ∇ key simultaneously.

(Above examples may be adjusted to change high and low vacuum/gas settings within the entire range.)

CHANGING DIGITAL PROGRAMER (648) TO DISPLAY mm Hg

The 648 Digital Programmer may be programmed to display millimeters of Hg. To change the display settings:

1. Press and hold the SET button until the display reads the current setting. Release the SET button.

2. Press the Δ or ∇ key until the display reads mmHg.

3. Press the SET button to store your changes to the display mode.

4. Set desired values as per above instructions, substituting mm Hg values for in Hg values.

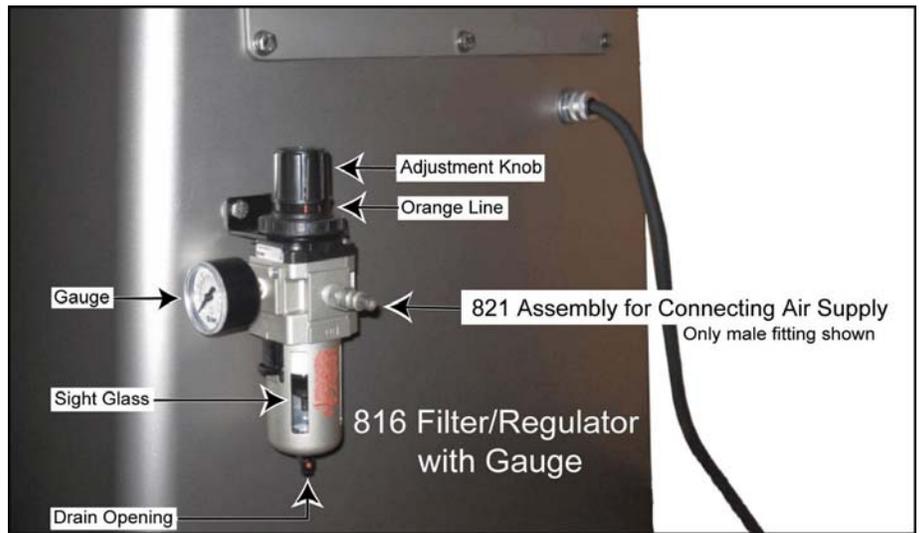
(NOTE: A convenient equation is $25 \text{ x in Hg} = \text{mm Hg}$.)

AIR FILTER/REGULATOR ADJUSTMENT

Recommended air supply is 80-100 psi maximum. Different types of containers may require specific psi settings. The air pressure filter/regulator (816) on your machine has been set at the factory for the sample containers submitted with your order. If you find your air supply is inconsistent, or if you change containers or lids, you may need to adjust the air pressure filter/regulator. Too much air pressure may cause your container to crush your lid against the chuck. Too little air pressure will not lift the container against the lid properly. Any adjustments to the air pressure regulator should be made in small increments until a satisfactory pressure is achieved.

As a general rule, composite containers require a pressure setting of 70 psi; aluminum containers, 85 psi; and tin or steel containers require about 95 psi. However, particular container types may require minimal experimentation to determine the optimum pressure setting.

To set or change the air pressure, pull up on the black knob on top of the regulator until the orange band is visible. Turning the adjustment knob clockwise increases the pressure and turning the knob counterclockwise reduces the pressure. Adjust as necessary while observing the pressure gauge. *Do not exceed 100 psi.* Push down on the adjustment knob to lock air filter/regulator at selected psi to prevent accidental setting change.



The filter element should be changed after 1 year or when a pressure drop of 15 psi is reached. Periodically observe condensate level through sight glass in filter and manually drain as needed.

NOTE: Sufficient air pressure must be provided to cause the plunger of the air lift assembly (803) to extend to its locked position. *Do not exceed 100 psi.*

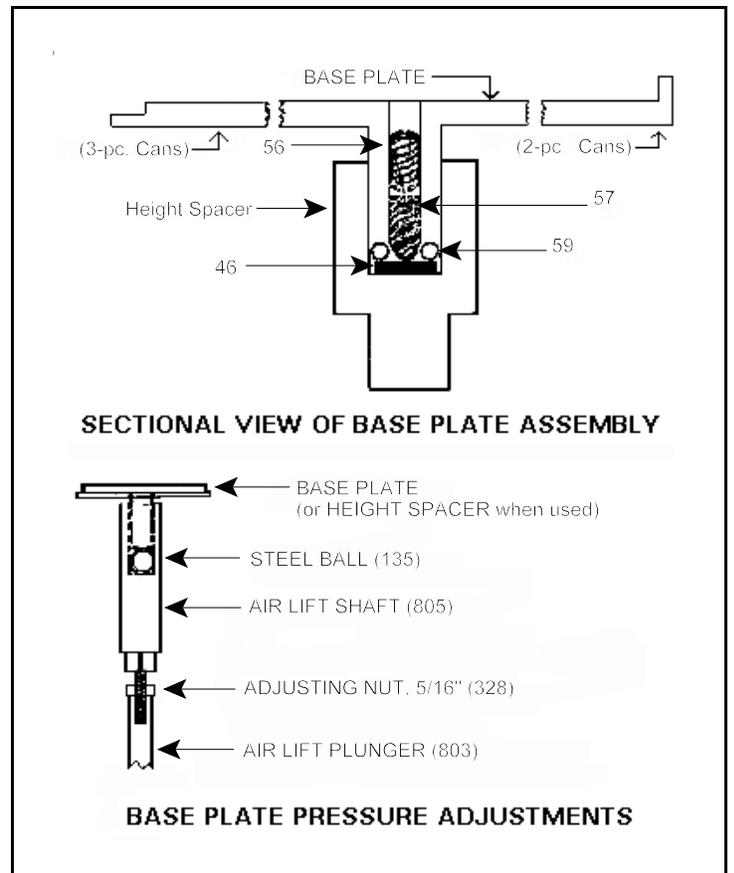
BASE PLATE PRESSURE ADJUSTMENTS

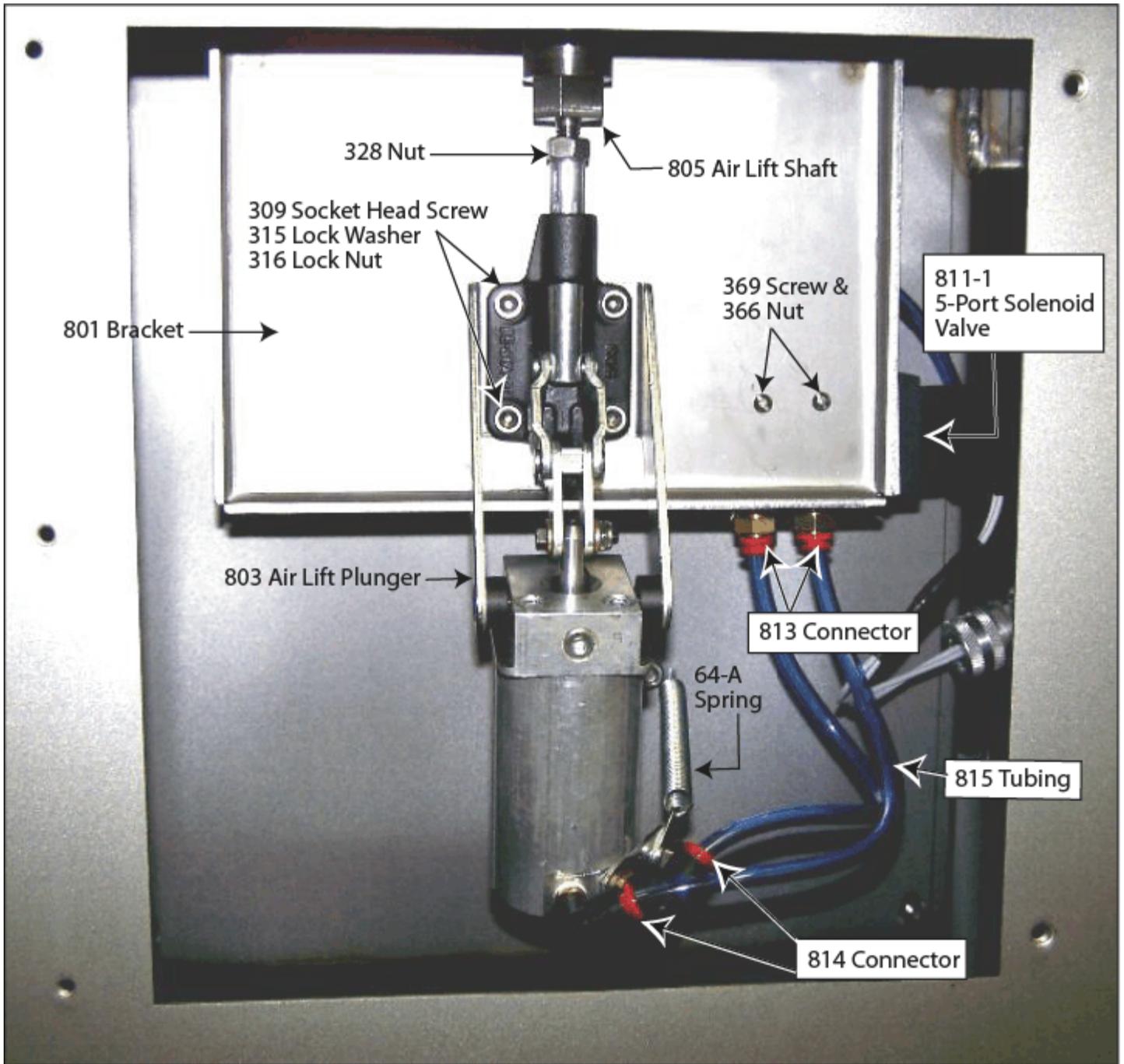
Proper base plate pressure is required to produce essential body hook, and also prevents slipping during the seaming cycle.

Initially, the machine was set-up and adjusted to close cans size 603 x 700 then changed and tested for closing other size cans. Before shipping the machine was equipped and tested to close the cans specified on your order. To make minute adjustments in base plate pressure or to change to cans shorter than 7" proceed as follows:

1. Cans 7" tall do not require a height spacer. Base plate pressure adjustments are made by loosening the 5/16" nut at the base of the 805 lift shaft then turning the lift shaft with a 5/8" open-end wrench at the "flats" on the lift shaft.
2. Cans shorter than 7" require a height spacer and a separate base plate which has an adjusting screw (57) and set screw (56) in it's stem. After loosening the set screw with a screwdriver inserted into the hole, the adjusting screw can be turned with fingers or carefully with pliers to the proper setting. **CAUTION:** If using pliers or nippers to turn the adjusting screw, be careful not to damage threads.

After making adjustments, tighten jam nuts or set screw.





View inside access panel on front of cabinet

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 second operation seam roll is to complete the sealing of the can.

FIRST OPERATION

1. Put machine in neutral position.
2. With power ON, press and release the actuator on the clutch/brake assembly four (4) times. Turn machine OFF, then press the actuator ONE more time to release the clutch brake. Then manually turn the clutch ONE HALF revolution. Grasp the collar (508) by hand, OR, use a wrench to turn the chuck shaft, to turn the assembly in a clockwise direction. These 4½ revolutions of the clutch/brake assembly places the first operation seam roll in its innermost position with the chuck.
3. While power to machine remains OFF, loosen lock nut (16) and adjust set screw (17-A) until the first operation seam roll is snugly in position with the chuck. While holding the first operation gauge wire (40) in position between the chuck lip and the ground profile of the first operation seam roll, tighten the lock nut. The larger diameter gauge wire (40) is the approximate THICKNESS of the first operation seam. Final adjustments may be made after a can is closed and the double seam inspected.

NOTE: It may be helpful to remove or back off the second operation seam roll while setting the first operation. This will perform the seaming cycle without engaging the second operation seam roll. The first operation seam may be visually inspected and/or measured to insure the setting is correct before proceeding with adjustments to the second operation seam roll.

SECOND OPERATION

1. Turn power to machine ON which will automatically complete the fifth revolution. Press and release the actuator FOUR times and turn power to machine OFF. This is a total of nine (9) revolutions from the beginning and puts the second operation seam roll into its innermost position with the chuck.
2. Using your wrench and screwdriver, adjust the second operation seam roll into position. Use the second operation gauge wire (41) to fit the seam roll snugly in position with the chuck then tighten the lock nut. The small diameter gauge wire (41) represents the approximate THICKNESS of the second roll seam. Final adjustments may be made after a can is closed and the double seam inspected.
3. Press the actuator ONE time and turn power to machine ON to complete the 10th revolution and cycle. This will return the machine to its neutral position.
4. Close a can, tear down and inspect the double seam. Make final adjustments of the seaming rolls and base plate pressure to produce essential body hook, cover hook, overlap and tightness recommended by the container manufacturer or for a hermetically sealed can. **NOTE:** 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. Be 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 adjust set screws (17-A) until both seaming roll levers (206) are back as far as they will go. If needed, change seaming rolls and/or reposition seam levers on the splined shafts (204-A). Leave the seaming roll levers backed into this position until after the chuck has been changed.
3. Change chucks. Make certain that the new chuck is properly tightened into position against the shoulder of the chuck shaft.

CAUTION: (a) Use an open end wrench at the flat surface on the chuck shaft and the chuck wrench while loosening or tightening the chuck to prevent damage to the clutch/brake. (b) If it is necessary to reposition 206 and 204-A, make certain the lip of each seaming roll runs freely in the chuck groove when in their innermost (seaming) position after the cap screws (322) are tightened.

CHANGING CHUCKS

To remove the chuck, hold the chuck shaft with a 5/8" wrench on the cut side of the shaft, located in the exposed area under the gear housing. Then place the two pins of the chuck wrench (44) 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. When necessary remove and reset the seam roll levers (206) so the seam rolls will be about 1/2" from the chuck lip. Minimum travel of the seam roll levers is desired when turning the adjusting screws. **CAUTION:** Use a box wrench to loosen or tighten the bolt securing the seaming roll levers in position on the splined seam roll lever drive shaft. After tightening the bolt make certain that the lip of each seaming roll runs freely in the chuck groove when they are in their innermost (seaming) position and if necessary repeat the adjustment until the seaming roll levers are properly secured into position on the splined shaft.
5. Install the proper base plate

Model UVGMD-ALCC 115 Volts

Brown - 648 Digital Programmer +
Black- 650-2 Command Center

Brown - 664 Sensor Counter

Brown - 659 Door Switch

White - 650-2 Command Center

Red - 648

Red - 650-2

White - 648

Black - 648

Red - 664

Red - 659

Black - 684

Black - Power Cord

Black - 684

Black - Motor

Black

Black

Black - 811-1

Black - Vacuum Pump 1L1

Black - 666 Gassing

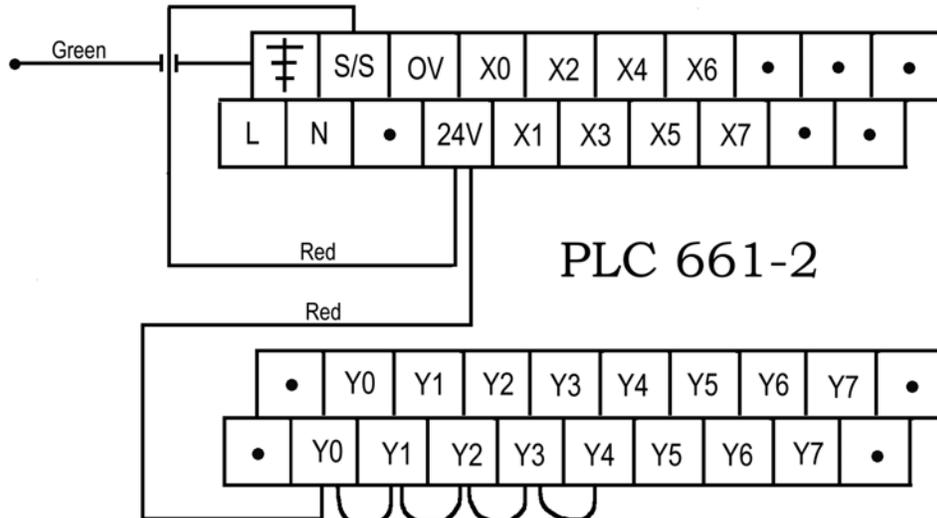
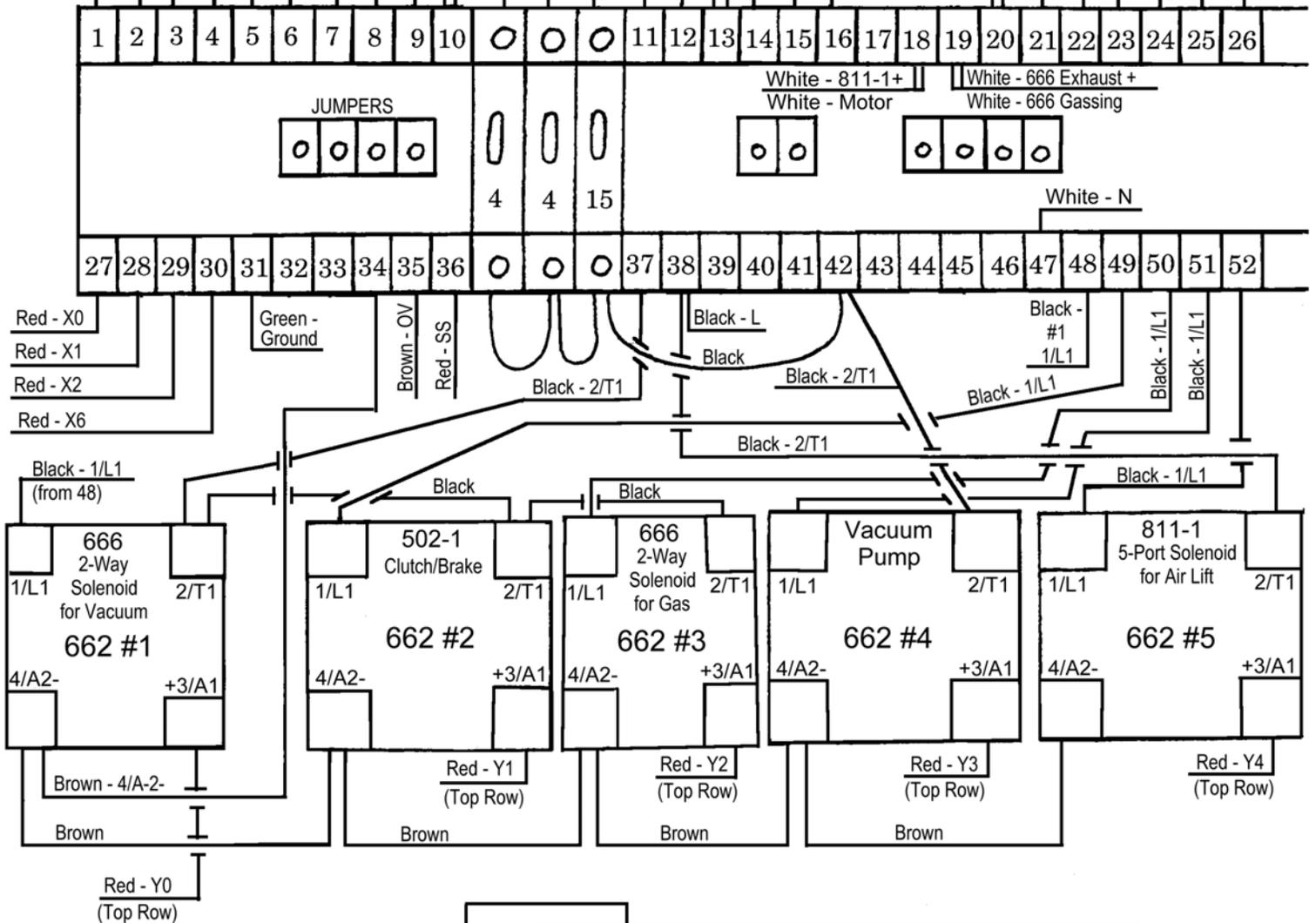
Black - 502-1 Clutch/Brake

Black - 666 Exhaust

White - Power Cord

White 502-1 +

White - Vacuum Pump 3L2



Model UVGMD-ALCC 220 Volts

Brown - 648 Digital Programmer +
Black - 650-2 Command Center

Brown - 664 Sensor Counter

Brown - 659 Door Switch

White - 650-2 Command Center

Red - 648

Red - 650-2

White - 648

Black - 648

Red - 664

Red - 659

Black - 684

Black - Power Cord

Black - 684

Black - Motor

Black

Black

Black - 811-1

Black - Vacuum Pump 5L3

Black - 666 Gassing

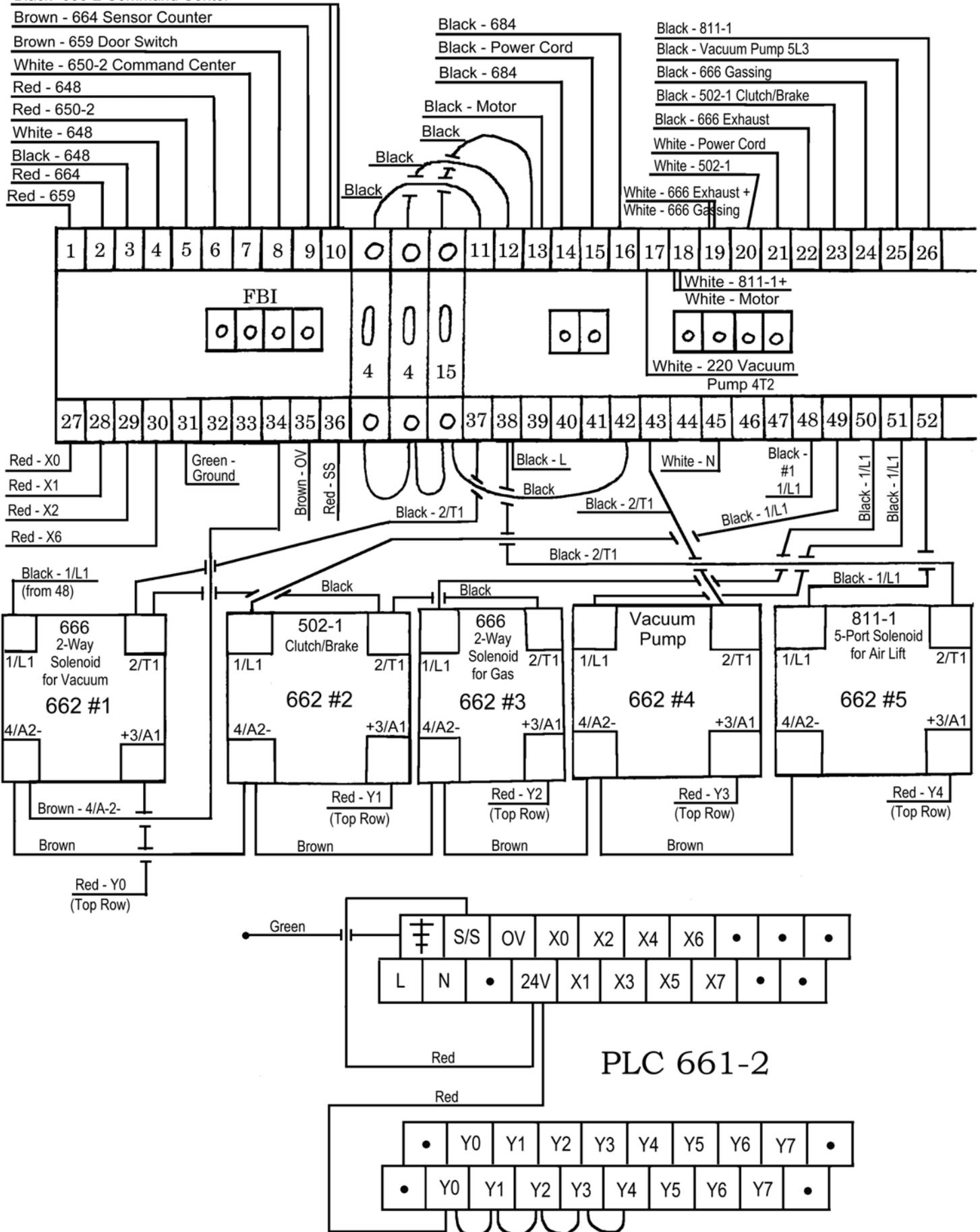
Black - 502-1 Clutch/Brake

Black - 666 Exhaust

White - Power Cord

White - 502-1

White - 666 Exhaust +
White - 666 Gassing





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Worldwide Dependability — Can Packaging & Processing Equipment

MODEL UVGMD-ALCC PARTS LIST

PART NO.	DESCRIPTION
8	Cam Housing with 8-B Insert
8-B	Insert for Cam Housing
11	Seam Roll Lever Spring
13	Seaming Cam
15	Spur Gear
16	Lock Nut, S.S.
17-A	Seam Roll Lever Set Screw, Swivel Pad
18	Cam Roll Lever Set Screw
19	Cam Roll Lever Spring
20	Cam Roll
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
63	Clip for Tension Spring No. 64
64	Tension Spring
123-1	1st Operation Cam Roll Lever
124-1	2nd Operation Cam Roll Lever
135	Steel Ball
200	Guard
200-2	Bushing
20123	Chamber, 7"
20123-1	Chamber, 15"
201-1	Bushing
201-2	Seal
201-3	Seal
201-4	Bearing
201-5	Can Top Retainer
202-1	Bushing
202-2	Seal
204-A	Seam Roll Drive Shaft
205	Seam Roll Drive Lever
206	Seam Roll Lever
207	Seam Roll Screw
208D-1	Chuck Shaft
209	Door, 7"
209-A	Door Gasket, 7"
209-1	Door, 15"
209-A15	Door Gasket, 15"

PART NO.	DESCRIPTION
210	Door Window
210-A	O-Ring for Door Window
211	Door Handle
212	Door Lever Arm, 7"
212-1	Door Lever Arm, 15"
213	Door Spring Stud (Door)
213-A	Door Spring Stud (Chamber)
214	Door Lever Bushing
216	Spacer for Door Pivot Stop
216-A	Bolt, 3/8" x 2-1/2" Round Head, S.S.
217	Spring (Door/Treadle)
218	Door Pivot Stop
223-2	Nut
248	Vacuum Pump 115/60/1
248-X	Vacuum Pump 220/50/1
248-B	Bushing
248-Filter Assem	Assembly, Inlet Filter for 248
303	8-32 x 3/4" Socket Cap Screw
304	10-32 x 1/4" Set Screw
305	1/4"-20 x 1/4" Set Screw
308	1/4"-28 x 3/4" S.S. Hex Head Cap Screw
309	1/4"-20 x 3/4" S.S. Socket Head Cap Screw
311	1/4"-20 x 1" S.S. Hex Head Cap Screw
314	1/4" S.S. Flat Washer
315	1/4" S.S. Lock Washer
316	1/4" Lock Nut for Mounting 816
322	5/16" x 1-1/4" S.S. Hex Head Cap Screw
323	5/16" x 1-1/2" S.S. Hex Head Cap Screw
325	5/16" S.S. Flat Washer
326	5/16" S. S. Lock Washer
328	5/16" S.S. Hex Nut
330	3/8"-16 x 3/4" Hex Head Cap Screw
331	3/8"-16 x 1" Hex Head Cap Screw
332	3/8" x 2-1/2" S.S. Cap Screw
333	3/8" x 4" S.S. Hex Head Cap Screw
334	3/8" S.S. Flat Washer
335	3/8" S.S. Lock Washer
336	3/8"-16 S.S. Finished Nut
341	1/2" S.S. Flat Washer
342	1/2" S.S. Lock Washer
352	3/8"-16 x 4-1/4" S.S. Hex Head Cap Screw
366	6-32 Hex Nut
367	6-32 x 1/2" S.S. Machine Screw
369	6-32 x 1-1/4" S.S. Machine Screw
371	10-32 S.S. Nut
373	10-32 x 3/4" S.S. Machine Screw
374	1/4"-20 x 1-1/2" S. S. Socket Head Cap Screw
374-1	Modified 374 S.S. Socket Head Cap Screw
375	8-32 x 1/2" S.S. Machine Screw
379	1/2"-13 x 1-1/2" S.S. Hex Head Cap Screw
381	10-32 x 1/4" S.S. Machine Screw
382	1/4"-20 x 1/2" S.S. Hex Head Cap Screw
400	1/4" 90° Elbow, S.S.

PART NO.	DESCRIPTION
415	Gas Inlet Fitting
415-D	1/2" Square Head Plug, S.S.
425	1/2" 90° Elbow, S.S.
427	1/2" Tee, S.S.
428	1/2" Union, S.S.
431	1/2" Closed Nipple, S.S.
433	1/2" x 2" Nipple, S.S.
446	1/2" x 3" Nipple, S.S.
447	1/2" x 4-1/2" Nipple, S.S.
450	1/4" x 3" Nipple, S.S.
452	1/4" x 1/8" Bushing, S.S.
454	1/4" x 1-1/2" Nipple, S.S.
501-6	Motor
502-1	Clutch/Brake/Solenoid Assembly
503	Gear Housing with Flange Bearing 503-A
503-A	Flange Bearing for 503
504-1	Gear Housing Cover Plate
505-1	Spacer
506-1	Motor Platform
507	Frame Post for Motor Platform
508	Drive Collar
511	#9 Woodruff Key
526-1	Cabinet
526-A	Gasket for 526-1 Cabinet
526-C	Face Plate
570	Clutch/Brake Guard & Frame
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
603-2	Connector, 45°
604	Terminal Cap
605-1	Cord Connector - 1850
605-2	Cord Connector - 3150
605-3	Cord Connector - CG1250
605-4	Cord Connector - CG250
606	1/2" Straight C Condulet
607	1/2" T Condulet
607-A	1/2" Condulet Cover & Gasket
608	1/2" Pull Elbow
609	1/2" Aluminum Lock Nut
610	1/2" Aluminum Coupling
611	1/2" Aluminum Closed Nipple
612-1-1/2	1/2" 1-1/2" Aluminum Nipple
612-2	1/2" x 2" Aluminum Nipple
612-3	1/2" x 3" Aluminum Nipple
612-4	1/2" x 4" Aluminum Nipple
612-5	1/2" x 5" Aluminum Nipple
612-7	1/2" x 7" Aluminum Nipple
612-8	1/2" x 8" Aluminum Nipple
612-12	1/2" x 12" Aluminum Nipple

PART NO.	DESCRIPTION
612-13	1/2" x 13" Aluminum Nipple
612-15	1/2" x 15" Aluminum Nipple
612-18	1/2" x 18" Aluminum Nipple
614	Sealing Ring
627	1/2" LB Condulet
648	Digital Vacuum and Gas Programmer
650-A	Bezel Frame
650-2	Multiversa Command Center
651-2	OIT to PLC Cable for Command Center
659	Door Switch
659-1	Magnet for 659 Door Switch
659-2	Bracket for Mounting 659-1
661-2	Programmable Controller for Command Center
662	Solid State Relay 25 Amps 120
664	Sensor/Counter
664-A	Magnet for 664 Sensor/Counter
664-B	Bracket for 664 Sensor/Counter
666	2-Way Solenoid Valve
674	Terminal Block
675	Terminal Block
675-A	FBI 10-6 Jumper
676	End for Terminal Block
678	4 Amp Fuse
684	Start/Stop Switch with Contact Block
684-2	Pull to Start/Push to Stop Legend Plate
689	15 Amp Fuse MDA-15 Time Delay Ceramic Tube
801	Bracket for 803 Air Lift Plunger
803	Air Lift Plunger
804	Platform Spacer, 3/4" x 5/8"
805	Air Lift Shaft
811-1	5-Port Solenoid Valve
813	Male Connector
814	Male Elbow, 1/8" NPT
815	Polyurethane Tubing, per foot
816	Filter/Regulator with Gauge
816-A	Gauge for 816
819-1	Muffler, 1/8" for 5-Port Solenoid Valve 811-1
821	1/4" NPT Coupler/Plug Assembly

PART NO.	DESCRIPTION
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CHANGE PARTS

Seam Rolls
Seam Roll Bushing

Chucks 108 to 404 diameter
 405 to 603 diameter
 604 to 610 diameter
 Add for Magnets in Chuck (vac/gas seamers only)
 Add for Special

Base Plates 108 to 404 diameter
 405 to 603 diameter
 604 to 610 diameter
 Add for Modified Base Plate

Height Spacer

SPK/UVGMD-ALCC SPARE PARTS KIT for UVGMD-ALCC		
2	11	Seam Roll Lever Spring
2	18	Cam Roll Lever Set Screw
2	19	Cam Roll Lever Spring
2	207	Seam Roll Screw
2	678	4 Amp Fuse
5	689	15 Amp Fuse
1	664	Sensor/Counter
4	664-A	Magnet for 664 Sensor/Counter
1	803	Air Lift Plunger
1	805	Air Lift Shaft

HEAD-UD-UVGD HEAD ASSEMBLY (assembled)		
1	8	Cam Housing with 8-B Insert
1	13	Seaming Cam
1	15	Spur Gear
1	208D-1	Chuck Shaft
1	503	Gear Housing with Flange Bearing
2	309	1/4-20 x 3/4 S.S. Socket Head Cap Screw
2	315	1/4 Lock Washer