

# OKTOBER CAN SEAMERS

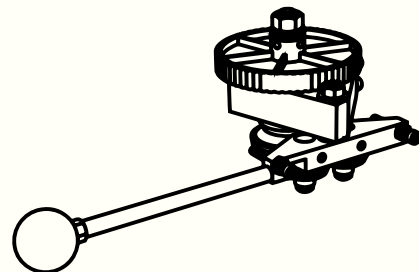
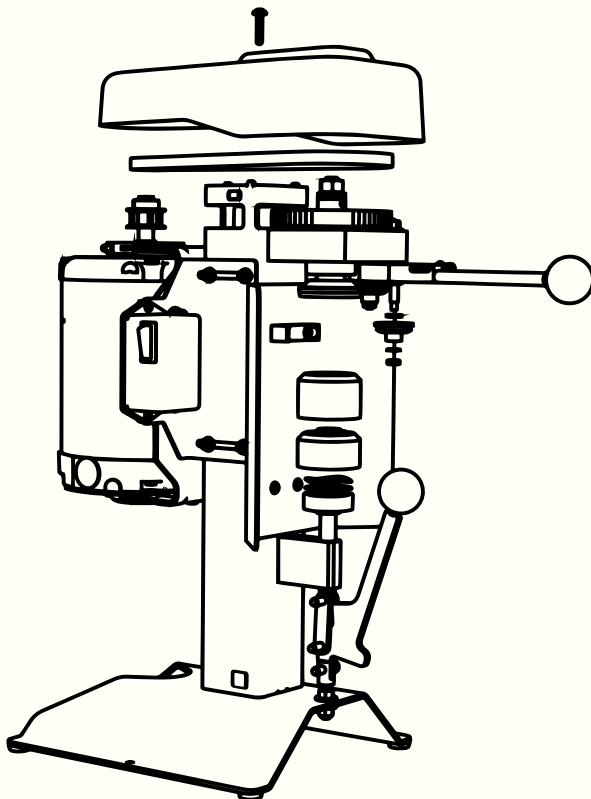
*Oktober*

CAN SEAMERS

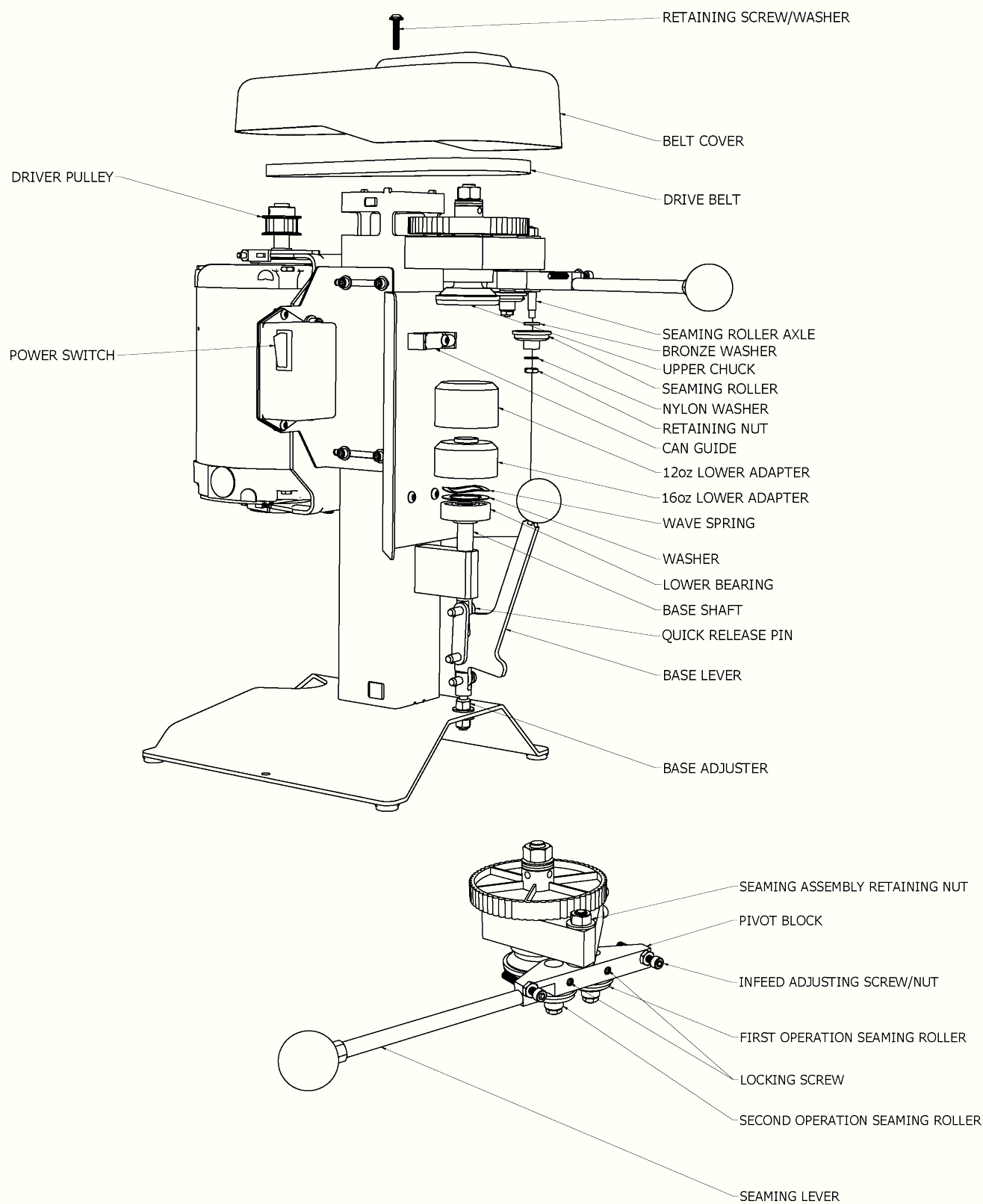
## Operator's Manual.



### SL1 Homebrewer Can Seamer



# The SL1 Homebrewer Can Seamer



# Setup

To get started, assemble the Seaming Lever into the Pivot Block. Use a 7/16in wrench to lightly tighten the lever as shown. If the lever backs out during seaming, it can bend the threads and break!



The SL1 comes set up for 16oz cans. To seam 12oz cans, place the 12oz lower adapter (white plastic cylinder) onto the 16oz lower adapter and press it into place.



You seamer comes PRE-CALIBRATED, so you don't need to make any adjustments before getting started.

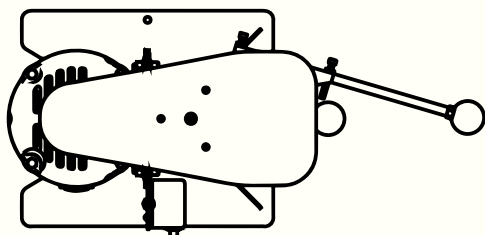
# Safety First!



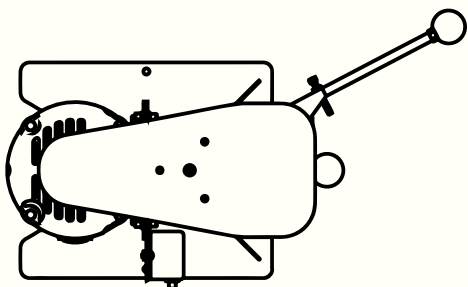
Make sure to locate your seamer in a position that has enough space to move around it easily. Also, make sure to pay attention to things like long hair, loose clothing, etc. as **the can will be spinning and can cause injury** if anything gets caught on or around it. Be careful to not reach into the machine or remove the cover at any time while it is plugged in! Canning is done in a wet environment, so always plug the seamer into a GFCI outlet to avoid shocking hazards.

## Seaming

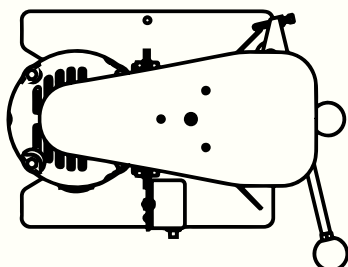
Seaming is simple, and after a few practice cans it should be a smooth, continuous process. It helps to go through the steps without a can a few times to get a feel for it. The force required to actually seam a can is not much more than it takes to run the seamer without a can.



POSITION 0



POSITION 1



POSITION 2

1. Rotate the Seaming Lever to position 0 as shown. The black knob should be somewhere near centerline of the seamer.
2. Place an end (can top) onto the can to be seamed.
3. Set the can onto the lower adapter, and lean the can back against the Can Guide.
4. Raise the Base Lever until it is locked into place. Note: the lever will not lock in-place without a can placed on the lower adapter.
5. Turn the Power Switch to “on”
6. Rotate the Seaming Lever to the right until the first operation Seaming Roller contacts the rim of the can end, then continue rotating the lever until it contacts the hard-stop. It should take about 2sec to rotate from first contact to the stop. Hold the lever against the stop for a second or two, then rotate the lever back to position 0. Note: it doesn't take much force to seam the can; as soon as the lever stops, it has gone far enough.
7. Rotate the Seaming Lever toward position 2 until the second operation Seaming Roller contacts the rim of the can end. Continue rotating the lever to until it contacts the hard-stop. It should take about 2sec to rotate from first contact to the stop. Hold the lever against the stop for a second or two, then immediately rotate the lever back to position 0.
8. Turn the Power Switch to “off”
9. Rotate the Base Lever down to release the sealed can.

**If the can stops spinning during the seaming cycle, its likely that the lever is being rotated too quickly.**

**Make sure to not hold the lever against the stops at position 1 and 2 for too long; eventually the seaming rollers will create a rough surface on the edges of the can.**

# After Every Use

Keeping your seamer clean from sticky beer residue is key to keeping everything working properly. Warm water and a rag is all that is needed to keep residues from building up. Make sure to dry everything off after wiping it down.

The upper chuck and rollers are made of hardened steel. After every use, clean them with a wet rag and dry them thoroughly. Use a dry rag to rub a thin layer of food-safe grease or oil onto those surfaces to minimize surface rust.

Lift the 16oz lower adapter off the Lower Bearing and use a rag to clean the Wave Spring (looks like a curved/bent washer) and Washer with water. Dry them and apply some grease. Apply a small amount of grease to the bearing as well before re-assembling them in the same order (bearing-washer-spring-adapter).



Remove the Quick-Release Pin from the Base Lever and pull the Base Shaft up and out of the housing. Clean the bore and shaft, and apply a layer of grease to the shaft. If the shaft becomes jammed due to sticky residue or lack of grease, the Base Adjuster can bend and break.





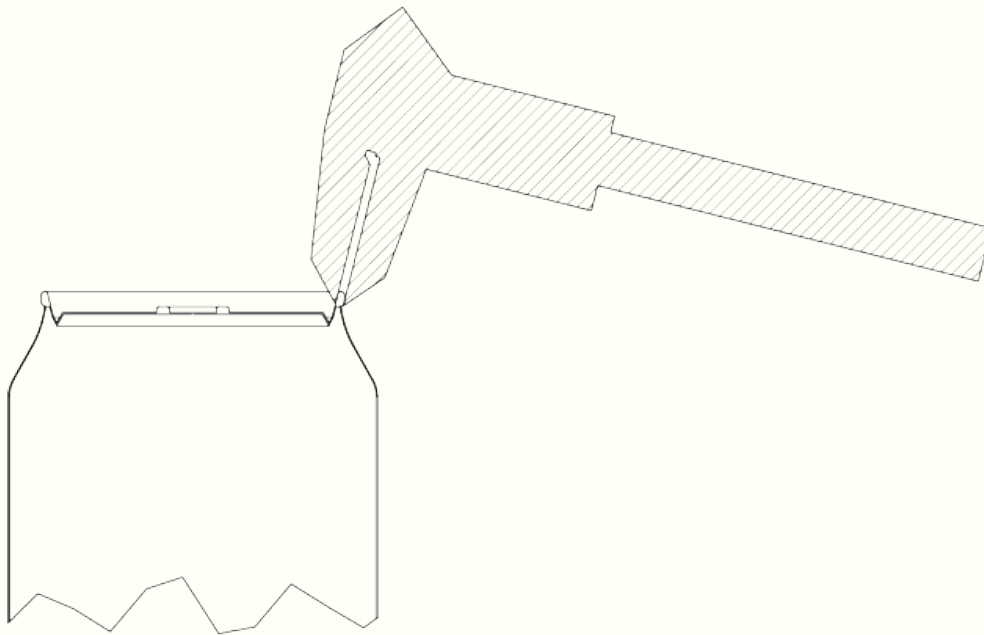
# Seam Inspection

Inspecting seams periodically will ensure the quality of your seams over time. It's a good idea to inspect a seam after every 500 cans or so. If they remain in-specification, you can inspect them less often.

Our method of seam inspection requires a “tear down tool”, some nippers or wire cutters, and a set of calipers. The tear-down tool and calipers are available on the Oktober website.

When measuring the seam thicknesses, the calipers should be parallel to the inside taper of the can (as shown below), rather than the straight sides of the can. If the calipers are parallel to the sides of the can, the measurements will be incorrectly large.

Make sure to not squeeze the calipers too tightly when measuring. Use the lightest pressure possible to allow the calipers to close against the seam. If too much pressure is used, the seam will appear smaller than reality.







1. Complete the first seaming operation ONLY, and remove the can from the seamer.

2. Using calipers, measure the thickness of the seam as shown. The first operation seam thickness should be between **.074 and .078in**



3. Complete the second operation ONLY, and measure that thickness as shown. The second operation seam thickness should be between **.046in and .048in.**



4. Using a tear-down tool, cut the top of the can off.





5. Using nippers or wire cutters, cut all the way through the remaining seam



6. Pull the seam down and out of the can body as shown.



7. Measure the “body hook” and “cover hook” as shown in at least 3 places around the perimeter of the seam. The Cover hook should be **.053in-.065in**, and the body hook should be between **.055in and .075in**



# Calibration

## Infeed Adjustment

1. Start by measuring the 1st operation seam thickness as described in the seam inspection steps.

2. Always start adjustments from a thickness measurement that is too large (For instance, .080in for the 1st operation). Going too far in with adjustments can damage the seaming rollers.



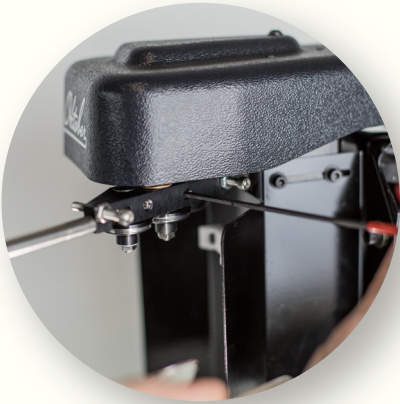
3. Loosen the first operation adjusting nut. To adjust the seam thickness, rotate the adjusting screw OUT (counter clockwise) approx. 1 turn for every .001in the thickness is too large, then re-tighten the nut. ***For instance, if the measurement was .080in, rotate the screw OUT 2 rotations to get down to approx. .078in***



4. Run the 1st operation again, and re-measure the 1st operation seam thickness. Continue adjusting the screw position until the 1st operation thickness is within specification.

5. Calibration of the 2nd operation is the same steps as for the 1st operation. Run the operation, measure, and adjust the screw as necessary.

## Vertical Adjustment



1. To reset the vertical roller positions, rotate the seaming lever to position 1



2. Loosen the 1st operation locking screw as shown



3. The roller should now be free to move up and down. Hold the roller up against the pivot block, then rotate the pivot block to locate that roller over the top of the upper chuck



4. Pull the roller down to contact the upper chuck, and re-tighten the locking screw.

5. Repeat the same procedure for the second operation roller

# Base Force

The base force is critical to a good seam, and can have a strong effect on the hook lengths, particularly the body hook length. Generally, a short hook length, particularly body hook, can be caused by insufficient base force. Note that a broken or missing lower chuck spring can also cause deficient lower lifter force..

1. To adjust the base force, first loosen (counterclockwise rotate) the "upper" Base Adjustment nut until there is no clamping force when raising the lever with a can loaded onto the lower chuck (the handle will no longer stay up on its own). You will need to snug up the lower nut before checking to make sure there is no clamping force.



2. With a can engaged in the chucks and the base lever held up by hand (it should not stay up on its own at this point) loosen the bottom nut, and tighten the top nut in sequence until the base lever no longer has any "play". The lever should stay up on its own at this point, but just barely.

3. Loosen the bottom nut 2 full turns (12 "flats" on the nut), then rotate the upper nut approx. 1 3/4 rotations clockwise to raise the adjuster to the correct position.

4. Finally, adjust the lower nut so that it creates a light resistance when rotating the lever horizontally.

5. Load a can and confirm a solid clamp when locking the base lever into place.

Seam a can, and confirm the hook lengths are sufficient. If they are still low, adjust the nuts ¼ turn or so, and re-check. If the cans are crushing, the force is too high.



# Maintenance/Troubleshooting

## Greasing Roller Axels

After every 1000 cans or so, the seaming roller axles need to be greased. Remove the seaming roller retaining nuts and remove the rollers and washers from their axles. Clean the rollers and axles with warm water, dry them, and apply a thin layer of grease to the axle shafts. Reassemble the rollers, washers, and retaining nuts in the order they were removed. Tighten the retaining nuts only enough to take up the vertical play, but also allow free rotation of the seaming rollers. For further cleaning, it may help to remove the seaming roller axles from the pivot block by loosening the locking screws and pulling them down and out of the block.



## Motor Won't Turn On

If the motor does not turn, it is likely that the thermal overload switch has tripped. It can be reset by pushing the red button located under the motor.



## Rough Sound/Clicking

If the seamer makes a loud clicking noise during the seaming operations, it is likely that the timing belt is slipping. Remove the belt cover retaining screw and pull the belt cover off the machine. Loosen the (4) screws located on each side of the frame (8 screws total). Slide the motor back to tighten the belt and re-tighten the screws. The belt only needs to be tight enough to take up the slack.



## Belt Slips Off

You may need to re-align the small driver pulley after tightening the belt, or if the motor becomes out of alignment during shipping. To do that, loosen the set screw located on the side of the pulley and raise or lower the pulley to center it relative to the main driven pulley and re-tighten the set screw. To make sure the pulley is properly aligned, you will need to turn the motor “on”. Be careful when turning it on, as the belt and pulleys will be spinning and are hazardous.





## Loose Seaming Assembly

Over time, the roller assembly pivot block may need to be tightened up. Basically, there should be minimum “play” between the rotating assembly and the housing and a light friction drag. Use a 3/16in allen key and a 1/2in wrench to snug up the seaming assembly retaining nut. The lever should still rotate freely, but with as little play as possible. There should be a light drag on the lever when rotated.



## Contact Us

Feel free to contact us if you have any other questions! Our team is always happy to help.

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