

**OKTOBER CAN SEAMERS  
MODEL 8  
CALIBRATION INSTRUCTIONS**



**ORIGINAL LANGUAGE - AUGUST 8, 2023**

**OKTOBER CAN SEAMERS  
5 COLFAX ST. NE  
GRAND RAPIDS, MI 49505**

CHECK OUT OUR HOW-TO VIDEOS ON OUR WEBSITE OKTOBERDESIGN.COM



**READ THIS FIRST!**



Oktober Can Seamers are factory calibrated and tested before they ship. There are situations that can effect seam quality other than roller calibration, so be sure to rule out those factors before attempting to recalibrate your seamer. Those factors include:

**Improper Base Force**

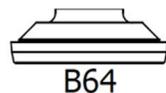
Depending on the source or manufacturer of the cans you are sealing, the base may require initial adjustments. If the can stops spinning during any part of the cycle, it is likely due to insufficient base force (the force that clamps the can in the machine). The force is increased by adding spacers under the base adapter (see diagram on page 2). If cans are being crushed while loading, spacers can be removed to lower the force. The base force has a large effect on the body hook length of the seam, and a seam inspection is required after any base force adjustments.

**Upper Chuck is Loose**

Another reason the can may stop spinning could be insufficient torque on the upper chuck's fastening screw. Use a 3/16in hex key to hand-tighten the screw if it is loose.

**Incorrect Can Ends**

There are several sizes and "profiles" of can ends (tops), and seamers tooling is specific to each one. Check to ensure that the can ends you are sealing match the tooling of your seamer.



B64



CDL



SuperEnd (360end)

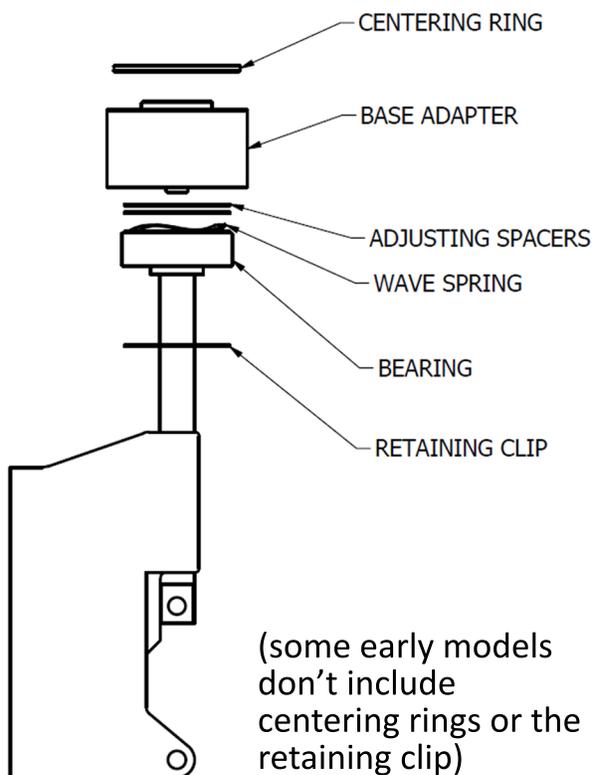


**Rollers Assembled in the Wrong Locations**

It is possible that when changing the tooling, the 1st and 2nd operation rollers were improperly assembled. Make sure that the 1st op roller is located on the left side (as shown on page 2) and the 2nd on the right. Rollers are labeled on their top surface.



REMOVE THE RETANING CLIP WITH A SMALL SCREWDRIVER



RE-ASSEMBLE IT BY SETTING THE FLAT EDGE IN THE SLOT AND PRESS IT IN BY FOLLOWING IT AROUND WITH A FINGER



## Centering Ring is the Incorrect Size

Check that the centering ring (see page 2) fits your cans. The bottom dome of the can should fit over the ring with a minimum of radial play. Seamers are shipped with several sizes of rings to fit most can manufacturers. Use a small screwdriver to remove the ring from the base adapter. Set the ring inside the bottom dome of the can to check the fit. If the ring is too small the can will wobble which may effect the seam quality. If it is too big the can will not load properly.



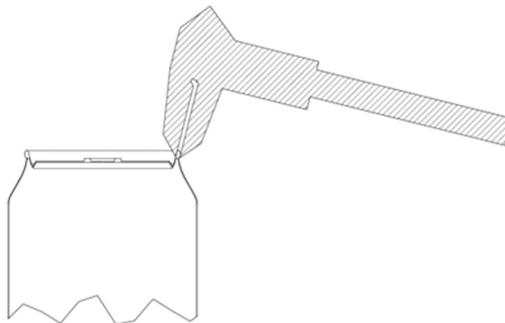
# SEAM INSPECTION

Before calibration it is essential to inspect a can seam. The values measured will guide the amount and direction needed to adjust the rollers. After adjustments it will be necessary to inspect another seam to ensure the seamer is within specification.

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 parallel to the straight sides of the can.

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) remove the 2nd operation roller using a 7/16in wrench.



2) Load an unseamed can and end into the seamer and run the seaming cycle.

3) Remove the can and measure the first operation seam thickness using calipers. Make sure to record the value, you will need it to know how much to adjust the roller infeed.

**FIRST OPERATION SEAM THICKNESS:**

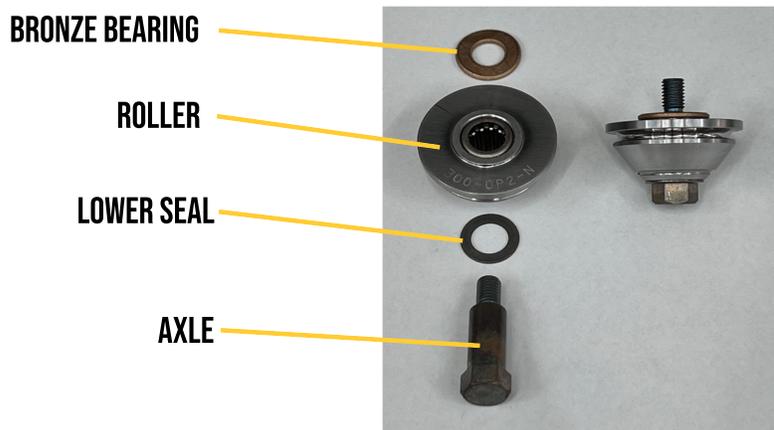
**SIZE 200 AND 202 ENDS  
.074IN - .078IN**

**SIZE 206 ENDS  
.074IN-.078IN**

**SIZE 300 ENDS  
.104IN - .112IN**

**SIZE 401 ENDS  
.070-.080**

4) Re-install the 2nd operation roller. When re-installing the roller, make sure the bronze bearing remains centered on the roller axle. If it becomes pinched while tightening the axle it can deform the washer or lead to the axle breaking at the threads. Also this may be a good opportunity to add food-safe grease to the needle bearing and bronze bearing.



5) Place a can in the seamer and re-run the cycle. Remove the can and measure the 2nd operation seam thickness. Record the value.

**SECOND OPERATION SEAM THICKNESS:**

**SIZE 200 AND 202 ENDS  
.043IN - .046IN**

**SIZE 206 ENDS  
.046IN-.050IN**

**SIZE 300 ENDS  
.064IN - .068IN**

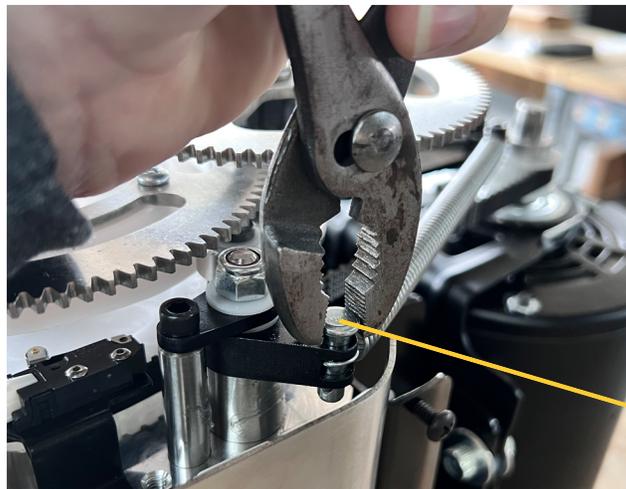
**SIZE 401  
.046-.052**

# CALIBRATION



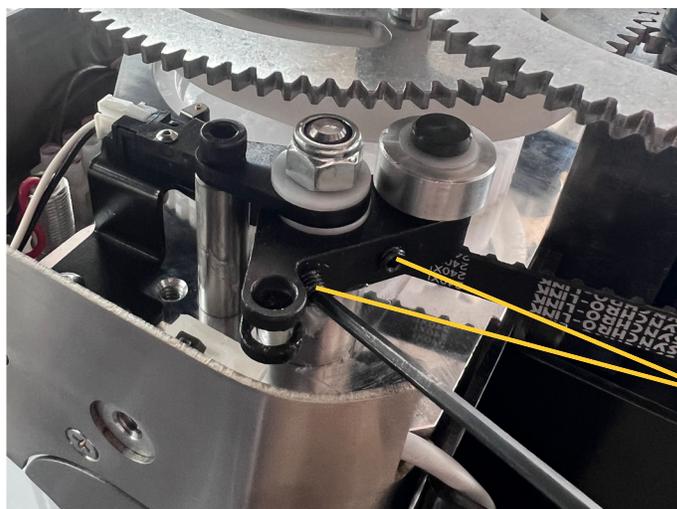
Calibrating the Model 8 MUST be done correctly and in the proper order as described below. Failure to follow the proper procedure will lead to damage to the cam system and gear drive.

- 1) Disconnect the seamer from power.
- 2) Remove the top cover (metal panel and black plastic bezel) by removing the (4) screws on the top surface of the seamer.
- 3) Remove the spring retaining pin from the operation you plan to recalibrate by pulling it up and out using pliers.



spring retaining pin

- 4) Loosen BOTH rocker screws enough to show threads outside of the rocker housing. A 3/32in ball-tipped hex key works best.



rocker screws

5) Loosen the infeed adjuster screw nut using the provided wrench and adjust the stop screw based on the seam inspection values. Turning the screw clockwise will make the seam thickness smaller; counterclockwise will make it larger.



To roughly calculate the number of rotations required, divide the amount you need to adjust by the following value:

200, 202 and 206 ends: **.004**

209 and 300 ends: **.003**

401 ends: **.002**

for example: if the 1st op seam thickness on a 202 seam measured .085in, you would turn the screw clockwise  $(.085-.076)/.004=2.25$  turns.

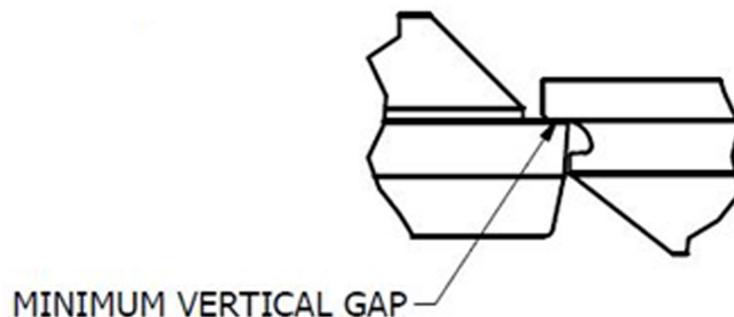
NOTE\* this adjustment isn't exact, and you may need to go through this procedure more than once to reach the desired operation thickness.

6) while holding the screw to keep it from turning, re-tighten the nut.

7) At this point you should check the vertical position of the roller and reset it if necessary.

-Rotate the roller toward the upper chuck until the stop screw contacts the chuck bearing.

-Check the gap between the top surface of the chuck and the roller (see bellow) is minimal but still allows the roller to rotate freely. The gap should remain small while pushing up on the roller.



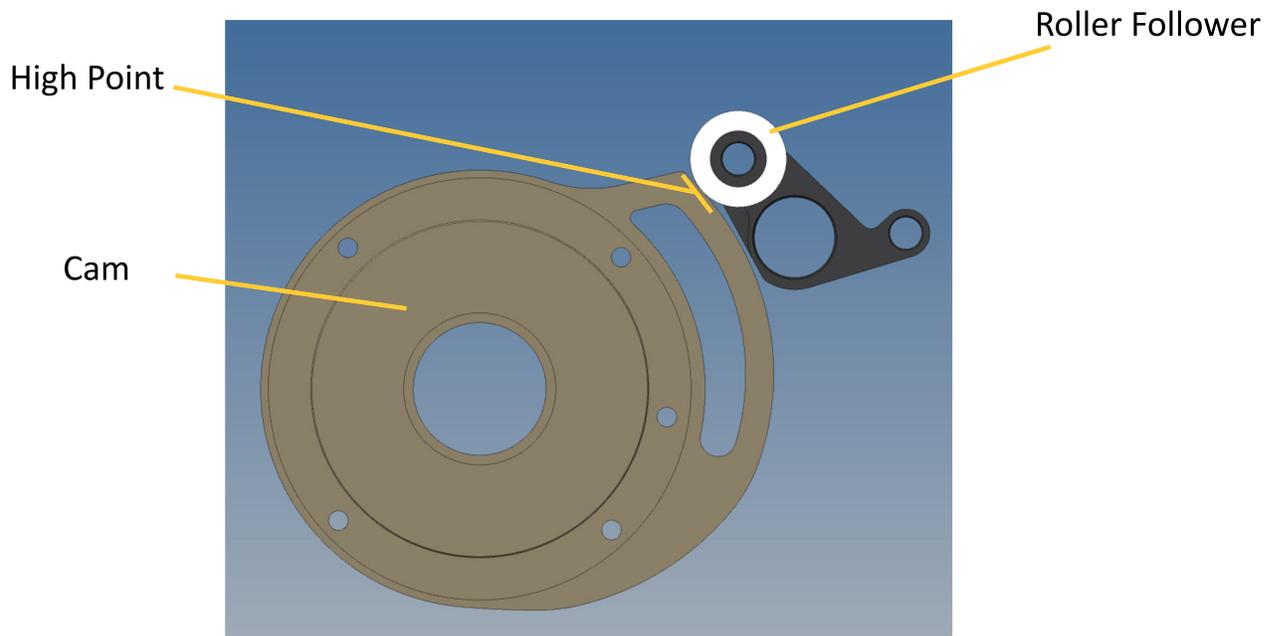
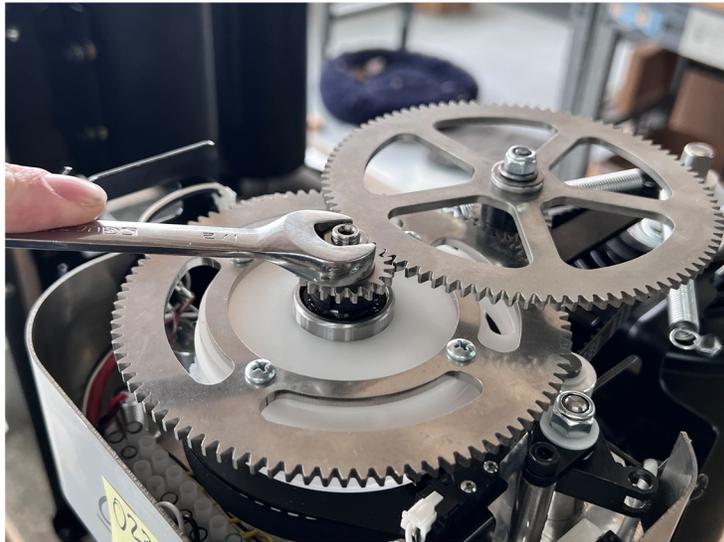
-If there is a fairly large gap, remove the access screw (see diagram on page 2) and use a 1/8in hex key to loosen the set screw that is in the same threaded hole. This will allow the roller to slide freely up and down.

-With the stop screw still contacting the upper chuck bearing, set the roller on the chucks upper surface and re-tightent the set screw.

-Check that the gap is now set correctly.

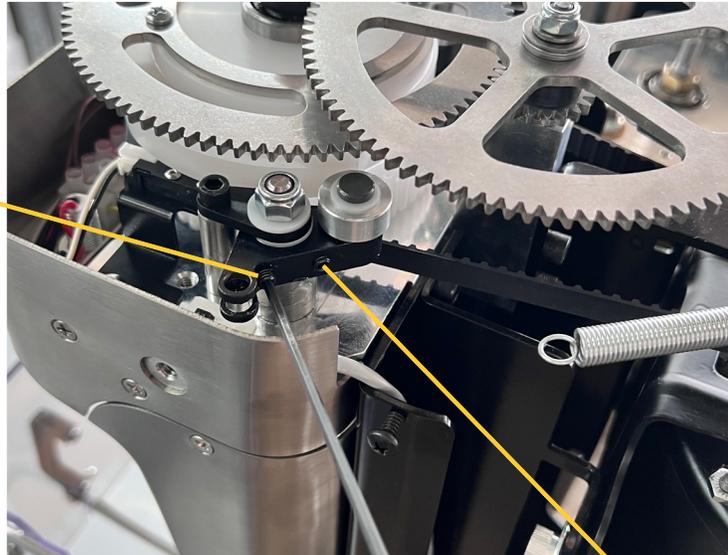
-Re-assemble the access screw.

8) Use a 1/2in wrench (as shown below) to manually rotate the cam clockwise until the high point of the cam contacts the roller follower. The high point is the last 3/8in before the steep drop off.



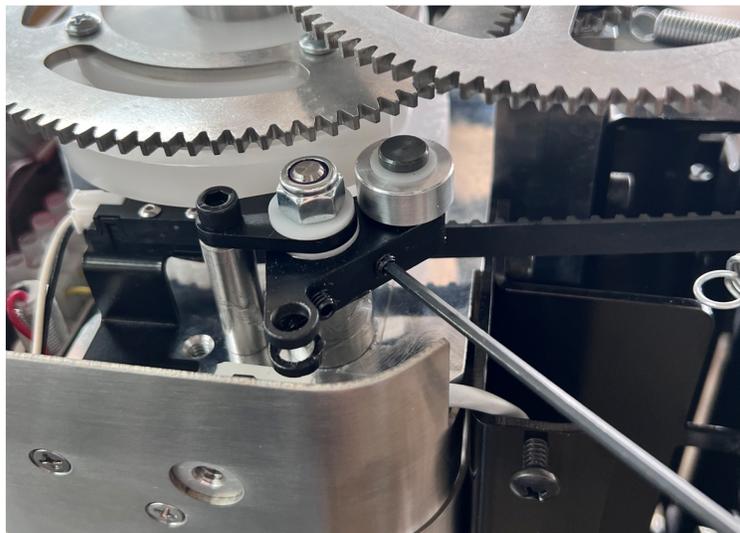
9) Using a 3/32in hex key, slowly rotate the forward rocker screw clockwise until the cam follower wheel contacts the cam. once it has made contact, turn the wrench about 1/3 turn further. The roller follower should now be tight against the cam high point.

Forward rocker screw

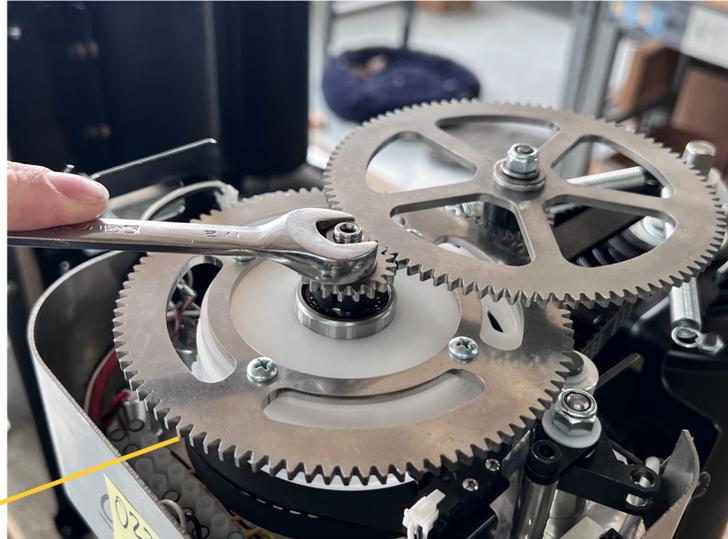


Rear rocker screw

10) Tighten the rear rocker screw to lock the roller follower in-place.



11) Using a 1/2in wrench, rotate the high point of the cam again clockwise until it is roughly the front center position on the seamer. This will position the machine in the start position.



Position the cam high-point here

12) Replace the spring and pin and top cover

13) Run a seam inspection to check the new calibration. You may need to repeat this process to fine tune the seam dimensions.

**FOR MORE INFORMATION CHECK OUT OUR HOW-TO VIDEOS [OKTOBERDESIGN.COM](http://OKTOBERDESIGN.COM)**

**IF YOU HAVE ANY QUESTIONS OR NEED TECHNICAL ASSISTANCE FEEL FREE TO CONTACT US:**

**EMAIL [INFO@OKTOBERDESIGN.COM](mailto:INFO@OKTOBERDESIGN.COM)  
PHONE 231-750-1998**

