VISY Chuck for CDLE/CDL Can Ends

Guide To Achieve Correct Double Seam Specification

KL14670

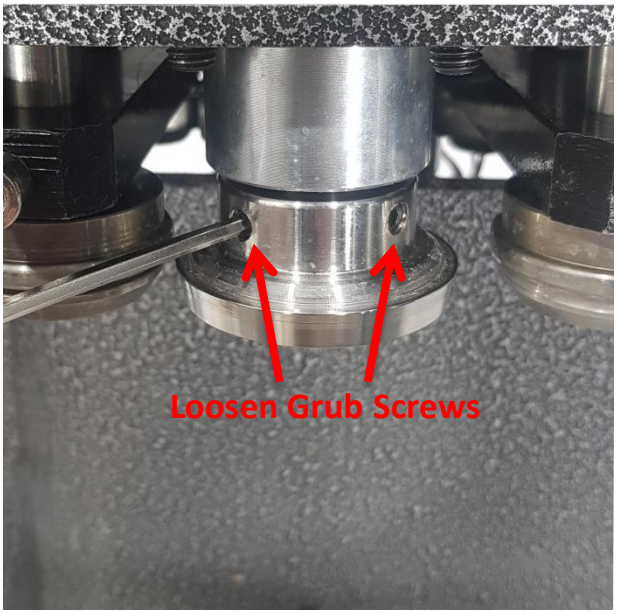
KegLand Distribution PTY LTD

www.KegLand.com.au

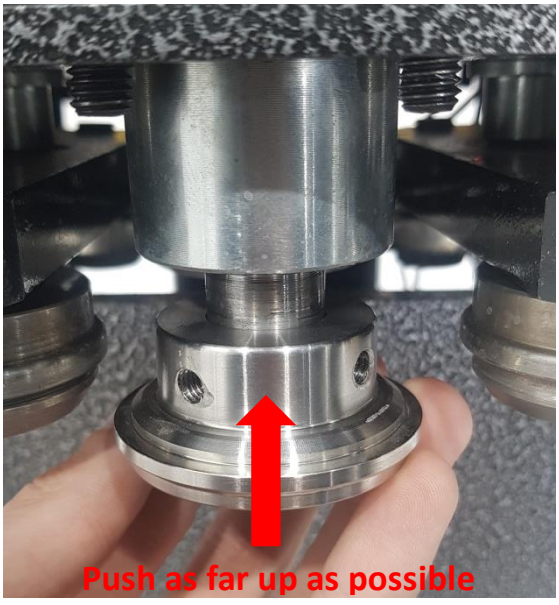
Please use this guide to get your Cannular into specification when using the VISY chuck with CDLE/CDL Can ends.

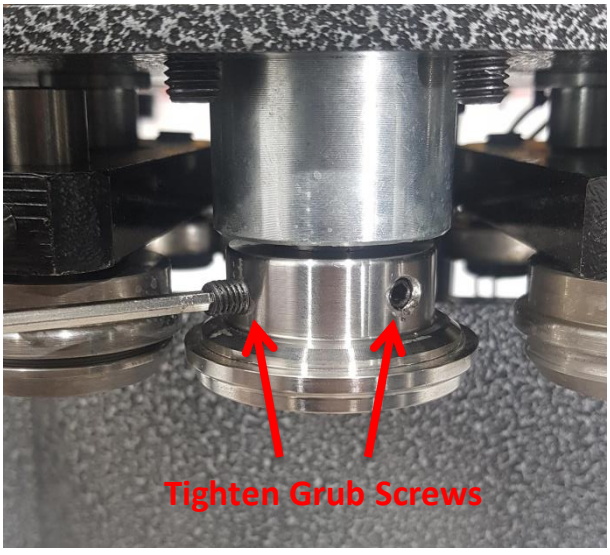
Changing and Adjusting the Chuck

The Cannular is originally setup for use with B64 can ends and hence to seam CDLE/CDL Can ends you will need to swap the B64 chuck for the CDLE/CDL chuck. This can be done by unscrewing the two grub screws that hold the chuck in place and then pull down firmly on the chuck to remove it from the drive shaft.

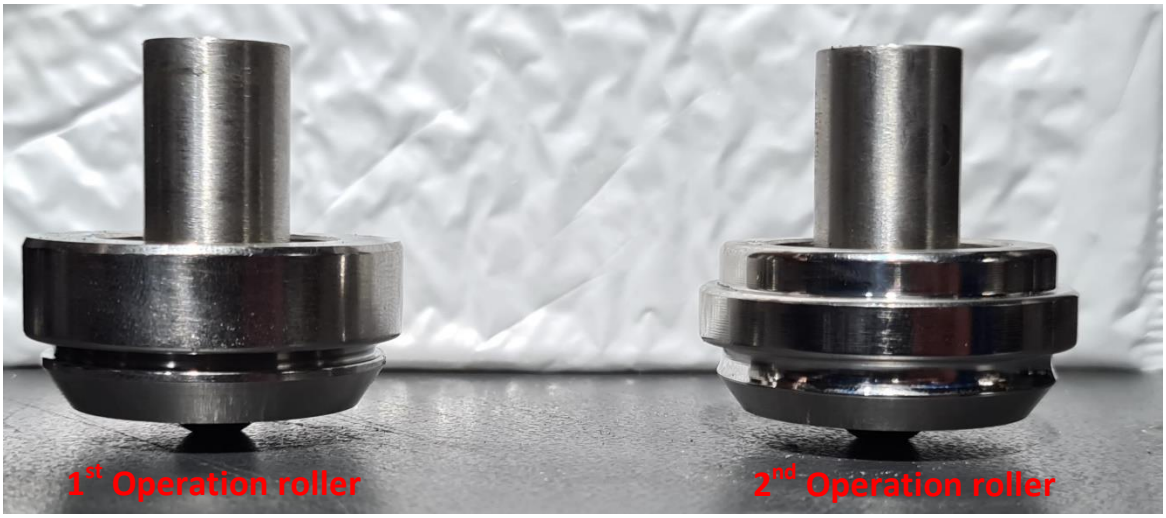


Then push the CDLE/CDL chuck as high as possible onto the drive shaft and retighten the grub screws to hold it in position.





Before adjusting the 1st and 2nd operation rollers ensure that you have identified which roller is undertaking each operation. Please refer to the below image to determine which roller is undertaking each operation.



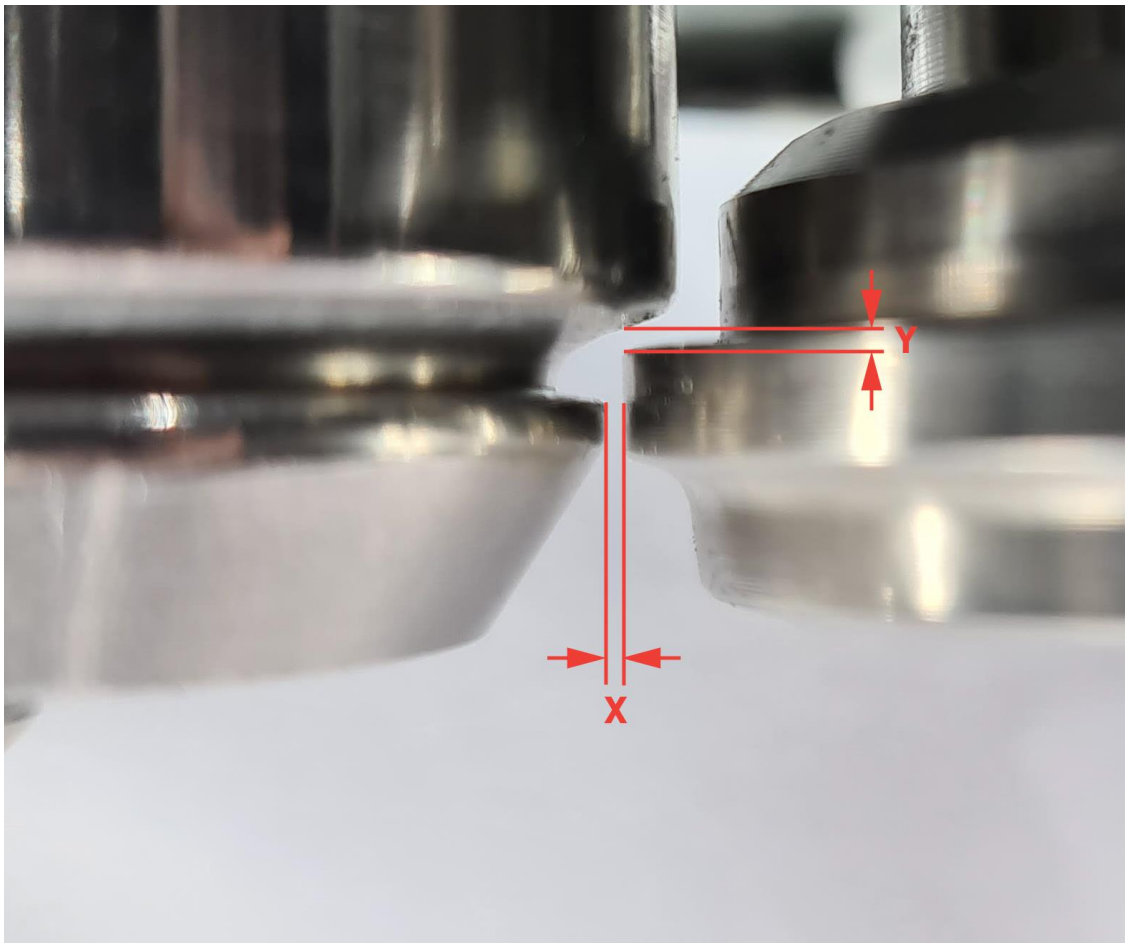
Please note the position of the rollers differ between the manual and semi-automatic Cannular.

Manual Cannular – 1st operation roller is on the left, 2nd operation roller is on the right

Semi-automatic Cannular – 1st operation roller is on the right, 2nd operation rollers is on the left.

1st Op Roll Height and Gap Settings

When adjusting the roll height and gap settings for the 1st operation roller refer to the image below to determine where the feeler gauge should be placed and which surfaces on the chuck and rollers the measurements are taken from.

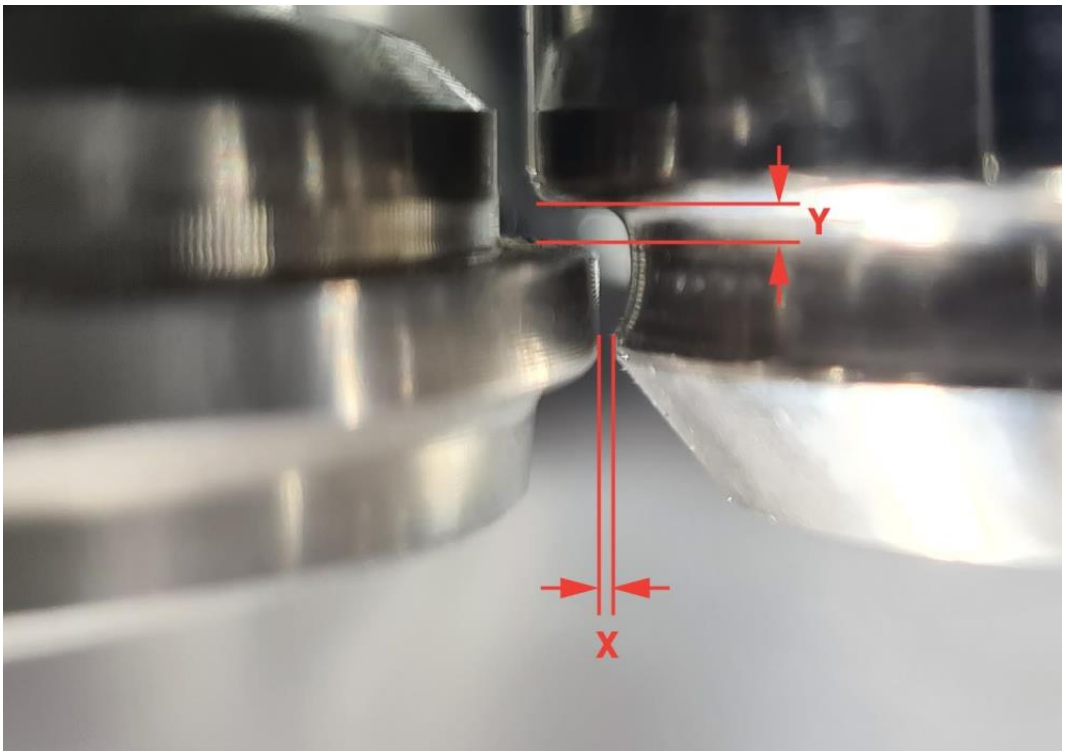


Note: The above photo is for demonstration purposes only. The 1st Op roller should be as close as possible (without touching) to the chuck in the Y direction.

Y = 0.05 – 0.15 mm
X = 0.4 mm

2nd Op Roll Height and Gap Settings

When adjusting the roll height and gap settings for the 2nd operation roller refer to the image below to determine where the feeler gauge should be placed and which surfaces on the chuck and rollers the measurements are taken from.



Y = 1.2 mm
X = 0.25 – 0.3 mm