



# Dixie Canner Company

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Worldwide Dependability ————— Can Packaging & Processing Equipment

## Model UVGD-AL-HMI VACUUM/GAS FLUSH SEAMER OPERATORS MANUAL



Model UVGD-AL-HMI

# INSTALLATION INSTRUCTIONS

## Vacuum Seamers

BEFORE OPERATING YOUR DIXIE DOUBLE SEAMER REVIEW THE OPERATOR'S MANUAL, supplementary information pertaining to the **Vacuum Pump**, Regulator, Motors and other auxiliary or accessory items furnished with this machine.

1. Position the machine and secure directly to the floor or other stable base with concrete drill-in anchor bolts or lag screws using the appropriate anchoring system suitable for your specific flooring and/or sub-flooring. Four (4) mounting brackets with 9/16" diameter holes are located at each corner of the cabinet base.
2. **Fill the port on the vacuum pump to the recommended level. Capacity is approximately 0.5 quart. A quart of Vacuum Pump Oil is supplied with the seamer.**
3. Plug the electrical cord into a 20 amp outlet.
4. Provide an external source of compressed air at 5 CFM (not to exceed 100 psi). Connect the air supply to the 1/4" quick-connect fitting of the 816 Air/Filter/Regulator on the rear of the seamer. A consistent supply of 95 psi is required for most type containers. The 816 Air/Filter/Regulator on your seamer was preset at the factory to provide the correct air pressure for closing the sample containers submitted with your order. (Refer to your Operator's Manual for more detail on the 816 Air/Filter/Regulator Assembly.)
5. For models with gas flush or multiflush modes, connect an external gas tank or cylinder and a regulator to the 3/4" opening of the upper 666 solenoid valve located on the right side of the seamer. (The gas tank and regulator are not provided and should be obtained locally.)
6. Lubricate/grease all locations on the seamer as indicated in your Operator's Manual.
7. Connecting the air supply to the seamer will lower the base plate and allow you to remove the sample sealed can from the vacuum chamber. (Change parts are installed on the seamer for closing the sample sealed container. Follow the instructions in your Operator's Manual for changing from one size can to another.)

## EXPORT INSTALLATION

### WHEN EQUIPPED WITH TRANSFORMER AND 220-50-1 VACUUM PUMP

1. Position the machine and secure directly to the floor or other stable base with concrete drill-in anchor bolts or lag screws using the appropriate anchoring system suitable for your specific flooring and/or sub-flooring. Four (4) mounting brackets with 9/16" diameter holes are located at each corner of the cabinet base.
2. **Fill the port on the vacuum pump to the recommended level. Capacity is approximately 0.5 quart. A quart of Vacuum Pump Oil is supplied with the seamer.**
3. Two electrical connections are required.
  - A. Connect 220 volts, 50 Hz, 1-Phase electrical supply to the transformer. This will operate the gearhead motor on the seamer.
  - B. Connect 220 volts, 50 Hz, 1-Phase electrical supply to the vacuum pump motor.
4. Provide an external source of compressed air at 5 CFM (not to exceed 100 psi). Connect the air supply to the 1/4" quick-connect fitting of the 816 Air/Filter/Regulator on the rear of the seamer. A consistent supply of 90 psi is required for most type containers. The 816 Air/Filter/Regulator on your seamer was preset at the factory to provide the correct air pressure for closing the sample containers submitted with your order. (Refer to your Operator's Manual for more detail on the 816 Air/Filter/Regulator Assembly.)
5. For models with gas flush or multiflush modes, connect an external gas tank or cylinder and a regulator to the 3/4" opening of the upper 666 solenoid valve located on the right side of the seamer. (The gas tank and regulator are not provided and should be obtained locally.)
6. Lubricate/grease all locations on the seamer as indicated in your Operator's Manual.
7. Connecting the air supply to the seamer will lower the base plate and allow you to remove the sample sealed can from the vacuum chamber. (Change parts are installed on the seamer for closing the sample sealed container. Follow the instructions in your Operator's Manual for changing from one size can to another.)

## INTRODUCTION

The Dixie Model UVGD-AL-HMI offers your choice of atmospheric, vacuum only or vacuum then gas flush double seaming.

**RANGE:** 2" to 6¼" diameter, up to 7" tall.  
Change parts are required for each size can.

**CAPACITY:** 15 Cans Per Minute - Atmospheric  
8 Cans Per Minute - Vacuum  
6 Cans Per Minute - Vacuum and Gas

For other than atmospheric mode, averages are based on 15" vacuum and then gas flush to 6".

### \*\*\*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.

- Important considerations when choosing preset vacuum/gas values are:
- Choose Atmospheric Mode if no vacuum or gas flush is desired.
- If you desire to pull vacuum one time then close your container, select the Vacuum Only operating mode
- If you desire to pull vacuum one time then gas flush one time, select the Vacuum Then Gas operating 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 HMI values and/or the number of times selected to Vac/Gas Flush.

### The HMI DISPLAY SCREEN (661-4A)

Enter values for Vacuum, Gas Flush, or Multiflush Operations. You may also access a Can Closing Count performed in each operating mode.



#### Operating Functions

Press Desired Function Button to Begin Operation



#### Atmospheric Operating Mode

Can Seaming Operation That Hermetically Seams Container and Lid in Normal Environmental Conditions

**Place Lid on Unsealed Container. Place Container on Base Plate. Press Start Button Below or Close Chamber Door and Seaming Cycle will Begin. Remove Sealed Can and Repeat to Duplicate the Process.**



#### Vacuum Only Operating Mode

This Operating Mode Mechanically Removes Oxygen From The Chamber and Container Before Can and Lid are Hermetically Sealed

**Set Value for the Amount of Vacuum in Hg" on Gauge Below. Position Lid on The Seaming Chuck. Place Container on Base Plate. Close Chamber Door to Complete the Seaming Cycle.**



setpoint - In Hg: 0



#### Vacuum with Gas Flush Operating Mode

Allows for an Inert Gas Flush, After the Mechanical Vacuum has Exhausted the Chamber, and Before the Container is Hermetically Seamed. This may be Required Depending on the Type/Size/Strength of Container.

**Set Value for Vacuum and Positive Gas Flush on Gauges Below. Position Lid on Seaming Chuck. Place Container on Base Plate. Close Door and Seaming Cycle will Start.**



Vacuum - In Hg: 0  
Gas - In Hg: 0



## 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.

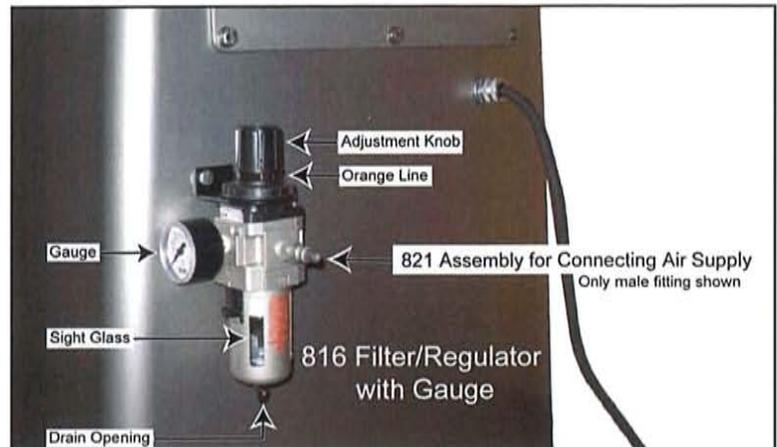
## BASE PLATE PRESSURE ADJUSTMENTS

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:

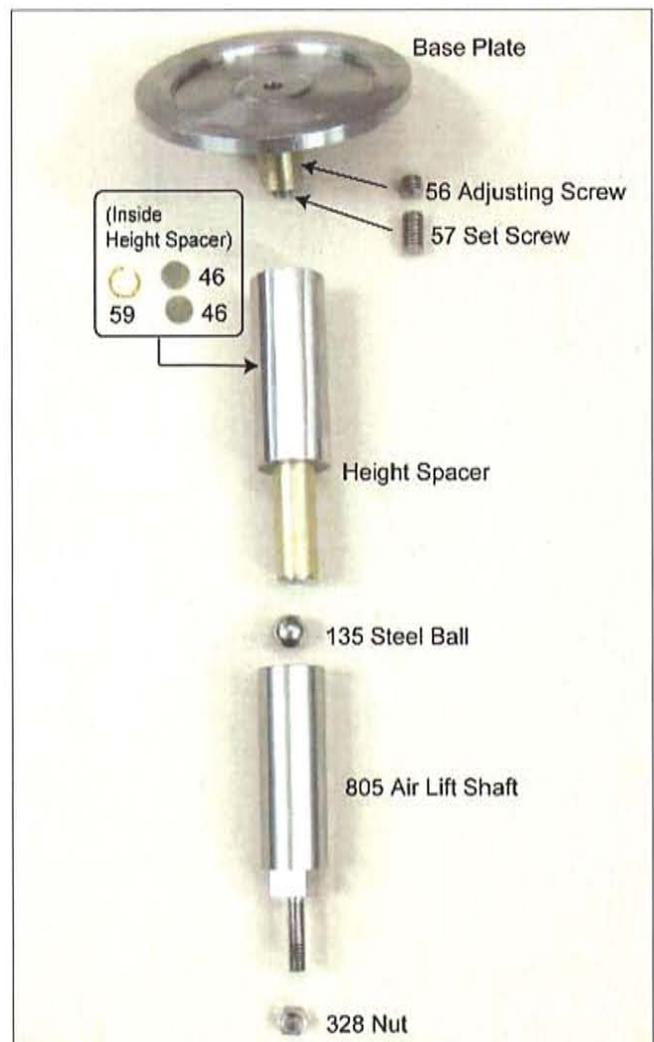
1. Cans 7" tall do not require a height spacer. Base plate pressure adjustments are made by loosening the 5/16" nut at the base of the 805 lift shaft then turning the lift shaft with a 5/8" open-end wrench at the "flats" on the lift shaft.
2. Cans shorter than 7" require a height spacer and a separate base plate which has an adjusting screw (56) and set screw (57) in its 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.

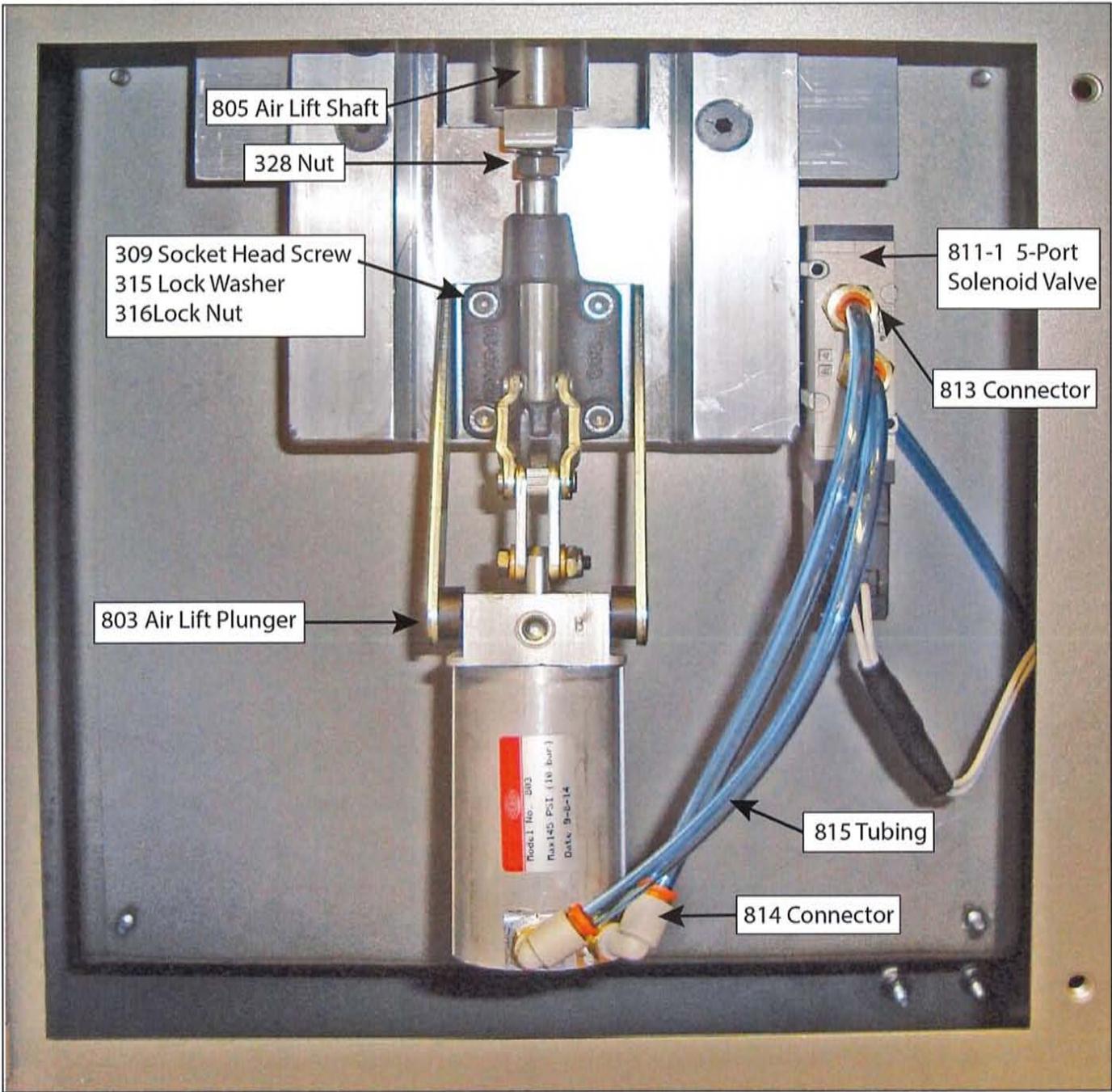
After making adjustments, tighten jam nuts or set screw.



The filter element should be changed after 1 year or when a pressure drop of 15 psi is reached. Periodically observe condensate level through the filter sight glass 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.*





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.
  1. 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.
  2. 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.
  3. 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 and height spacer for the can to be closed. Adjust the base pressure and seaming rolls as outlined above.

# GAUGE WIRES

Gauge wires are used as a starting point for adjusting seaming rolls. Final adjustments may be necessary to obtain specific seam dimensions recommended by your can supplier or manufacturer.

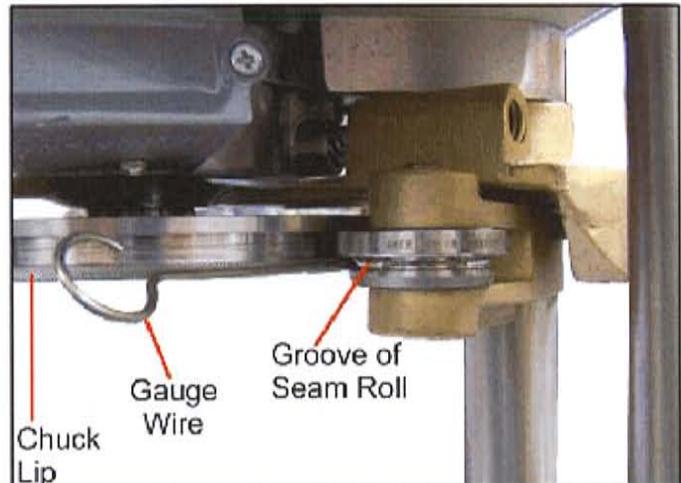
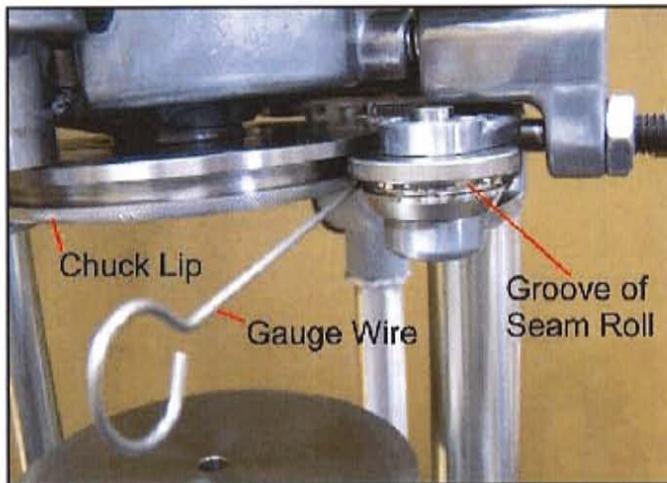
The first operation gauge wire is the approximate thickness of the first operation seam. The second operation gauge wire is the approximate thickness of the second operation seam.

## Gauge Wire Sizes

	Dixie Part No.	Thickness
Metal containers:	40 1st Operation	0.062
	41 2nd Operation	0.031
Composite Containers:	40-C 1st Operation	0.080
	41-C 2nd Operation	0.050
Plastic Containers:	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.



## ADJUSTING THE CAN TOP RETAINER

The purpose of the can top retainer (201-5) is to hold the can top in position on the chuck, separated from the can, when desired. This feature is particularly useful to permit maximum exchange of vacuum to gas when using the Vacuum Then Gas or the Multiflush modes. The can top retainer is adjusted as follows:

1. After the machine has been properly equipped and adjusted for the size cans to be closed, place the can end snugly into position on the chuck.
2. Adjust the can top retainer so the tip of the spring plunger is just barely against the can top curled edge and tighten both nuts holding the plunger in place.
3. If necessary, relocate the screw holding the can retainer bracket to another hole. This allows a greater range of adjustments. Minute adjustments may be made by adjusting the lock nuts and spring plunger.

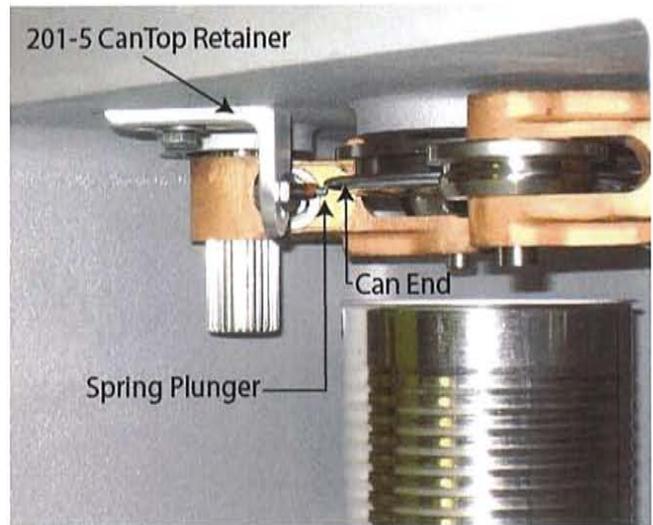
Magnets are pressed in chucks fabricated for plain steel or tin can tops to hold the tops in position on the chuck. The can top retainers are not used for chucks with magnets and may be removed or rotated 180° when not needed.

## NEUTRAL POSITION

The machine is in a neutral position when both cam rolls (20) are in their innermost position and both seaming rolls are in their outermost position.

## TIMING THE MACHINE

"Timing" and "in a neutral position" are synonymous. The machine is properly timed (or in neutral position) when both cam rolls (20) are at their innermost position and both seaming rolls (1st and 2nd) are at their outermost position. There are ten (10) revolutions per seaming cycle. Therefore, with power to the machine ON, by pressing the actuator on the clutch/brake assembly to turn the clutch/brake assembly one revolution at a time, the machine will have been "timed" by or before the 9th revolution. Then turn the power OFF, which allows the revolutions counter to "reset" while the machine is in a neutral position. Turn power ON again and continue closing cans.



## NOTES AND TROUBLESHOOTING

Refer to this manual and supplementary information pertaining to the vacuum pump and other auxiliary or accessory items furnished with this machine for troubleshooting assistance. If you have any doubts concerning your diagnosis of a problem or its correct solution, please contact Dixie Canner Company technicians before making changes or adjustments to factory settings.

- If machine stops and door won't open, turn power OFF then ON again which will allow the vacuum in the chamber to be released so door may be opened. Check machine for proper adjustments before resuming operation.
- The Model UVGMD-AL-HMI is equipped with a Can Counter feature. The counter maintains the number of cans closed in each operating mode as well as a grand total count. To clear can closing counts, follow the following steps:
  1. A flash screen showing contact information for Dixie Canner Company appears on the HMI display for 3 seconds when the seamer is turned on and booting is complete. When the flash screen appears, immediately press the bottom right of the HMI display to access the Maintenance Screen. This is the only opportunity to access the Maintenance Screen.

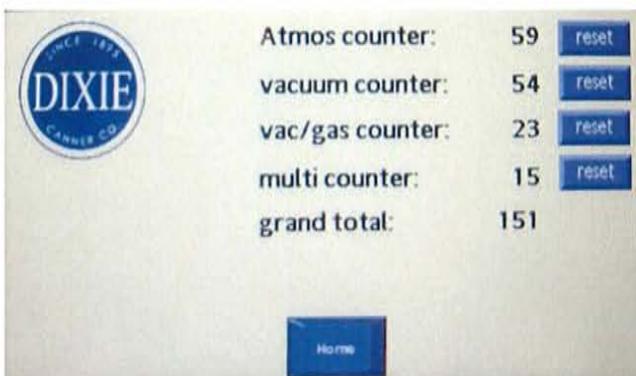


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**Follow Daily Recommended Maintenance**

**Contact Dixie for Parts, Service  
and Maintenance Questions**



2. The Maintenance Screen displays RESET buttons which are pressed to clear the can counts for each operating mode. The Grand Total Count will also be cleared when the operating mode counts are reset.
- Machine won't operate:
    1. Solenoid (666) in vacuum and gas pipes won't open or close, or the solenoid in the clutch-brake assembly (502-1) doesn't work.
    2. Air lift doesn't work, or
    3. Direct Drive Motor doesn't run — check FUSES.
  - Open electrical box on rear of machine and locate the fuse blocks. Refer as need to the separate page on Electrical Box provided in this manual. Each of the three sections of the fuse blocks have two (2) fuses — one is a spare. Proceed to replace the top fuse, one section at a time until problem is solved. Order spare fuses as needed. NOTE: Two fuses are 4 amp and one is 15 amp.
  - IF PROBLEM is not a "blown" fuse, your electrician may locate and correct a loose connection in the wiring — or contact the factory.
  - Vacuum pump does not operate. Check switch on top of vacuum pump to make sure it has not been accidentally turned off.
  - Vacuum pump "labors" or cuts off. First, check filter and clean if dirty. Second, disconnect the union, if present, between the filter and vacuum chamber, then swivel elbow to expose inside of pipe and if clogged, clean and reconnect the union.
  - Oil in the vacuum pump should be changed after 500 operating hours or every three months, whichever comes first.
  - Machine won't stop, continues running. Check the clutch-brake (502-1) to see if the Magnet (664-A) is in place. The Sensor (664) needs the magnet in place on the clutch-brake to count each revolution. Use "Krazy Glue" to replace the magnet if needed.
  - Power "accidentally" turned OFF during a seaming cycle will cause the machine to be "out of time" or "not in neutral."
  - Close door and machine does NOT start: switch (659) and magnet (659-1) on door may be out of alignment. Realign and adjust to 1/8" space when door is closed.
  - You may wish to connect your seamer to a power surge suppresser if your electrical supply is subject to electrical spikes or surges.

## CHANGE PARTS AND REPAIR PARTS

Photographs or schematics of parts, assemblies, machine sections, base plates and height spacers with the corresponding part number are shown on other pages. A Parts List is furnished separately. When ordering parts, always furnish both the part number and the name of the part. When ordering change parts for cans, always send six (6) loose tops and can bodies of the size can(s) to be closed.

## REPAIR PARTS AND REBUILDING SERVICE

### HELPFUL HINTS — 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 outline below is intended to help detect obvious defects and list some causes that may serve as a guide in correcting minor troubles.

### MECHANICAL DEFECTS AND COMMON CAUSES

- A. Can slips during seaming operation
  - 1. Damage or lack of oil in the base plate, lift shaft, height spacer or steel ball
  - 2. Insufficient base plate pressure
  - 3. Worn or wrong size chuck
  - 4. Seaming rolls binding on pins
- B. Machine operates with undue noise or "locks"
  - 1. Machine not properly timed
- C. Unusually loose seaming rolls
  - 1. Seaming roll or pins worn
- D. Seaming rolls do not return to neutral position
  - 1. Seaming roll levers 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

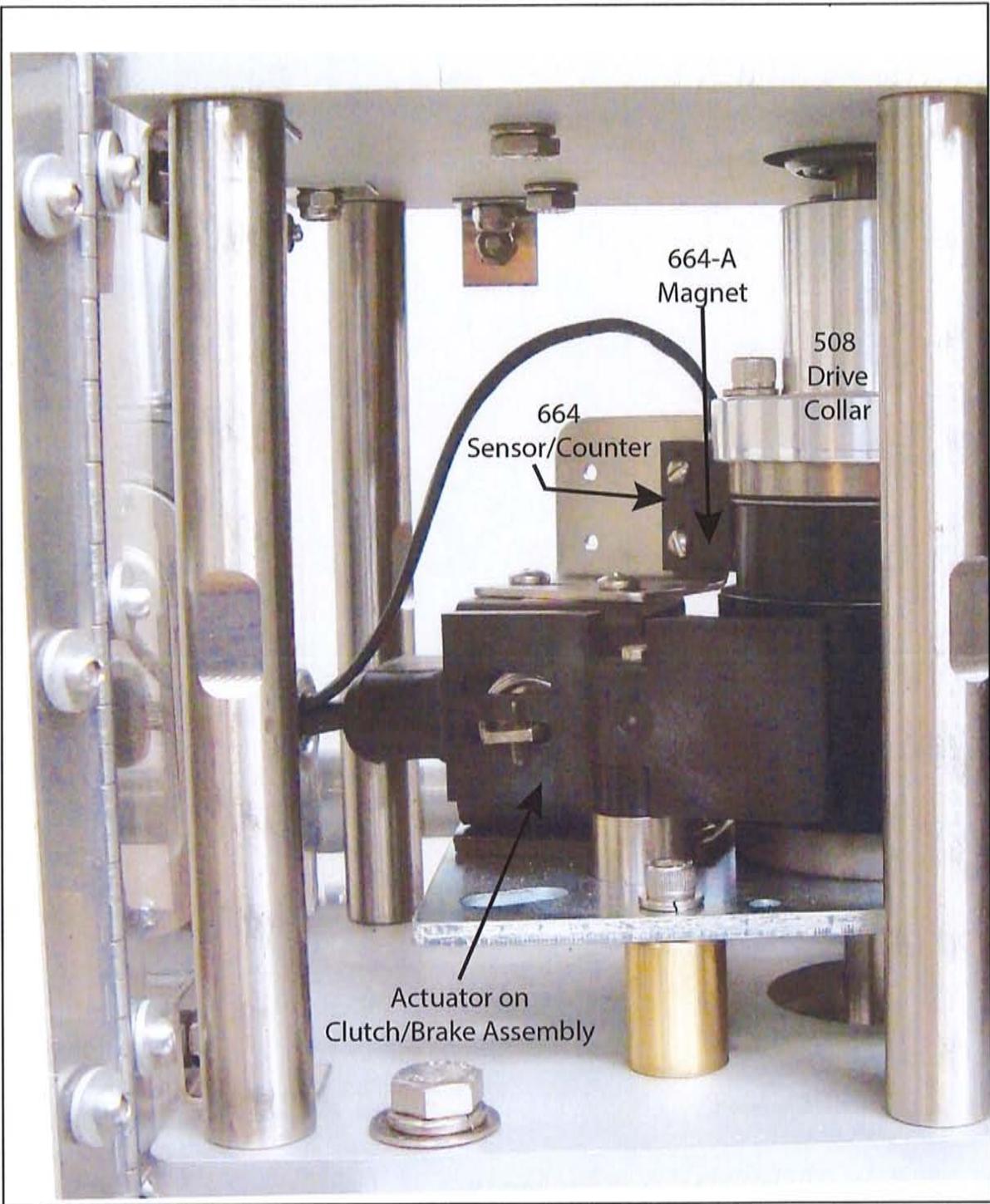
### DOUBLE SEAM DEFECTS and COMMON CAUSES

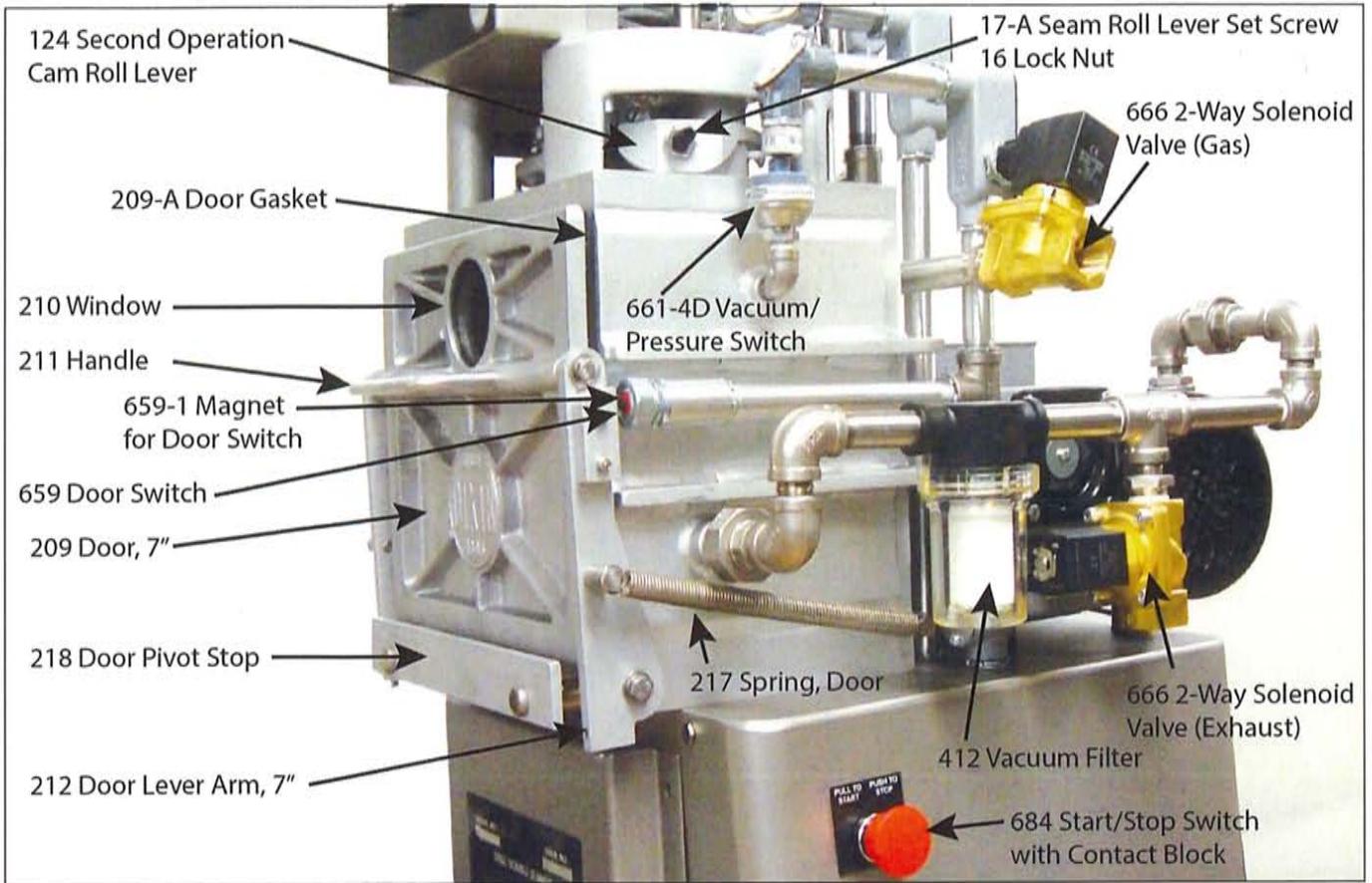
- A. Cut over. Unusually sharp edge at top inside edge of seam
  - 1. 1st or 2nd operation seam roll set too tight
  - 2. Worn seam rolls or worn chuck
- B. Cut or fractured seam
  - 1. Seam rolls set too tight

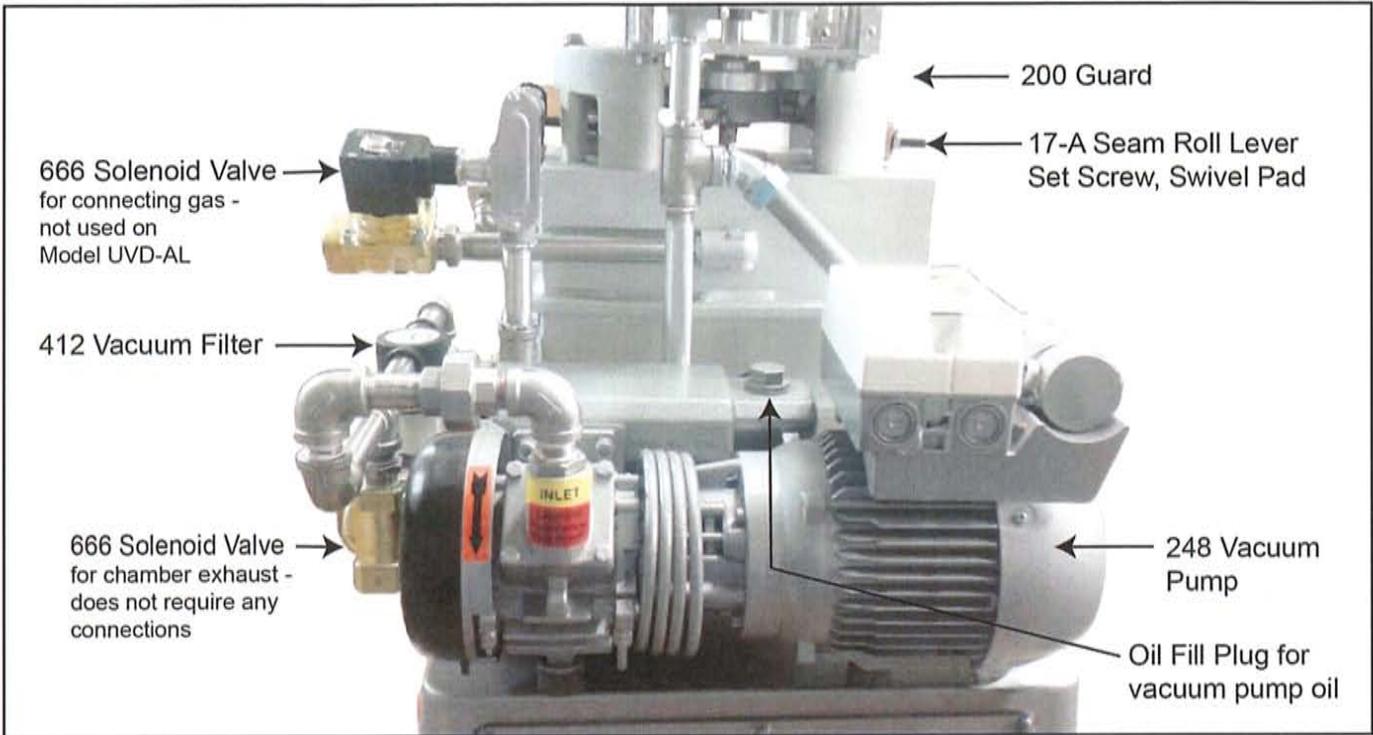
A complete stock of parts is maintained by Dixie Canner Company, Athens, Georgia, USA. Parts may be ordered as needed to replace worn or damaged parts.

Your Dixie Model UVGMD-AL-HMI may be returned to Athens, Georgia for a complete rebuilding at a nominal service charge, plus the cost of parts needed. When returning the machine for the rebuilding service please observe the following:

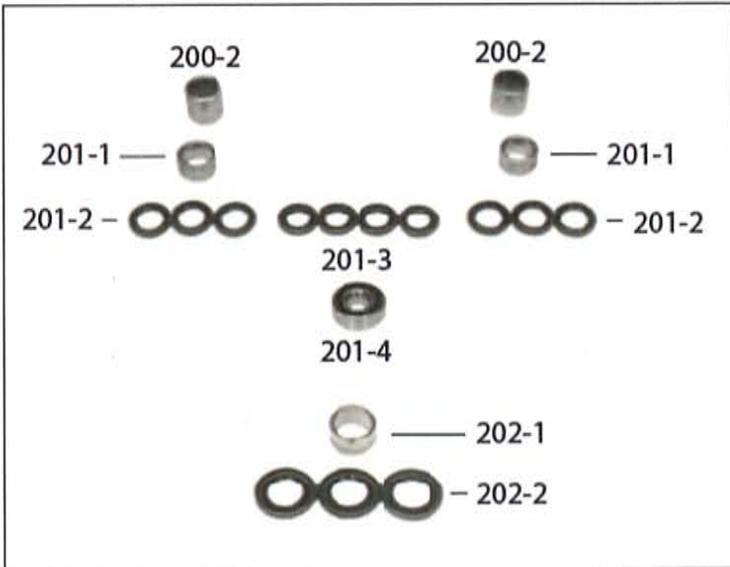
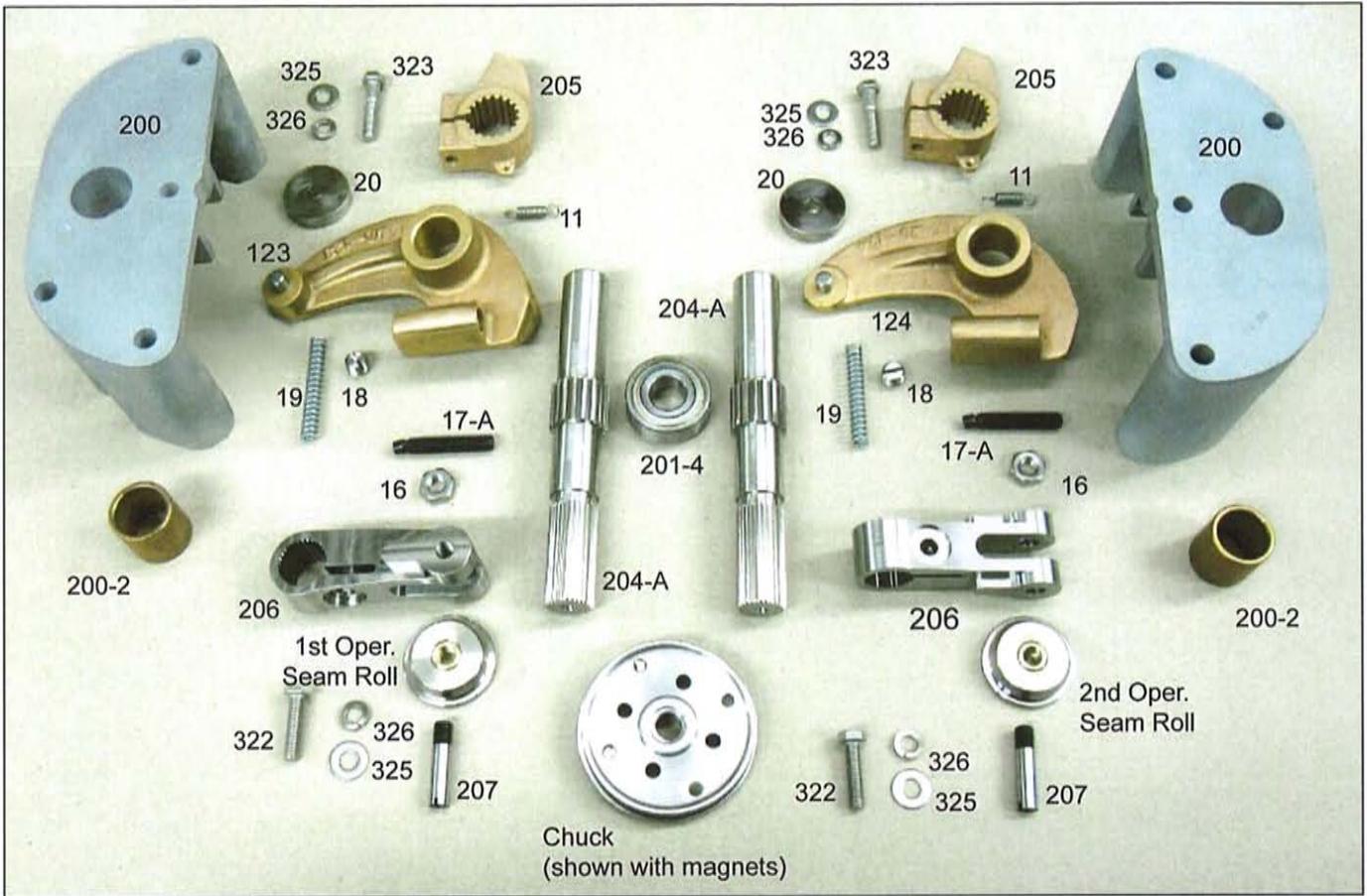
- 1. Return the complete machine and include several cans and tops of the exact size and type closed. Properly crate the machine and cans for safe delivery and return shipment, and prepay the shipping cost.
- 2. Write a letter authorizing the rebuilding service and mention any problem with the machine. Also mention particular instructions concerning return shipment, urgency, and other pertinent instructions.
- C. Droop or lap in double seam at or near can body side seam
  - 1. Too much base pressure
  - 2. 1st operation seam roll set too loose
  - 3. Worn 1st operation seam roll
- D. Excessive countersink depth
  - 1. Too much base pressure
  - 2. 1st operation seam 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. Can top not properly seated on can
  - 2. Damaged can flange or can top curl
- F. Long body hook
  - 1. Too much base pressure
- G. Long cover hook
  - 1. 1st operation seam roll set too tight
- H. Short body hook
  - 1. Insufficient base pressure
  - 2. 1st operation seam roll set too tight
  - 3. 2nd operation seam roll set too loose
- I. Short cover hook
  - 1. Too much base pressure
  - 2. 1st operation seam roll set too loose
  - 3. Worn 1st operation seam roll
  - 4. Excessive countersink depth
- J. Cover hook or body hook not uniform
  - 1. Base plate or plunger worn
  - 2. Chuck or seam rolls out of alignment
- K. Droops, vees, wrinkles
  - 1. Excessive base pressure
  - 2. 1st operation seam roll too loose or worn
  - 3. 2nd operation seam roll too tight
  - 4. Defects in can body or top
  - 5. Incorrect seam roll profiles



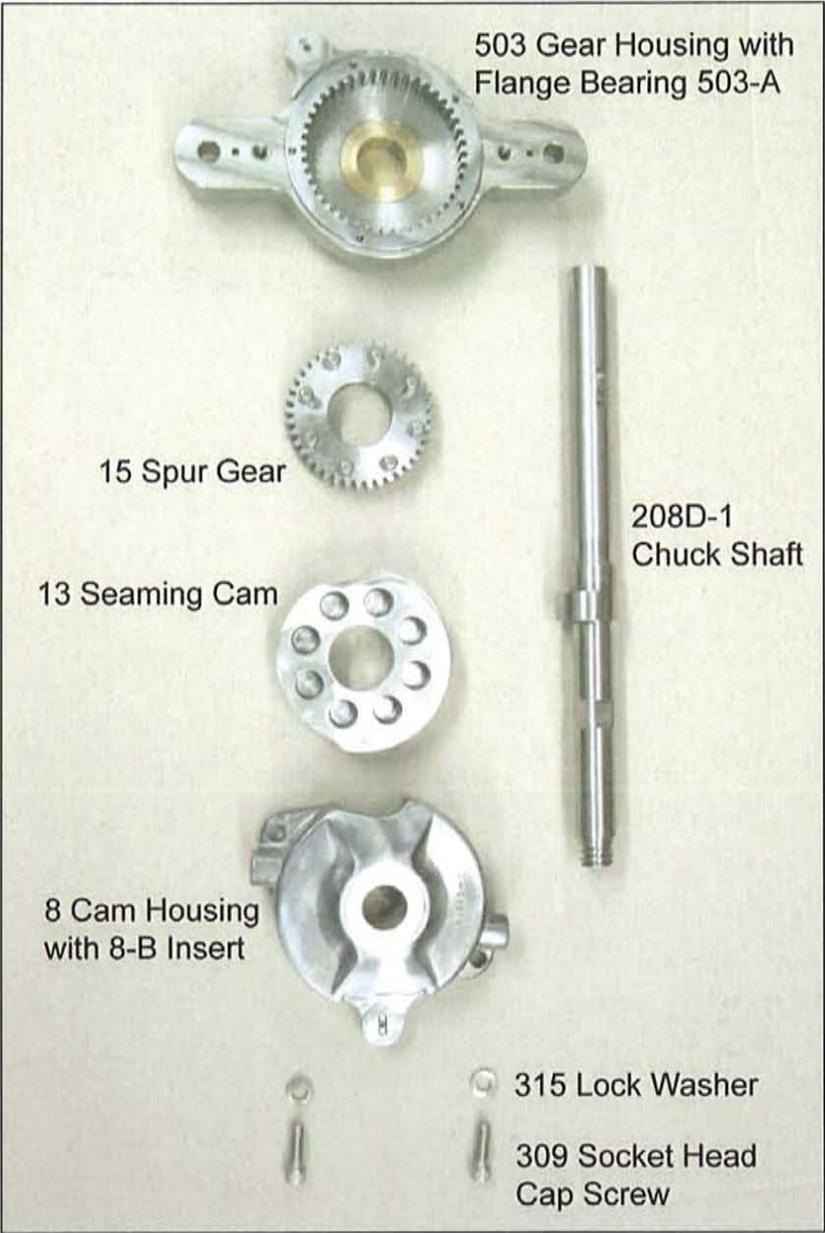




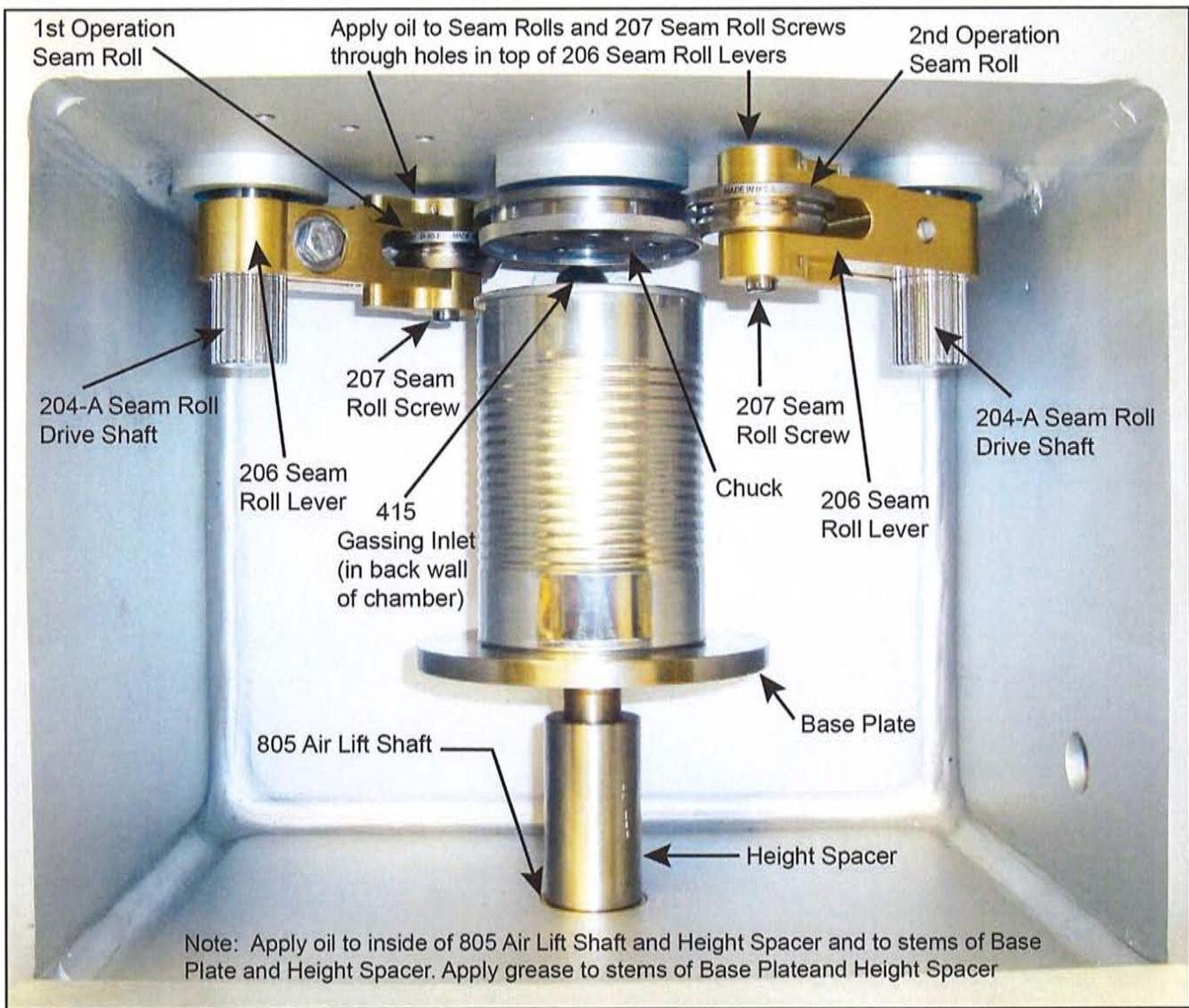
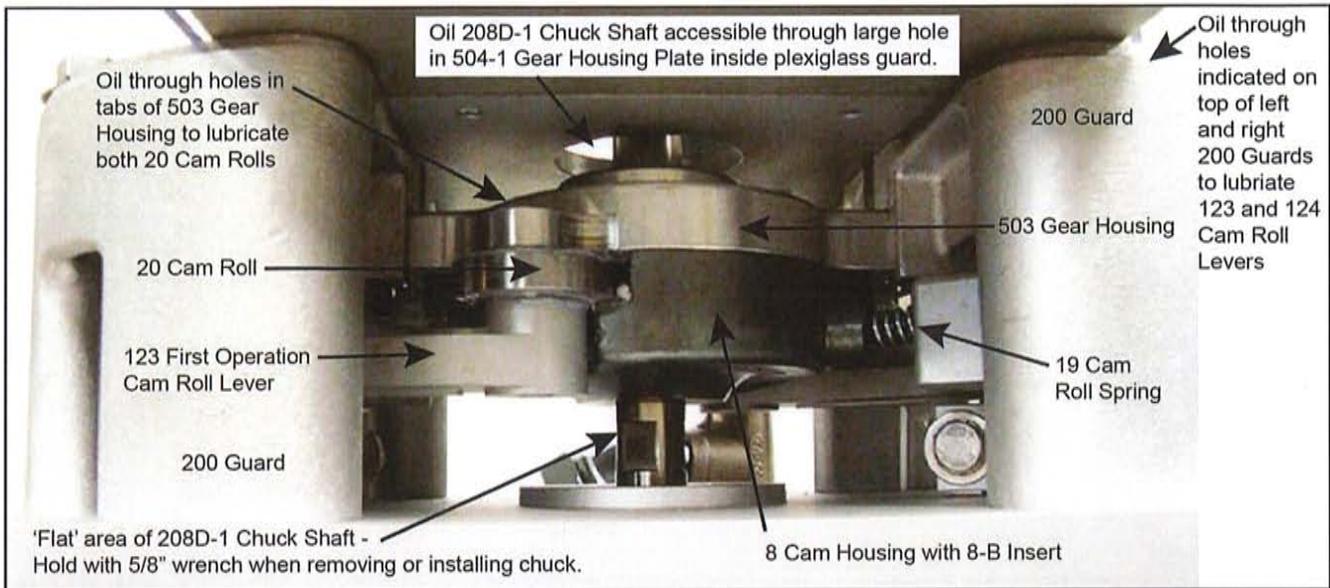
Rear View

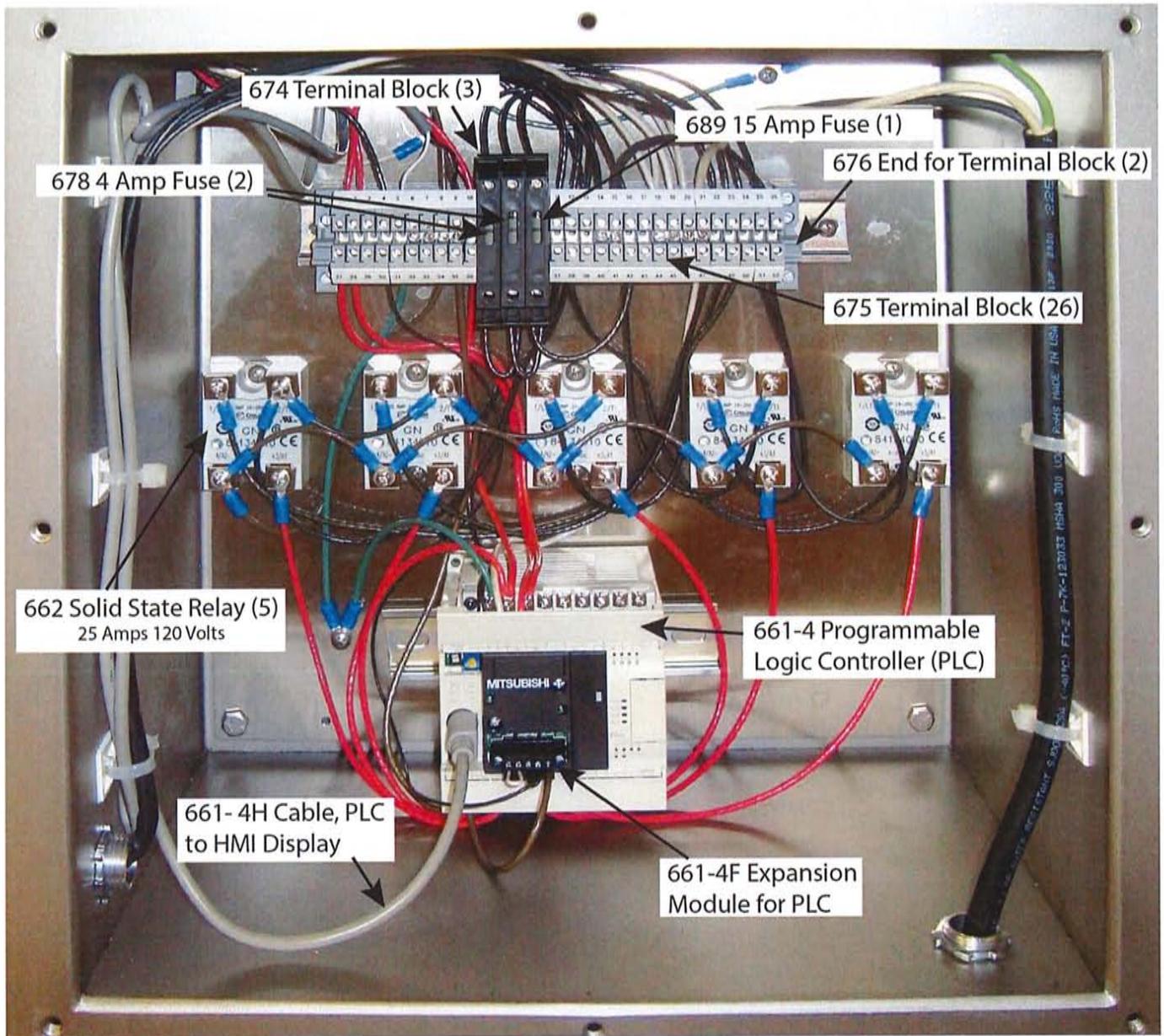


Seals, Bushings and Bearings for Guards and Chamber



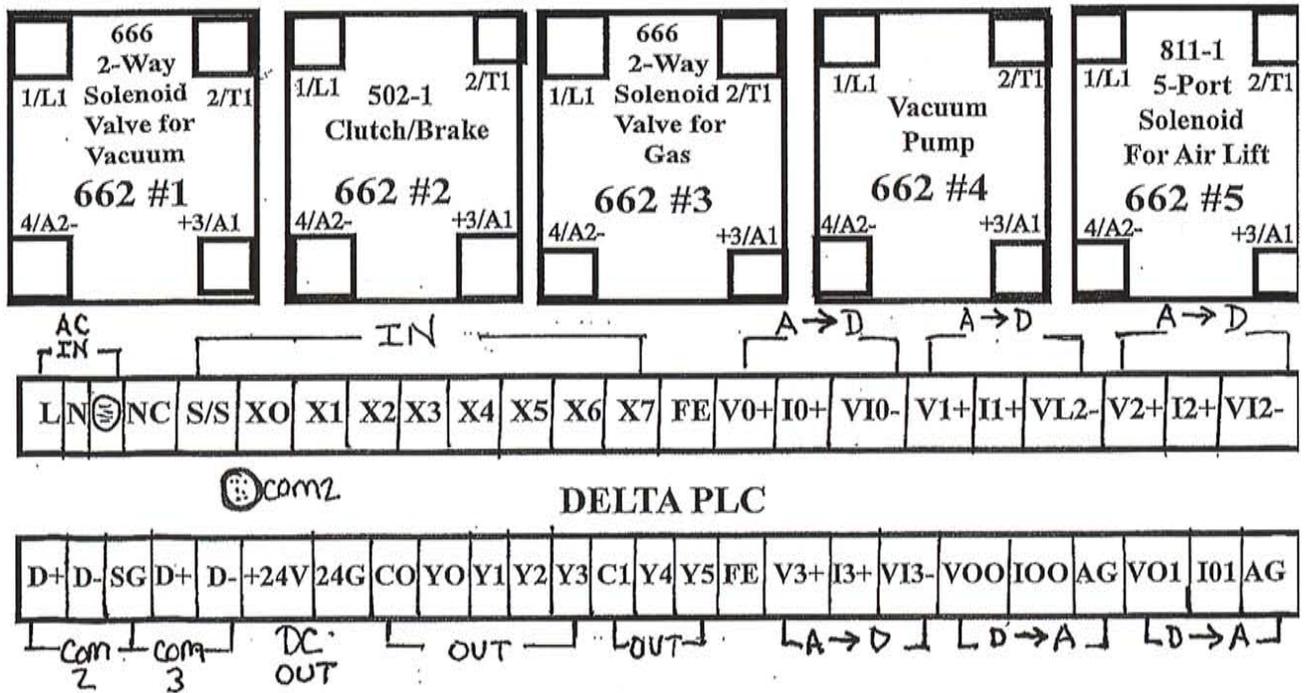
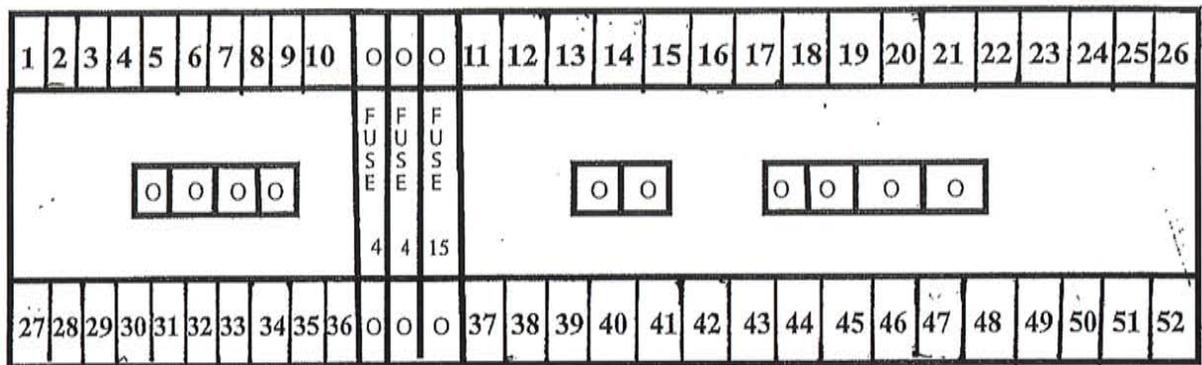
Components of Head Assembly





Model UVGD-AL-HMI Electrical Panel

# Model UVGMD-AL-HMI 115 Volts



# Wiring Dixie UVGD-AL-HMI

Page 1 of 3

## Terminal Block

1	Red	659 Door switch
2	Red	664 Sensor counter on clutch brake
3		
4	Brown	- pole Vacuum switch (SPT25 or Dwyer 673)
5	White	Ground Red Lion
6	Brown	Door Switch
7	Brown	664 Sensor Counter and Black –Red Lion
8		
9		
10	Red	+ Red Lion
	Red	+ Pressure switch (SPT25 or Dwyer 673)
11	Black	678 4 Amp
12	Black	678 4 Amp
13	Black	501-6 Motor
	Black	689 15 Amp
14	Black	684 Start / Stop switch
15	Black	Power cord
16	Black	684 Start / Stop switch
17	White	FOR 220V ONLY 248 4T2
18	White	811-1 5-port solenoid valve for air lift
	White	501-6 Motor
19	White	666 2-way solenoid valve Vacuum
	White	666 2-way solenoid valve Gas
20	White	502-1 Clutch brake
	White	248 Vacuum pump 3L2
21	White	Power cord
22	Black	666 2-way solenoid valve Vacuum
23	Black	502-1 Clutch brake
24	Black	666 2-way solenoid valve Gas
25	Black	248 Vacuum Pump 1L1 ( FOR 220V 5L3 )
26	Black	811-1 5-port solenoid valve for air lift

# Wiring Dixie UVGD-AL-HMI

Page 2 of 3

27	Red	X0 PLC
28	Red	X1 on PLC
29		
30	Black	V0+ on PLC and I0+ on PLC
31	Green	Ground
32	Brown	#1 4/A2-
33	Brown	24G on PLC and VI0- on PLC
34		
35	Red	C0 on PLC and C1 on PLC
36	Red	S/S on PLC and +24V on PLC
	Black	4 Amp to 4 Amp to 15 Amp
37	Black	#1 2/T1
38	Black	#5 2/T1
	Black	L on PLC
39		
40		
41		
42	Black	#4 2/T1 for 110V
	Black	689 15 Amp
43	Black	FOR 220V #4 2/T1
44		
45		
46		
47	White	N on PLC
48	Black	#1 1/L1
49	Black	#2 1/L1
50	Black	#3 1/L1
51	Black	#4 1/L1
52	Black	#5 1/L1

D- on Com2 to 7 on Red Lion serial adapter  
D+ on Com2 to 8 on Red Lion serial adapter

# Wiring Dixie UVGD-AL-HMI

Page 3 of 3

## 662 Relay Switch

#1 +3/A1	Red	Y0 on PLC
#2 +3/A1	Red	Y1 on PLC
#3 +3/A1	Red	Y2 on PLC
#4 +3/A1	Red	Y3 on PLC
#5 +3/A1	Red	Y4 on PLC

## Relay Jumpers

#1 2/T1	Black	#2 2T1/
#2 2/T1	Black	#3 2T1/
#1 4/A2	Brown	#2 4/A2
#2 4/A2		#3 4/A2
#3 4/A2		#4 4/A2
#4 4/A2		#5 4/A2

FBI Jumpers on terminal blocks  
6-7 9-10 14-15 18-21

**Din Rails** 9" and 6"  
**Poly tube** 24" 9" 9"

Motor 44"  
Vac 42" Black White  
664 26" Red Brown  
502-1 26" Black White  
684 52" Black Black  
811-1 41" Black White  
666 Gas 29" Black White  
659 Door switch 23" Red Brown

## 6" 602 Flex Tube

Red Lion power Red + Black - White ground

# Wiring Dixie UVGD-AL-HMI

## Plumbing

5 425 Elbow  
3 427 T  
2 428 Coupler  
7 431 1"  
432 2 1/2"  
1 433 2"  
434 4"  
1 446 3"  
1 447 4 1/2"  
1 455 3 1/2"  
3 240B

## With clear filter

431, 428, 431, 425, 431, 425, 446, Filter, 455, 427, 447, 425, 431,  
425, 433, 428, 431, 425, 431, 248B

## With metal filter

### Chamber to Vacuum pump

431, 428, 431, 425, 431, 425, 447, 428, 434, 427, 433, 428, 433,  
425, 433, 425, 433, 248B

# Wiring Dixie UVGD-AL-HMI

## Programming RedLion Display

On Red Lion set dip switch 1,2,and 4 up.3 down(4 should always be up)

Power up with 24V

Manually set ip address to 192.168.10.20

Subnet mask 255.255.255.0

Save

Connect Ethernet cable

Open Crimson software

Open \production\delta\RedLion Command Center Delta\9-22-16 UVDMGAHM130PSlc

Chose Link and update

## Programming Delta PLC

Connect serial adapter and Delta data cable

Turn on machine

PLC switch on stop

Open WPL software, File, Open, 7-5-16 UVGMD-AL-HMI

Click on RS232 and correct serial port if necessary

Click Options, Communication settings, For the Com port choose Prolific USB to Serial Com port

Communications, Transfer setup, PC=> PLC The program should transfer

Turn off machine

Flip switch to run



# Dixie Canner Company

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Worldwide Dependability ————— Can Packaging & Processing Equipment

## MODEL UVGMD-AL-HMI 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
123	1st Operation Cam Roll Lever
124	2nd Operation Cam Roll Lever
135	Steel Ball
200	Guard
200-2	Bushing
20123W	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 (Lower Arm)
214-A	Door Lever Bushing (Chamber)
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
303	8-32 x 3/4" Socket Cap Screw
304	10-32 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
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
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
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
412	Vacuum Filter
415	Gas Inlet Fitting
415-D	1/2" Square Head Plug, S.S.
425	1/2" 90E 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.
447	1/2" x 4-1/2" Nipple, S.S.
452	1/4" x 1/8" Bushing, S.S.
454	1/4" x 1-1/2" Nipple, S.S.
455	1/2" x 3-1/2" Nipple, S.S.
457	1/2" x 8" 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, 45E
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

<b>PART NO.</b>	<b>DESCRIPTION</b>
612-4	1/2" x 4" Aluminum Nipple
612-6	1/2" x 6" Aluminum Nipple
612-7	1/2" x 7" Aluminum Nipple
612-8	1/2" x 8" Aluminum Nipple
612-15	1/2" x 15" Aluminum Nipple
614	Sealing Ring
627	1/2" LB Condulet
661-4	Expandable Compact PLC, 8 inputs, 6 outputs
661-4A	Operator Interface with 4.3" HMI Display
661-4D	Vacuum/Pressure Switch
661-4F	Analog Expansion Module for PLC
661-4H	Cable, PLC to HMI Display
659	Door Switch
659-1	Magnet for 659 Door Switch
659-2	Bracket for Mounting 659-1
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

<b>PART NO.</b>	<b>DESCRIPTION</b>
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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  
                      Add for Special

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

Height Spacer

<b>SPK/UVGMD-AL-HMI    SPARE PARTS KIT for UVGMD-AL-HMI</b>		
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

<b>HEAD-UD-UVGD    HEAD ASSEMBLY (assembled)</b>		
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