

**OPERATING INSTRUCTIONS  
AND PARTS LIST FOR  
IVES-WAY  
AUTOMATIC  
CAN SEALER**

**Model Number**

The Model Number of your Can Sealer will be found on the lever. Always mention this number when communicating with us regarding your Can Sealer or when ordering parts.

**How to Order Parts**

When ordering repair parts, always include the following information:

1. The part number and name.
2. The model number, which will be found on the lever.

If Sealer Head is ever in need of repair, it is recommended that it be returned to the factory. Do not attempt to remove the two screws on the front, underside of the head.

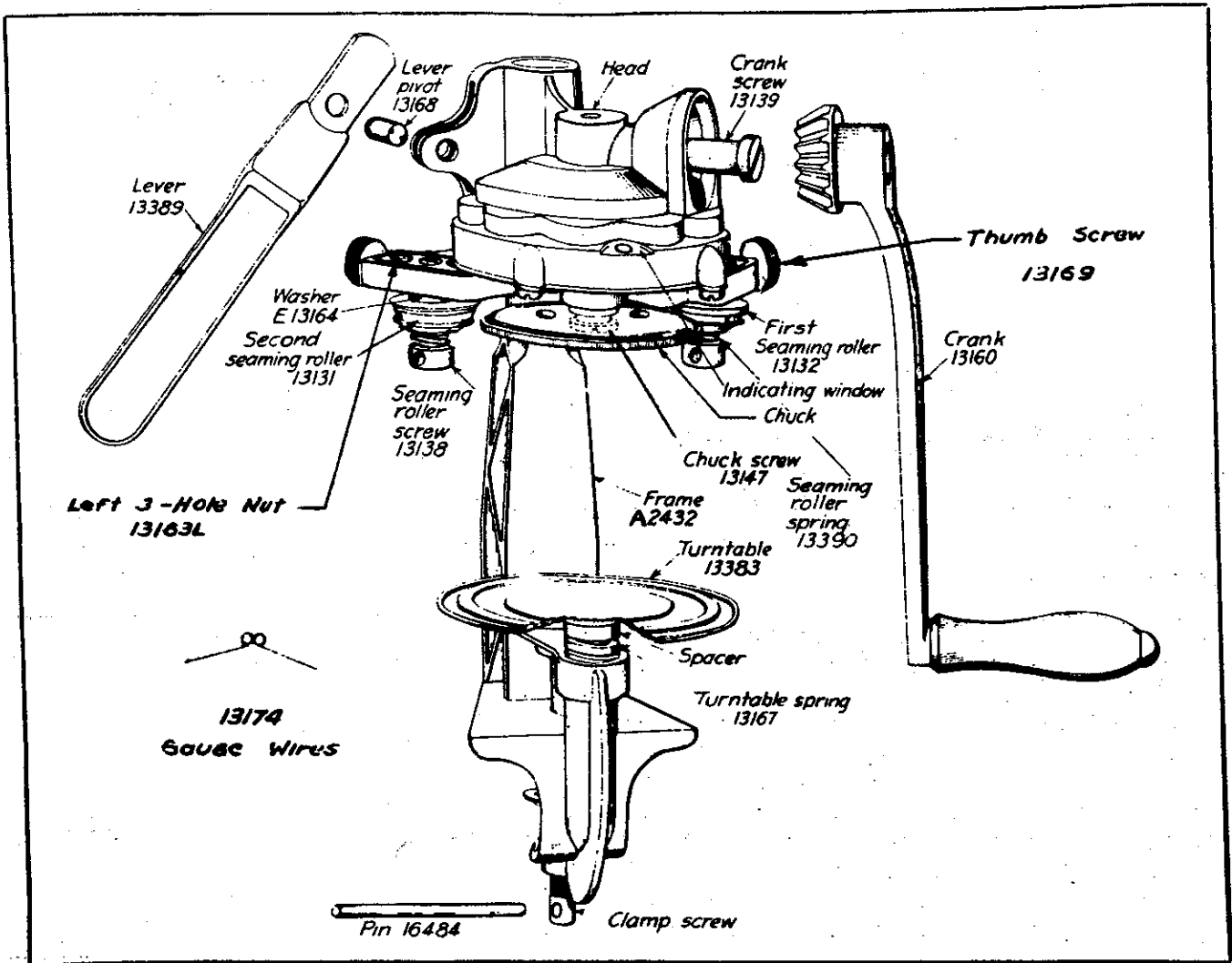
This list is valuable: It will assure your being able to obtain proper part service at all times. We suggest you keep it with other valuable papers.

**IVES-WAY PRODUCTS, INC.**

P.O. Box 70

Round Lake Beach, Illinois 60073

PHONE: (847) 740-0658



## PARTS LIST

Quantity	Part No.	Part Name
1	A2432	Frame Assembly
1	13131	Second Seaming Roller
1	13132	First Seaming Roller
2	13138	Seaming Roller Screw
1	13139	Crank Screw
1	13147	Chuck Screw
1	13160	Crank Assembly
1	13163L	Left 3-Hole Nut
1	13163R	Right 3-Hole Nut
2	E13164	Roller Washer
1	13167	Turntable Spring
1	13168	Lever Pivot
2	13169	Thumb Screw
1	13174	Gauge Wires
1	13383	Turntable
1	13389	Lever
2	13390	Seaming Roller Spring
1	16484	3" Pin
1	16485	Instruction Sheet

The part number of the spacer and chuck varies depending on the model of your sealer. See the first page of your instruction sheet for location of the model number. The table below shows the part numbers of these items for your particular sealer.

Model No.	Can Size	Spacer Part No.	Chuck Part No.
40	1	B13171	A13152
50	2	A13171	B13152
60	2-1/2	D13164	C13152
70	3	None	D13152

Other Model Numbers shown on insert page.

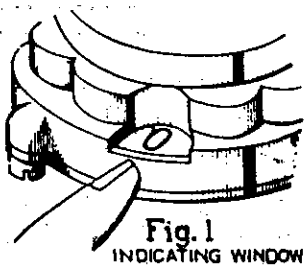
# Instructions for Care and Operation

Your sealer comes with the crank and lever detached. To assemble, clamp the sealer to a table using the pin to tighten the clamp screw. Do not overtighten this screw or use an extension on the end of the pin to gain more leverage. A moderate amount of force on the pin furnished is sufficient to secure the sealer to the table. The hand lever is used for raising and lowering the head and should be inserted into the slot on the left side of the head. The lever should project through the head and enter the slot in the frame post. Check the alignment of the holes in the lever and the head and insert the lever pivot from the back, with the knurled side of the pivot out. Tap the pivot in all the way, moving the lever slightly, if necessary, to align the holes. To attach the crank, turn the chuck by hand until the "0" appears in the center of the window. Insert the gear end of the crank into the housing so that it hangs down and a few inches forward. While holding the crank in this position, insert the crank screw and tighten. Before using the sealer, oil all points shown in Fig. 5.

## SEALING CANS

Before sealing, turn crank, if necessary, so that the "0" is in the center of the window. When the can is ready for sealing, hold it in your right hand and center a cover on top of the can. Raise the lever with the left hand and center the can on the turntable. Lower lever slowly and move can sideways, if necessary, to center chuck on the cover. Press lever down to locked position. Turn crank clockwise and note first and second operations taking place automatically as "1" and "2" appear in the window respectively. The crank should turn rather hard toward the end of each operation so that the seam will be rolled "tight". Continue turning until "0" reappears in window. The can is then tightly sealed. Lift lever to remove sealed can. The rollers may loosen on account of newness. On new sealers be sure to check both rollers and adjust, if necessary, during sealing of first two dozen cans. See Adjustment procedure below.

## ADJUSTING SEAMING ROLLERS



CORRECT ADJUSTMENT OF SEAMING ROLLS SHOWING PROPER USE OF GAUGE WIRES.

The first seaming roller is on the right side of the sealer (Fig. 2) and is for curling the seam. Turn the crank until "1" appears in the window. Loosen the roller screw with the pin and loosen the thumb screw two or three turns. Slide the seaming roller assembly back until the 3-hole nut touches the thumb screw or stops against the rocker frame. Remove the pin and retighten the roller screw by hand. Insert the heavy gauge wire between the chuck and the first seaming roller (Fig. 3). Tighten the thumb screw until a drag is felt on the gauge wire as it is being pulled forward, then tighten the thumb screw an additional 1/4 turn. Lock the roller screw in place by tightening with the pin. Check to see that the gauge wire cannot be pulled out easily. If it can, loosen the roller screw slightly and tighten the thumb screw slightly. Lock the roller screw in place and re-check to see that the gauge wire cannot be pulled out easily. If it still can, repeat the above step until it cannot. To remove the gauge wire turn the crank clockwise. After the adjustment is complete and the roller screw is locked in place, tighten the thumb screw. The second seaming roller is on the left side of the sealer and is for flattening the seam. Turn the crank until "2" appears in the center of the window. The thin gauge wire is used to adjust this seaming roller (Fig. 3). Follow the same procedure used for the first seaming roller, except turn the crank counterclockwise to remove the gauge wire.

## REMOVING THE CHUCK

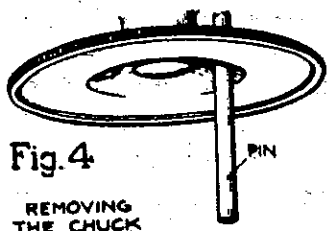


Fig. 4

REMOVING  
THE CHUCK

If replacement of the chuck becomes necessary it can be removed as shown in Fig. 4. Place the pin through one of the two holes in the chuck, to keep it from turning, and urge the crank counter-clockwise until chuck is loose. Then turn the crank until the "O" is in the window and unscrew the chuck by hand. After unscrewing hold chuck in hand and strike the threaded end of the chuck screw with the flat side of a hammer. This will pop the screw out of the chuck. To replace the chuck, insert screw in the center hole of the chuck, from the hollow side and screw into place by hand. Put the pin through one of the holes as before and urge the crank clockwise until tight.

## LUBRICATION INSTRUCTIONS

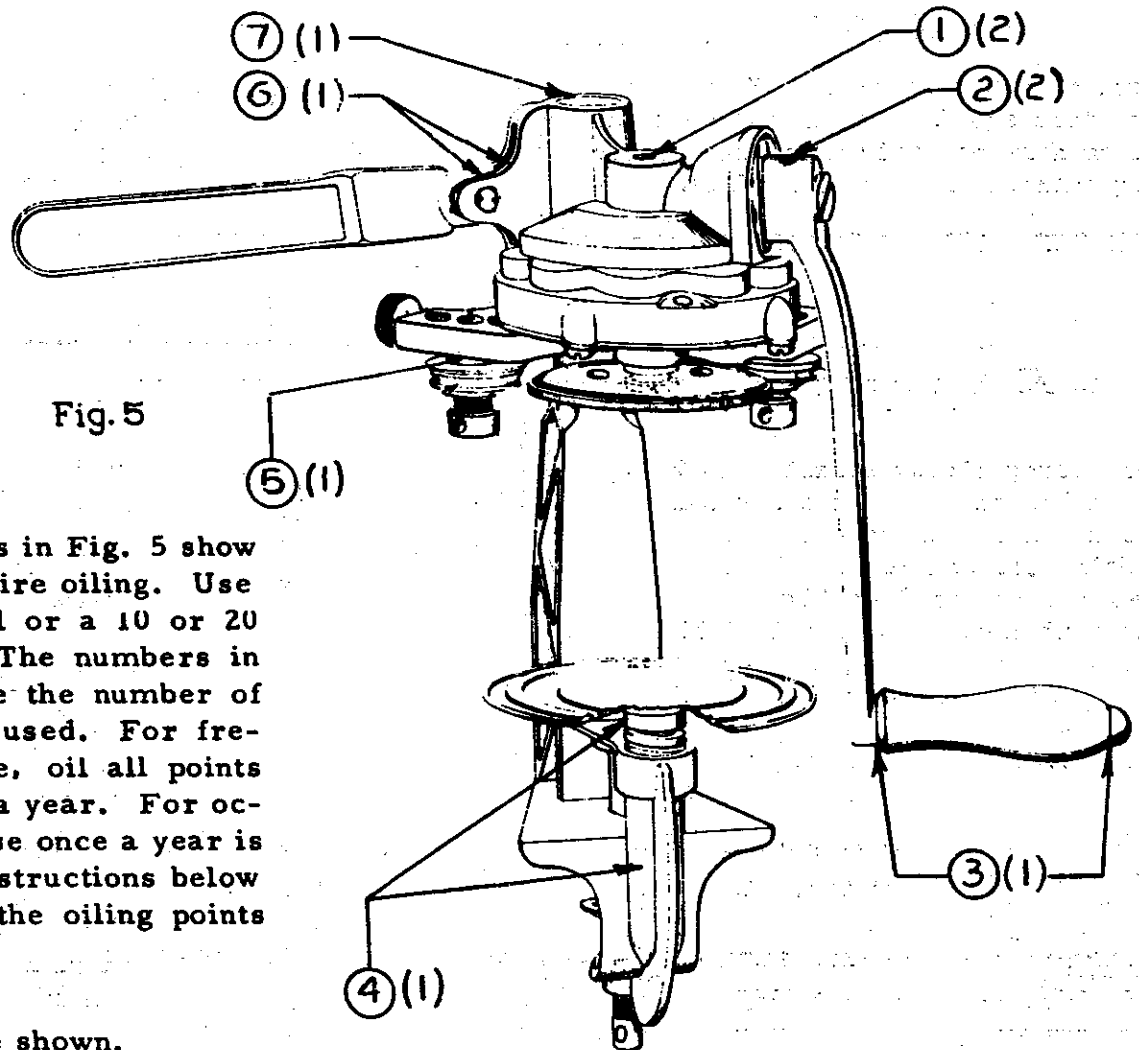


Fig. 5

The circled numbers in Fig. 5 show the points that require oiling. Use a light machine oil or a 10 or 20 weight motor oil. The numbers in parenthesis indicate the number of drops of oil to be used. For frequent or heavy use, oil all points two or three times a year. For occasional or light use once a year is sufficient. In the instructions below the numbers are the oiling points circled in Fig. 5.

- 1- Apply oil to hole shown.
- 2- Apply oil to hole shown.
- 3- Slide the handle away from the point that is being oiled. Apply oil, then rotate handle to allow oil to be drawn into the hole in the handle.
- 4- Remove the turntable and apply one drop of oil to each side of the spacers and on the turntable stem.
- 5- Apply oil to outside surface of washer. This is required on both the first and second seaming roller washers.
- 6- Move lever to "Up" position and apply oil above lever pivot and at end of lever inside the slot in the head.
- 7- With lever still in "Up" position apply oil to inside surface of head.