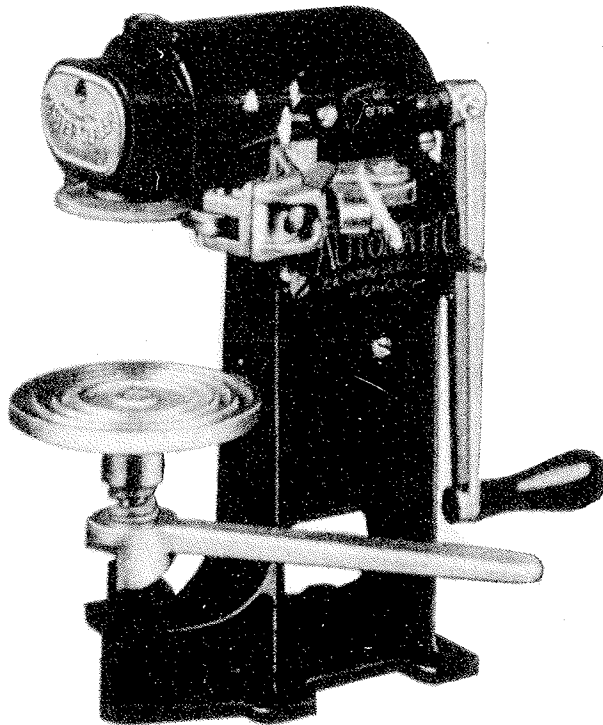


# ALL-AMERICAN AUTOMATIC MASTER SEALER

*America's original and finest automatic can sealer.*



## OPERATING INSTRUCTIONS

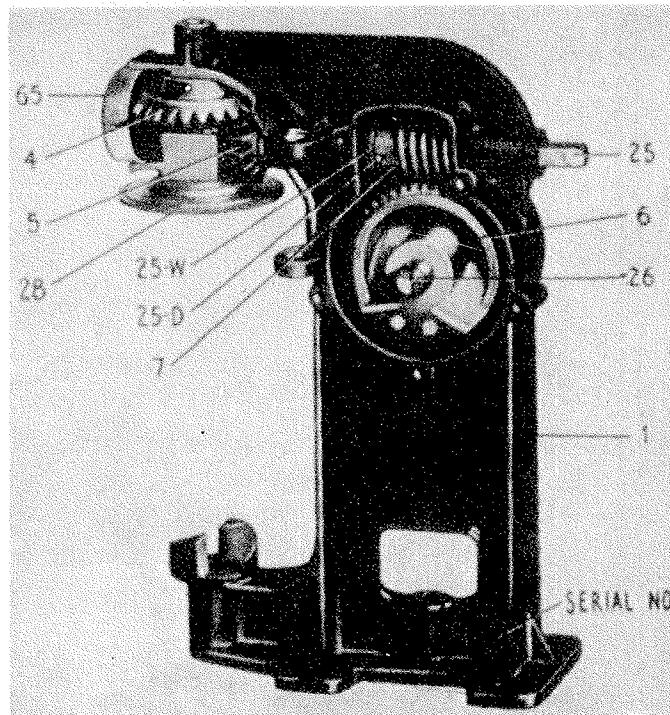
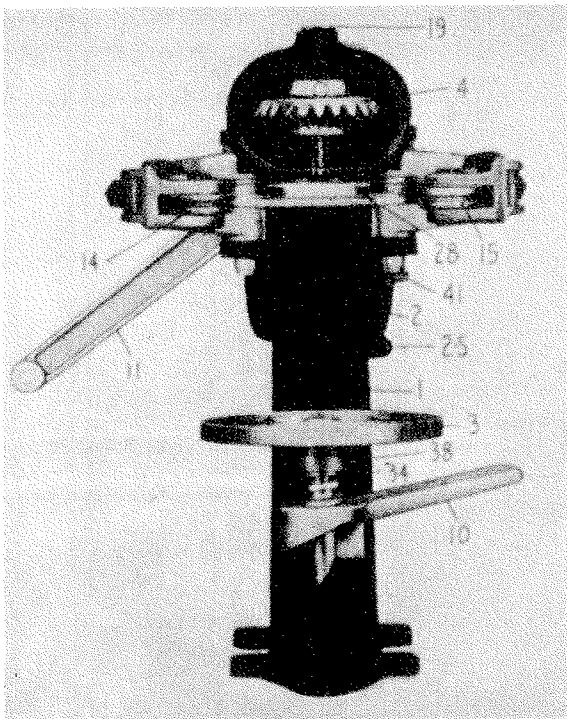
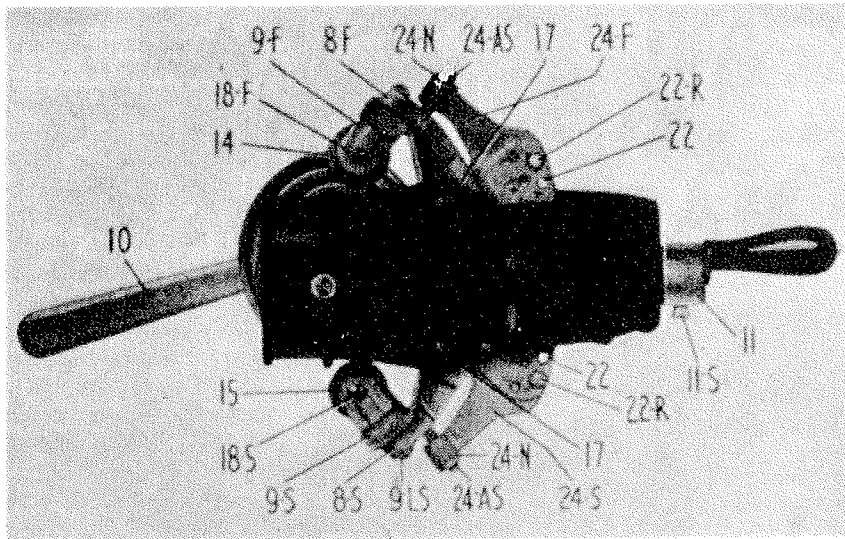


WISCONSIN ALUMINUM FOUNDRY CO., INC.

MANITOWOC, WISCONSIN, U.S.A. 54220

## OPERATING INSTRUCTIONS

The numbers shown in the accompanying photograph are the numbers referred to in the operating instructions. They also may be used in conjunction with the photographs on the parts price list when ordering replacement parts.



### HOW TO SEAL CANS WITH AUTOMATIC MASTER SEALER

1. Fasten sealer firmly to table or bench using clamp (No. 44). The sealer also has four bolt holes so that it may be permanently bolted to the table.
2. Attach crank (No. 11) to worm shaft (No. 25) and tighten set screw (No. 11S).
3. Change the chuck, height washer, and levers to the size can be to be sealed, as described in directions on following page.
4. Lower base plate (No. 3) by turning can lifter handle (No. 10) as far as possible to the left.
5. Place lid on can and set can on base plate (No. 3).
6. Raise can until it is clamped firmly between base plate (No. 3) and chuck (No. 28) by turning can lifter handle (No. 10) as far as possible to the right until handle locks itself against the frame (No. 1). The can is now ready to be sealed.
7. Turn crank (No. 11) clock-wise (twenty-one turns) until second operation roll (No. 15) returns to its normal position — away from chuck (No. 28). If the second operation roll (No. 15) starts toward the can before the first operation roll (No. 14) remove the chuck (No. 28) and turn the

crank (No. 11) clockwise (ten turns) until the first operation roll (No. 14) starts toward the can. Replace the chuck (No. 28) and continue item 7.

8. Release sealed can by turning can lifter handle (No. 10) as far as possible to the left. The machine is now ready to receive another can for sealing.

**Note:** If it is necessary to operate sealer without a can in place, remove the chuck (No. 28) to prevent damage to it and the seaming rolls.

## INSTRUCTIONS FOR CHANGING THE AUTOMATIC MASTER SEALER FROM ONE SIZE TO ANOTHER

1. Pull down on chuck (No. 28) which will slip out of place. While sealer is new it is sometimes necessary to force the chuck down by placing a screw driver against the chuck shaft which is inside of the chuck holder bushing (No. 19).
2. Remove base plate (No. 3), base plate shaft, and height washer (No. 38). Put washer, marked with the size of can to be sealed, on top of base compression spring (No. 34) and replace base plate and shaft. No. washer is used for the No. 3 can. When opening or sealing a can that has been reflanged, use the same washers that were used when reflanging the can but do not use the reflanging collar (No. 64).
3. Lift the rivet (No. 22R) from the cam roller lever (No. 22) and adjusting lever (No. 24). Move the adjusting lever (No. 24) until the rivet (No. 22R) may be dropped into the hole marked with the size of can to be sealed. The rivet must be changed on both the first and second operation side of sealer. The holes that are marked "S" in the cam roller levers (No. 22) are for use with special adjusting levers (No. 24) if the sealer is equipped to seal cans not mentioned on page 4.
4. Slip the chuck of the desired size up into place. It may be necessary to turn the chuck while pushing upward. A ball race holds it.

**Flanging parts are no longer manufactured!  
This includes the cutting roll (part no. 16) as well.**

## MAINTENANCE ADVICE TO USER OF AUTOMATIC MASTER CAN SEALER

### Oil sealer frequently as follows:

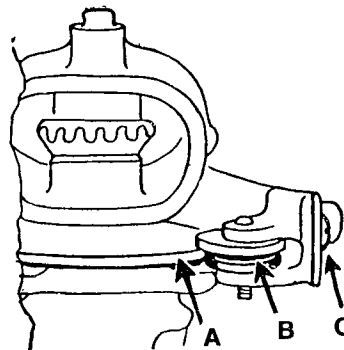
1. All oil holes on frame and cover (Nos. 1 and 2).
2. Rollers on Cam Roller Levers (No. 22).
3. Seaming Roller Pins (No. 18F and 18S).
4. Seaming Lever Pins (No. 17).
5. Chuck Holder Bushing (No. 19).
6. Complete Base Plate Shaft (No. 32).
7. Can Lifter Handle (No. 10) where it comes in contact with frame (No. 1).

Put grease on gears at least once a season as follows:

1. Cam Worm Wheel (No. 6) and Worm Gear (No. 7).
2. Bevel Gear (No. 4) and Bevel Gear (No. 5).

Clean your sealer thoroughly after using it. Then cover the seaming rolls (No. 14 and 15) and the cutter (No. 16) with oil to prevent rusting.

Check the adjustment of the seaming rolls occasionally. First check the height adjustment as follows: When chuck (A in sketch) is held up tightly against frame the top flange of seaming roll (B in sketch) must fit closely on top of chuck (A). To make adjustments, turn crank until seaming roll touches chuck; slightly loosen screw (9LS) which is "C" in sketch, push down on casting that contains seaming roll (B) until top flange of seaming roll (B) rests on top of chuck (A). Now tighten screw (9LS) which is "C" in sketch **as tight as possible**. This adjustment should be made on both 1st and 2nd operation rolls. After height adjustment has been made, use the seam gauge which is for checking the seam on No. 2 cans only. If adjusted correctly for No. 2 cans, the sealer will seal all other sizes correctly without further change of adjusting screw. To use the gauge, first



check to see if the No. 2 can to be used has a paper gasket or compound (wax or rubber) gasket and use side of gauge so stamped. The side marked "Compound" is for use on cans with a compound gasket and the side marked "Gasket" is for use on cans with a paper gasket. After sealing the can with only the first operation roll (No. 14 on page 2) slip the gauge over seam. The groove marked "1st" should slide over seam on can. The seam will not fill the entire length of the groove but the gauge should slip on far enough so that it touches the can cover. If groove in gauge will not slip over seam, tighten seaming roll (No. 14) by loosening lock nut (No. 24N) and turning adjusting screw (No. 24AS) not more than a quarter turn to the right. If the groove in gauge is loose on the seam turn the adjusting screw to the left. Remove rivet (No. 22R) from second operation levers (No. 22 and 24S) and repeat above operation until seam gauge fits over seam.

When first operation seam is correct, change the rivet (No. 22R) from the first operation levers (No. 22 and 24F) to the second operation levers (No. 22 and 24S) and adjust the second operation roll in the same manner as the first operation roll using the can that has a proper first operation roll seam. The groove in the seam gauge marked 2nd is used when adjusting the second operation roll. Be sure to tighten the lock nuts (No. 24N) after adjusting each roller.

If it is necessary to operate sealer without a can in place, remove chuck (No. 28) to prevent damage to it and seaming rolls.

Be sure the first operation roll (No. 14) comes in first. The second operation roll (No. 15) completes the seam started by the first.

If you desire to send your sealer to the factory for repairs, be sure to write us before shipping the machine. In many cases time and transportation charges can be saved by giving you the necessary information on repairs by mail.

A dull or nicked cutter causes small cracks in the can. These small cracks are greatly enlarged during the reflanging process.

To avoid having more flange on one side of the can than the other, be sure the can is set in the center of the base plate groove when cutting the reflanging.

If the can sticks to the chuck slightly it may be removed by pushing the can towards the sealer. If the can is pulled downward, it will usually pull the chuck with it.

If the can sticks excessively examine the height adjustment of the first operation roll (No. 14) and the second operation roll (No. 15). In some cases a worn chuck will also cause the can to become sealed over the chuck.

If the chuck slips in the can instead of revolving it examine the lower portion of the knurl on the chuck. If the knurl has become worn or damaged the chuck needs replacement.

The side of seaming rolls that is larger in diameter is the top.

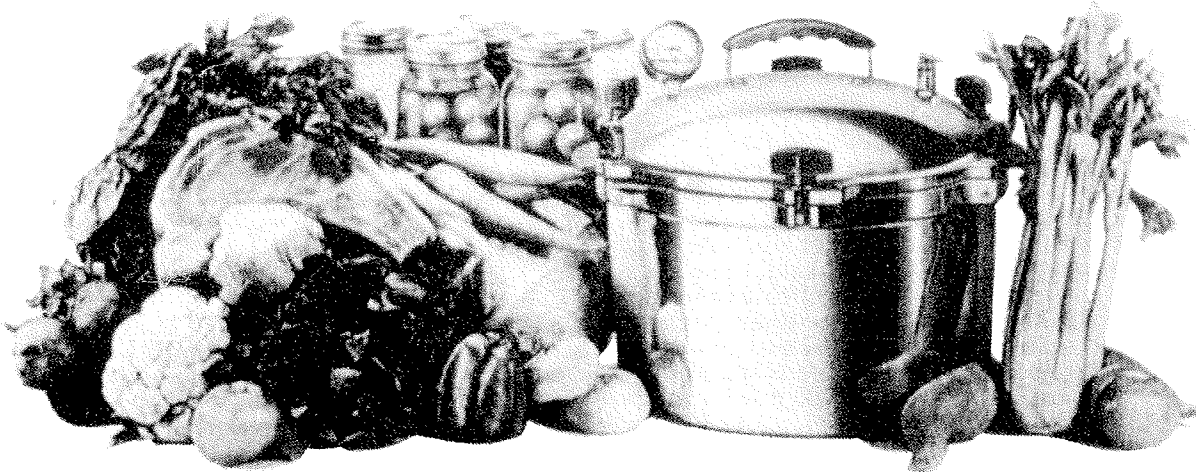
For lubrication we recommend a USDA and FDA approved food machinery grease.

### TIN CAN SPECIFICATIONS

Trade Name	Common Name	Dimensions in Inches	Capacity in Ounces of Water	Capacity in Cups	Commonly Used for
<b>No. 1</b>	Half Pint	2 <sup>11</sup> / <sub>16</sub> by 4	11	1 <sup>1</sup> / <sub>3</sub>	Soups, Chicken, Chili Con Carne.
<b>No. 2</b>	Pint	3 <sup>7</sup> / <sub>16</sub> by 4 <sup>9</sup> / <sub>16</sub>	20 <sup>1</sup> / <sub>2</sub>	2 <sup>1</sup> / <sub>2</sub>	Peas, Corn, Green Beans, Fruits, Meats.
<b>No. 2<sup>1</sup>/<sub>2</sub></b>	30 Ounce	4 <sup>1</sup> / <sub>16</sub> by 4 <sup>11</sup> / <sub>16</sub>	30	3 <sup>1</sup> / <sub>2</sub>	Fruits and Vegetables, west of Rocky Mountains.
<b>No. 3</b>	Quart	4 <sup>1</sup> / <sub>4</sub> by 4 <sup>7</sup> / <sub>8</sub>	35	4	Tomatoes, Hominy, Pumpkin, Meats, Fruits of all kinds.

Additional parts to seal special size cans are available upon request.

### Do All Your Canning in ALL-AMERICAN PRESSURE COOKERS



Made in a complete range of sizes for all cooking and canning purposes.

For further information write to:

**WISCONSIN ALUMINUM FOUNDRY CO., INC. MANITOWOC, WISCONSIN 54220**