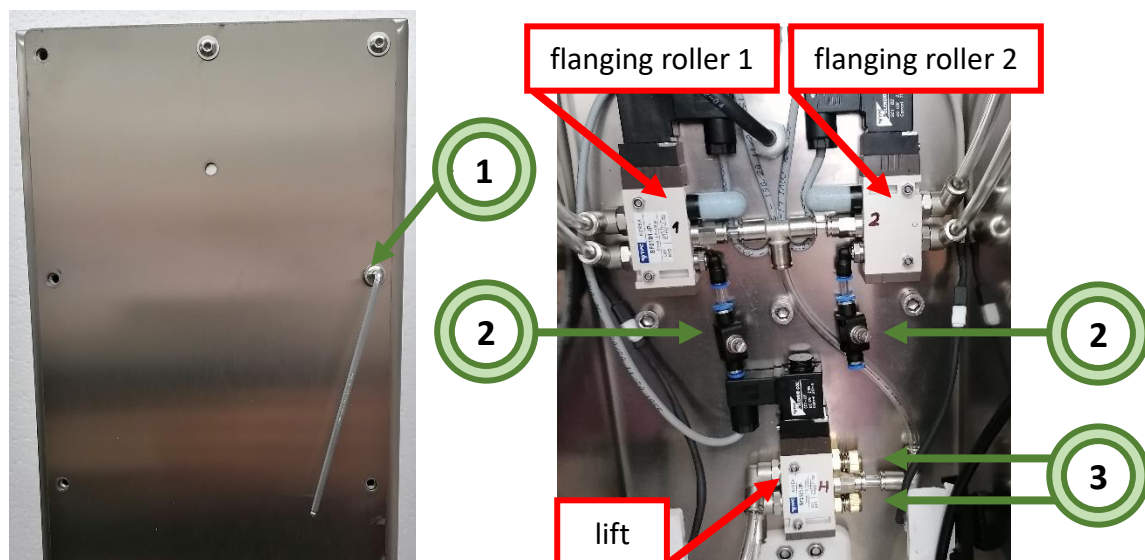


# Adjusting the flanging rollers

## Speed

The travel speed of the flanging rollers can be adjusted via various throttle valves inside the can sealer. Access is gained via the rear of the unit.

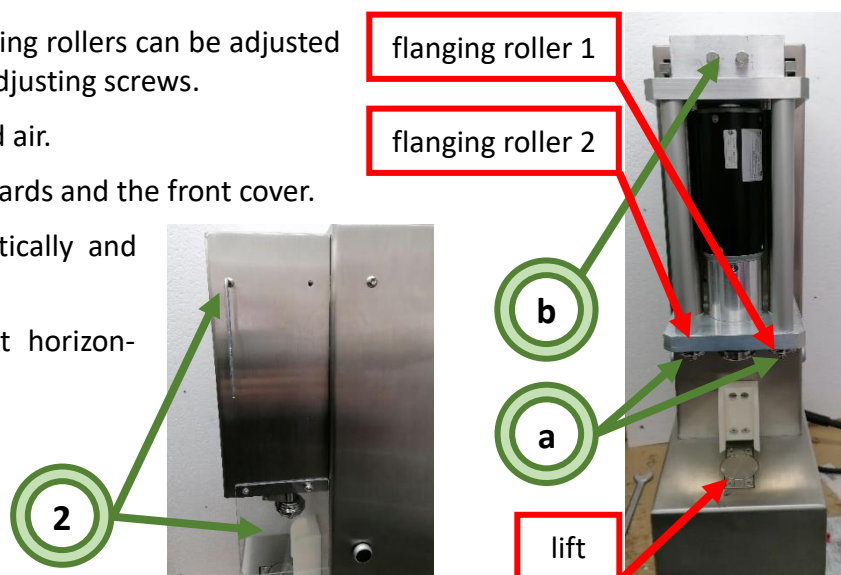
1. Remove rear cover.
2. The travel speed of the flanging rollers is set by turning the respective throttle valves.
3. By turning the respective rotary control, the travel speed of the can is set. The upper knob controls the downward movement, the lower knob the upward movement of the can.
4. After the settings, the rear cover must be refastened.



## Position

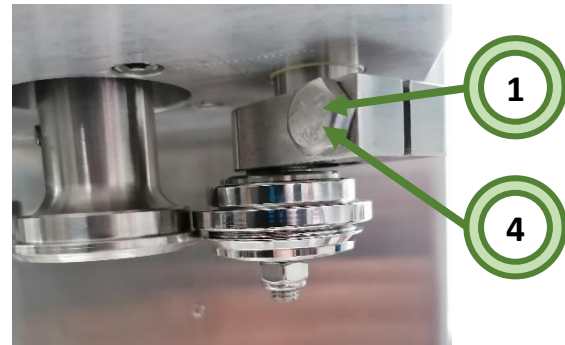
The positioning of the flanging rollers can be adjusted from the front via various adjusting screws.

1. Remove compressed air.
2. Remove the side guards and the front cover.
  - a. Adjustment vertically and horizontally
  - b. Fine adjustment horizontally

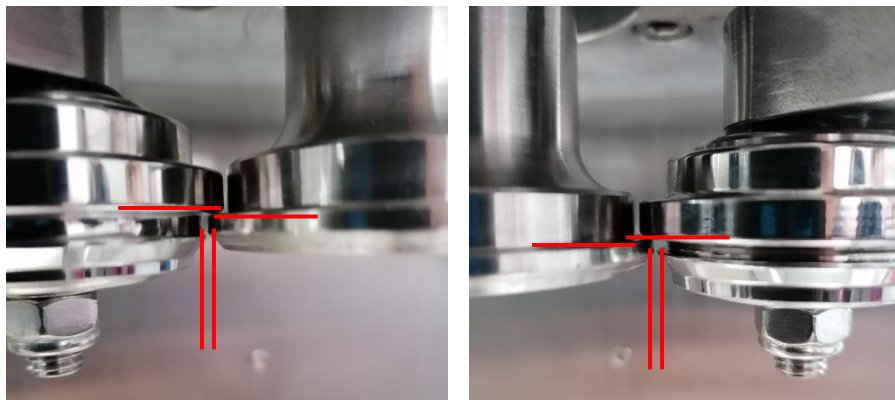


a. Adjustment vertically and horizontally

1. Loosen the screw, hold the flanging roller while doing so.
2. Move the flanging roller vertically until a distance of **max. 0.5mm** is reached.
3. Move the flanging roller horizontally until a distance of **approx. 0.5 to 1mm** is reached.
4. Tighten the screw.

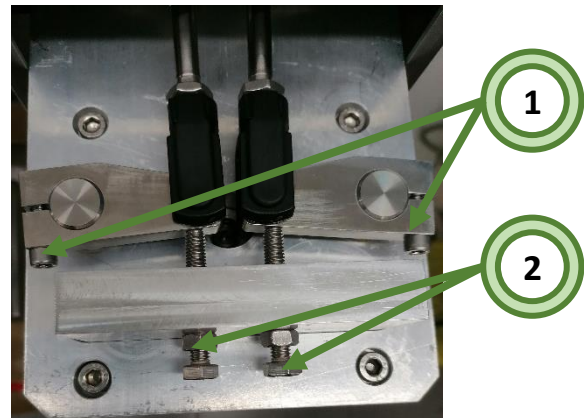


2,3



b. Fine adjustment horizontally

1. Check screws for tight fit; *do not use for adjustment!*
2. Turn the adjustment screws to move the stop.
3. Check settings by trial and error.



3



Flanging roller 1 is too far away.



Flanging roller 2 is too far away.



Ideal flanging.