



# **Seamer Screw Position**

# Disclaimer

**Before going through this guide, Ensure the following:**

- **Seamer is in time**
- **Seamer rail spacing is good**
- **Pin Height and Spring pressure are in spec**
- **No worn parts (ex. Lifter bearing, idler belt/sprocket, lifter spring).**

**You can easily make the damage worse if these things are not checked beforehand**

**This guide will assist you in understanding the positioning of the seamer screw.**

# Symptoms of Poor Screw Positioning



Consistently  
damaged cans

Other symptoms:

- Poor or completely unseamed cans
- Deadhead skidders

Note: the can will almost always center into the chuck no matter how far off the screw is. If it doesn't center it won't seam and potentially won't spin (deadhead skidder).

Note 2: This is easily confused with screw timing –

- Timing refers to when the can will lift (See Seamer Timing Guide)
- Position determines where the can will lift

# Checking Seamer Screw Position

The screenshot displays the control interface for the CODI FILLER CCL-45. At the top, it shows 'CODI V12.3 FILLER CCL-45'. The main area is divided into several sections:

- Top Left:** 'FILLING PAUSED' (yellow), 'RUN ONE CYCLE' (blue), 'FILL CYCLE AUTO CIP' (green), and 'Reset Alarms & Faults' (blue).
- Top Center:** 'TANK' section with a temperature of 65 °F, a circled '0%' and '5%' indicator, and pressure settings of 0.0 psi and 0.1 psi.
- Top Right:** 'INLETS' section with 'AIR 112.6 psi' and 'CO2 50.1 psi'.
- Middle Left:** 'Can Diameter' selection (211 Std. Body, 202 Slim Body, 204 Sleek Body, 203 Slender) and 'INDEX CANS' (green).
- Middle Center:** 'Seamer Lid Separate' (Man, Retracted) and 'Seamer Lift' (Man, Lowered) buttons.
- Middle Right:** 'Lid Jam Detect' (OFF), 'Lids Missed Retry' (OFF), and 'Can In Pocket' checkboxes (0-5).
- Bottom Left:** 'Conveyor' section with 'STOPPED' status and manual speed settings (35 ft/min).
- Bottom Center:** 'Seamer' section with 'MAN STOPPED' status and 'JOG' button, along with manual RPM settings (2 RPM).
- Bottom Right:** 'Encoder Position' (10204) and a list of 'Jog To' values for various stages: Can At Lid Drop (19550), Lid Screw Cutting (43275), Can At Dwell Start (33333), Seam Op1 Start (38240), Seam Op1 Engage (47350), and Seam Op2 Engage (50000).

Start by:

- Putting your lid dropper and seamer lift into manual and turning off the Lid Jam Detect
- Placing a seamed, undamaged, unlabeled can on the conveyor belt with the conveyor running
  - If you do not have a seamed, unlabeled can you can use an full, unseamed can of water but just need to be careful not to damage said can when making adjustments

# Checking Seamer Screw Position

The screenshot shows the control panel for a CODI FILLER CCL-45 machine. The interface includes several sections:

- Top Bar:** CODI V12.3 FILLER CCL-45
- Left Panel:** FILLING PAUSED, RUN ONE CYCLE, FILL CYCLE AUTO CIP, Reset Alarms & Faults, Can Diameter (211 Std. Body, 202 Slim Body, 204 Sleek Body, 203 Slender), INDEX CANS, Seamer Lid Separate (Man, Retracted), E-Stop Okay, Can At Lid Drop, Lid Missed, Lid Chute Jam, Conveyor (STOPPED), Man. (ft/min) 35, Act. (ft/min) 0.
- Center Panel:** Seamer Setup PDF, Seamer Timing PDF, Seamer Lift (Man, Lowered), Underlid Gas Open checkbox.
- Right Panel:** TANK (65 °F, 0% to 5% scale, 0.0 psi to 0.1 psi), INLETS (AIR 112.6 psi, CO2 50.1 psi), Lid Jam Detect (OFF), Lids Missed Retry (OFF), Can In Pocket (0-5 checkboxes), Encoder Position (10204, 0), Apply Value, Can At Lid Drop (19550, Jog To), Lid Screw Cutting (43275, Jog To), Can At Dwell Start (33333, Jog To), Seam Op1 Start (38240, Jog To), Seam Op1 Engage (47350, Jog To), Seam Op2 Engage (50000, Jog To), Hide Advanced Setup.

- Put the seamer in manual and change the RPM to 25
- Press and hold jog until just after the can has grabbed an end

If you have a universally timed machine you will need to hit “Show Advanced Setup” to get to this menu

Next, press Jog to “Can at Dwell Start”

## Checking Seamer Screw Position

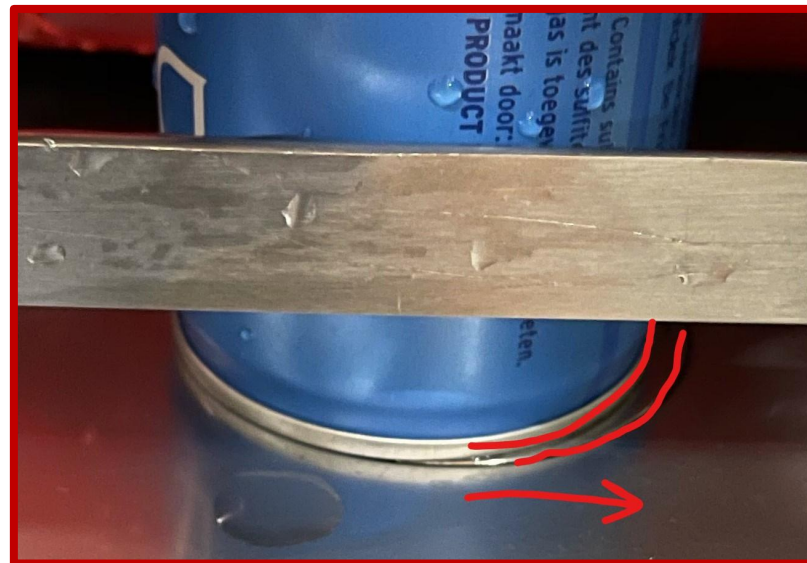


Now, gently push the can from the base into the back of the dwell and evaluate the positioning of the screw. The can should land dead center on the lifter pad.

# Checking Seamer Screw Position



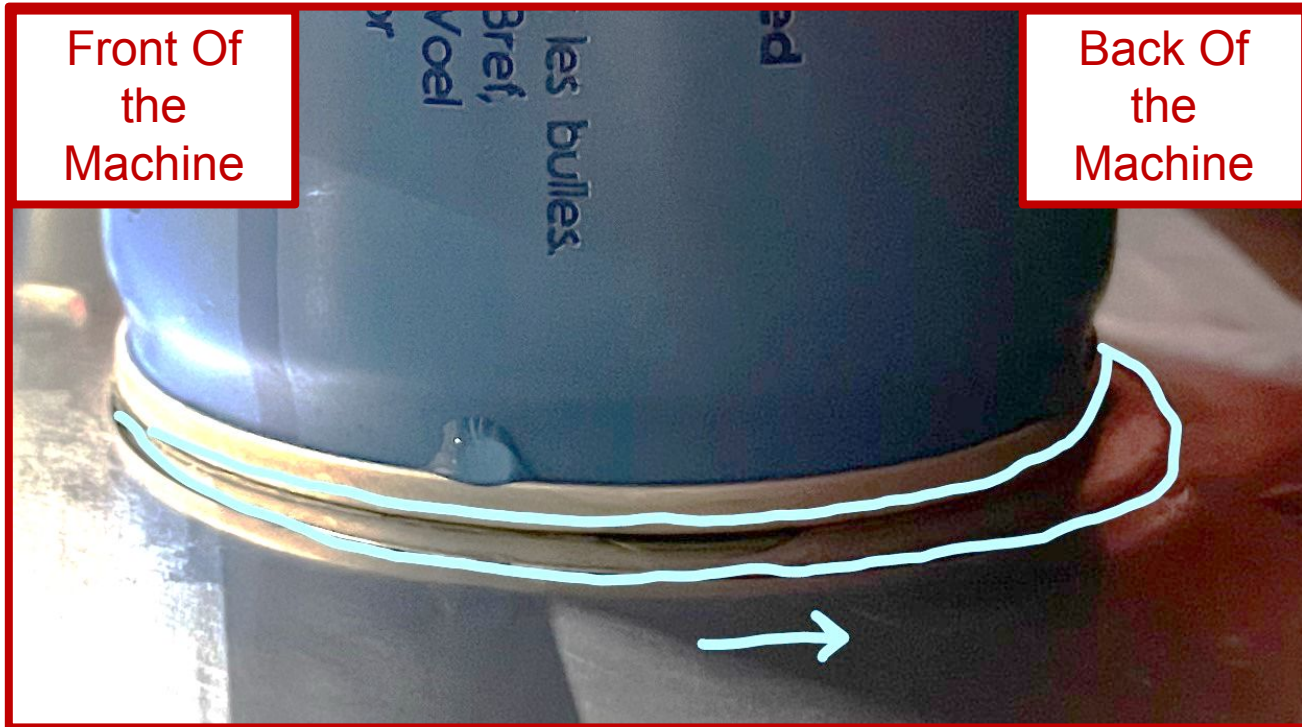
Now, gently push the can from the base into the back of the dwell and evaluate the positioning of the screw. Ideally the can should land dead center on the lifter pad.



This particular screw, on a Right Hand Filler, needs to move towards the outfeed of the seamer.

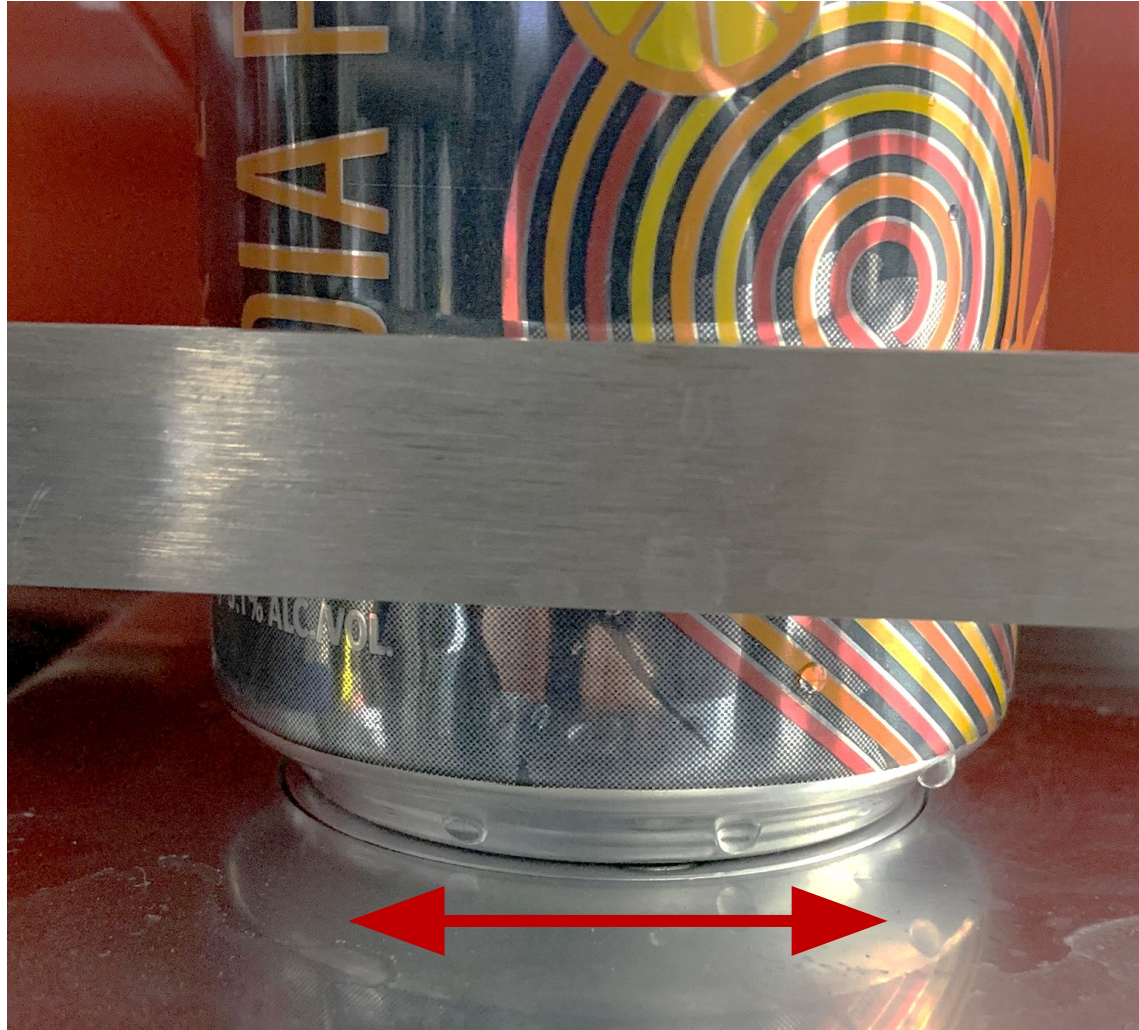


# Checking Seamer Screw Position



Looking straight down the conveyor, you can also see that the can needs to move toward the back of the machine to get it fully centered on that plate.

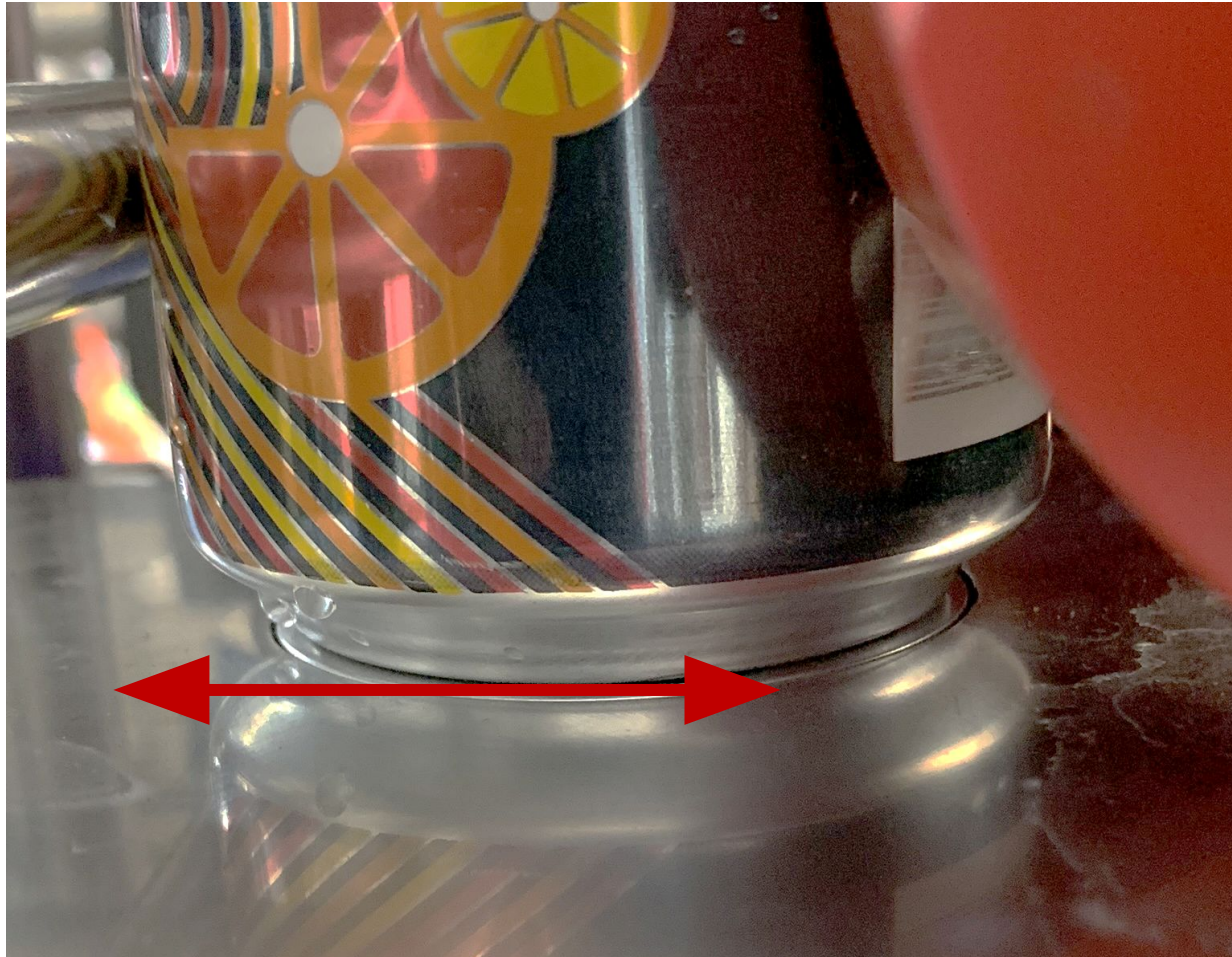
# Checking Seamer Screw Position



The goal is to get the can as dead center on the lifter pad.

Both laterally...

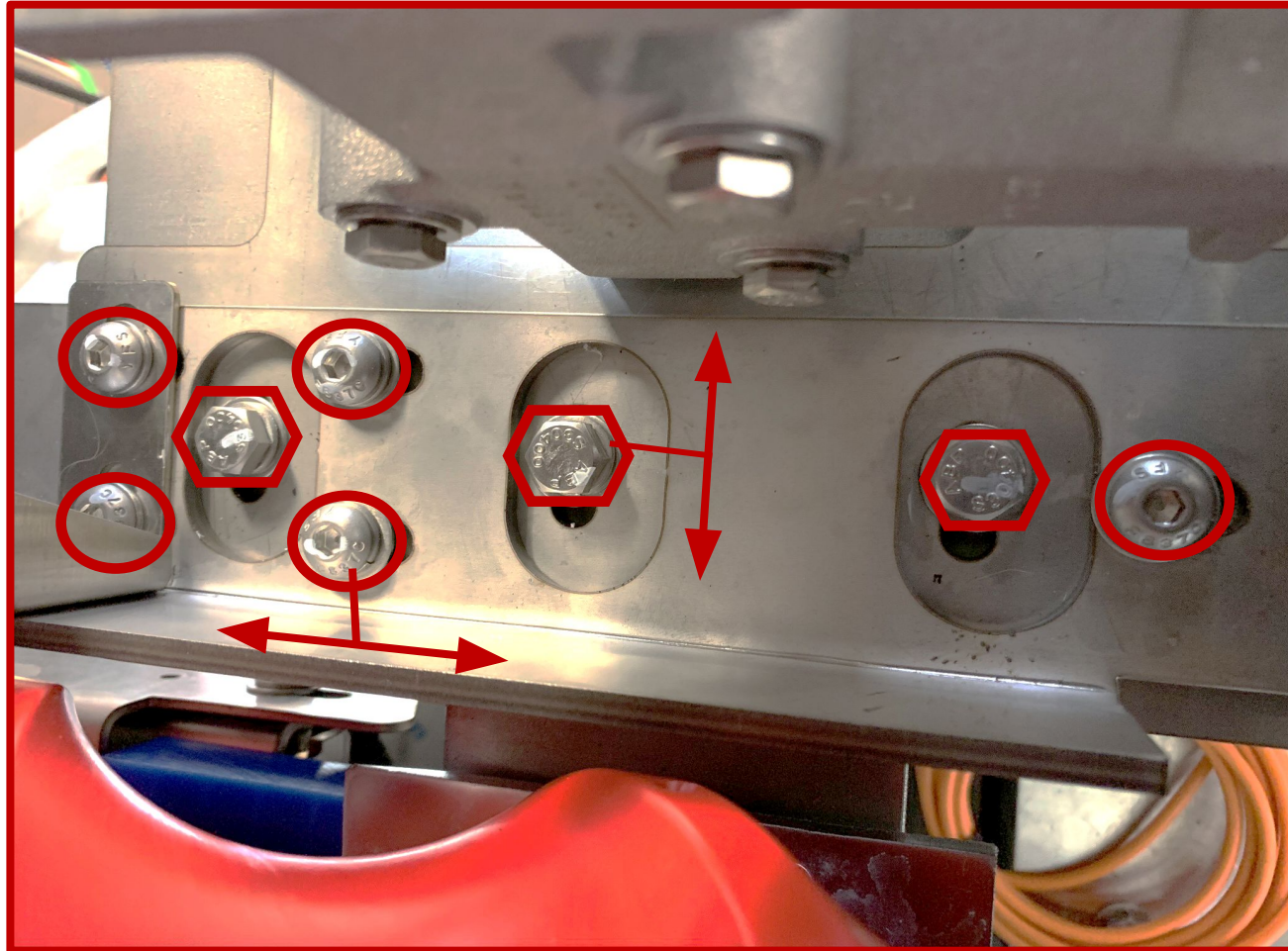
# Checking Seamer Screw Position



...As well as  
front to back

**If your can is already centered on your lift pad, double check that it is also centered under your chuck. If it is, your issue is likely not the screw position. See guides on “Seamer Timing” and “Rail Spacing”**

# Adjusting Seamer Screw Position



Locate the 5 button head bolts and 3 hex head bolts behind the screw.

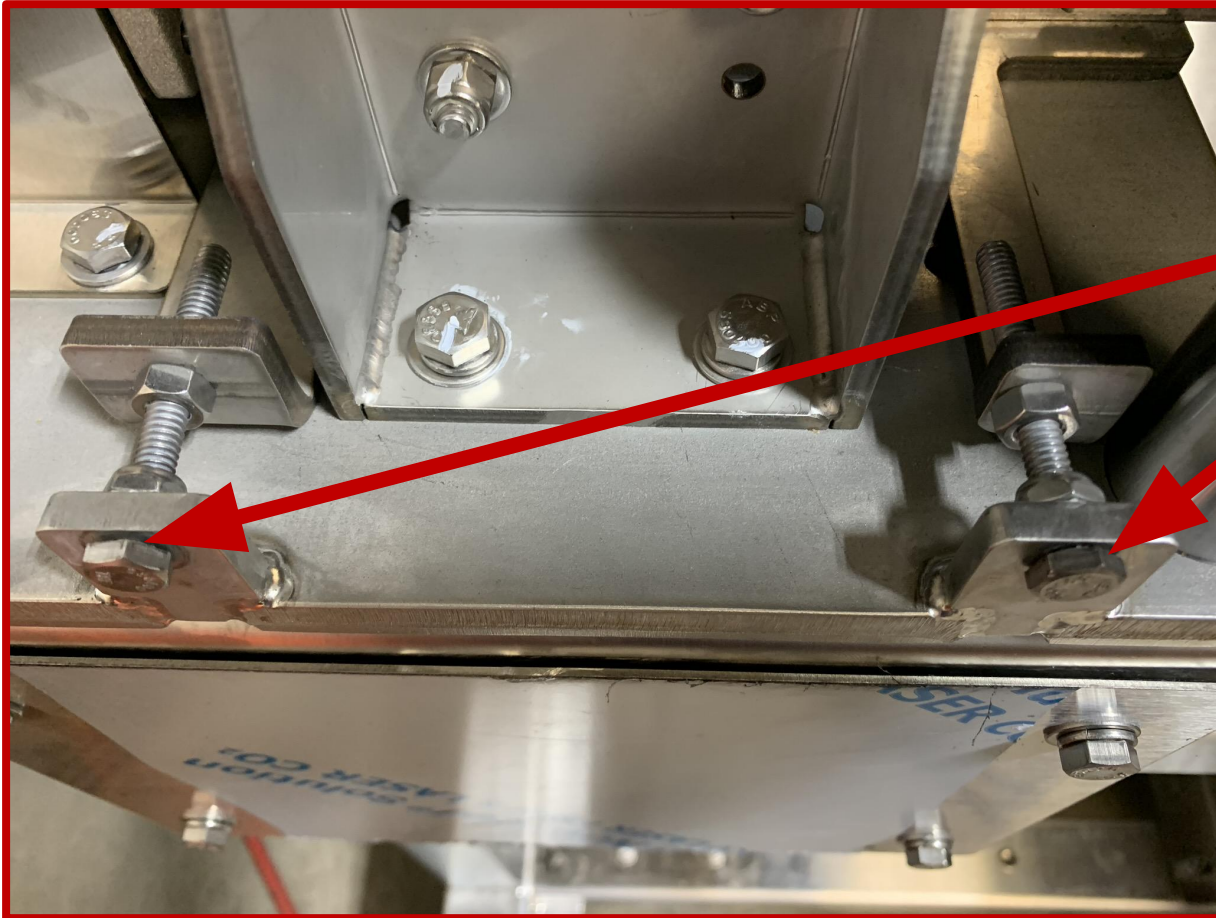
Use a  $\frac{5}{32}$ " allen key to loosen the button heads for a side to side adjustment

Use a  $\frac{1}{2}$ " deep well socket with a small extension to loosen the hex heads for a front to back adjustment.

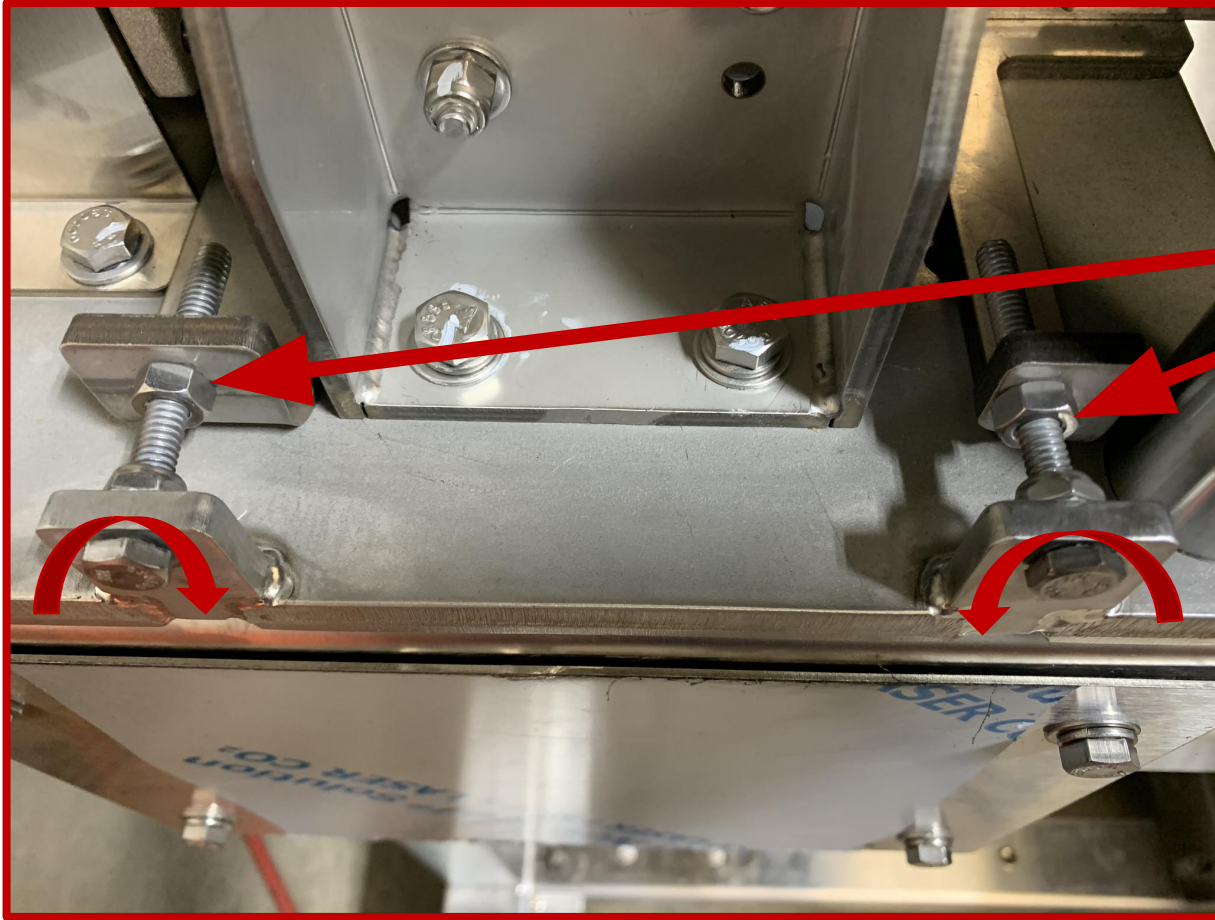
## Adjusting Seamer Screw Position

For a front to back adjustment, locate the 2 positioning bolts on the backside of the seamer

These control the front to back adjustment of the screw (operator side to electrical panel side of the machine). And should be adjusted in tandem to ensure the screw does not get angled.



# Adjusting Seamer Screw Position



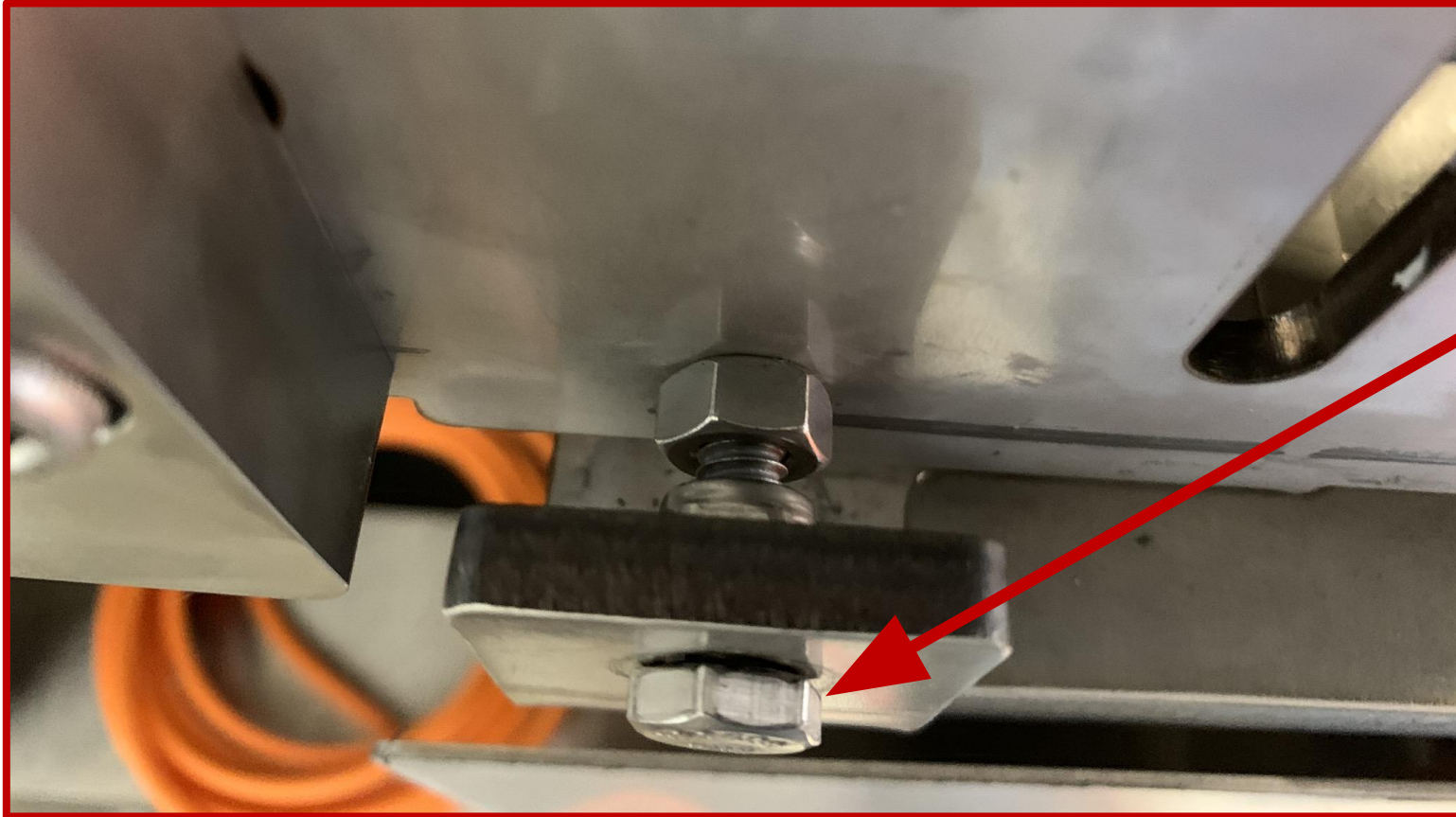
Loosen the jam nuts  
with a 7/16 wrench

With a 7/16" socket, Turn the  
positioning bolt head to the  
left to push the screw to the  
front of the machine

Turn the positioning bolt head  
to the right to pull the screw  
to the back of the machine

Note: You may need to loosen both the side rails and the tensioner if the screw needs to go too far forward to accommodate the can and stretch in the belt.

# Adjusting Seamer Screw Position

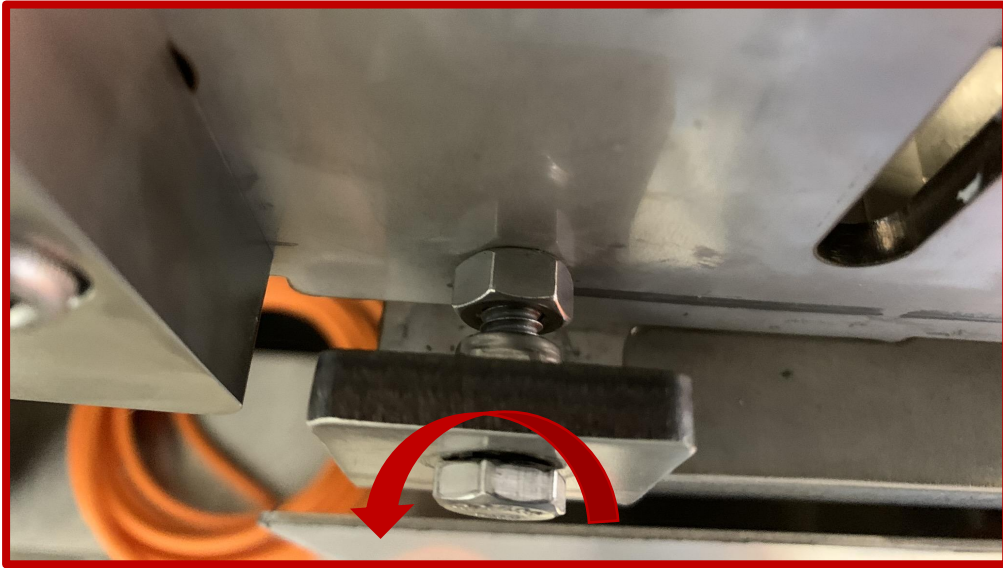


You also have an end positioning bolt on the discharge side of the seamer screw for side to side adjustments

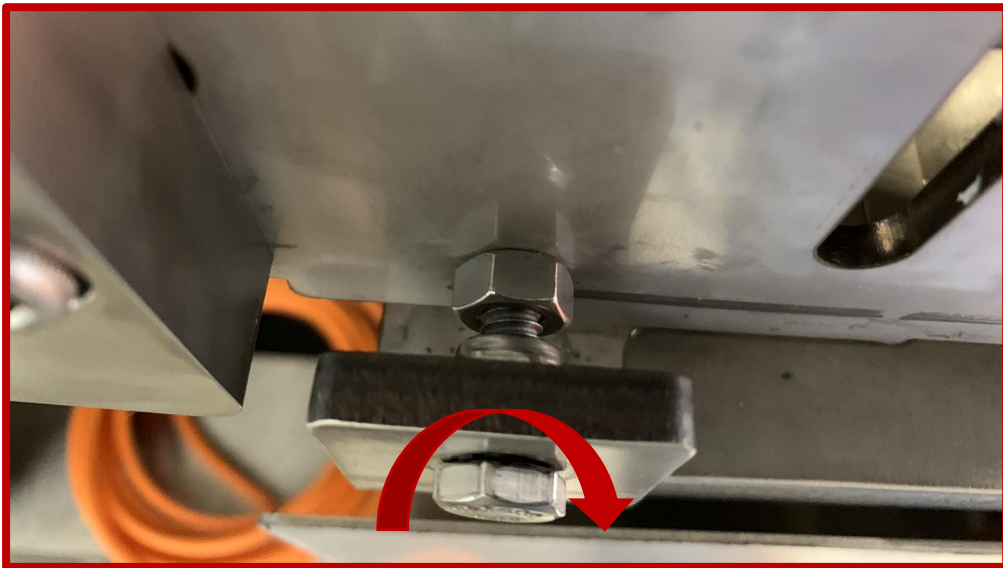
This positioning bolt adjusts the same as those at the rear of the machine.



# Adjusting Seamer Screw Position

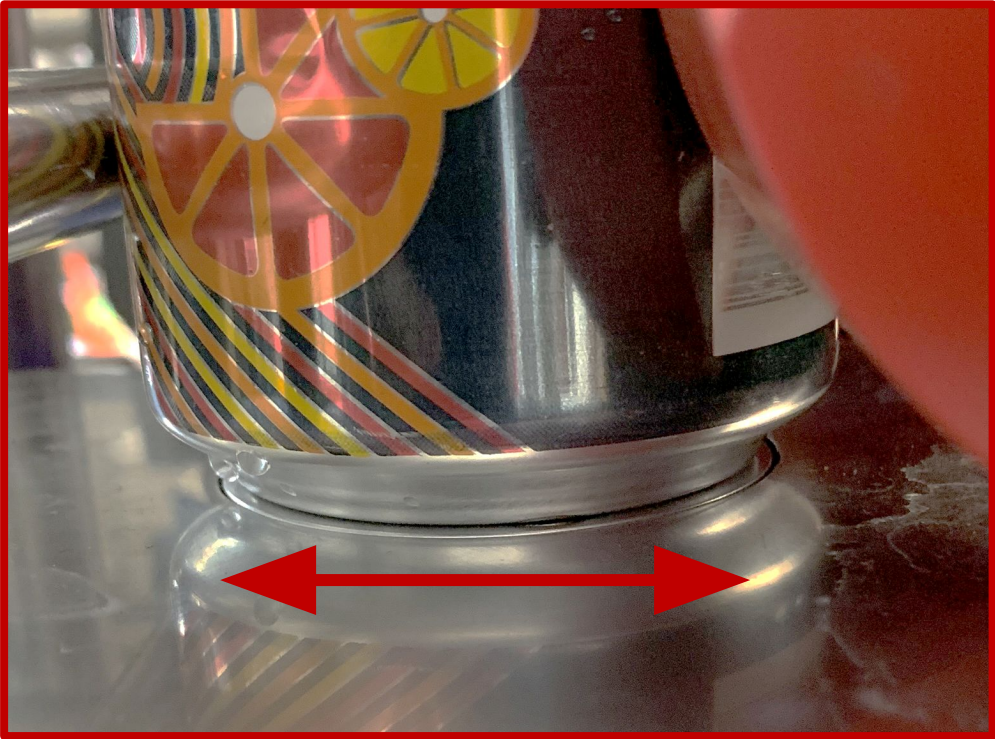
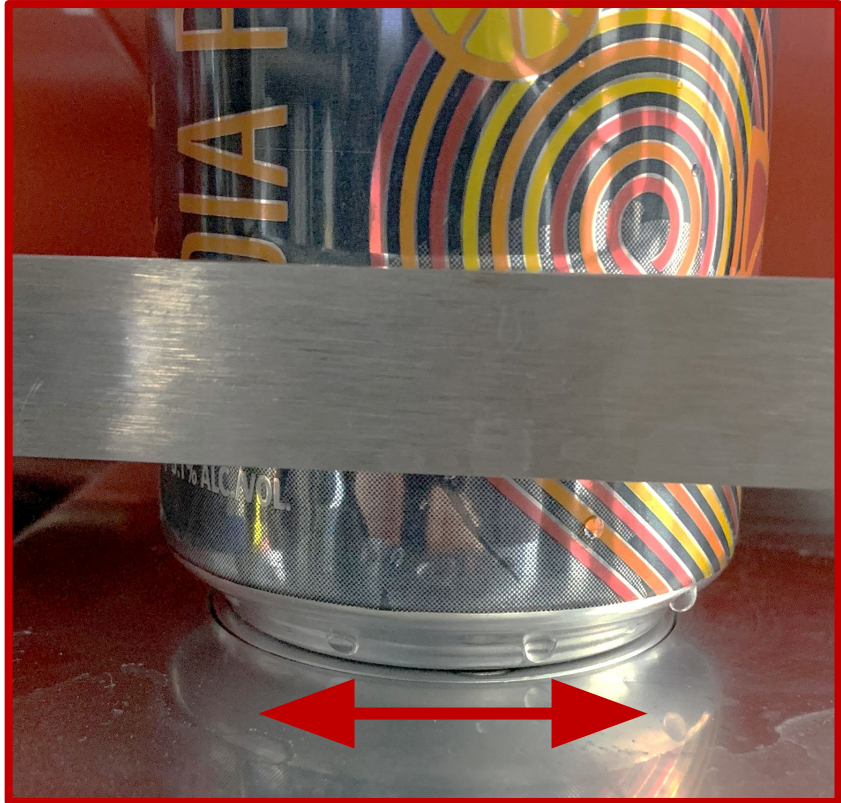


Turn the end positioning bolt head to the left to push the screw towards the filler



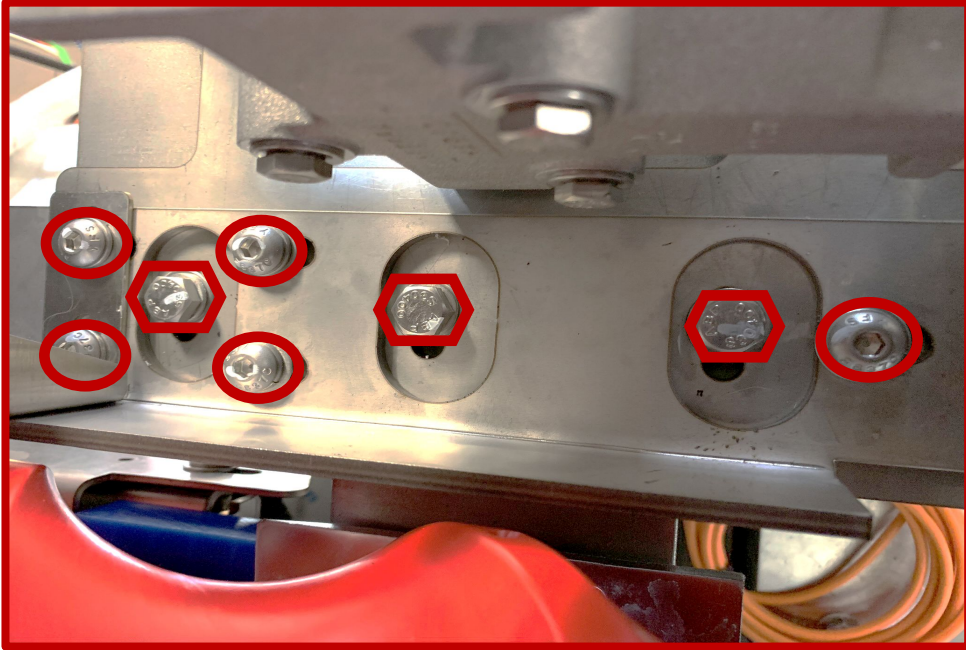
Turn the end positioning bolt head to the right to pull the screw towards the discharge

# Adjusting Seamer Screw Position

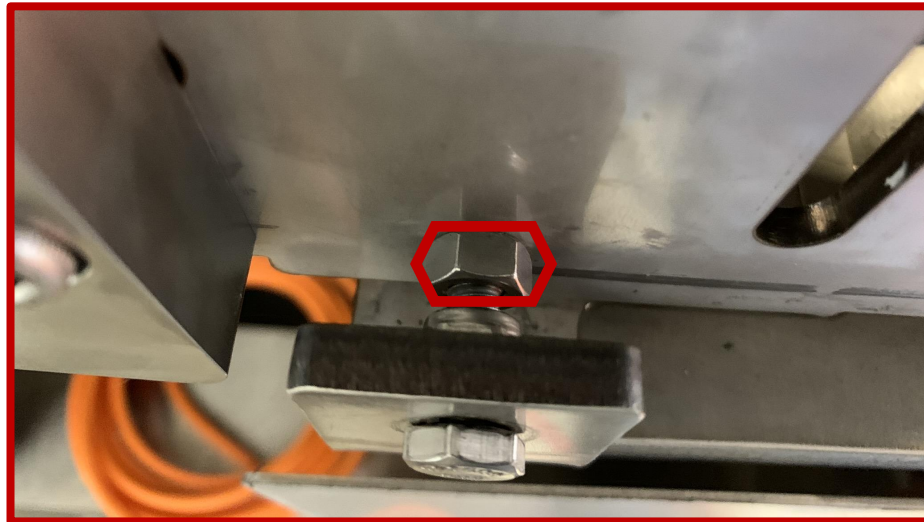


After making these adjustments, your can should look like the above pictures when gently pressed into the Dwell pocket on the screw.

# Adjusting Seamer Screw Position



Once adjustments are finalized and you are happy with your centering job. Tighten down all of the bolts behind the screw that were loosened while making adjustments. Also ensure to tighten the jam nut on the screw positioning bolts.



# Adjusting Seamer Screw Position



Now, reset and double check side rail spacing. They should look very similar to this picture – zoom in if you need to.

See “Rail spacing” guide for a more in depth walkthrough

# Notes

- It is always a good idea to check screw timing both before and after seamer screw position adjustment
- Always double check your work by jogging in a fresh can multiple times to ensure screw position is centered
- If the screw position is perfect and you still experience damaged cans:
  - Inspect can flow into and leaving the seamer (see How to Can Flow Guide)
  - Check pin height (See How to Measure Pin Height Video)
  - Check spring pressure (See How to Measure Spring Pressure video)
  - Double check side rail spacing
  - Inspect bearing (lifter, op rollers, and chuck)
  - Ensure cans entering seamer are not damaged
  - All the above can be in specification, but if matte sleeves are being used or if the machine is very sticky, can flow may never be ideal
- Don't forget to tighten all nuts and bolts associated with this adjustment
- Always tighten the tensioner in the up position
- Ensure sprockets are as best lined up as they can be to ensure belt longevity



**If you have any further questions, please email: [service@codimfg.com](mailto:service@codimfg.com) or call (303) 277-1542.**

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