Quick Start Manual

Fully Automatic Cannular Canning Machine
Single Lane

KegLand Distribution PTY LTD

www.KegLand.com.au

Contents

All Fully Automatic Cannular Canning Machines – Single Lane are calibrated and fitted with a B64 Chuck. The reason being is that the B64 can ends have a wider tolerance range compared to VISY/CDLE or Super Can ends. Meaning that you will save money in the long term with maintenance costs being heavily reduced and a greater consistency of cans that are within specification as a result of wider double seam tolerances.

1.0 – Level your Cannular using a spirit level in relation to the filling/seaming table.

The Fully Automatic Cannular features castor wheels with adjustable levelling feet allowing it to be easily manoeuvred around on the castor wheels when the feet are fully raised or secured in position by dropping the levelling feet.

It is important to level the filling/seaming table using a spirit level. Drop/Raise the levelling foot in each corner of the Cannular to level out the machine. Rotate the red cog on the castor wheel assembly to raise or lower the levelling feet.

2.0 - Identifying parts on the Cannular Single Lane Canning System

2.1 - Beverage Line / Liquid Flow Meter

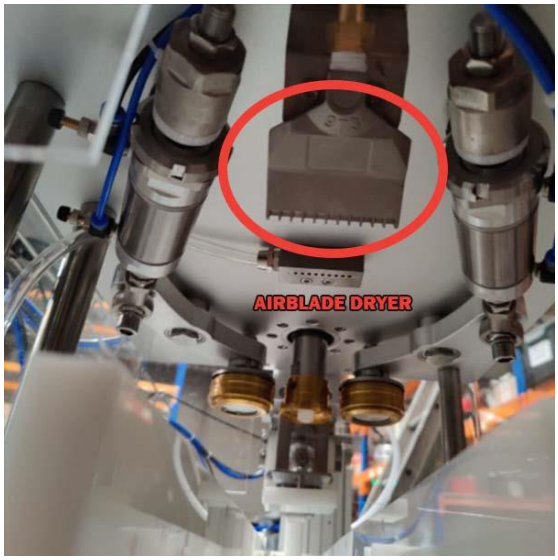
Inlet fitting 8mm OD Barb x 1/2" Female Threaded Fitting. The 6.35mm x 9.5mm EVABarrier can be stretched over this fitting and secured with a clamp. Your beverage line will be attached here.

Please note we recommend to pre-chill your beverage down so that carbonation levels can remain as steady as possible. We have found using a G40 set to -2°C with 2m of 5mm x 8mm EVABarrier from Keg to G40, and a short line (1m) from the G40 to Cannular to be a suitable option. The more insulation you give your liquid line, the better the temperature stability of your beverage.

Please note the gas pressure will change depending on your beverages carbonation level, ambient temperature and desired finished CO2 level.

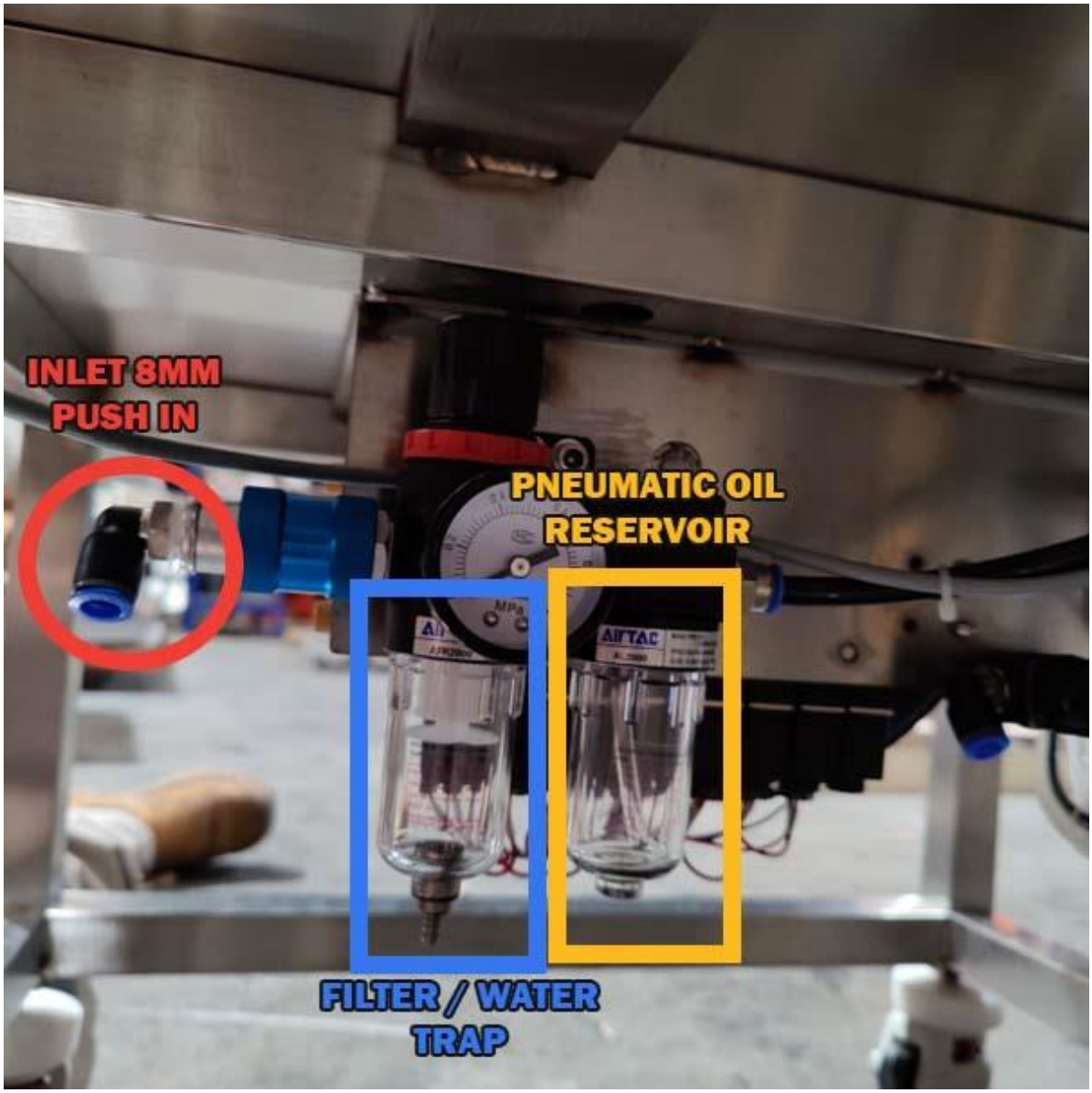
2.2 – Compressed Air Inlet

All pneumatic actuators and the Airblade Dryer run from the air inlet shown below.



Inlet Fitting = 8mm OD Push In Fitting.
Requirements: The Cannular requires an inlet air pressure of 100psi (7 BAR) to function optimally.
The Filter / Water trap will need to be emptied on a regular basis depending on your air quality.
All pneumatics are pre-lubricated, but you will be required to fill the pneumatic oil reservoir with any light pneumatic tool oil.

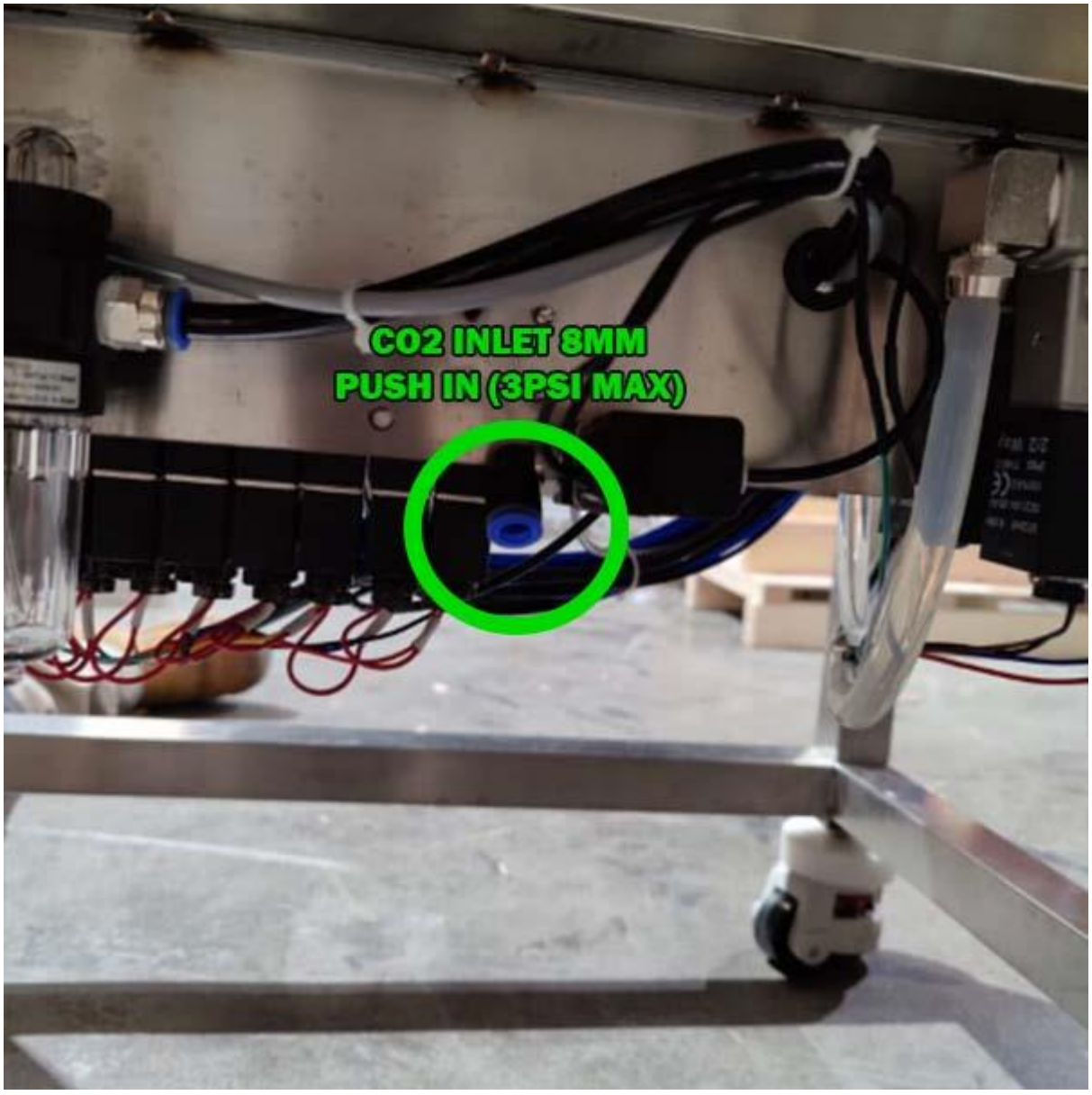
We recommend topping up the Pneumatic Oil Reservoir periodically based on your use
e.g. -> Ozito Air Tool Oil (Bunnings).



2.3 – CO2 Inlet for Purging

Inlet Fitting = 8mm OD Push In Fitting.

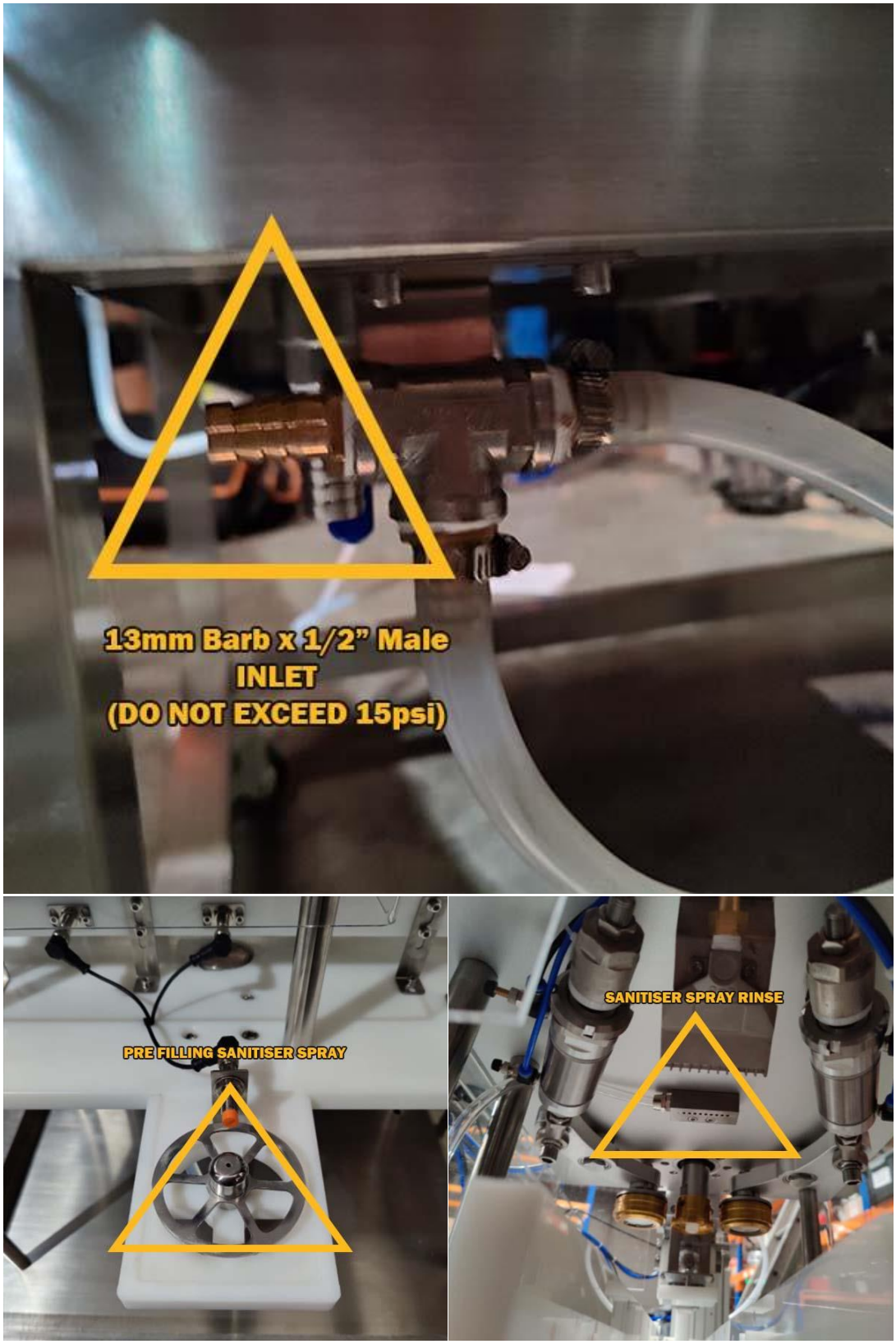
We recommend not exceeding 3psi worth of CO_2 for the oxygen reducing purging pre-filling process. Please note depending on your can volumes you may need to set the Timer Parameters in the PLC longer or shorter.



2.4 – Sanitiser Inlet (Pre Can Filling Sanitiser Spray and Post Seam Spritz)

Inlet Fitting = 13mm OD Barb x 1/2" Male Thread

Please note: DO NOT EXCEED 15PSI, this silicone hosing cannot withstand large amounts of pressure and will burst under pressures higher than 15PSI.

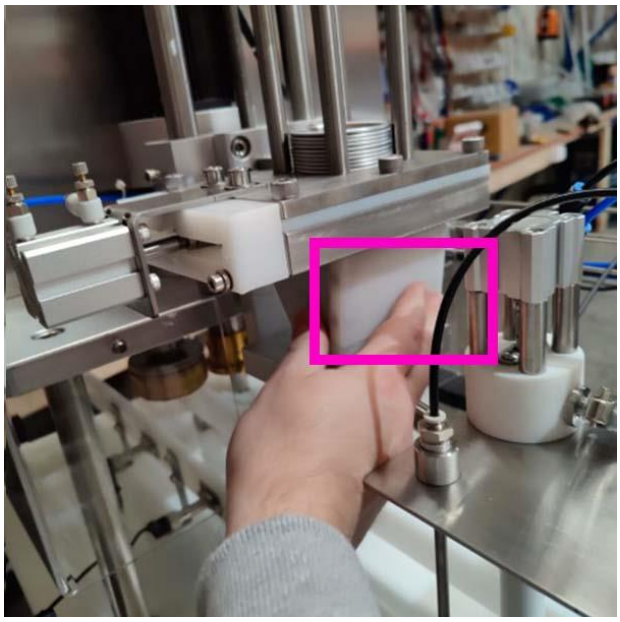


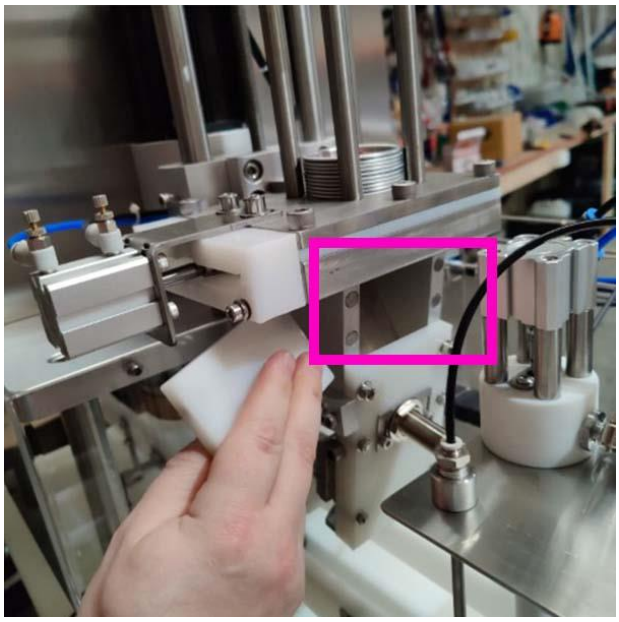
2.5 – Can Lid Dropper Apparatus

This section will require adjustment out of box if you are **not** using 500mL cans. For a complete walkthrough process, the cans tested would ideally be filled with carbonated water. Or still water if sparkling is not available.

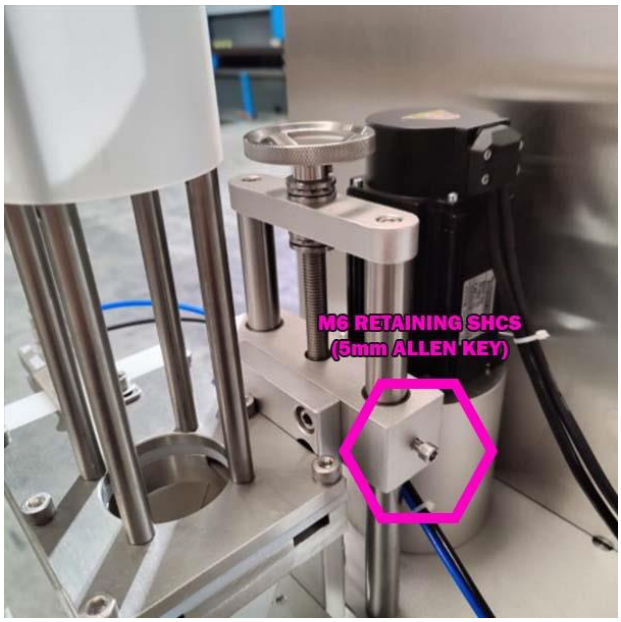
Before adjusting the height of the can lid dropper you must disconnect the air supply to the unit.

2.5.1 - Manually drop a lid in from the magnetic block access port. Ring pull facing away from you.





2.5.2 – Unscrew / Loosen (to the point of falling off) the two retaining socket head screw caps on each side of the can lid dropper apparatus. With the 5mm Allen key in your toolkit.



2.5.3 – Lower the apparatus to your desired can height. To test if the height is correct, push a can through with your hands. The can should not jam on the next spring apparatus (foam dampener).

2.5.4 – Once your desired height is reached, tighten the retaining SHCS back in firmly.

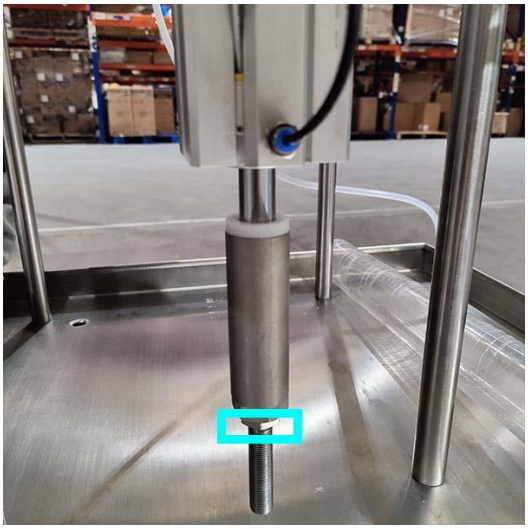
2.6 – Can Platform Raising Apparatus

This section will require adjustment again if you are **not** using 500mL cans.

2.6.1 – Ensure your air supply is still turned off.

2.6.2 – Place the previous can you have tested with the lid dropping apparatus further forward onto the can lifting platform.

2.6.3 – Unscrew the locking nut underneath the filling/seaming table that is connected to the platform with a 32mm Spanner for the Bump Stop Shaft and a 24mm Spanner for the Locking Nut. Depending on the can size you are using.



2.6.4 – Rotate the bump stop shaft further down with your hand. Its best to go further down than you need.

2.6.5 – Now using a small amount of force, raise the shaft so that the can engages with the chuck. This is easier to do with your hand cupping the base of the shaft.

2.6.6 – Once the can feels firm and in place, rotate the Bump Stop Shaft upwards until it touches the piston block. Followed by the locking nut. Then use the two spanners again to tighten against each other.

2.6.7 – Connect pressure and test in Paused/Manual Operation with “Canned Lift” Function. The can should not get crushed, nor should it not be touching at all.

3.0 – Automatic Can seam testing (Using water)

3.1 – Adjust the fill amount in the Parameter Settings to what your fill level will be, and your maximum volume. E.g., We filled 315mL, with 330mL being the max can value.
The water can come from a pressurised keg or from a tap.

3.2 – If you have adjusted from a 500mL Can you will need to increase the Timer Settings of the first Can Raise Delay or else the First Operation roller will start to engage before the can is fully engaged with the chuck.
This is crucial to setting up the Cannular system.

If you are not familiar with the functions of these Timers, it is best to take note of the default values and adjust the setting you're not familiar with up by to 10 seconds and run a can through. This will then help you get a better understanding of what that timer function does.

4.0 – Beverage Filling in Automatic Mode

4.1 – It is recommended to can the beverages as cold as possible through a glycol chiller unit or from a cold taproom with some sort of insulation to the Cannular.
Capping on foam is essential for reduced dissolved oxygen in your final product. Adjusting the First Stage Fill in the Parameter settings may help this. But ultimately it will come down to adjusting how the beverage is being dispensed to the Cannular. E.g., adjusting pressures, temperatures and the length of hosing used.
From our testing we found that 2m of 5mm x 8mm EVAbarrier from a keg at 2.4 CO2 serving volume connected to a G40 Icebank chiller, then a small 0.5m hose length of 5mm x 8mm.
That was then dispensed at approximately 25psi.

5.0 – Calibrating to Achieve Correct Double Seam Specification on B64 Can ends

The Cannular Full Auto Canning Line should already be calibrated upon arrival however if it has gone out of specification during transit or over the course of its life you may need to adjust the position of the rollers to achieve a hermetic double seam which is within tolerances.

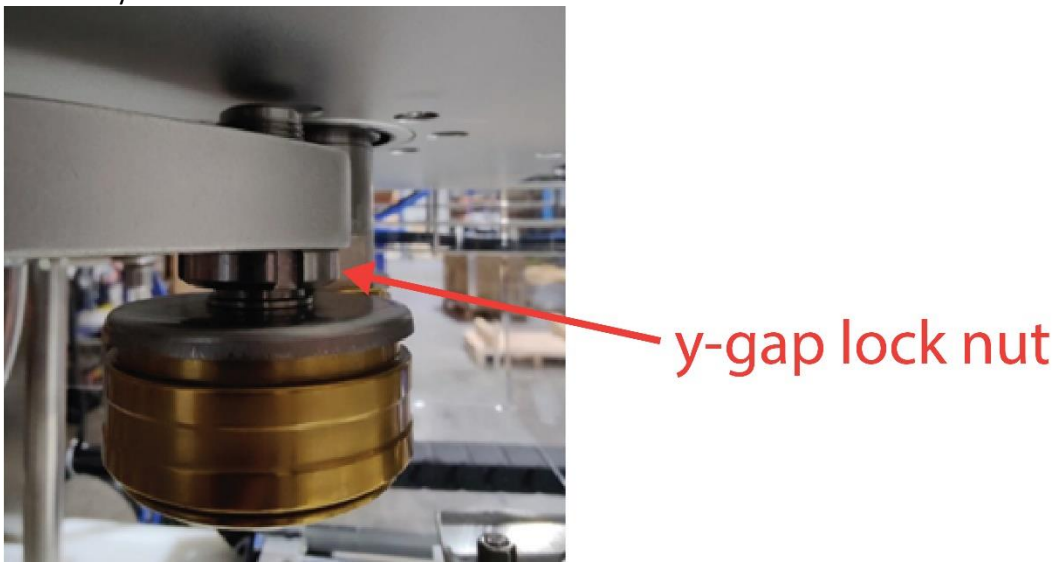
We recommend customers check the specifications on the seam every 50,000 cans or once a year to ensure the cans remain within allowable tolerances. If you find that the seam measurements are outside the allowable tolerances of a B64 seam then follow the instructions below to adjust the position of the rollers in relation to the chuck.

5.1 – Setting the Roller Height (y-axis)

Undo the lock nut on the thread above the roller you need to adjust the height of.

Then adjust the height of the roller by rotating the thread clockwise or counter clockwise to the desired height of the roller relative to the chuck. Then set the height by tightening the lock nut firmly.

After adjusting the roller height and before operating the Cannular it is vital that you check that the roller does not make contact with the chuck. To confirm this, disconnect the air supply to the unit. Then manually push the roller towards the chuck (so that the piston is fully actuated) then spin the roller with your hands to make sure it does not hit the chuck.



5.2 – Setting the Roller Gap (x-axis)

Before adjusting the x-axis gap of the roller, you must disconnect the air supply to the unit.

With the air disconnected manually push the roller towards the chuck.

Loosen the lock nut while holding the piston in position with the provided spanner.

Tighten or loosen the lock nut on the thread to adjust the stroke length of the piston. This stroke length will correlate with how close the roller ends up to the chuck.

For example, a longer stroke length (less thread visible behind the piston) will result in the roller being closer to the chuck.

After adjusting the roller gap and before operating the Cannular it is vital that you check that the roller does not make contact with the chuck. To confirm this, disconnect the air supply to the unit. Then manually push the roller towards the chuck (so that the piston is fully actuated) then spin the roller with your hands to make sure it does not hit the chuck.

Warranty and Support (Australia)

To lodge a warranty claim in Australia please forward as many visual pieces of supporting information and a detailed description of your issue to beer@kegland.com.au

If you purchased your unit from an international distributor, you will be required to go through their warranty claims process.

For full terms and conditions, please visit our website here -> Terms & Conditions