SET-UP

Check out the how-to videos on our website!

To remove your seamer from its box, lift as shown below. It is heavy (~45lbs) so use caution while lifting.

Locate your seamer on a flat, level tabletop or bar-height surface. Make sure there is enough room around the seamer to move around it easily.

Attach the lever arms (located in the accessories box that comes with the seamer) by threading them into the holes located on the roller housings. !ATTENTION! Use a 7/16in wrench on the nut located between the shaft and knob to tighten the handle into the roller housing. If the handle’s threads back out they will bend or break over time.

⚠️ATTENTION! ⚠️ Canning is done in a wet environment, so always plug the seamer into a GFCI outlet to avoid shocking hazards.

The power cable is located “under” the seamer and held on with paper tape. You can either tilt it forward and reach under to remove the cable or pull off the back cover. The cover is attached using magnets. Just pull back to remove the cover.
SAFETY PRECAUTIONS

- Since canning is likely to create a wet environment, make sure the flooring around the seamer is non-slip.

- Always plug the seamer into a GFCI outlet to avoid shocking hazards.

- Pay attention to things like loose clothing, long hair, etc. The can and upper and lower chucks will be spinning and can cause injury if anything gets wrapped around them.

- Never reach into area around the upper chuck and rollers while operating. The rollers can pinch or draw-in fingers and objects and cause injury.

- Never remove the top cover while operating. The spinning belt and motor will be exposed and can cause injury.

- Never remove the switch enclosure box, or the motor connection panel while the seamer is plugged in. There are open live connections inside each that risk a shocking hazard.

POWER REQUIREMENTS

Short Circuit Current Rating:

120V: 220V:

Rated Frequency

120V: 60Hz 220V: 50Hz

Full Load Current

120V: 220V:
GETTING STARTED

Your seamer comes calibrated and ready to go so you shouldn’t need to adjust anything. If you do have an issue, check the troubleshooting list at the end of the manual. There are a few things that may need to be adjusted due to shipping, issues, etc.

There are two issues that come up with MKseries seamers... broken handles (operation levers) and broken base adjusters. As long as the handles are tightened into the roller housings, they will last the life of the seamer. As long as the base shaft is kept clean and greased (see daily maintenance) the threaded base adjuster will also last the life of the seamer. Both are easy to replace, but its always easier to maintain them than to replace them.

Terminology

Can Body- the main (bottom) part of a can

Can End- the “top” of the can
Seaming

Seaming is super simple. The basic idea is to rotate the right handle all the way to its stop, back it off to its starting position, then do the same for the left handle. The can spins fast enough that the speed you go isn’t super critical, but you don’t want to slam the handles in either. Keep in mind that it doesn’t take much force to seam the can. As soon as the lever has hit its hard-stop the operation is completed. Make sure to read through the detailed instructions below. It is a good idea to run through the steps a few times without a can to get a feel for it.

Helpful tip: The can-guide (see above diagram) is capable of holding the can upright and in the correct position to close the splash guard door. Set the can onto the lower adapter and lean it back against the guide. Pull your hand out of the machine and then close the splash guard door.
Make sure the correct adapter is in place for the can size you plan to use. Adapters generally snap onto the top of the standard adapter like a “Lego” piece.

1. Rotate both operation levers outward to their starting positions.
2. Open the splash guard door by pulling the splash guard handle out and downward.
3. Set a filled can (and end) onto the lower adapter and rotate the can back into the seamer. The can should rest against the “Can Guide.” The can should stay upright on its own once placed against the can guide.
4. Close the splash guard door. It should feel a bit heavy as it clamps the can and will lock in-place with a solid feeling. *note closing the splash guard will not feel the same without a can loaded into the seamer.
5. Turn the power switch to the “on” position. The can will start to spin.
6. Rotate the first operation lever (right side of the seamer when facing it) until the roller makes contact with the edge of the can end.
7. Once the roller makes contact, continue to rotate the lever until it stops. It should take 1-2 seconds for the roller to rotate between initial contact and the hard-stop.
8. Once the lever has reached the hard-stop, hold for 1 second, then return the lever to its starting position.
9. Repeat the same process for the second operation lever.
10. Turn the power switch to the “off” position
11. Once the can has stopped rotating, open the splash guard door and remove the can.

Sometimes it’s helpful to explain the things to NOT do. These include:

**Do Not**: use the left handle first

**Do Not**: hold both handles IN at the same time

**Do Not**: run either operation more than once.

**Do Not**: go back and do the first operation after the second operation is completed.

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**Daily Maintenance**

- Wipe down the seamer with warm water and a rag to keep it clean of sticky residue. You can add a small amount of sanitizer or dish soap, but it is NOT suggested to use other cleaners. Warm water is all that is needed to break up sticky residues. Make sure to dry everything off thoroughly. If the seamer is going to be stored for a period of time, we suggest rubbing a thin layer of food-safe grease onto the seaming roller surfaces to avoid surface rust.

- The Splash Guard is attached onto the back of the seamer using magnets. Pull the magnetic base back and off the inner panel to make it easier to clean the inner surfaces of the plexiglass guard and the base shaft. When replacing the magnetic base, attach the magnets to the vertical surface and slide it down until it contacts the sloped surface of the inner panel.

- Pull the white plastic lower adapter off and use a rag and warm water to wipe down the bearing, washer(s) and wave spring (see diagram above). Dry them off and add a dab of grease into the bearing and rub some onto the spring and washer(s). Replace them in the same order they were removed.

- Remove the base shaft by pulling out the quick-release pin. The shaft can then be pulled upward and out of the machine. Wipe down the shaft and the bore that the shaft rides in with water and a rag. Dry them off and rub a dab of grease onto the shaft. If this isn’t done regularly, the shaft will eventually become sticky and the splash guard handle will become difficult to close. **DO NOT** force the handle if it becomes sticky or you will **BEND OR BREAK!** The base adjuster.

*Helpful Hint: remove and clean the base shaft at the end of the day and leave the assembly on the counter next to the seamer so that the morning shift opener sets it back into the seamer. This way there is a reminder that it is getting cleaned often.*
Seam Inspection

Check out our how-to videos on the website!

Our method of seam inspection requires a “tear-down tool,” some nippers or wire cutters, and a set of calipers. The tear-down tool and calipers are available on the Oktober website.

When measuring the seam thicknesses, the calipers should be parallel to the inside taper of the can (as shown below), rather than parallel to the straight sides of the can.

Make sure to not squeeze the calipers too tightly when measuring. Use the lightest pressure possible to allow the calipers to close against the seam. If too much pressure is used, the seam will appear smaller than reality.
1) Complete the first operation ONLY, remove the can from the seamer, and measure the first operation seam thickness as shown.

First Operation Seam Thickness:
MK16s (and MK19s)  
.074in - .078in  
MK32  
.104in - .112in

2) Place the can back into the seamer and run the second operation. Remove the can and measure the final seam thickness as shown.

Second Operation Seam Thickness:
MK16s (and MK19s)  
.043in - .046in  
MK32  
.064in - .068in

3) Using a tear-down tool, cut the top of the can off.
4) Using nippers or wire cutters, cut a notch through the entire remaining seam.

5) Pull the seam out of the can body as shown. Start from the notch that you cut with the nippers.

6) Measure the “cover hook length” in at least 3 places around the inside lip of the removed seam.

Cover Hook Length:
MK16s (and MK19s) .053in - .065in
MK32 .065in - .085in
7) Measure the “body hook length” in at least 3 positions around the perimeter of the can.

**Body Hook Length:**

MK16s (and MK19s)  
.055in - .075in

MK32  
.072in - .088in

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**Calibration**

If any of the measurements from the seam inspection aren’t within the specifications, it may be time to adjust the seamer’s calibration.

**Infeed Calibration**

If the first or second operation seam thickness is incorrect, you can adjust them by adjusting the infeed adjuster screws (see diagram) located on the sides of the seamer.

To decrease the operation seam thickness, loosen the adjuster screw nut, and turn the screw counterclockwise.

If the seam is too small turn the screw clockwise.

Each rotation adjusts the thickness approximately .001in.

After adjusting the screw, run the operation again and measure the new seam thickness. Continue to adjust, test, and re-measure until the seam thickness is within the specification.
Remove the seamer’s top cover (see MKseries Seamer Diagram)

The gap between the roller and the top surface of the upper chuck needs to be set to a minimum (see diagram above).

Basically the gap should be as small as possible, while allowing free rotation of the roller when it is engaged over the chuck (hard-stop position).

To set the gap, first back off the upper vertical adjust nut a few turns.

Position the roller above the chuck (as shown) by rotating the operation lever to the hard-stop position.

The lower vertical adjust nut should be used to set the gap, and the upper nut used to take out the play once the lower nut is set.
While adjusting the gap, you will need to push UP on the bottom of the roller. That will hold the assembly against the lower adjuster nut while you make adjustments.

Adjust the lower nut and spin the roller by hand until it starts to be slightly difficult to turn, then back the nut off just enough to allow the roller to turn freely again.

Once the gap is set properly, snug up the upper nut to take out the play. Make sure that the operation lever still rotates freely, with a slight drag. DO NOT OVERTIGHTEN THE UPPER ADJUSTER NUT.

If the top surface of the can seam is rough after re-adjusting, you may need to raise the vertical position of the roller slightly.

Base Force Adjustment

The clamping force between the lower adapter and the upper chuck is critical to a good seam. In particular, the base force has a strong effect on the seam’s body hook (more base force typically will create a larger body hook).

In general, the base force is set to just less than the maximum that the can will take before it collapses. If your cans are denting and/or collapsing when closing the splash guard door then it is possible that the base force is too high. (Note: cans that are empty are much more likely to crush than a full can)

Before adjusting the base force, make sure the wave spring and washers are located correctly inside the lower adapter (see MKseries SEAMER DIAGRAM).

To adjust the base force, first back off the lower base adjuster nut a couple turns. Note: the lower nut’s function is to take up play in the base adjuster. The upper nut is used to set the actual base force.

Pull the splash guard’s magnetic base off the back panel and out of the seamer. You will need an un-seamed can and end to set the base force.

Turning the upper base adjuster nut clockwise will increase the base force, while turning it counterclockwise will decrease it.
To RESET the base force:

1) With a can loaded into the seamer, use the upper nut to lower the base force to nearly zero. As you adjust the nut, the handle will feel lighter and lighter until the can never fully clamps.

2) Once the force is set to zero, rotate the upper nut:
   
   1-3/4 turns for MK16s and MK19s (10-11 “flats” of the side of the nut)
   
   2-1/2 turns for MK32s (15-16 “flats” of the side of the nut)

3) Snug up the lower base adjuster nut

4) Test a can by seaming it and measuring the body hook. If it is sufficient then the base force is also sufficient.
Other Maintenance

Seaming Rollers:

The bearings in the seaming rollers are oil-impregnated bronze bearings and are nearly maintenance free. If the rollers become sticky, they probably need to be thoroughly rinsed with water to break up the sticky residue.

In extreme cases, you can remove the entire roller assembly out of the seamer and soak it in warm water (see diagram below). 15 minutes should be enough to loosen up sticky residues. Work the roller by hand until it becomes free and easy to rotate. Dry everything off and add a few drops of food-safe oil (like super-lube) above and below the roller. Spin the roller to work the new oil into the bearing and its axle.

To re-assemble, rub some grease onto the pivot shaft (see diagram below), and slide the assembly back into the aluminum receiver. Thread the upper adjuster nut back onto the pivot shaft. Snug up the upper nut so that it still allows the handle to rotate easily with a slight drag. DO NOT overtighten the upper adjuster nut. *Note- if the lower adjuster nut does not get out of place, the vertical calibration should still remain accurate after re-assembly.
Troubleshooting

Can does not spin when seamer is turned on

Sometimes during shipping, the motor gets displaced enough for the drive belt to slip off the pulleys. **Unplug the seamer** and remove the top cover and check to make sure the belt is correctly running over all three pulleys (see below). If it is not, you should be able to slip the belt back on by first wrapping it around the black pulleys, then slipping the belt over the inside edge of the white plastic pulley. Rotating the large pulley by hand should “pull” the belt back onto the pulleys without any adjustments.

If the belt continues to fall off after it has been placed back on the pulleys, you may need to align the driver pulley. This can happen when the box is dropped during shipping and the motor becomes misaligned, but it is easy to fix. There is a small set screw on the side of the pulley. Loosen the set screw, and raise or lower the pulley-
to be in-line with the larger pulley. Tighten the screw, place the belt onto the pulleys, and test by spinning the large pulley by hand. If the belt stays on the pulleys then it is aligned properly.

**If the seamer does not turn on**, it may be because either the thermal overload switch (located on the bottom of the motor) or circuit breaker (white button located on the backside of the electrical box) has tripped. You will need to remove the seamer’s back cover to access the electrical box and/or motor. Pushing either of these reset buttons in will reset them. *One common cause for them tripping is pulling both operation levers at the same time.*

*Note: older seamers use a fuse, rather than the circuit breaker. For seamers that have power cables that connect to the outside of the seamer frame, the fuse is located in a small holder between the cable and on/off switch. You will need a small screwdriver to pry the fuse holder out of the switch body.*

*For seamers with the power cable that comes out of the box on the inner side of the seamer, the fuse holder is located inside the electrical box. Unplug the seamer and remove the two screws to access the inside of the box. The fuse is an in-line design.*
Seaming problems that can occur when you first receive your seamer

Seamers should arrive calibrated and ready to use. If you are having trouble with seams initially:

First make sure you are using the RIGHT handle first. Then the LEFT. Re-read the seaming instructions to make sure the procedure is followed correctly.

Check to ensure that the wave spring and washer are located properly under the lower adapter (see MKseries SEAMER DIAGRAM). The base force (clamping pressure) will not be correct without the spring in place.

Make sure you have the correct type of end for the upper chuck. There are several can end “profiles” available, and they are not compatible with each other. The B64 profile comes standard on Oktober seamers, others are available when you place your seamer order. They can also be swapped out fairly easily.

![Diagram and images of different ends]
Broken Handle

If you do happen to break a handle off, it is easy to replace. Chances are, the broken threads are still in the roller housing. To remove them, use a small drill bit (1/8in works well) to “drill out” the threads. You won’t actually drill into the metal, but the bit will use friction to spin the threads out the other side of the hole. When replacing the handle with a new one, make sure to tighten it in using the nut between the handle and the black knob.

Contact Us
Feel free to contact us if you have any other questions! Our team is always happy to help.

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