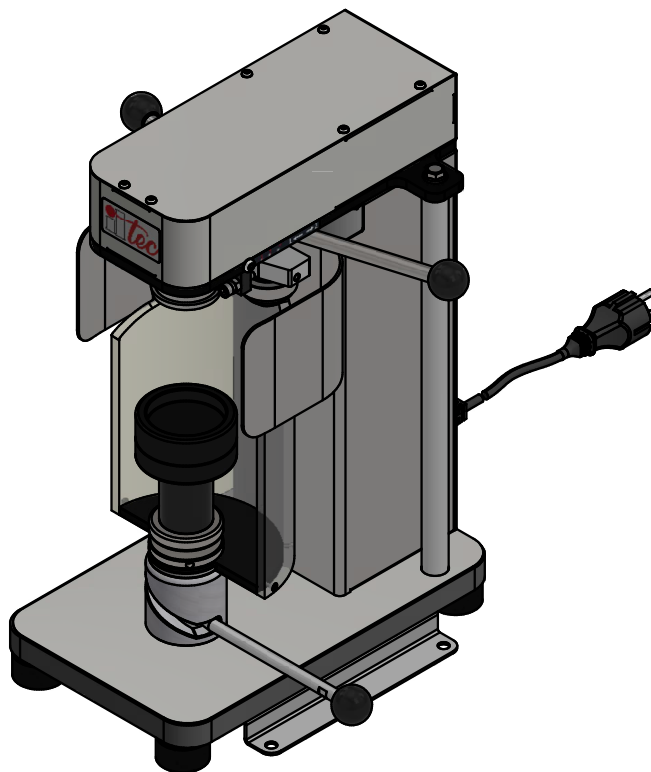




# Use and maintenance manual

Original instruction



Ultraseamer

This INSTRUCTIONS FOR USE manual has been produced  
in accordance with Directive 2006/42/EC

It is prohibited to reproduce it, even partially, without the prior  
written authorization of ILTEC by I.L. INDUSTRIA di LEIVI Srl



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## INTRODUCTION TO MANUAL

The Instruction Manual represents the training reference document prepared by the Manufacturer, aimed at users who will come into contact with the machine throughout its life cycle.

The purpose of the document is to provide information for proper use of the equipment, from installation to disposal, highlighting the dangers that can result from incorrect use.

In order to achieve good results in the installation environment, the instructions given in this Manual should be strictly followed, avoiding, above all, the occurrence of technical problems and the exposure of operators to health hazards.

The following symbology is used within the User's Manual to indicate the presence of hazards and draw the reader's attention to important information:

### NOTE

The important notation to be highlighted is inserted in this area.

### CAUTION

Indicates a reminder to apply safety practices or calls attention to unsafe practices that could cause personal injury or damage to the machine or components or the environment.

### WARNING

Indicates that there is a danger that may cause injury or death if appropriate precautions are not taken.

## RETENTION OF INSTRUCTIONS FOR USE

### NOTE

This user's manual is an integral part of ULTRASEAMER tumblers and should be read carefully before use as it provides important guidance regarding safe installation, operation and maintenance.

Therefore, keep it carefully.

### ATTENTION

Failure to follow the instructions below is a dangerous condition and puts the proper operation of the equipment at risk.

### ATTENTION

Before using ULTRASEAMER ladders, carefully read the general safety rules below.

## DEVICE IDENTIFICATION DATA

On the back of the equipment is affixed the nameplate where the manufacturer's identification data and compliance with European Directives are given.



### ULTRASEAMER

220-240 Vac, 50/60 Hz, 160 W, IP10

PN: 4S0XXXXX SN: XXXXXXXXXXXXXXXX



### ULTRASEAMER

110-120 Vac, 60Hz, 160W, IP10

PN: 4S0XXXXX SN: XXXXXXXXXXXXXXXX

## INTENDED USE

ULTRASEAMER is designed to perform seaming of cans of different sizes.

### ATTENTION

It is absolutely forbidden to make any changes to any component of the product or replace it with non-original parts.

### WARNING

Uses of the product not in accordance with what is described in this document are considered improper and therefore declared unsafe.

Such unintended uses may result in damage to the equipment and personal injury, including serious injury. Any other use other than that for which the product was designed and described in this document is considered non-compliant, and therefore the Manufacturer disclaims all liability.

### NOTE

ILTEC by I.L. INDUSTRIA di LEIVI Srl shall not be held liable in the event of damage to the machine and/or injury to personnel due to failure to comply with the safety requirements set forth in this Manual.

## SAFETY PRESCRIPTIONS

### WARNING

Before using the ULTRASEAMER laminer, please read the general safety rules below carefully.

- After removing the packaging make sure of the integrity of the device. If in doubt, do not use them and contact ILTEC by I.L. INDUSTRIA di LEIVI Srl. Do not leave any packaging items (plastic bags, cardboard, etc.) within reach of children or disabled persons as they are potential sources of danger. The safety concept of the appliance is only valid in perfect condition.
- This equipment is not designed to be used by persons (including children) with reduced physical, physiological or intellectual capabilities, or who lack experience and/or ability, unless they are under the supervision of a person responsible for their safety or providing them with instructions on how to use the equipment.
- Check that the power cable is intact before use. If not, contact customer service.
- Check that the plug fits the socket before use. If not, contact customer service.
- Do not plug or unplug with wet hands.
- Place the device on a dry and stable surface.
- To ensure sufficient ventilation, leave at least 12 cm of clearance around the device.
- Do not expose the device to direct sunlight, to wind, rain and splashing water.
- Do not obstruct the device with objects when it is in operation.
- Disconnect the plug from the outlet before cleaning the device-otherwise you risk electric shock or death.
- Do not use metal sponges or abrasive products to clean the device.
- Supervise children so that they do not play with the ULTRASEAMER.
- The device is for use in the home and similar environments (workplaces, hotels, motels, and similar facilities). The device is not for industrial use.

- Entrust customer service to repair or replace damaged or malfunctioning connection cables and/or devices.
- Do not open the casing of the device to try to repair it yourself. Doing so may compromise the safety of the device and void the warranty.
- NEVER immerse the device in water or other liquids; clean it only with a slightly damp cloth.
- Never leave the device switched on.
- Use the device in environments with temperature between 10°C and 35°C.
- Keep hands away from moving parts when operating the device.
- Do not use the device if it is damaged.

#### **ATTENTION**

The original configuration of the equipment must not be changed at all. Upon receipt of the same, check that the delivery corresponds to the order specifications. In case of nonconformity inform the manufacturer immediately.

Also check for damage during transport.

---

#### **WARNING**

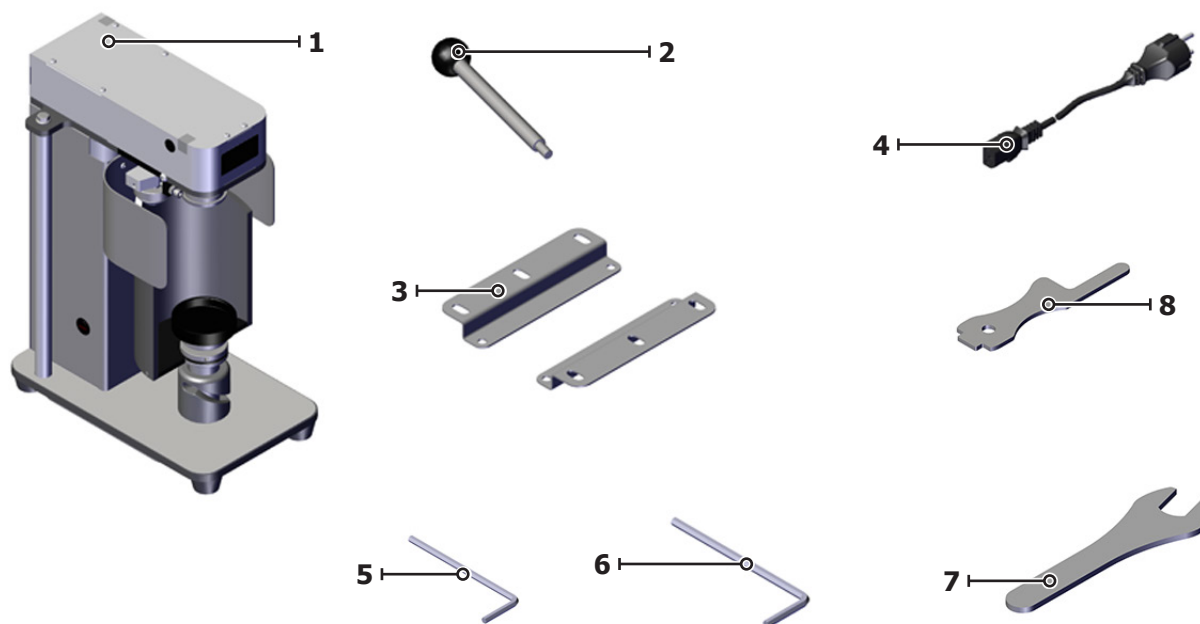
Leivi's Industria products are not designed to operate in explosive and high fire hazard environments. In case of failure or improper operation, the equipment should not be used until the Technical Service Department has completed repair work.

---

## PACKAGE CONTENTS

The device comes in a box inside which are contained:

1. Ultraseamer
2. Rods
3. 2 fixing brackets + 6 M8x10 screws
4. Power cable
5. 3 mm allen wrench
6. 5 mm allen wrench
7. 8 mm wrench
8. Thickness gauge



## UNPACKING

Open the box and take out all components inside. Verify the presence of all components listed in the previous paragraph and their integrity.

### WARNING

Don't let children play with plastic bags.

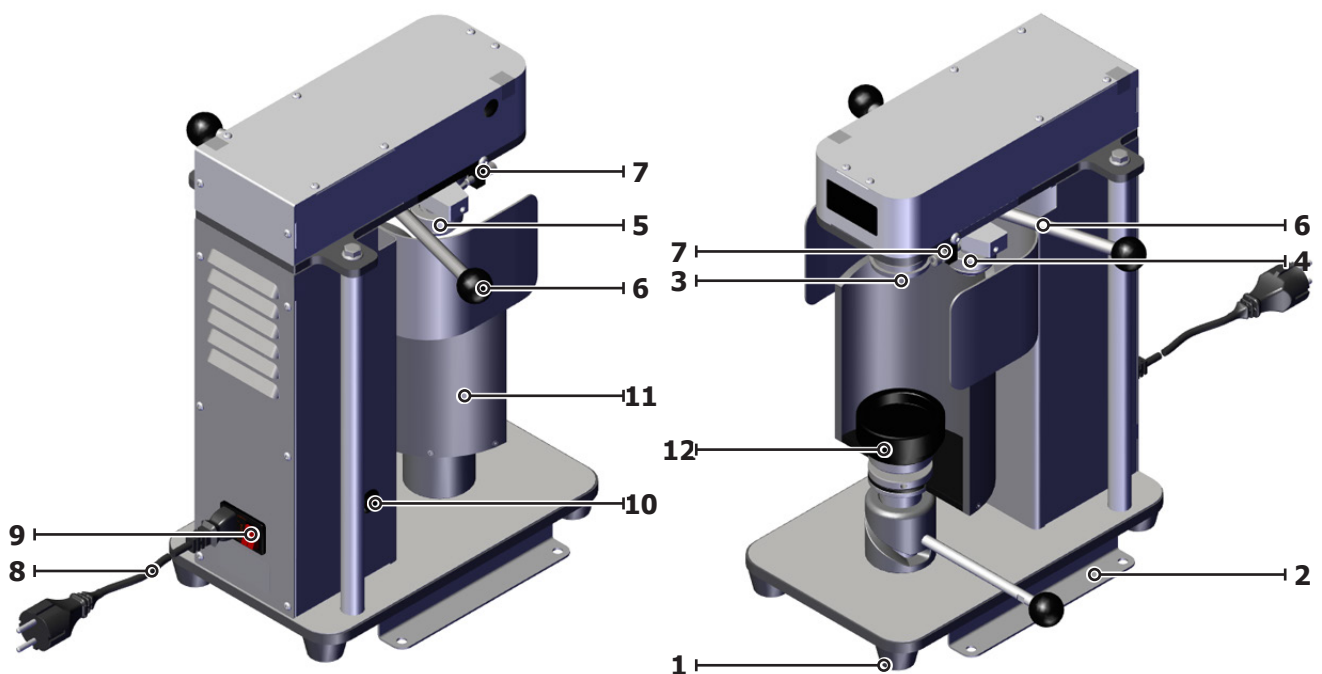
They risk choking on them.



## DESCRIPTION OF THE DEVICE

The device consists of the following main components:

1. Support foot
2. Fixing bracket
3. Rotation head
4. Deformation roller 1
5. Deformation roller 2
6. Rollers rod 1/2
7. Rollers stop/adjustment 1/2
8. Power cable
9. Power switch
10. Rotation activation button
11. Anti-splash
12. Can seat



## TECHNICAL DATA

MODEL	B64	CDL
Power supply	110V 60 Hz o 230V 50 Hz	
Dimensions	330x200x450	
Weight	15,4 kg	15,4 kg
Degree of protection	IP10	

## INSTALLATION

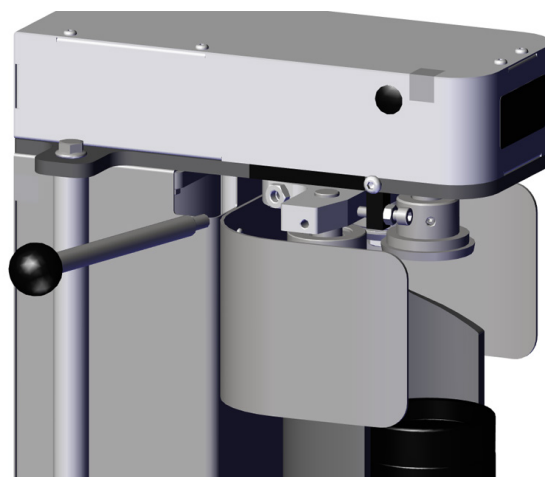
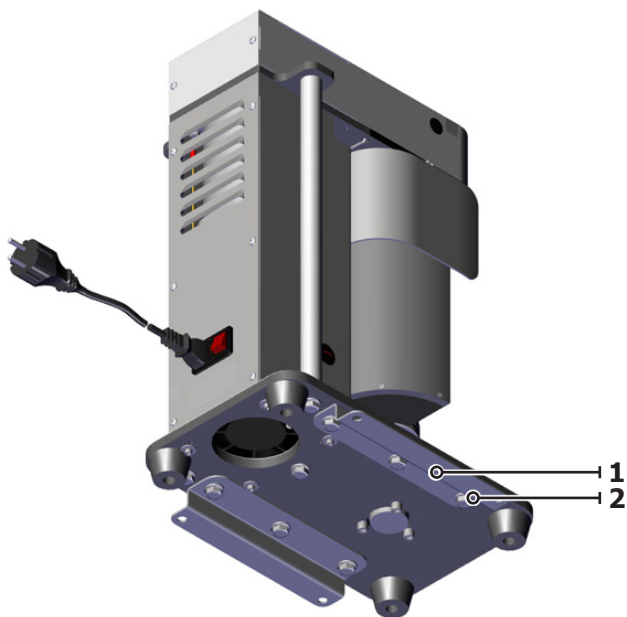
### Completion of assembly

Before putting the device into operation, it is necessary to install the components supplied disassembled.

To do so, place the fixing brackets [1] as shown in the figure and tighten the screws [2].

Secure the device to the work table to ensure optimal functionality.

Screw roller rod 1 and 2 into its seat using the 8 mm wrench.



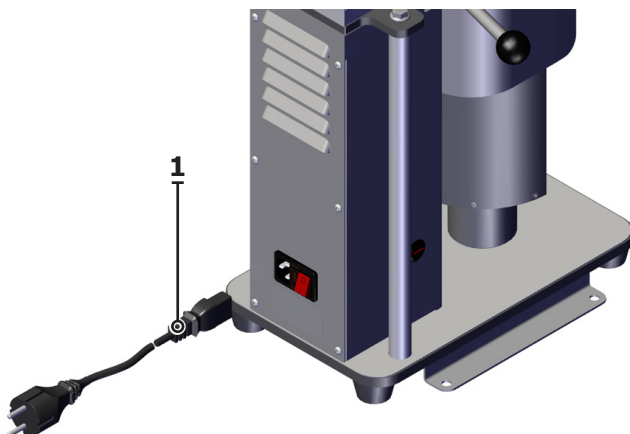
## Electrical connection

### ATTENTION

Before connecting the device to a voltage source, check that its voltage matches that indicated on the machine's nameplate data and that the power switch is in the "0" position.

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Connect the supplied power cable [1] and then connect the device to the power supply.



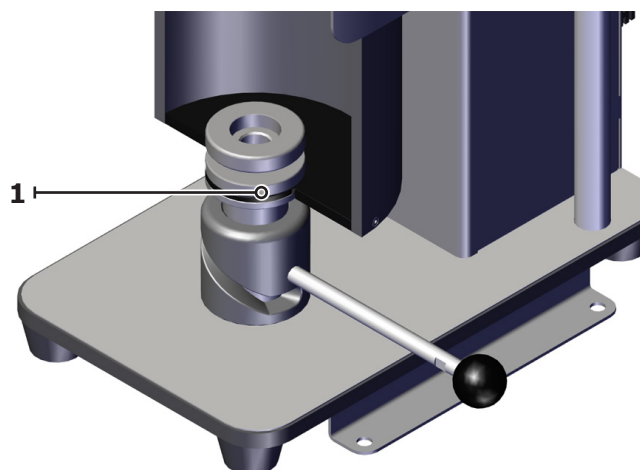
## ADJUSTMENT

The device needs mechanical adjustments before being put into operation.

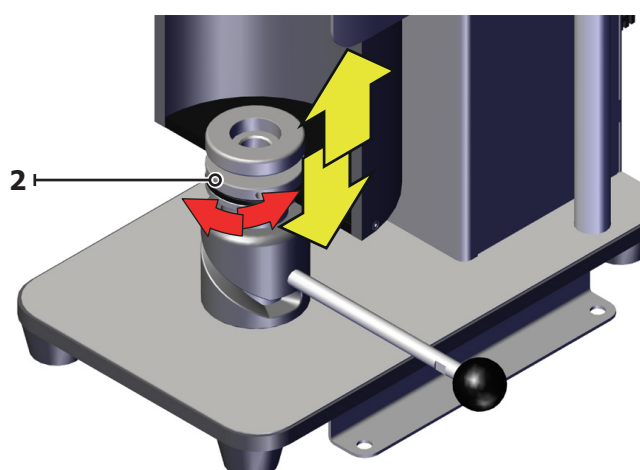
### How to adjust the height of the can seat

To adjust the height of the can seat, proceed as described below:

- use the allen wrench (5 mm) to loosen the ring [1].
- Once the desired position is reached, lower the seat by turning the rod counterclockwise and use the allen wrench (5mm) to tighten the ring [1].



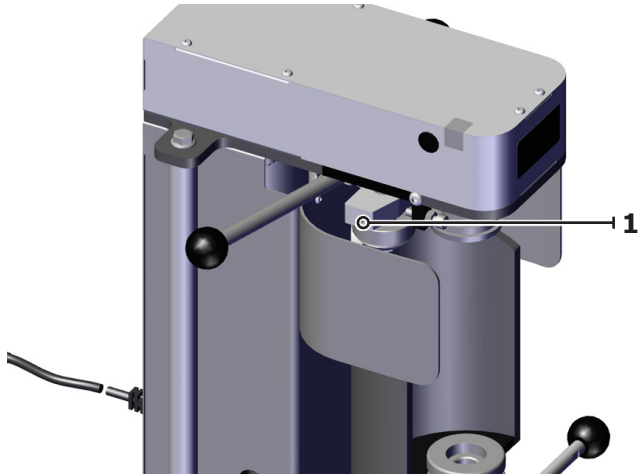
- With the can in the housing and in the working position (up), unscrew/screw the can housing [2] until the can is firmly pressed against the rotation head.



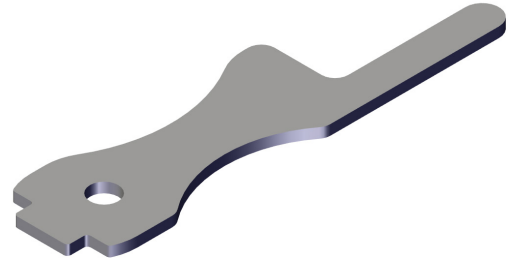
## How to adjust the height of rollers

To adjust the height of roller 1, proceed as described below:

- loosen the grub screw [1] with the allen wrench (3 mm) provided.

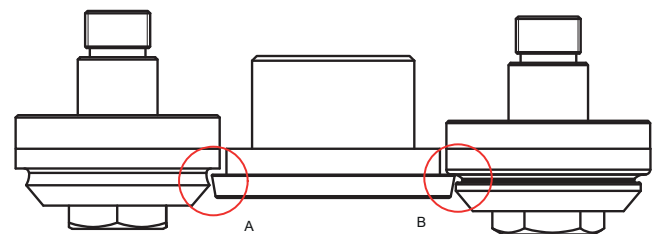
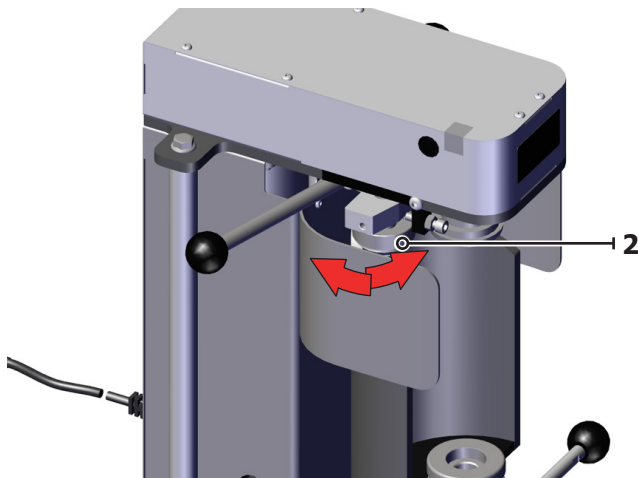


- Place the thickness gauge between roller 2 and the rotation head.



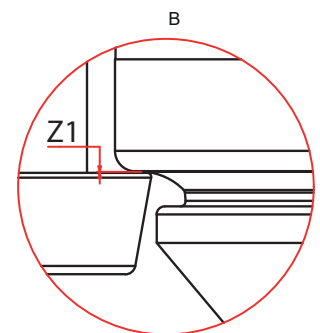
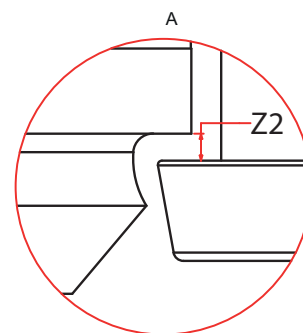
- Raise/lower the roller until roller 2 and the pivot head are both in contact with the thickness gauge.

- Screw/unscrew roller 1 [2] to lower/raise the roller position.



Roller 1 - 16065

Roller 2 - 16066



- Raise/lower roller 1 so that it is as close as possible to the rotation head, without ever letting them come into contact.
- Once the desired height has been reached, screw in the set screw [1].

## How to adjust the distance of roller 1 from the rotation head

### ATTENTION

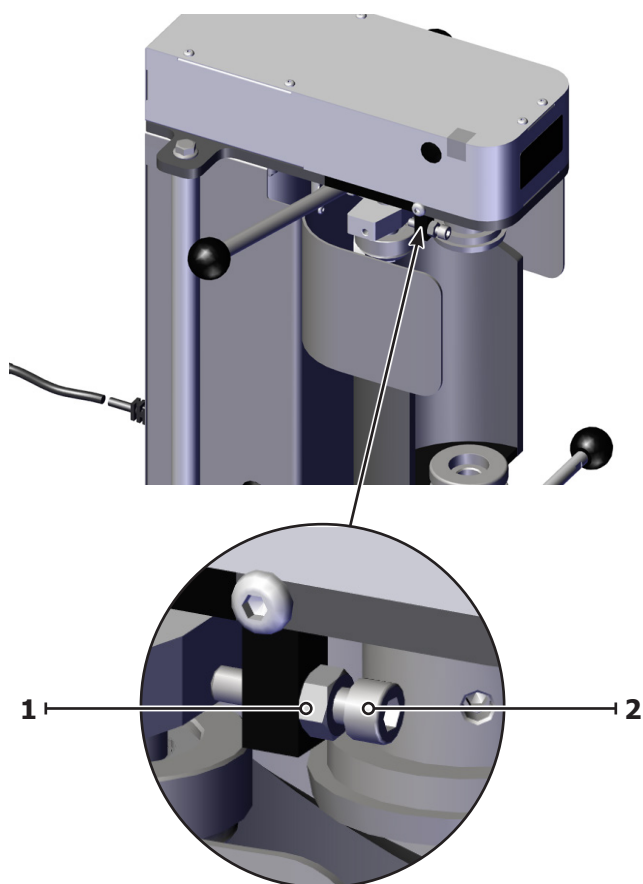
Always carry out the adjustment of the height of roller 1 first, and then the adjustment of the distance between roller 1 and rotation head.

### ATTENTION

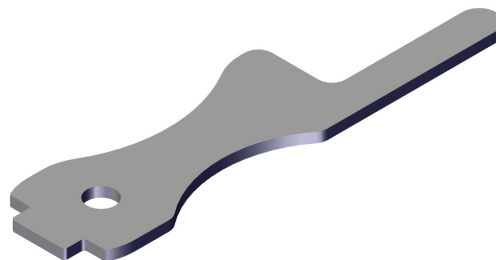
The roller should never be in contact with the rotation head. Contact between the two will cause it to be damaged quickly.

To adjust the distance of roller 1 from the rotation head, proceed as described below:

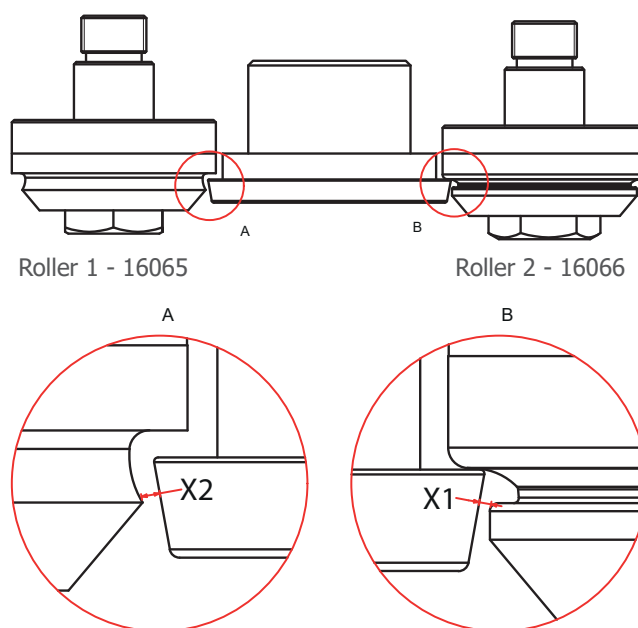
- Loosen the nut [1] using the supplied 10 mm wrench; loosen/screw the screw [2] to adjust the roller distance from the rotation head.



- To check the adjustment value, place the feeler gauge between the roller and the rotation head.



- Once the desired distance is reached, tighten the nut [1] by means of the supplied 10 mm wrench; while tightening the nut [1] maintain the stop between the screw [2] and the roller support.
- Repeat the operation to adjust position of roller 2.



## CAN SIZE CHANGE

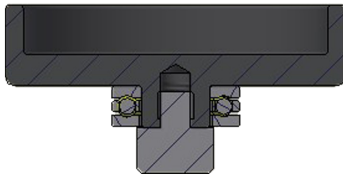
The device can process three types of cans (STD 500 ml, STD 330 ml and sleek 330) ml.

Depending on the type of can you want to process, you need to install adapters (not included) on the can seat and rotation head.

The following are the adapters to be installed on the can seat according to the type of can to be processed.

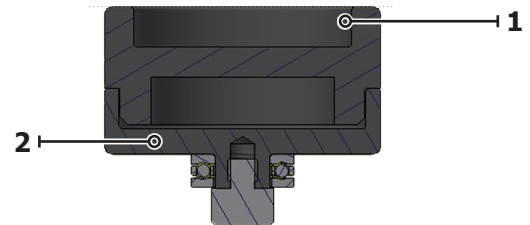
### STD 500 ml can

To process the STD 500 ml can, it is necessary to install adapter 16052 on the can seat.



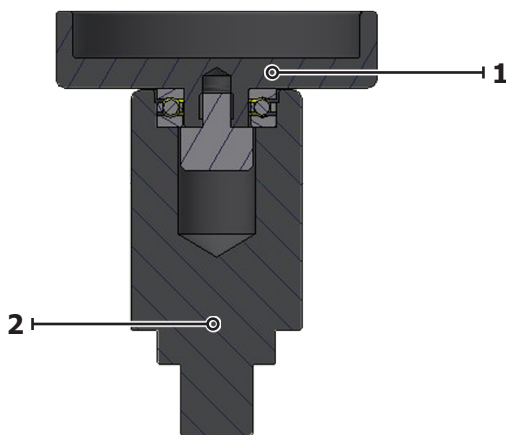
### Sleek 330 ml can

To process the STD 500 ml can, it is necessary to install adapter 16754 on the can seat.



### STD 330 ml can

To process the STD 330 ml can, it is necessary to install adapter 16746 [1] and adapter 16052 [2] on the can seat.



### How to replace the can seat adapter

The can seat adapters are interlocking assembled; to replace them, it is necessary to remove them from the can seat and replace them with the desired adapter.

## CAP SIZE CHANGE

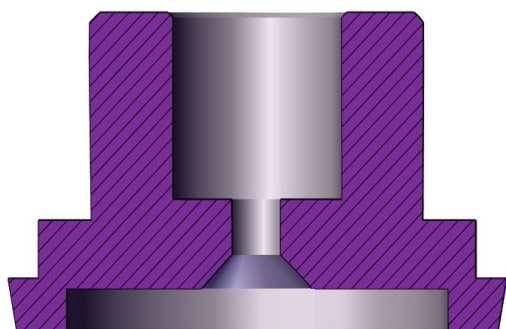
The device can process two types of caps (B64 or CDL) and three types of cans (STD 500 ml, STD 300 ml and sleek 330) ml.

Depending on the type of can and cap you want to process, you need to install adapters (not included) on the can seat and rotation head.

The following are the adapters to be installed on the can seat according to the type of can to be processed.

### B64 cap

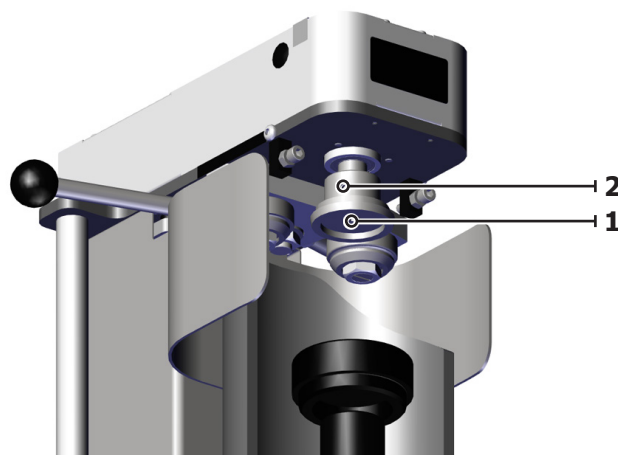
To process the B64 cap, it's necessary to install the 16464 rotation head



## How to replace the rotation head adapter

To replace the rotation head adapter, proceed as described below:

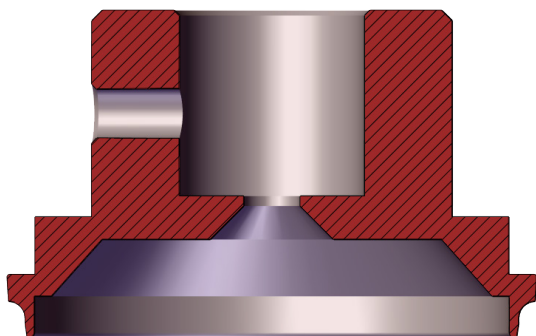
- unscrew the lower screw [1].
- unscrew the set screw [2]



- remove the rotation head.
- Install the replacing rotation head by following the procedure in the reverse direction.

### CDL cap

To process the CDL cap, it's necessary to install the rotation head 16769





## WORK CYCLE

After connecting the device to the power source, installing the adapters according to the type of can and cap, and making adjustments, it can be put into operation.

To perform a work cycle, proceed as described below:

- Press the power switch to "1".
- Place the can on the seat
- Place the cap on the can

### ATTENTION

Position the can and cap correctly to avoid damaging them during processing.

- Turn the can positioning rod clockwise.
- Press the rotation activation button to activate the rotational movement of the can seat.
- With both hands on the rods, rotate clockwise until reaching roller stop 1.
- Turn roller rod 2 clockwise until it comes to a stop with roller 2 stop and hold the position for about one second; return roller rod 1 to the non-working position.
- Press the rotation activation button to turn off the rotational movement of the can seat.
- Rotate the can positioning rod counterclockwise.
- Remove the can from the can seat.

At this point the processing is finished and you can continue with the next processing. If you do not proceed with a new machining, press the power switch to "0".

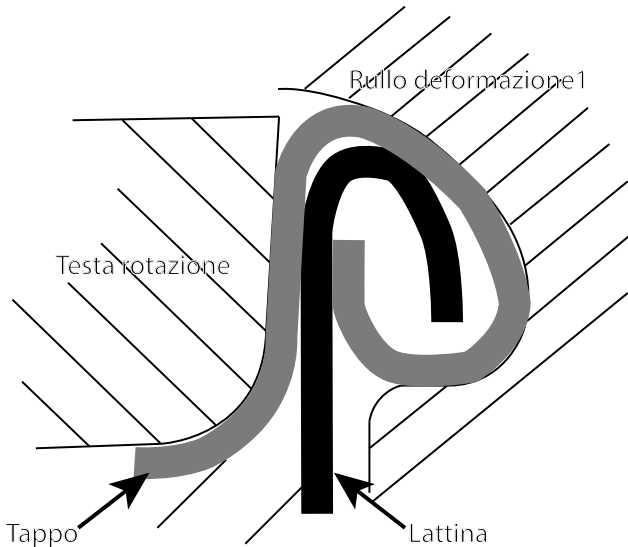
### ATTENTION

Do not leave the rotation of the can seat active between one machining operation and the next.

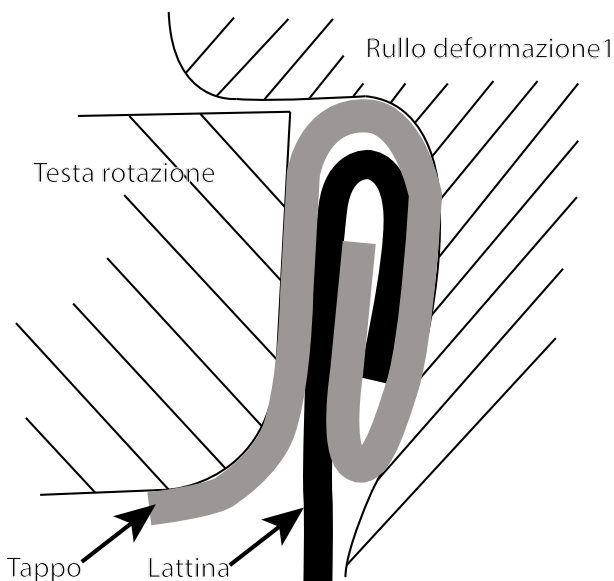
After the application of the cap on the can is finished, always deactivate the rotation of the can seat.

## PROCESS CHECK

The seaming that the machine performs takes place in two operations (cycle 1 and cycle 2). During cycle 1, the curl of the cap and the edge of the can are folded on themselves in a kind of sandwich.



During cycle 2 the device compresses the sandwich, sealing the closure.



The seam of a can must be inspected to verify its quality. The parameters listed below are used for inspection.

**Thickness of seam:** There are specific ranges that the seam of a can must have to be cleared for use. The thicker the can is, the more pressure it can withstand. Thickness is usually measured with a micrometer.

**Seam Height:** The seam height is an indicator of the overall pressure the container can withstand during the seaming operation. The seam height can also be measured with the micrometer.

**Seam imprint:** The seam imprint refers to the inner lining of the can. It is what facilitates the seaming rollers to push the lid onto the can body and engage each part together, giving them the force to push against the rotating head. Great care must be taken during this process, as too much pressure can damage the can.

**Lid wrinkles:** Lid or lid wrinkles are common during seaming, especially when different amounts of pressure are applied to the same can. Differences in radius also play a role in creating wrinkles. During an inspection, it is important that wrinkles be eliminated, as they could threaten the integrity of the can and anything stored inside.

## MAINTENANCE

### Checking and replacing the fuse

To check the integrity of the fuse, proceed as described below:

- Press the power switch to "0".
- Disconnect the power supply to the appliance.
- Open the closing door of the fuse drawer.
- Pull out the drawer.
- Pull out the fuse and check its integrity.
- If necessary, replace the fuse with one of equal characteristics.

## TROUBLESHOOTING

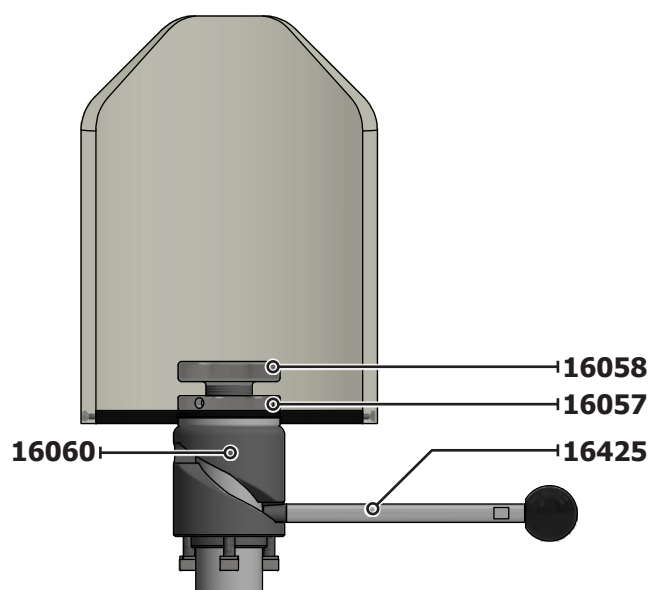
Problem	Resolution
The can slip on rotation head	Adjust the height of the seat by increasing the pressure of the can on the rotation head. Check the tightness of the screw and set screw of the rotation head.
Seaming results in uneven or defective seaming.	Check that the roller rods are tightened well and that there is no clearance in vertical direction. Check that the mechanical adjustments have been made correctly. Check that the part in contact between rollers and cap is clean.
The value of seam thickness and height is out of the correct range.	If the thickness value is too large, the deformation roller 2 is too far from the rotation head. If the thickness value is too small the deformation roller 2 is too close from the rotation head. If the height value is too small the deformation roller 1 is too close to the rotation head or that the deformation roller 2 is too far from the forming head. If the height value is too large the deformation roller 2 is too close to the forming head.

## SPARE PARTS

Only original spare parts should be used for proper operation of the ULTRASEAMER.

At the customer's request they can be provided:

- 16060 Rototranslation guide
- 15500 UE Power cable
- 15565 UK Power cable
- 15564 USA Power cable
- 16753 Lower fixing plate
- 16060 Rototranslation guide
- 16057 Height adjustment ring nut
- 16058 Height adjuster
- 16431 Long knob rod
- 16425 Rototranslation lever

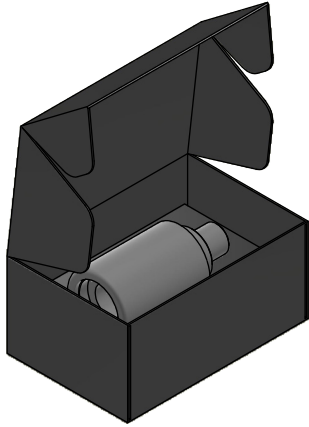


## ACCESSORIES

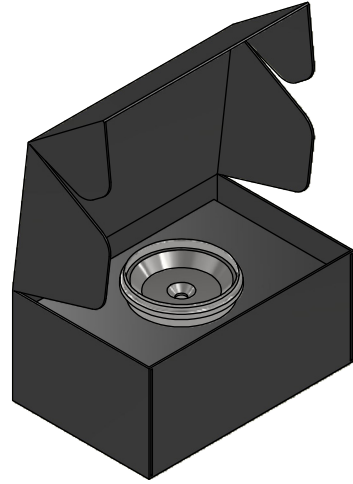
You can purchase the components needed to process different types of cans.

At the customer's request they can be provided:

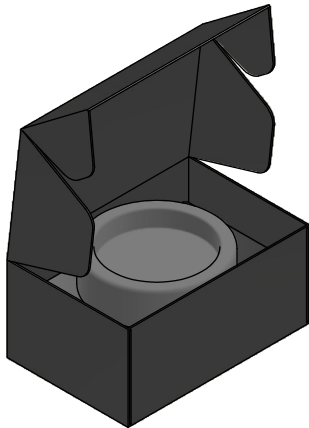
- 16836 Adapter kit 33cl std



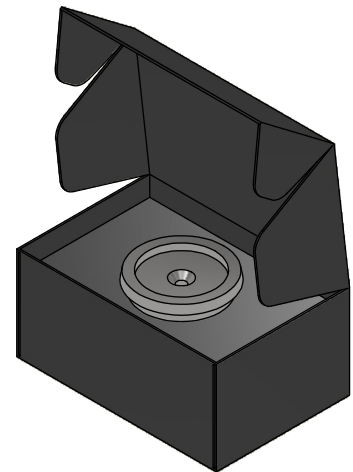
- 16842 CDL head kit



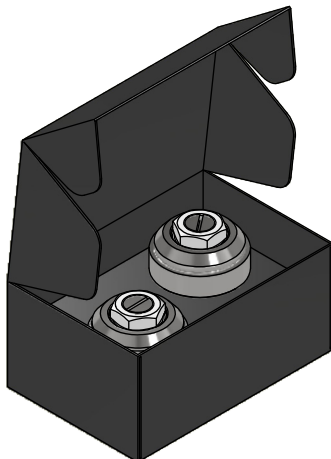
- 16838 33cl sleek adapter kit



- 16843 B64 head kit



- 16840 Roller set kit



## DISPOSAL

If the figure below (the crossed-out mobile waste bin) is on the product, European Directive 2012/19/EU applies. These products cannot be disposed of with normal waste. Find out about current regulations on separate collection of electrical and electronic devices. Do not dispose of old devices with household waste. By properly disposing of old devices, you protect the planet and people's health from possible negative consequences. Recycling materials helps reduce the consumption of raw materials.



## DECLARATION OF CONFORMITY



**Manufacturer:** Industria di Leivi - Via Gazzo, 1 - 16040 Leivi (GE) - Italy

It is declared that the CE-marked machine complies with the following Directives:

- 2014/30/UE EMC directive
- EN IEC 55014-1/2021 + A1/2010 + A2/2012
- EN IEC 61000-6-2/2019
- EN IEC 61000-6-3/2021 + A1/2013
- 2014/35/UE Low voltage directive
- EN 60335-1:2013 + A11/2023 + A13/2018
- 1935/2004/CE Regulations
- 2023/2006/CE Regulations

## WARRANTY

ULTRASEAMER Industry of Leivi canners are guaranteed for 12 months from the date of purchase, unless otherwise agreed in writing.

The warranty covers all defects in materials and workmanship and provides for replacement parts or repair of defective parts only at the dealer's premises. In the case of warranty repair returns, the customer is obligated to always ship complete ULTRASEAMER to the dealer. Warranty repairs on individual failed components will not be accepted.

Material under repair should be sent to FREE PORT.

When the repair has been completed, the device will be sent to FREIGHT COLLECT.

The warranty does not require our technicians to intervene at the place of use of ULTRASEAMER or disassemble them.

There are warranty stickers on ULTRASEAMER that If removed without the manufacturer's permission, they will 100% void the warranty.

They are excluded from the warranty:

- failures caused by improper use or assembly;
- failures caused by external agents;
- failures caused by neglect or poor maintenance.

The warranty is void:

- in case of delinquency or other breach of contract;
- if repairs or modifications are made to our equipment without our consent;
- should the damage be caused by misuse, as well as by mishandling such as knocks, falls, and other causes not attributable to normal operating conditions;
- should the device be found to have been disassembled, tampered with, or repaired by unauthorized personnel;
- should the equipment be used for purposes other than those specified in this manual.

Repairs made under warranty do not interrupt the duration of the warranty.

We thank you in advance for your attention to this handbook and invite you to let us know of any suggestions you feel are necessary to make it more complete.



## NOTE



## NOTE