

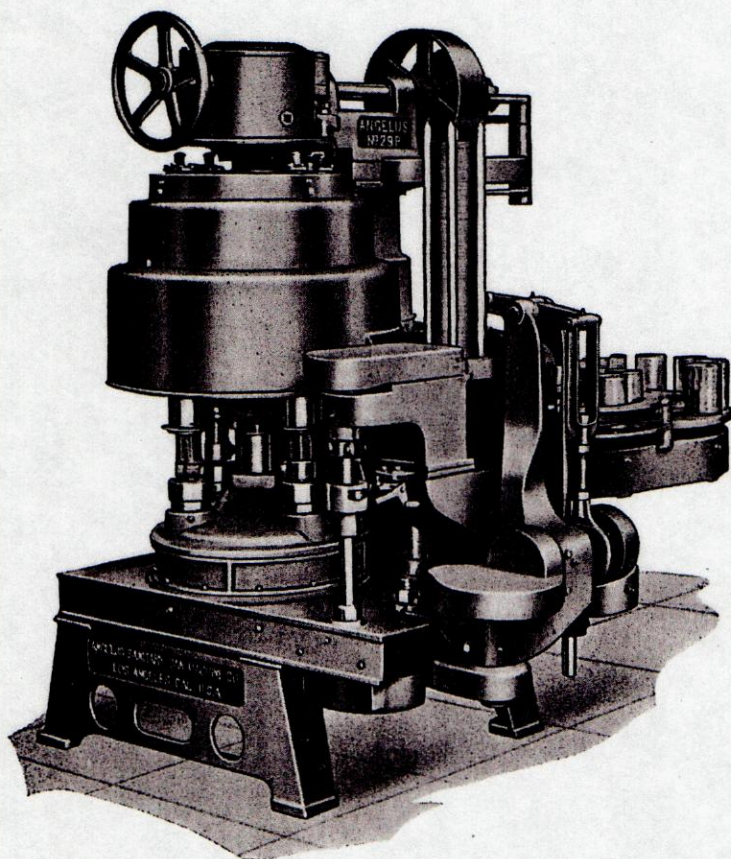
ANGELUS SEAMERS

SINCE 1910

Packaging – Processing
Bid on Equipment

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for Dependable Service



MODEL 29P

AUTOMATIC SEAMER FOR MAKING
OR CLOSING ROUND CANS TWO
TO FOUR AND ONE-QUARTER
INCHES IN DIAMETER AT SPEEDS
UP TO 200 CANS PER MINUTE.

ANGELUS SANITARY CAN MACHINE CO.

PHONE 583-2174

CABLE ADDRESS "ANGELMACO"
WESTERN UNION CODE

4900 PACIFIC BOULEVARD
LOS ANGELES, CALIFORNIA 90058

ANGELUS 29P DOUBLE SEAMER

The Angelus 29P Double Seamer is a general purpose machine suitable for cannery or can manufacturing use where sustained production is required at moderate rates. It is a four head rotary machine recommended for use at 200 cans per minute, except on spillable products where several factors control the maximum desirable speed.

CAN FEED

This machine is equipped with a disc-type can feed which can be set up either for receiving cans at random or arranged for synchronized operation with a compatible filler. Cans received on the timer disc are gradually accelerated through a series of turrets until they are finally transferred into the seaming turret at the speed thereof. This gradual acceleration eliminates the possibility of damage to cans and permits higher operating speeds without spill.

COVER FEED AND MARKER

The separation of covers from the cover stack is accomplished by a pair of reciprocating blades which separate off the bottom cover and force it down to the level of the cover carrying rails. No cover is separated when there is no can available for it, as a very positive means is used for the detecting of the availability of a can. Although the drive for the cover separator is in continuous motion, the reciprocation of the separating knives occurs only as a result of can contact with the detecting lever of the no-can no-cover device.

The Angelus 29P, when equipped as a can closing machine, is supplied with a marking device for embossing covers. The typeholder for the marker is available in two forms. The single row typeholder accommodates five characters, figures or letters in one row, and the double row typeholder provides for five characters in each of two rows. The 29P Closing Machine is regularly supplied with a double row typeholder unless otherwise specified. The typeholder may readily be removed from the machine without modifying adjustment, and through the use of alternate typeholders the changing of code can be accomplished in a matter of seconds.

No marking type is included with the machine but may be ordered from this or other sources.

From the marking station, covers are transported by a carrier finger and guided by cover rails in a semi-circular, spiral path to the point of assembly of the can and cover. The spiraling downward of the cover onto the can is a very desirable feature as it provides a means of assembling the cover on the can when product extends above the can flange.

SEAMING MECHANISM

This model is equipped with four seaming heads located in a revolving turret. The heads revolve continuously and perform the seaming function while the can remains stationary as to its own axis. Each head is equipped with four seaming rolls mounted on levers which are cam actuated. Two opposing first operation seaming rolls form the seam of the cover on the can, and when they retract, two opposing second operation rolls compress the seam. The adjustment of both first and second operation rolls can be performed accurately and rapidly by the repositioning of eccentrically mounted cam rolls on the upper ends of the seaming roll levers. A simple but effective means is provided for throwing second operation seaming roll levers out of position to permit the checking of first operation seams and for accurately repositioning the second operation levers when the examination has been completed.

At the moment of assembly of can and cover, the two are transferred onto one of four lifters which are elements of the seaming turret assembly and which carry the can and cover up into the seaming turret. The proper relationship of can and cover is maintained during the lifting stage by positive contact with a cam controlled plunger located in the axis of the seaming head. When the seaming operation is completed, this same plunger is forced downward by cam action to assure the disengagement of the seamed can from the seaming chuck and thereby assuring the positive discharge of the can.

ADVANTAGES

Over a period of approximately 50 years Angelus has manufactured a series of seamers and can closing machines, all bearing the designation "P" in their model numbers. There have been over 20 different models so closely related that wearing parts are common to all, or at least to several models. This basic Angelus policy assures readily available parts at low cost and provides for the simplification of parts inventory when more than one Angelus model is to be used.

Another basic policy of Angelus machine design practice assures ease of lubrication and maintenance. Most users of Angelus equipment carry on these maintenance functions through their own personnel rather than relying on an outside source for such aids. It is therefore Angelus' policy to design all equipment with a maximum degree of simplicity and accessibility commensurate with effective performance.

ACCESSORIES

MOTOR DRIVES

This model can be equipped with either a V-Belt Motor Drive for fixed speed operation, or a Variable Speed Drive providing a ratio of maximum speed three times minimum.

FILLER DRIVE

When this closing machine is to be synchronously attached to a compatible rotary filler, the filler is driven by the closing machine. This means of transmitting power is equipped with a ball-type safety clutch to provide a means of disengaging the filler from the closing machine when a jam occurs on the filler or at the discharge thereof.

When spillable products are involved, maximum spill-free operation can be achieved only by properly engineered transfers of cans from filler to closing machines. In order to aid our customers in employing Angelus equipment to its fullest capacity, it is Angelus' policy to encourage customers relying on us for the parts and accessories to equip the closing machine for direct connection to the filler. We maintain contact with all major filler manufacturers whereby an exchange of engineering information assures satisfactory performance with Angelus engineered filler seamer transfers.

TOPPER

A topper attachment is available for pressing down products filled above the can flange level, or for displacing liquid to maintain a uniform head space where liquid fill cannot be adequately controlled. This device is equipped with six plungers. On the end of each is a topper cup or pad of the diameter suitable for a particular can diameter. Six additional pads are required where the seamer is to be used for a second can diameter.

CHANGE PARTS

A set of change parts is used to equip the Angelus 29P to handle a particular can diameter of limited height range. Additional sets of change parts are necessary where the machine is to be equipped for additional can sizes. For cannery use, change parts are available in either Regular or Corrosion Resistant form with the Corrosion Resistant change parts being preferable for food products. A set of height change parts is used to equip the machine to handle two different can sizes with a common diameter, but with a difference in can height in excess of the height range limitation of a set of change parts. Where two different can heights of a common diameter are to be operated on the same machine, it is necessary to specify both heights to make it possible for Angelus to determine what height change parts may be required.

NOTICE

The following information must be provided on inquiries and orders:

1. Diameter and height of each individual can.
2. Speed in cans per minute.
3. Current characteristics of power source.
4. Make and model of filler used and products packed.

With your order, in addition to the above information, it is also necessary to have the following:

5. Upper Chuck diameter to a tolerance of plus or minus .0005".
6. Chuck flange thickness to a like tolerance.
7. Chuck flange taper.
8. Chuck flange radius.
9. Outside diameter of curled cover.

In lieu of the data required by items 5 through 9, three sample covers of each can size may be substituted.

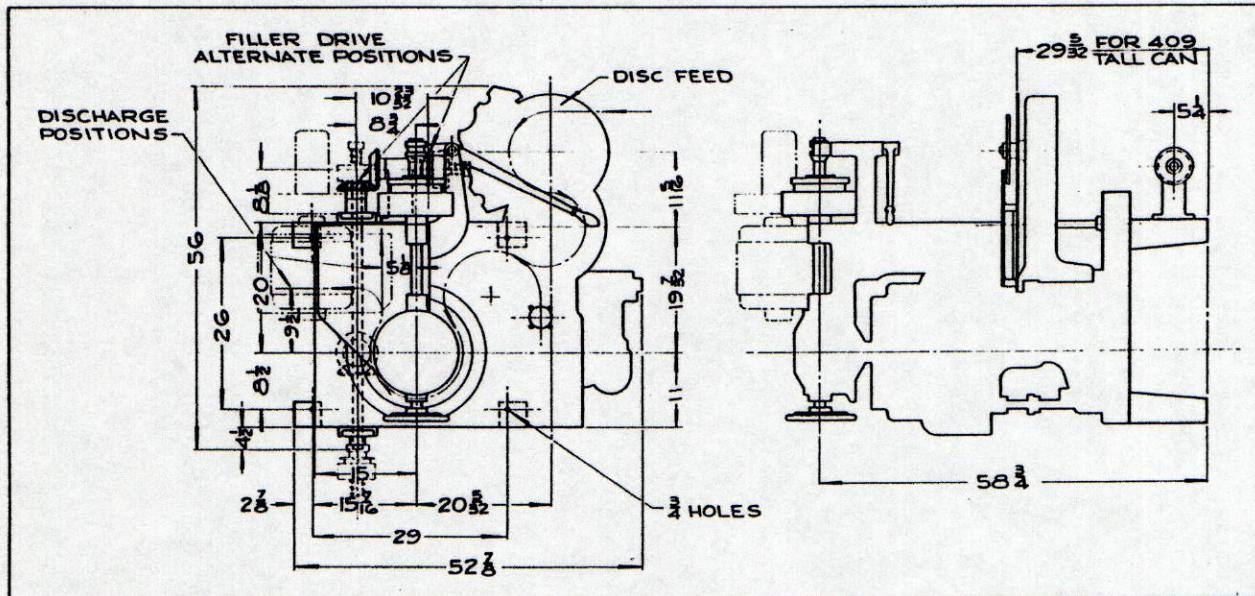
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FLOOR PLAN



SPECIFICATIONS

Nominal Minimum Can Diameter	2 1/8"
Maximum Can Diameter	4 1/4"
Nominal Minimum Can Height	1 1/2"
Nominal Maximum Can Height	5 1/2"
Horsepower Required	3 to 5
Net Weight of Machine	Approx. 2900 lbs.
Shipping Weight — Domestic	Approx. 3150 lbs.
Export	Approx. 4000 lbs.
Size of Box for Export	71" x 82" x 81"
Volume	271 cu. ft.
Revolutions of Drive Shaft	4.05 per can
Revolutions of Filler Drive Shaft	1 per can
Maximum Recommended Speed — 200 cans per minute for can manufacturing use or for closing non-spillable products.	

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