

SERVICE MANUAL M102

MODEL # 625T CROWN OPENER



MODEL 625 OPERATING AND ADJUSTING INSTRUCTIONS

The Edlund Model 625 Pneumatic Can Opener operates at a minimum pressure of 75 PSIG. Lubrication is not necessary but clean, dry air will prolong the units.

The opener may be connected to the air line using the quick disconnect coupling furnished and a length of air hose.

The opener is simple to operate using the following procedure:

1. Connect air line and set inlet pressure to 75 PSIG minimum.
2. Place can to be opened on base against tab on guard ring. The can will be aligned with can guard at the top of the opener.
3. Press both red buttons on sides of head at the same time. Hold until cylinder completes its downward stroke and then release both buttons. Crown punch will retract to its starting position.
4. Remove can and repeat steps 2 and 3 as required.

The Model 625 opener is factory adjusted to open a standard #10 can or the particular size can ordered. The crown punch should penetrate the can just far enough to cut off the cover but not so far as to cause excessive splashing of liquid in can. If an adjustment is required to improve operation of the opener, the following procedure will be used:

CAUTION: To avoid personal injury, disconnect air line before making any adjustment to opener.

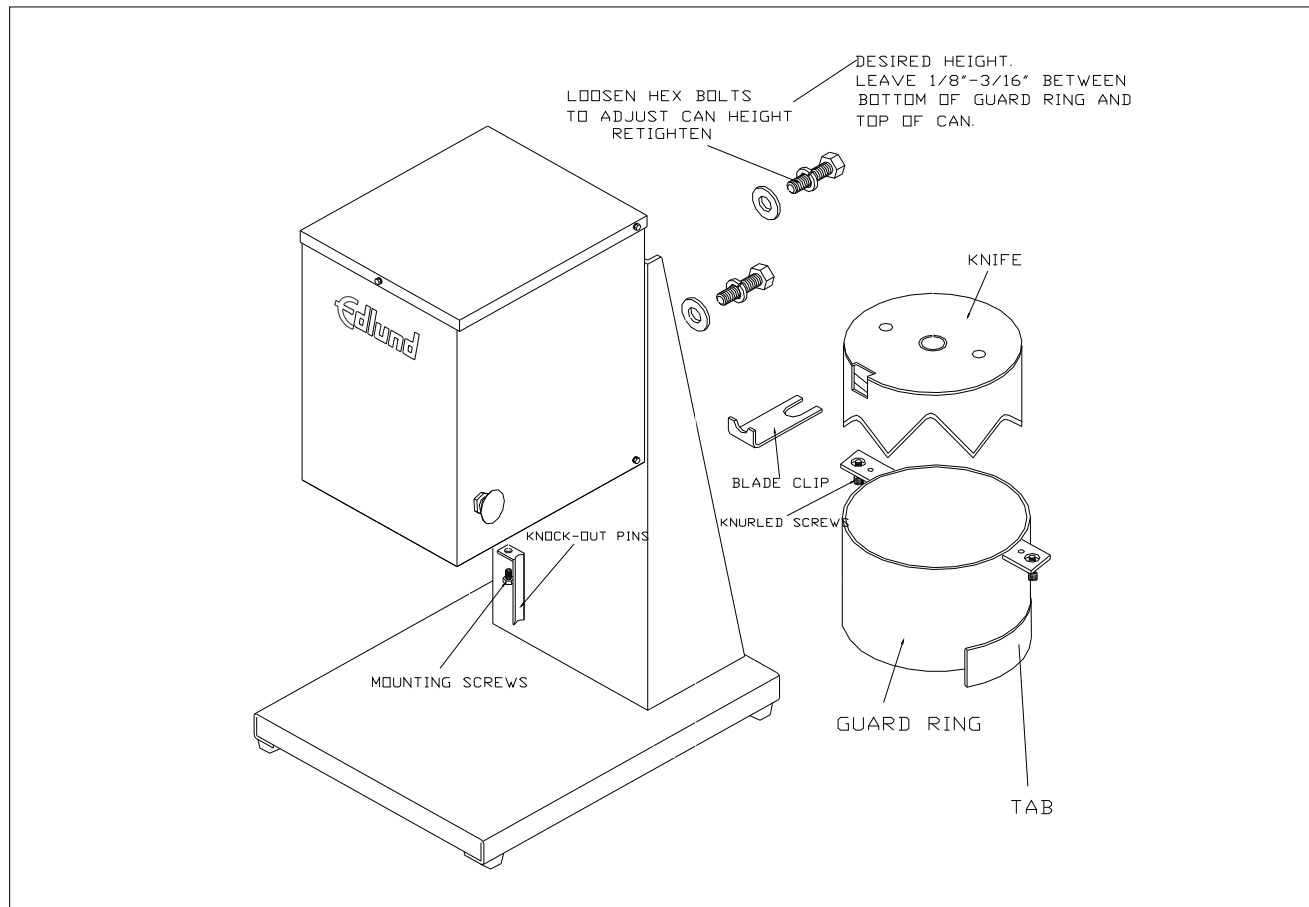
1. Disconnect air line to unit.
2. Place can to be opened under can guard.
3. Loosen the four nuts or bolts at the rear of the vertical (see drawing) and raise or lower the head as desired, keeping the can and can guard aligned and level.
4. Tighten fasteners and close interlock door. Operate according to operating instructions.

If a new size can is required to be opened, the following procedure will be used:

1. Disconnect airline to unit.
2. With one hand, hold up on the knife guard ring and with the other hand unscrew the two thumb screws. (A flathead screwdriver may be needed to start the screws.) Let the guard ring down and place to the side. Now hold up on the knife with one hand (being careful of any sharp parts of the knife), and with the other hand, pull the blade clip straight out. (You may have to wiggle the knife to loosen the blade clip.) Let the knife down. Place knife and clip with guard ring. Do not let knife fall in the deck.
3. Install desired crown punch and can guard onto opener.
4. If can knockout pin does not align with holes in crown punch rotate crown punch or remove pin and use proper size pin in alternate location.
5. Place can to be opened under can guard. If new can is taller than former size can, loosen the four nuts or bolts at rear of vertical (see drawing) and raise head so can will fit.
6. Place ¼ inch to 5/16-inch thick shim between can and can guard.
7. Level and align head and tighten fasteners at rear of vertical.
8. Operate according to preceding instructions.

The knife, guard and clip should be removed after every use for cleaning. To remove any preservatives or brine from the unit clean with mild soap and water. For disassembly see #2 above. The entire machine may be hosed down inside and out.

Blade Cleaning and Inspection



1. Disconnect air remove two knurled screws that hold the guard ring in place. It may be necessary to pull down on the guard ring to remove it, if the locating pins are tight.
2. Support the blade with your hand, lifting slightly to loosen blade clip so it can be pulled out releasing the blade to drop out.
3. Wash blade, guards ring and clip in dishwasher if desired to sterilize. The rest of the machine can be washed with soap and water.
4. Check that the knock-out pins are straight and line up with holes in the blade backing plate and that their mounting screws are tight.
5. Inspect blade for nicks and other damage that may cause metal slivers when opening the can. Replace or return to the factory for repair if damaged.
6. Reassemble blade, blade clip and all guarding. Be sure all screws are tight. Reconnect air supply

625 Operations and Troubleshooting

Operation Description

1. Place can in position against guard ring tab. There should be approximately 1/8" between the top of the can and the bottom of the guard ring. Adjust, if necessary, keeping the head level and spaced evenly.
2. Connect a clean and dry air supply set to about 85 psi pressure.
3. Depress both red buttons at the same time and hold down until blade hits the end of stroke and release. Lid should be completely separated from the can.
4. After removing the opened can, while holding the can by the sides, put the lid up against the magnet. Then pull the can down leaving the lid. When the next can is opened, the lid will be knocked off by a pin which is connected to a small air cylinder.

Pneumatic Description

The two red palm buttons (B138) are attached to one normally open (V005) and one normally closed 3-way air valve (V002). The output of these two valves is connected to the pilot actuators of a 5-way valve (V015S). The two outputs of the 5-way valve are connected to a 5" dia. Air cylinder (C148), which is connected to a blade (A756), which removes the lid. Both buttons must be actuated to shift the 5-way valve and extend the cylinder and open the can. Releasing them shifts the 5-way valve back and retracts the air cylinder.



Troubleshooting

Only qualified maintenance personnel should do repairs.

Symptom

1.	Unit will not operate when buttons are pushed.	<p>a. Check air connection and supply pressure (air should come out of unit when it is disconnected).</p> <p>b. Remove cover to check valve operation. The valve (V005) connected to the right button should only let airflow through it when actuated. Remove the side hose by pushing in collar and pulling out the hose at the same time. Operating the button sh</p>
2.	Air leaks out around cylinder shaft near blade.	The cover must be removed to pinpoint leaks. Worn seals usually cause cylinder end leaks and the cylinder must be removed and repaired or replaced.
3.	Air leaks out the 5-way valve (V015S) exhaust.	The valve (V015S) probably needs repair or replacing. Remove cylinder top hose to check if only the valve (V015S) is faulty. If cylinder piston seals are bad, air will come out of the top cylinder port.
4.	Air leaks around one of the valves, V002, V005 or V015S.	Check to be sure all connections are tight and hoses are pushed all the way on. If the three way valves are stuck or worn out they can leak around the actuating stem. Disassembly and cleaning is possible but replacement is recommended.
5.	Blade goes down, but will not return.	<p>a. V002 valve stuck in and/or</p> <p>b. V005 valve stuck in and/or</p> <p>c. V015S valve stuck in open position</p> <p>d. and/or cylinder seized in down position. Repair or replace factory parts.</p>
6.	Blade fails to open can completely.	<p>a. Inspect blade for damage – replace or return to the factory for reconditioning.</p> <p>b. To check cylinder stroke, hold both buttons down – blade should come down at least 1-1/2" to the points or 3/8" to the valley. Cylinder may be loose, binding or filled with water or oil and hydraulically locked, repair or replace as necessary.</p> <p>c. To adjust the head height – loosen bolts in back and adjust head to correct height or slightly closer being sure to keep the gap between guard ring and can even on both sides.</p> <p>d. If the lid is still attached near the front or back, check the gap there, excessive variation before operation or too much flexing during operation can be caused by a bent frame or broken welds (be sure knife is good and you have 85 psi of pressur</p>
7.	Lid does not fall out of knife.	<p>a. Bent or broken knockout pin. Repair or replace.</p> <p>b. Damaged blade holding the lid. Repair or replace.</p>



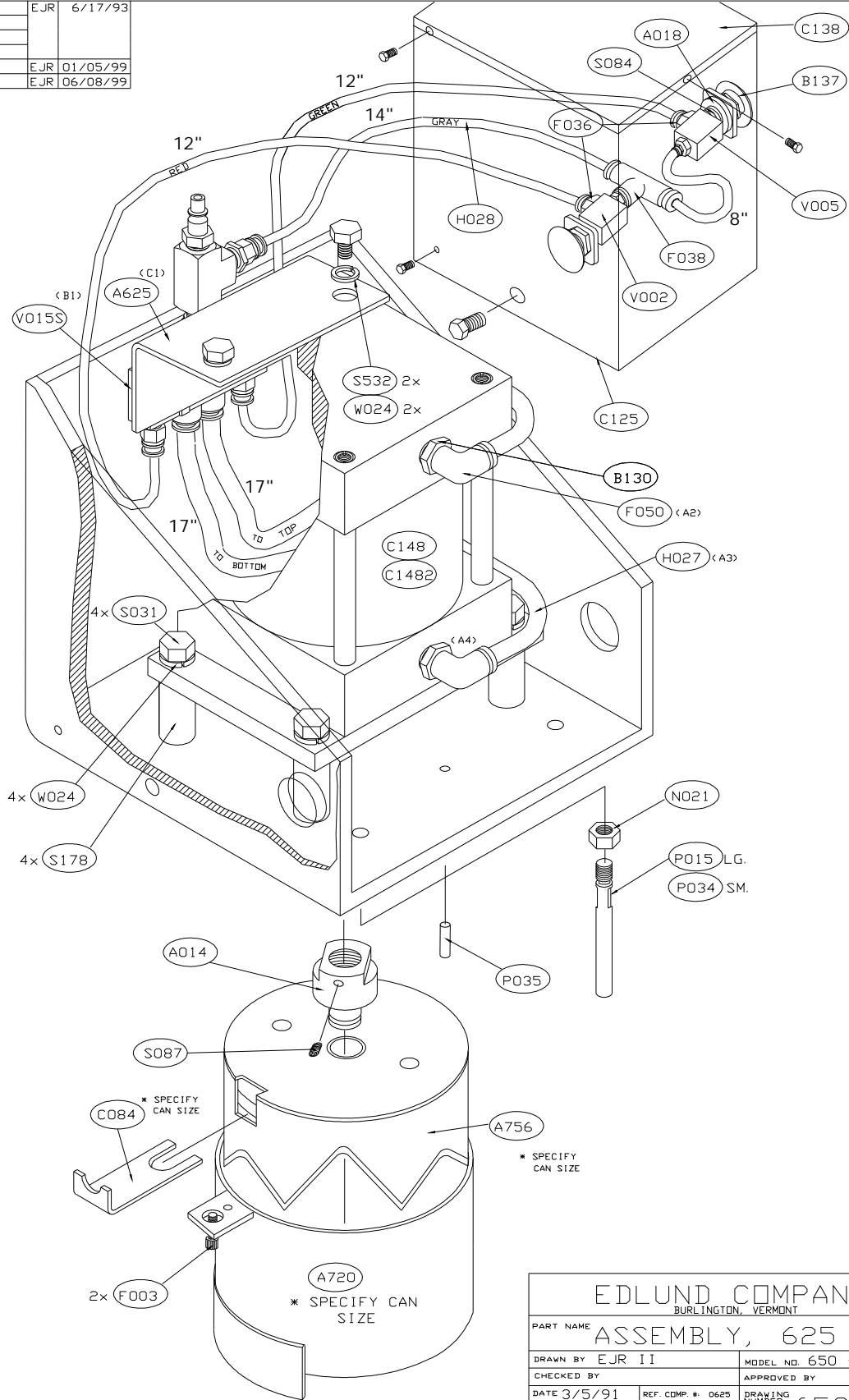
Edlund Company, Inc. 159 Industrial Parkway Burlington VT 05401 802-862-9661

Parts List

PART #	DESCRIPTION
A 014	ADAPTOR, 625 CYLINDER
A 018	ADAPTOR, PUSH BUTTON
A 625	ASSEMBLY, 625 SMC VALVE
A 629	WELDMENT, #625 HEAD
A 630	WELDMENT, #625 VERTICAL/BASE
A 720	WELDMENT, #700 GUARD RING, #603 DIA
A 756	WELDMENT, #10 KNIFE S/S
A 805	ASSEMBLY, #625/#825 ADJ NUT
B 097	BRACKET, #625 RETAINING
B 099	BRACKET, ROD GUIDE
B 130	BUSHING, REDUCTION, 3220 X 8 X 4
B 137	BUTTON, RED MUSHROOM PUSH, 800T-D 6
C 084	CLIP, RETAINING #10, 603 SIZE
C 104	COUPLING, #210-3003, 1/4" FEMALE
C 125	COVER, #625 FRONT
C 138	COVER, #625 TOP
C 148	CYLINDER, #625 OPNR 5" BX 1 5S S#91-628286
F 036	FITTING, 1/4" OD PUSH-IN to 1/8 NPT MALE
F 038	FITTING, 1/4" Push-in Branch Tee 1/8"
F 045	FOOT, #625 MECH., BLK FI 5200-01-13-5052
F 050	FITTING, 3/8" OD PUSH-IN ELBOW TO 1/4 NPT
H 027	HOSE, 3/8" OD CLEAR PAR FLEX
H 028	HOSE, 1/4" OD CLEAR
H 030	HOSE, H 101-3/8 ID
K 064	KEY, T27 TORX-L (FOR S514)
K 065	KEY, T25 TORX-L (FOR S513)
L 004	LABEL, #610 "CAUTION - DISCONN"
L 005	LABEL, "CAUTION, DUE TO CHEM"
L 017	LABEL, BLADE CAUTION
L 057	LABEL, CP LID CAUTION
M 10080	MANUAL, #625 CP INSTR/SERV-TAMPER PROOF
N 017	NUT, 1/2"-13 S/S HEX
N 021	NUT, 3/8"-16 S/S HEX
P 015	PIN, KNOCKOUT, 3/8 X 3-1/4 S/S
P 034	PIN, SMALL KNOCKOUT/LOCATING
P 035	PIN, S/S SMALL LOC, DOWEL, 3/16 X 1/2
R 033	RING, RETAINING, 5133-50H
R 057	ROD, #825 ADJUSTING
S 021	SCREW, 3/8-16 X 5/8 S/S FHS
S 026	SCREW, 1/2"-13 X 1 S/S HEX HEAD
S 028	SCREW, 1/2"-13 X 1-1/4 S/S HEX HEAD
S 031	SCREW, 1/2"-13 X 2-1/2 S/S HEX HEAD
S 045	SCREW, 10-32 X 1/2 S/S HEX HEAD
S 084	SCREW, 8-32 X 5/16 S/S RHM
S 093	SCREW, 10-32 X 1/4 SOCHD CAP S/S
S 178	STANDOFF, #625 CYLINDER
S 191	SCREW, BRASS TIP SET, 1/4"-20 X 1/4
S 379	SCREW, 3/8-16 X 3/4 HEX S/S
S 513	SCREW, #10-32 X 1/2 BUT HD SS TORX SECR T
S 514	SCREW, 1/4"-20 X 1/2 BUT HD SS TORX SECR T
V 002	VALVE, 3 WAY NO, MJV0-3
V 005	VALVE, 3 WAY NC, MJV-3
V 015 S	VALVE, SMC 5-WAY DBL. AIR PILOT
V 042	VALVE, 1/4 NPT BALL, LOCKOUT
V 055	VALVE, 3-PORT W/LOCKOUT 1/4 NPT
W 010	WASHER, #10 S/S FLAT
W 015	WASHER, 1/4 S/S FLAT
W 020	WASHER, 1/4" S/S LOCK
W 021	WASHER, #10 S/S LOCK
W 024	WASHER, 1/2" S/S LOCK
W 026	WASHER, 3/8" S/S LOCK
W 029	WASHER, #610/700 12 GA MOUNTING
W 041	WASHER, #825 THRUST #TT-1001-1
W 058	WASHER, 3/8" S/S FLAT

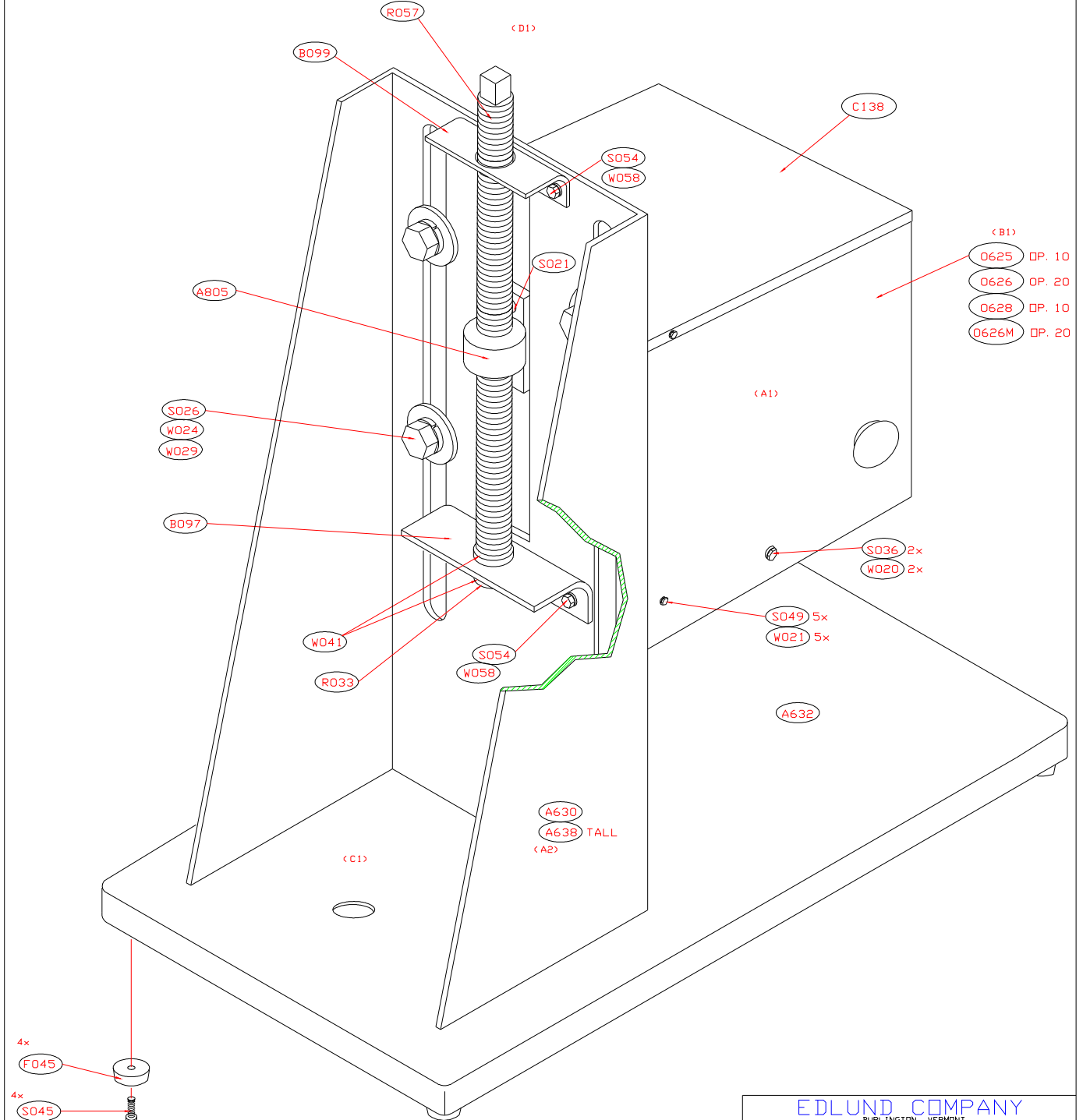
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033	A1> WAS (F014)	EJR	6/17/93
	A2> WAS (A020)		
	A3> WAS (H030)		
	A4> DEL (F017)		
1438	B1> UPDATE VALVE	EJR	01/05/99
1508	C1> UPDATE VALVE	EJR	06/08/99



EDLUND COMPANY BURLINGTON, VERMONT			
PART NAME ASSEMBLY, 625 HEAD			
DRAWN BY EJR II		MODEL NO. 650 - 625	
CHECKED BY		APPROVED BY	
DATE 3/5/91	REF. COMP. #: 0625	DRAWING NUMBER	
COMPUTER NO. 62500	REV. C 650-3X		

033	A1) DEL. (A629)	EJR	6/17/93
	A2) ADDED (A638)		
	A3) WAS (A625)		
273	B1) 0625, 0626, 0628, 0626M	EJR	01/13/94
304	C1) DEL. 6x (S028)	EJR	03/11/94
508	D1) DEL. (H004) HANDLE	EJR	11/07/94



EDLUND COMPANY BURLINGTON, VERMONT			
PART NAME 625/625T MAIN ASSEMBLY			
DRAWN BY EJR II		MODEL NO. 625, 625T	
CHECKED BY		APPROVED BY	
DATE 1/14/91	SCALE	DRAWING NUMBER 625-1X	
COMPUTER NO. 0625, 0626		REV. D	
(A3)			