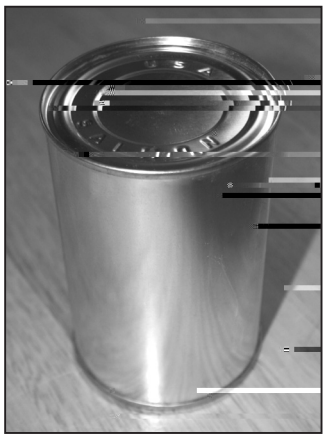
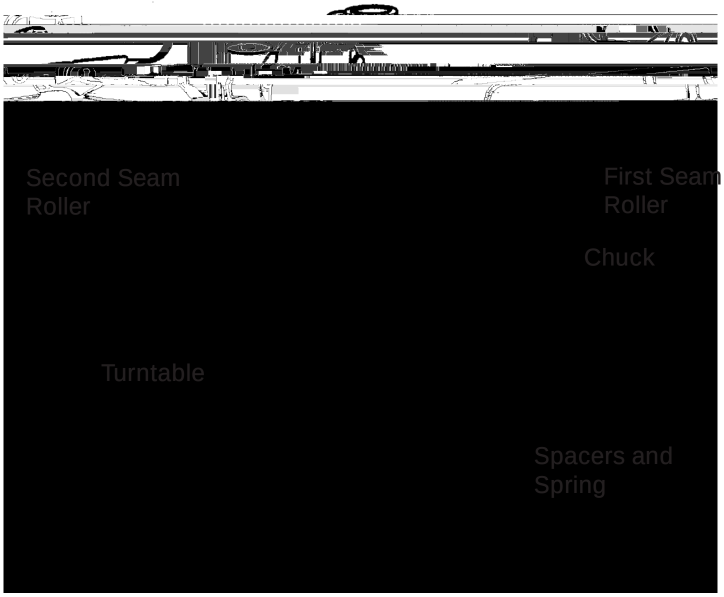


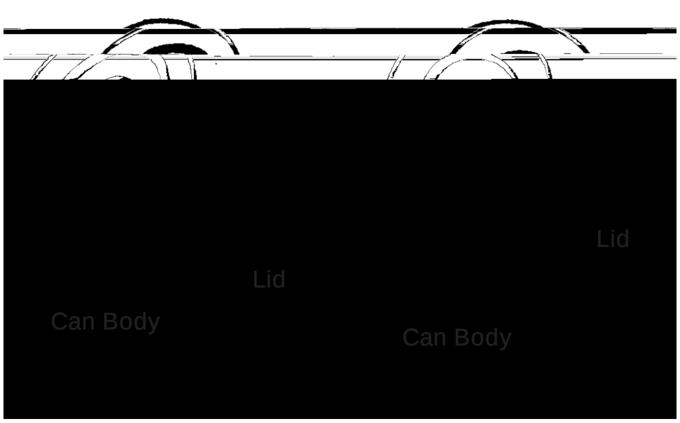


A double seam attaches the can lid to the can body. The seaming operation, which has two parts, is done with a can sealer.

The three-piece can's double seam has five layers of metal (seven at the side seam) that are curled or folded and then pressed together. The double seam on a two-piece can has a double seam made of five layers of metal that are curled or folded and then pressed together. A two-piece can has no side or bottom seams.

The can sealer's first seam roller operation interlocks the lid edge and sealing material with the can body edge by curling them together. It is important that this first seaming operation be correctly done, because it cannot be corrected during the second part of the seaming operation.

The can sealer's second seam roller operation flattens and smooths the seam by pressing the layers of metal tightly together. This operation also squeezes the lid sealing material into the spaces between the metal to give an airtight seal.

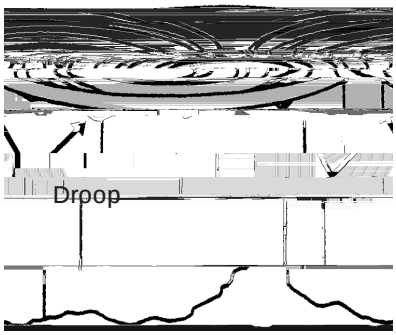


First Seaming Operation Second Seaming Operation

Seam droop is a smooth overhang along the bottom of the normal seal. Droop gives the bottom edge of the seam a scalloped look. This defect may occur at any point around the seam, but it is found most often where the can seam crosses the side seam of the can body (three-piece cans). A very slight droop at the side seam may be normal because of the extra thickness at this point.

Read sealer instructions before adjusting for defective seams.

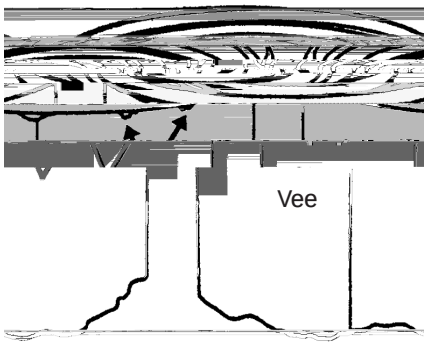
Problem Cause	**Problem Solution**
Turntable pressure is too great.	Decrease turntable pressure. Check number of spacers for can size.
First seam roller operation was too loose.	Tighten first seam roller operation.
Food is trapped in seam.	Clean can edge carefully before seaming on lid.
Cans are defective (bent or dented).	Inspect cod).



Seam vee is a sharp, pointed overhang along the bottom edge of the normal seam. e presence of vees means the lid and can body edges are not interlocking correctly.

Read sealer directions before adjusting for defective seams.

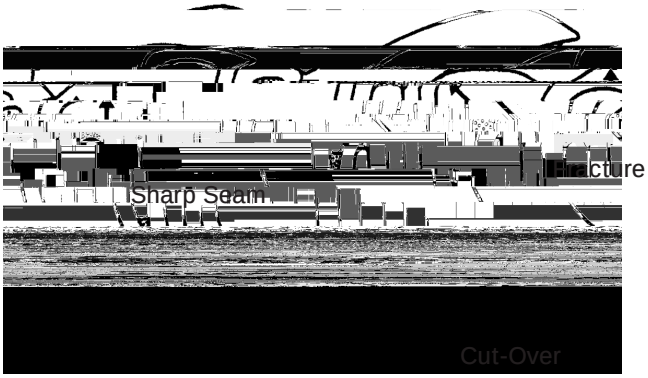
P . . b . Ca . .	P . . b . S . . . .
Turntable pressure is too great.	Decrease turntable pressure. Check number of spacers for can size.
First seam roller operation was too loose.	Tighten rst seam roller operation.
Food is trapped in seam.	Clean can edge carefully before seaming on lid.
First seam roller operation was too tight.	Loosen rst seam roller operation.
First seam roller is worn.	Replace seam roller.



A sharp seam is a sharp edge at the top inside portion of the seam. A sharp seam can usually be felt by running a nger around the inside part of the lid seam. is defect can be the rst indication of cut-over, where the seam is fractured. Sharp seam and cut-over have the same possible causes and possible solutions.

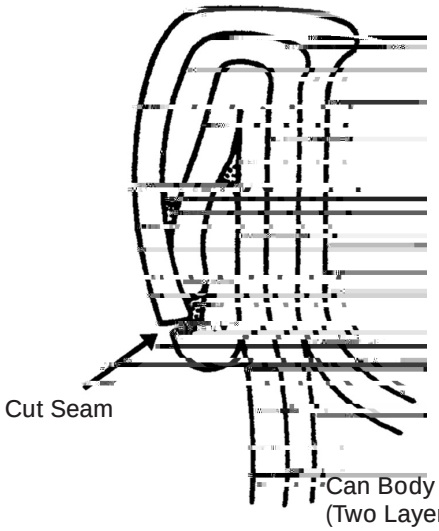
Read sealer directions before adjusting for defective seams.

P . . b . Ca . .	P . . b . S . . . .
First or second seam roller operations were too tight.	Loosen rst and/or second seam roller operation.
Food is trapped in seam.	Clean can edge carefully before seaming lid.
Turntable pressure is too great.	Decrease turntable pressure. Check number of spacers needed for can size.
Seam rollers and/or chuck are worn.	Replace seam rollers and/or chuck.



A cut seam is an extremely tight seam. e outer layer of the seam is fractured.

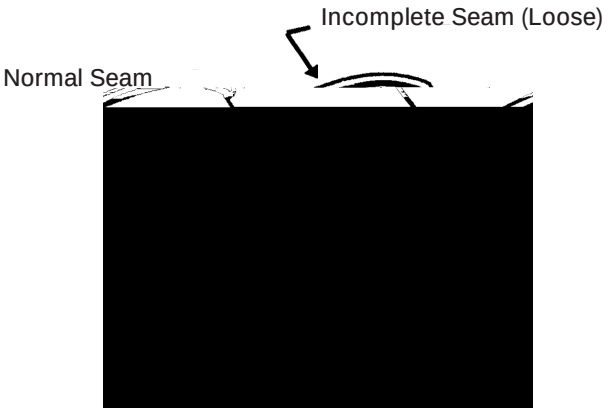
Read sealer instructions before adjusting for defective seams.



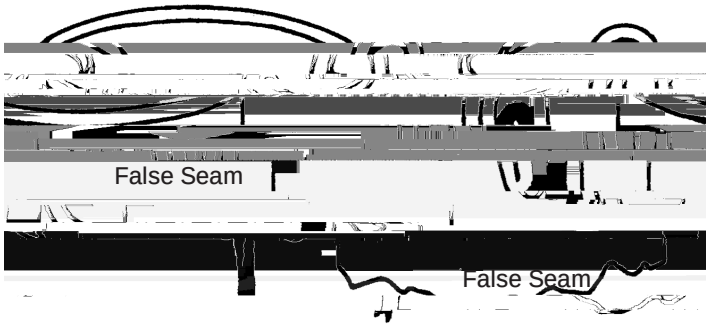
e incomplete seam is a defect where the seam is un nished or loose in sections around the completed seam.

Read sealer instructions carefully before adjusting for defective seams.

P b Ca	P b S
Turntable pressure is too high or too low.	Check sealer instructions for number of spacers needed for can size.
Seaming chuck is worn.	Replace chuck.
Seam rollers are not rotating freely.	Clean, oil or repair seam rollers so they rotate freely.
ere is oil or grease on seaming chuck or turntable.	Clean seaming chuck and/or turntable.



P b Ca	P b S
Lid or can edges are bent or damaged.	Inspect cans and lids for damage before using.
Food is trapped in seam and/ or can is over lled.	Clean can edge carefully before seaming. Check ll of can,
First seam roller operation was too loose.	Tighten rst seam roller operation.
Second seam roller operation roller was too tight.	Loosen second seam roller operation.



e false seam is a serious defect that will cause leakage of food from the can. Visible on the outside of the can by close inspection, the lid and can edges are pushed at against the can but are not hooked together.

is work was partially sponsored by the O ce of Sea Grant, NOAA, U.S. Department of Commerce, under Grant No. NA81AA-D-00025 and the Virginia Sea Grant Program through Project A/AS-1.

e U.S. government is authorized to produce and distribute reprints for governmental purposes, notwithstanding any copyright that may appear hereon.

. a . \ /c 1-877-520-5211

L A b , Extension Faculty, Health, Home and Family Development. Originally written by Kristy Long, former Extension Foods Specialist.

Published by the University of Alaska Fairbanks Cooperative Extension Service in cooperation with the United States Department of Agriculture. UAF is an AA/EO employer and educational institution and prohibits illegal discrimination against any individual: www.alaska.edu/nondiscrimination

08-02/KL/11-21

R \ J 2020