

SERVICE MANUAL- M129

MODEL #G-2 MANUAL CAN OPENER

Model #G-2 Can Opener Assembly Procedure

The Model #G-2 can opener will be assembled according to the following procedure.

I. Model #G-2 Handle and Arbor Assembly (A208) (Fig. 1)

Insert arbor (A026) into slot at end of handle assembly (A209). Align holes and secure using a roll pin (P030).

II. Model #2 Knife holder Assembly (A518) (Fig. 1)

Place the knife (K005) on tang of knife holder (H020). Secure knife holder using screws (S072).

III. Model #2 Main Assembly

Place spring (S151) and washer (W037) into hole in top of slide bar assembly (A206/A207). Insert spring compression tool (A5191) into rear of gear slot and compress washer and spring until knife holder ears will slide over the washer. Align the holes in slide bar and knife holder and insert rivet (R041) through both parts. Place head of rivet on top of steel plate and upset other end of rivet using hammer.

Remove the spring compression tool and insert gear (G004) with stamped word "Edlund Up" toward top of side bar. Place bushing (B121) into opening at top of slide bar and slide arbor of handle and arbor assembly (A208) down through bushing, washer and spring and into gear. Screw arbor into gear while keeping gear from rotating by inserting soft nail or screw into space on left side of gear between the gear and the edge of the gear slot. Turn handle clockwise until arbor and gear are fully tightened. When gear and arbor are properly assembled there should be very little space between the top of the bushing and the bottom of the handle.

Lubricate the arbor hole using non-sticking vegetable oil and inspect using final inspection instructions.

#G-2 Can Opener Maintenance

1. #G-2 Knife Replacement Procedure

The knife (K005) should be checked periodically to make sure that there are no nicks or grooves on the cutting edge of the knife. The knife should be reversed or replaced to use the unused cutting edge or replaced using new knife.

Raise the handle and remove the two screws (S072) that retain the knife to the knife holder and reverse the knife or replace with a new knife and secure using the two screws.

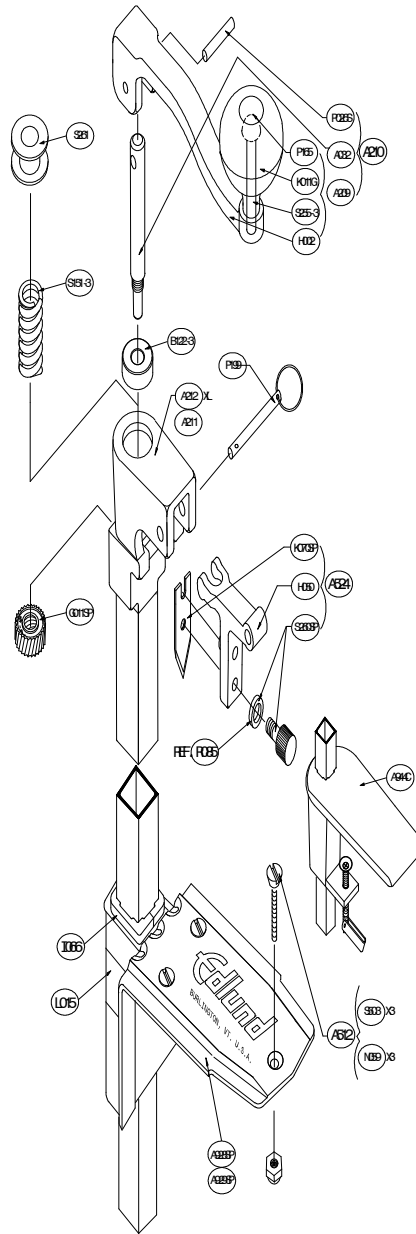
2. #G-2 Gear Replacement Procedure

If gear will no longer turn a can or starts to remove metal from the can bead, the gear needs to be replaced. To remove the gear, place a soft nail or screw on the right side of the gear between the gear and the edge of the gear slot to keep gear from rotating. Turn handle counterclockwise until arbor is free from gear. Replace the gear and assemble the gear according to the previous assembly procedure.



Model No. G-2 Can Opener
Trouble Shooting Guide

Problem	Cause	Correction
I. Can opener will not turn can.	1. Drive gear is worn.	1. Replace gear (G004).
	2. Drive gear needs cleaning.	2. Clean drive gear (G004) using cleaning brush (ST-93).
	3. Arbor hole in slide bar or arbor is worn allowing gear to move out of contact with the can bead.	3. Replace can opener.
II. Knife will not lift far enough from gear to pierce can when handle is lifted.	1. Worn ears on knife holder.	1. Replace knife holder (H020).
	2. Worn bushing (B121).	2. Replace bushing.
	3. Worn handle (H002).	3. Replace handle.
III. Metal slivers found in food product.	1. Nick or groove on cutting edge of knife (K005).	1. Reverse knife or replace
	2. Worn drive gear (G004).	2. Replace gear.
	3. Sharp edge on slide bar can stops.	3. Round sharp edges with file or replace can opener.
IV. Can Opener withdraws from can during can opening procedure.	1. Worn or loose bar holder on base.	1. Replace base.
	2. Can opener used in base or preparation table that doesn't have two-degree angle on bar holder.	2. Replace base or repair hole in table to include two-degree angle to bar holder.





#G-2 CAN OPENER

PART #	<u>U/M</u>	<u>DESCRIPTION</u>
A026	EA.	ARBOR, #2, #G-2
A206	EA.	ASSEMBLY, #G-2 HEAD/TUBE
A207	EA.	ASSEMBLY, #G-2 XL HEAD/TUBE
A208	EA.	ASSEMBLY, #G-2 HANDLE/ARBOR
A209	EA.	ASSEMBLY, #G-2 HANDLE & KNOB
A518	EA.	ASSEMBLY, #G-2, #2 KNIFEHOLDER
A5191	EA.	ASSEMBLY, #G-2, #1/#2 SPRING RELEASE CLAMP
A932	EA.	ASSEMBLY, CRS (MILD STEEL) BASE
A933	EA.	ASSEMBLY, #G-2 STAINLESS STEEL BASE
B121	EA.	BUSHING, #G-2, #2
G004M	BOX	GEAR, #G-2, #2 24 PKG.
G004SP	EA.	GEAR, #G-2, #2 SINGLE PACK
H002	EA.	HANDLE, #2, #8, #G-2
H020	EA.	HOLDER, #2, #G-2 KNIFE
I066	EA.	INSERT, #U-12 AND #G-2 BASE (#2 REG)
K005M	BOX	KNIFE, #G-2, #2/20 24 PKG.
K005SP	PKG.	KNIFE, #G-2, #2/20 SINGLE PACK
K011G	EA.	KNOB, #G-2 MANUAL CAN OPENER
L015	EA.	#G-2, #1/#2 WARNING LABEL FOR BASE
N059	PKG.	NUT, 10-32 SELF LOCKING (3 PKG. WITH S503)
P030	EA.	PIN, ROLL, 3/16 X 1-1/8 PLATED
P165	EA.	PLUG, 5/8"
R041	EA.	RIVET, #G-2, #2 KNIFEHOLDER
S072	EA.	SCREW 12-24 X 7/16 RHM
S151	EA.	SPRING, #G-2, #2
S255	EA.	STUD, #G-2, #1/#2/#U-12 KNOB
S503	PKG.	SCREW, 10-32 X 1 SS SLOTTED (3 PKG. WITH N059)
W037	EA.	WASHER, #G-2, #2 SPRING



FINAL INSPECTION INSTRUCTION DOC: EC1066 C

MODEL: NO. 2 MANUAL CAN OPENER DATE

MODEL: NO. G2 MANUAL CAN OPENER EFFECTIVE: 01 Oct 2000

OWNER: QUALITY ASSURANCE MANAGER

APPROVALS:

SIGNATURE/DATE

CHIEF ENGINEER

MANAGEMENT REPRESENTATIVE

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1.0 PURPOSE and SCOPE

To provide a uniform and consistent method for acceptance/rejection of finished product.

2.0 INSTRUCTION

2.1 FUNCTIONAL TEST

- 2.1.1 Select a No.10 can, lift the slide bar handle to the open position, the handle shall operate smoothly and freely without binding.
2.1.2 Check the "gap" or "lift" between the knife and gear using gauge no. EFG-30, the "gap" shall be between one hundred ten thousandths (.110) to one hundred seventy thousandths (.170).
2.1.3 With the opener in the closed position, the gap or space between the knife and gear shall not exceed fifteen thousandths (.015). Check with .015 feeler stock.
2.1.4 Place the slide bar into the test base, the stops under the head must contact the top of the test base, position the selected can, pierce the can and lower the handle to the closed position, open the can.
2.1.5 The knife shall puncture the can easily and cleanly, iron closely and sever the lid completely.
2.1.6 The gear shall not skip, mill, or chatter during opening, the gear must not "drag", in any way, on the top or bottom of the gear slot
2.1.7 The gear teeth shall not "chip or break" during opening.
2.1.8 Remove the opener from the can and inspect the "can bead" for any indication of "milling" or "skipping".

3.0 VISUAL INSPECTION

- 3.1 Check to ensure that all fasteners (S198-S072) are tight and free of looseness.
3.2 Inspect for damaged or chipped plating or "yellowing" of the plating ("yellowing" is most prevalent in "humid weather").
3.3 Inspect for obvious casting defects (holes-cracks-or broken slide bars).

G-2 ONLY:

- 3.1 Check to ensure that all weld seams are smooth and free of holes or pits.
3.2 Inspect for scratches or other surface blemishes that would take away from the appearance of the opener.
3.3 Inspect for obvious casting defects (holes, cracks or porosity)
3.4 Ensure the knifeholder can be easily removed for cleaning.
3.5 Ensure that the knife holder cannot be removed without lifting or "cocking" of the handle.

4.0 END OF DOCUMENT

Rev. B: Added requirement to inspect gap at closed position.