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Introduction

The User Manual contains useful information for the user on how to work correctly and in complete safety, and is designed to make it easier to use the machine (called «machine» or «appliance» below).

What follows is in no case intended to be a long list of warnings and constraints, but rather a series of instructions meant to improve the service provided by the machine in every respect, and particularly to avoid a series of injuries or damage to equipment that might result from inappropriate procedures for use and management.

It is essential that all the people responsible for transporting, installing, commissioning, using, maintaining, repairing or dismantling the machine should consult this manual and read it carefully before proceeding with the various operations, in order to avoid any incorrect or inappropriate handling that might be result in damage to the machine or put people's safety at risk.

It is just as important that the Manual should always be available

to the operator and it should be kept carefully where the machine is used ready for easy and immediate consultation in case of any doubt, or in any case, whenever the need arises.

If after reading the Manual, there are still any doubts concerning how to use the machine, please do not hesitate to contact the Manufacturer or approved After Sales Service provider, who is constantly available to ensure quick and careful service for improved machine operation and optimum efficiency.

Note that the safety, hygiene and environmental protection standards currently applicable in the country where the machine is installed must always be applied during all phases of machine operation. Consequently it is the user's responsibility to ensure that the machine is operated and used solely under the optimum safety conditions laid down for people, animals and property.

Introduction

1.1 DESCRIPTION

These pivoting head fork kneaders are professional bakery machines for kneading all types of doughs (croissants, brioches, special breads, French bread, pizzas, etc.).



1.1

A Base

B Bowl brake knob

C Removable bowl, (25 litre and 45 capacity)

D Kneading tool

E Head locking lever

F Pivoting head

G Fascia

Installation

2.1 DIMENSIONS - WEIGHT (for information only)



2.1

KNEADERS	25 Litre	45 Litre
Gross weight packaged (kg)	95	97
Net weight with equipment (kg)	70	79
Net weight of optional table (kg)	16	16

Dimensions of packaging L x W x H (mm):

- Machine : 916 x 736 x 985

Dimensions of packaging:

- Table : 735 x 480 x 160



Do not put the device down, risk of oil leakage.

2.2 LOCATION

These kneaders may be fitted on:

- a **fully stable and non-resonant support** (table, unit, etc.) of between 700 and 900 mm in height and capable of withstanding a load of 110 kg. Its four adjustable feet ensure that it is perfectly stable.

- a **mobile stainless steel table** available in option (730 mm high) featuring a storage shelf.



2.1

2.3 ELECTRICAL CONNECTION

- This kneader is powered from a single phase power supply.
- A standard 2 pole + earth wall socket will be required, rated at 16 A visible and accessible for the operator.
- Check that the electrical supply voltage, the value shown on the specifications plate.
- This kneader is fitted with a filter which sends interference from the supply to earth. To be effective, the system's earth must be of good quality or the interference may go via the variator and damage it.



Must be earthed by green/yellow wire.

NO EARTH = NO PROTECTION = RISK OF FAILURE

Note: the earth values are set according to the residual differential current.

Note: The machine can only be used on TN (earthing to neutral) and TT (earthed neutral) type supplies. Where a machine has to be installed on an IT (impeding or isolated neutral) supply, there is a solution which consists of inserting an isolating transformer and locally putting on the machine on TN or TT supply.

Not following these instructions may result in the guarantee being forfeited.

- The system should be protected by an RCD and a fuse rated at 16A.



In certain cases, depending on the sensitivity of the protective differentials, the installation of SI-type (super immunity) devices may be required to prevent any accidental triggering.

- Electrical specifications:

- A :Machine
- B :Motor code
- C :PNC motor
- D :Power supply voltage
- E :Power supply frequency
- F :Nominal rating



2.3

Use, safety



Any other use than that described in this manual will not be considered normal by the manufacturer.

- The user's safety is assured by:
 - The head raising which provides the means for removing the dough in complete safety
 - Presence of the bowl in position.
 - The need to press the ON button after a stoppage ("no power" device).
 - Following these instructions for using, cleaning and maintaining the machine.

- **Control panel**  3.1

A Decrease in the timer period

B Increase in the timer period

C OFF

D ON low speed I: tempering

E Timer period display

F ON fast speed II: kneading

- The kneader can only be turned on normally if:
 - The head-screen protective assembly is in the work position.
 - The timer is set to continuous or timed operation.
 - The bowl is in the work position.

a) Continuous operation:

- Selection of — on **E** by pressing and holding down key **A**.
- Start by pressing key **D**.

b) Timed operation:

- Selection of the time on **E** by pressing keys **A** and **B**.
- Start by pressing key **D**.

Note:

. To change the time being counted down, press key **C** and then change it with keys **A** and **B** and pick up the cycle again by pressing key **D** or **F**.

. The time selected at the start of the cycle is kept in memory.

. To stop a cycle in progress permanently, press twice on key **C**

c) Speed selection:

- Always start by pressing key **D** for tempering, then press key **F** for kneading

d) Stopping:

- Preferably use button **C**, then raise the screen-head assembly.

3.2 POSITIONS OF THE HEAD AND THE GUARD

The head of the kneaders is attached to the base by means of a hinge which means that two positions are possible:

- 1) Work position**, with the head and guard lowered for mixing - kneading.



3.2a

- 2) Raised position**, with the head in the rear position against the stop so that the bowl may be filled, the dough removed or the bowl cleaned.



3.2b

3.3 OPERATING MODE

1) To raise the head:

- Release the lever with your left hand, pushing it towards the rear and slowly raise the head of the kneader with your right hand by means of the screen handle until it reaches the rear stop.



3.3a

2) To lower the head:

- Release the lever by pushing it towards the rear and slowly lower the head with your right hand, holding the screen handle until on the stop.



3.3b

Note: If there is some dough left in the bowl, turn the bowl slightly to move the dough clear of the tool and thus make it easier to close.

3.4 ADJUSTMENT OF THE BOWL BRAKING 3.4

When turning in the dough, the tool drives the bowl in an anti-clockwise (↺) direction.

To reduce the speed of rotation of the bowl, turn the brake knob slightly in a clockwise (↻) direction (+ direction) so as to adjust it to the desired speed.

Turn the brake knob in an anti-clockwise (↺) direction to release the bowl.

3.5 FITTING - REMOVING THE BOWL 3.5

The removable bowl of the kneader is useful when working with poolish and facilitates cleaning.

Removal:

- Raise the head of the kneader (see § 3.3.1).
- Turn the two prongs of the tool to the horizontal position.
- Raise the bowl vertically.

Fitting:

- Tighten the brake knob to avoid any rotation (see § 3.4).

- Centre the bowl on its spindle and ensure that the drive pin is located in the cavity of the bowl.

Note: When the bowl is fitted correctly, it should sit on the drive ring.

- Loosen off the brake knob.
- Check that the bowl turns freely.

3.6 KNEADING CAPACITIES

The quantities that the BPO can take depend on the flour quality, its hygrometry and its degree of hydration.

In particular it is necessary to reduce the quantities of flours that have a high gluten content (W above 200).

Similarly when the hygrometry or degree of hydration is low, the amount of flour must be reduced.

• Too large a quantity is always detrimental to the quality of the work and the life of the mechanical parts of the beater. Reduce the quantities worked with when the moisture content is reduced, or (and) when the strength of the flour is increased (W above 200).

Percentage hydration of the different types of dough:

- "Firm" dough (cold water paste, pizza, croissants, leaven, etc.) 40 to 55 %
- "Medium" doughs (French bread, brioche, etc.) 55 to 60 %

- "Soft" doughs (special breads, poolish, etc.) over 60 %
- The table below gives information for baker's flour of type 55-65 and of strength W less than or equal to 200, stored in sacks.

KNEADERS	25 LITRES			45 LITRES		
	40 to 55	55 to 60	>60	40 to 55	55 to 60	>60
Percentage d'hydratation (%)						
Flour (Kg)	5	6	8	10	12	15
Liquids (L)	2,5	3,5	5	5	7	9
Dough (Kg)	7,5	9,5	13	15	19	24

3.7 CHOICE OF SPEEDS 3.7

1. Low mixing speed in rpm
 2. High kneading speed in rpm.
- **Always start mixing in low speed, which avoids clouds of flour from being given off.**

- As soon as the mixture is consistent (between 2 and 4 minutes, depending on the dough and the percentage hydration), change to the high speed 2 for kneading.



- Stop the machine in low speed
- Never introduce a hard object into the bowl when in operation

Cleaning and hygiene

4.1 AFTER USE

- Scrape the inside of the bowl to get rid of any crusts. Avoid using metal scrapers as they may scratch the bowl.
- Clean the bowl and the tool with a damp sponge and detergent - disinfectant.



Never use detergents containing chlorine, as they will blacken the aluminium.

- Carefully rinse and wipe.
- If necessary, remove any dust from the outside of the machine with a brush or a vacuum cleaner.

4.2 PERIODICALLY (AT LEAST ONCE A MONTH)

- Clean the outside of the machine with a non-abrasive detergent
- If necessary, unblock the ventilation holes at the back of the head



Do not clean the machine with a pressure cleaner.

4.3 STRAY FLOUR PARTICLES:

In order to reduce the emission of stray flour particles while loading the bowl, it is recommended as follows:

- Empty the flour bag or the container containing the flour without shaking it.
- Use a long flour chute which goes down to the bottom of the bowl

- Pour in the water before putting the flour in if that is possible
- Always start at slow speed during the water/flour mixing for at least 2 minutes
- Do not shake an empty flour bag. Roll it with care.

Keeping to these simple rules will contribute to reducing the emission of flour dust and consequently reducing the risks of allergy linked to that dust.

Fault finding

5.1 THE MACHINE WILL NOT START, CHECK THAT:

- The machine is plugged in.
- The electrical power supply to the socket is correct.
- The head is locked in place and the bowl in position.
- The timer is in the timer or continuous operation position.

5.2 ABNORMAL NOISES

Metallic noise:

- distorted tool that is rubbing, free the tool (see § 6.4).

Lack of power:

- The capacities are too great (see §3.3). Reduce the quantity of flour, increase the hydration, loosen the bowl brake, etc.

- Incorrect supply voltage causing abnormal overheating of motor.



If the problem persists, contact the service department of your local dealer.

5.3 POOR MIXING

Flour remains in the bottom of the bowl: the tool arms are too far away from the bowl (normally < 5mm). Adjust the tool (see § 6.5)

5.4 POOR KNEADING

The dough is torn while being worked or does not roll around the tool:

- 1) There is insufficient hydration.
- 2) The bowl brake is too tight: adjust the brake so that there is no tearing while working.

3) Quantity too great or too little.

4) The tool is too close to the edge of the bowl: adjust the head/bowl position (see § 6.5).

Maintenance

6.1 ELECTRICAL



Always disconnect the machine before any intervention on it.

- Check the condition of the cable of the electrical components regularly.

- It is recommended that at least once a year the rear plate is removed to check the condition of the electrical connections.

- Access to the electrical components
- Unplug the machine

6.3 VERIFICATION OF THE SAFETY DEVICES

- Check that the safety devices are operating correctly on a regular basis. The motor should stop when the guard is opened and should not re-start if the bowl is not in place.

If these functions do not work:

- Do not use the machine
- Have it adjusted by the service department of your local dealer.

Head raising safety device:  **6.3**

Adjustment:

- Loosen the screw which retains the sensor
- Turn the sensor support slightly so that the cut is higher or lower, as desired (50 mm max. between the edge of the bowl and the safety screen).

6.4 CHANGING THE TOOL

- Unplug the machine.
- Loosen off the 2 screws (5 mm Allen key).
- Remove the tool.


Note: If the tool cannot be easily extracted:

- Remove the hub plug.
- In its place, fit a HM 10 x 50 screw and screw it in until the tool comes out.

Refitting the tool

- Line up the flat on the shaft with the flat of the 2 screws.
- Mount the tool on the shaft.
- Lock in position with the 2 screws.
- Check that the tool operates correctly in the bowl.

6.5 POSITIONING OF THE HEAD/BOWL

1) Lateral adjustment: the tool arms should leave an identical space with the outside wall and the centre part of the bowl. If not, proceed as follows:  **6.5a**

- Push the kneader back against its rear stop.
- Unscrew the 4 base-plate screws (7 mm hex spanner)
- Loosen the 4 screws **A** (13 mm hex spanner)

Note: 25 l model unscrew the 4 lock-nuts.


- Re-centre the bowl.
- Re-tighten the screws.

2) Vertical adjustment: if the prongs of the tool touch or go too far into the base of the bowl (Distance > 5mm), proceed as follows:



- Put the head in the raised position.
- Unscrew the lock-nut **B** (13 mm hex spanner).
- Tighten or loosen screw **B** until a distance of 5mm is obtained between the bowl bottom and the tool arms

Note: if the stop is too short, the locking will need to be adjusted.

3) Locking adjustment  **6.5c**

- Unscrew the 4 head closing plate retaining screws **C**.
- Unscrew the lock-nuts and screws **D** (13 mm hex spanner).
- Note: the locking lever touches the stop*
- Move the locking plate **E** as far to the front of the kneader as possible.
- Re-tighten the screws **D** and the lock-nuts, then the 4 head closing plate retaining screws **C**.

6.6 CHANGING THE BOWL BRAKE PADS

- Push the kneader back against its rear stop.
- Unscrew the 4 base-plate screws (7 mm hex spanner).
- Unscrew the 2 screws F (13 mm hex spanner).
- Change the brake pad and re-assemble.

6.8 ADDRESS FOR SERVICE REQUIREMENTS

We advise you to contact the dealer who sold you the machine.



For any information or orders for spare parts, specify the type of machine, its serial number and the electrical characteristics.

The manufacturer reserves the right to modify and make improvements to the products without giving prior warning.

Dealer's stamp


Date of purchase.....

Conformity with regulations

The machine has been designed and manufactured in conformity with:

- Machine directive 2006/42 EEC
- The CEM directive 2014/30/ EU
- 2011/65/EU Directive on the restriction of the use of certain hazardous substances

2002/96/CEE « WEEE »

The symbol «  » on the product indicates that this product may not be treated as household waste. Instead it shall be handed over to the applicable collection point for the recycling of electrical and electronic equipment. By ensuring this product is disposed of correctly, you will help prevent potential negative consequences for the environment and human health, which could otherwise be caused by inappropriate waste handling of this product. For more detailed information about recycling of this product, please contact the sales agent or dealer for your product, your after-sales service, or the appropriate waste disposal service.

2006/12/CEE "Waste"

The machine is designed so that it does not contribute, or as little as possible, to increasing the quantity or harmfulness of the waste and the risks of pollution.

Make sure to observe the recycling conditions.

94/62/CEE "Packaging and packaging waste"

The packaging for the machine is designed so that it does not contribute, or as little as possible to increasing the quantity or harmfulness of the waste and the risks of pollution.

Make sure to eliminate the various parts of the packaging in appropriate recycling centres.

- To the European standards:

EN 453- kneaders. Safety and hygiene regulations

This conformity is certified by:

- The CE conformity mark, attached to the machine
- The corresponding CE declaration of conformity, associated with the warranty.
- This instruction manual, which must be given to the operator.

Acoustic characteristics:

- The acoustic pressure level measured in conformity with the EN ISO 3743.1-EN ISO 3744 <70 dBA.

Protection indices as per the EN 60529-2000 standard:

- IP55 electrical controls
- IP23 overall machine

Integrated safety

- The machine has been designed and manufactured in compliance with the relevant standards and regulations, mentioned above.
- Before using the machine, the operator must be trained to use the machine and informed of any possible residual risks (personnel work station training obligation).

Food hygiene:

The machine is made from materials that conform to the following regulations and standards:

- directive 1935/2004/EEC: materials and objects in contact with foodstuffs
- EN 601- standards: cast aluminium objects in contact with foodstuffs

The surfaces of the food area are smooth and easy to clean. Use detergents that are approved for food hygiene and respect the instructions for their use.