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## 2.1- ADVISING NOTE

### STOPPED MACHINE:

It is compulsory to dissect the electric feeding , to be sure the machine is really stopped and the start doesn't happen before any adjustment on the machine.

### OPERATOR:

16 aged operator qualified for exclusively executing the machine in use , the functioning and the machine not in use following carefully the instructions herewith enclosed.

### MECHANIC OPERATOR:

Qualified technician for exclusively executing interventions on the mechanic parts.

### ELECTRIC OPERATOR:

Qualified technician (technician in the possession of the technical professional requirements demand by the country in which the machine is put into use), for exclusively executing interventions on electric parts with electric tension too.

## 2.2- GUARANTEE

The guarantee of the machine lasts 12 (twelve) months from delivery date. All electrical parts , motors and tools are excluded from guarantee. As guarantee the construction firm intends the replacement of the broken parts.

**THE TAMPERING ESPECIALLY TO THE SAFETY DEVICES AND THE SUBSTITUTION OF SPARE PARTS WITH NOT ORIGINAL PIECES ,WILL MAKE THE GUARANTEE EXPIRE AND FREE THE BUILDER FROM ANY RESPONSIBILITY.**

## 2.3- COPYRIGHT

The copyright of this operating and maintenance manual remains the property of the construction firm.

No part of this manual must be reproduced and diffused ( completely or partially ) in any means without writing authorisation from the manufacturer.

## 3.1- DENOMINATION

The machine is named as follow: **DOUGH SHEETER**

**500 B**= Bench dough sheeter with 488 mms width fixed working planes;

**500**= Dough sheeter with 488 mms width fixed working planes;

**500 EX**= Dough sheeter with 488 mms width extractable working planes;

**600**= Dough sheeter with 588 mms width extractable working planes;

**MOD. / 1000** The length of the working planes is represented by the number which follows the model abbreviation.

## 3.2- NAME-PLATE CE

The red aluminium name-plate CE is attached by four reverts as shown on Fig.1. On the name-plate CE are written the following data :

- Name and address of manufacturer;
- CE;
- Model (MACH. TYPE);
- Matricula number (MACH. N°);
- Month and year construction (DATE);
- Electric power (kW);
- Starting pick up (A);
- Voltage (V);
- Phases (PHASE);

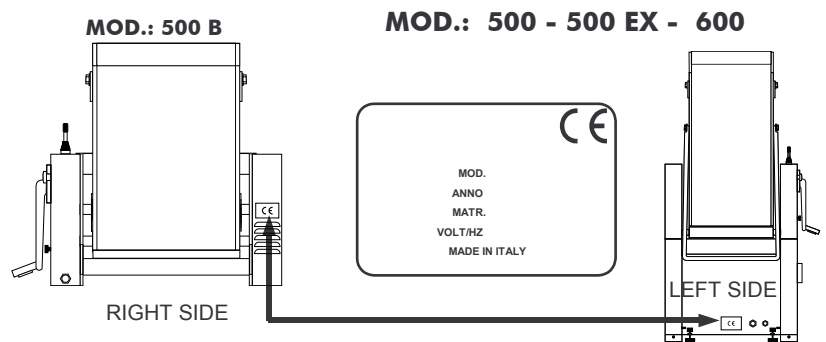
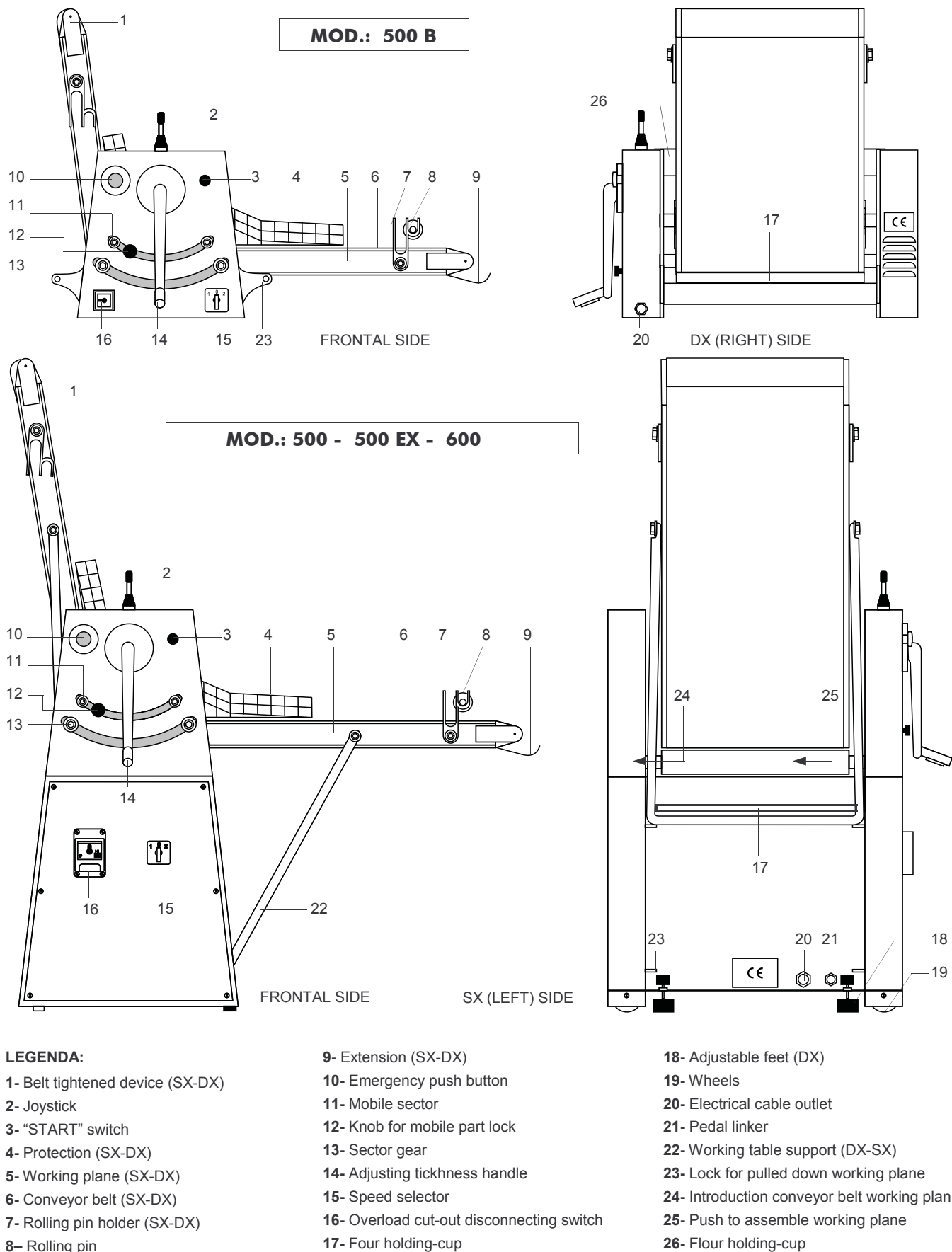


FIG.1 ( CE LABEL)

### 3.3- DESCRIPTION OF COMPONENTS



**FIG.2** (Components description)

### 3.5- TECHNICAL DATA

		500 B	500	500 EX	EASY 600
Rolling thickness	mm	0,1 ÷ 34			
Acoustic pressure	dBA	<70			
Operation temperature	°C	+10 ÷ +40			
Max operation humidity		90%			

TAB.2 (TECHNICAL DATA)

### 3.6- ELECTRICAL DATA

		500 B		500		500 EX		600	
		1SPEED	2SPEED	1SPEED	2SPEED	1SPEED	2SPEED	1SPEED	2SPEED
FEEDING ELECTRICAL VOLTAGE	VO	230 / 400							
FREQUENCY	HZ	50							
ELECTRICAL POWER	K	0.55	0.37/0.55	0.75	0.6 / 1.1	0.75	0.6 / 1.1	0.75	0.6 / 1.1
PHASES		1 / 3			3				
STEADY CONSUMPTION 400 V. - 3 PH	A	1.8	1.4 / 1.6	2.2	2.4 / 2.8	2.2	2.4 / 2.8	2.2	2.4 / 2.8
STEADY CONSUMPTION 220 / 230 V. -	A	3	2.4 / 2.7	3.8	3.8 / 4.2	3.8	3.8 / 4.2	3.8	3.8 / 4.2
STEADY CONSUMPTION 230 V. - 1 PH	A	3.8	/	5.8	/	5.8	/	5.8	/
MOTOR	HP	0.75	0.5 / 0.75	1	0.8 / 1.5	1	0.8 / 1.5	1	0.8 / 1.5

TAB.3 (ELECTRICAL DATA)

### 3.7- CONVEYOR BELTS SPEEDS

		500 B		500		500 EX		600	
		Inside	Outside	Inside	Outside	Inside	Outside	Inside	Outside
1 speed machine	m/min.	12,2	22,5	14	25	14	25	18	30,7
2 speeds mach. 1st	m/min.	8	15.5	10	18,3	10	18,3	11,5	21,4
2 speeds mach. 2nd	m/min.	18	33.8	20,6	36,9	20,6	36,9	24,4	42,7
VAR 1st	m/min	/	/	11	20	11	20	9	16
VAR 2nd	m/min	/	/	23	41	23	41	20	36
VAR 3rd	m/min	/	/	34	62	34	62	31	52
VAR	m/min	/	/	0-34	0-62	0-34	0-62	0-31	0-52

TAB.3 (CONVEYOR BELTS SPEEDS)

### 3.8- USE DESTINATION

THE DOUGH SHEETER HAS ONLY BEEN DESIGNED AND MANUFACTURED PRINCIPALLY TO ROLL OUT DOUGH FOR FOODSTAFF USE FOR BAKERIES, "PASTA" FACTORIES ,CONFECTIONER'S AND PIZZAS.

### 3.9- LIMITATION IN USE

THE MACHINE HAS EXCLUSIVELY BEEN DESIGNED FOR ITS USE AS SHOWN IN REF. 3.8. IT IS ABSOLUTELY FORBIDDEN TO USE IT IN ANY WAY OTHERWISE STATED, SO AS TO GUARANTEE THE GENERAL SAFETY OF IT ALWAYS.

### 3.10- FITTING BY REQUEST

- 1- Double pedal control system (changing way of belts' run);
- 2- "Croissant" cutter system

### 4.1- TRANSPORTATION AND LIFTING

The packed machine can be moved by an elevator respecting the following rules:

**DURING THE TRANSPORTATION AND LIFTING OF THE MACHINE ENSURE THAT IN THE AREA OF THE MANOEUVRE THERE ARE NO PERSON , ANIMALS AND THINGS WHICH MAY PROVOKE ACCIDENT.**

**DURING THE TRANSPORTATION AND LIFTING OF THE MACHINE BY THE ELEVATOR , PREVENT ABRUPT STOP, ACCELERATION AND UNEXPECTED CHANGE IN DIRECTION .**

- 1- The transportation and lifting of the machine must be performed with suitable elevator for its weight and dimensions (see TAB.1-3.5- TECHNICAL DATA);
- 2- Place as shown in FIG.4 and carefully insert the forks of the elevator in the spaces of the pallet, making sure that the forks get out from the opposite part on the fore (FIG.4);
- 3- Lifting carefully the machine down till the floor and take the forks out.

### 4.2- MANUAL TRANSPORTATION

- 1- Take the packing (cardboard) away and by a cutter cut the fastened bands;

**TO TAKE THE MACHINE FROM THE PALLET AWAY IT IS COMPULSORY THE EMPLOYMENT OF TWO OPERATORS WHO MAKE CAREFULLY THE MACHINE GET DOWN RAISING IT.**

- 2- After it the machine can be manually moved nby the four wheels assembled on the stand;

**THE MANUFACTURING FIRM DECLINES RESPONSIBILITY OF ANY DAMAGE TO PERSONS , ANIMALS AND THINGS CAUSED , DURING THE LIFTING OPERATIONS AND IN THE AREA OF THE MANOEUVRE OF THE MACHINE, BY THE INOBSERVATION OF RULES, REGULATIONS AND DIRECTION DESCRIBED .**

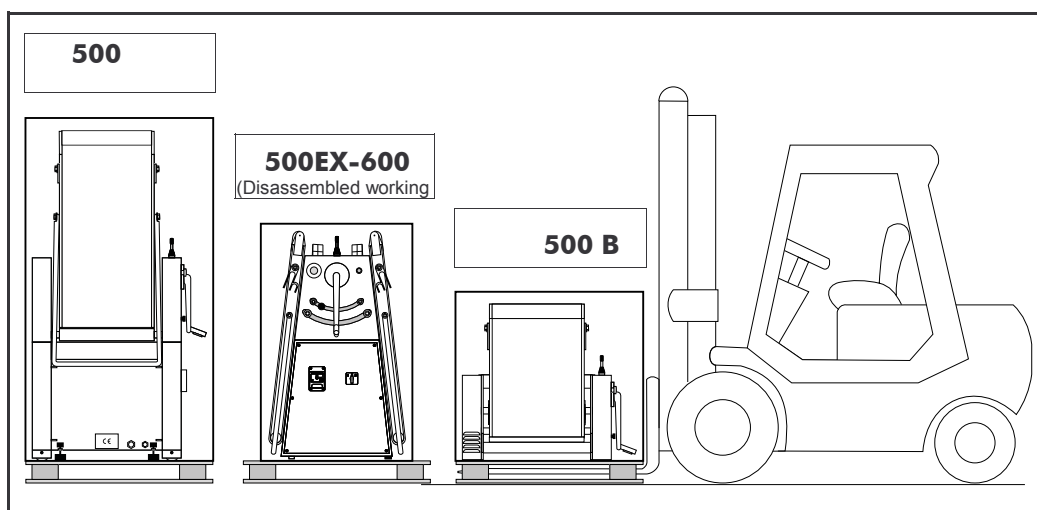


FIG.4 (MOVIMENTATION BY ELEVATOR - PACKED MACHINE ON PALLET)

## 5.1 - POSITIONING

The machine must be positioned on a close and dry place, placed on a suitable floor that can carry its weight (3.5- TECHNICAL DATA – TAB.1) and its dimensions (3.4-MACHINE DIMENSIONS – FIG.3).

After positioning the machine, be sure the feet rest on the floor (FIG.2-Rif.18).

**IT IS COMPULSORY TO RESPECT THE MINIMUM MEASUREMENTS AS SHOWN ON FIG.5, TO GRANT AN EASY AND SURE ACCESS TO THE OPERATOR.**

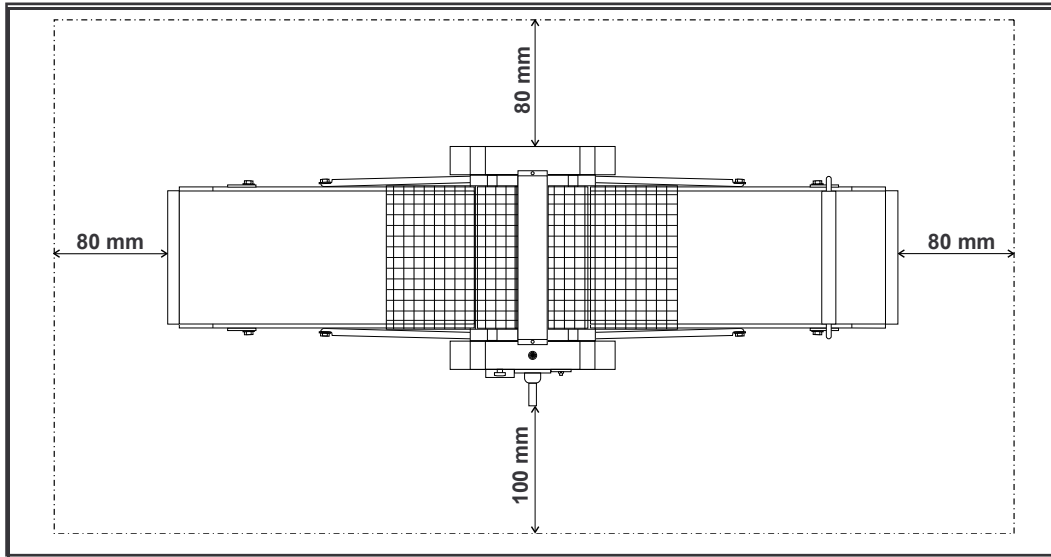


FIG.5 (MINIMAL MEASUREMENTS OF POSITIONING)

The dough sheeter is provided with electrical cable positioned at the back-side and it is without plug (FIG.1). The electrical data is shown on the name-plate CE

**THE ELECTRICAL CONNECTION OF THE MACHINE TO THE ELECTRICAL NETWORK MUST BE EXECUTED BY A QUALIFIED TECHNICIAN WHO IS IN THE POSSESSION OF TECHNICAL-PROFESSIONAL REQUIREMENTS DEMANDED BY THE COUNTRY IN WHICH THE MACHINE IS PUT INTO USE. THE TECHNICIAN MUST ISSUE A WRITTEN CONFORMITY DECLARATION OF THE WORK DONE.**

THE MANUFACTURING FIRM DECLINES RESPONSIBILITY OF ANY DAMAGE TO PERSONS, ANIMALS AND THINGS CAUSED BY INCORRECT ELECTRICAL CONNECTION.

## 5.2- ASSEMBLING OF WORKING PLANES (MOD. EASY 500 EX - EASY 600)

The dough sheeters MOD. EASY 500 EX - EASY 600 (extractable working planes) are delivered with disassembled working planes. To assemble the working planes it is compulsory the employment of two operators.

Lift carefully the working planes up and in parallel position to the floor, insert firstly the conveyor belt roll (conic part with spring) in the back shoulder of the machine (FIG.2-Rif.24) and at the same time push the working plane in the some direction of introduction (FIG.2-Rif.25).

## 6.1 - DIRECTIVES AND RULES

THE MACHINE OF THE CONSTRUCTION FIRM IS DESIGNED MANUFACTURED AND CONFORM TO THE FOLLOWING DIRECTIVES :

**89/392 EEC:** "Machine directive and following changes : 91/368 CEE - 93/44 CEE - 93/68 CEE" (Codified version: 98/37/CE) -

**73/23 EEC:** " Low voltage"

**EN 60204-1:** "SAFETY OF THE MACHINE: ELECTRIC EQUIPMENT OF THE MACHINE".

**EN 292-1-2:** "Base concepts for the machine safety and general principles for planning".

**EN 294:** "Safety distance to avoid the reach of dangerous zones with upper limbs".

**EN 349:** "Minimum distance to avoid the crushing of body parts".

## **6.2- SAFETY DEVICES**

### **1- EMERGENCY BUTTON**

THE EMERGENCY BUTTON IS PLACED ON THE CONTROL PANEL-BOARD (**FIG.1-RIF.10**); IT IS A HEAD AND HOLDING BUTTON ( RED WITH A YELLOW CIRCLE AT ITS BASE) AS PRESCRIBED BY THE REGULATIONS. SETTING THE EMERGENCY BUTTON , THE CONVEYOR BELT AND THE ROLLING CYLINDERS STOP IMMEDIATELY.

### **2- GUARDS (SX-DX)**

The guards are made of plasticized wire steel wires (**FIG.1-Rif.4**), hinged on the shoulders of the machine to prevent the access to the rolling cylinders area . They are provided with two microswitches which immediately stop the machine lifting the guards up

**IT IS COMPULSORY TO CUT OFF THE PLUG OF THE MACHINE FROM THE ELECTRIC FEEDING SOCKET BEFORE LIFTING THE GUARDS UP TO CLEAN THE ROLLING CYLINDERS AND TO MAINTAIN .**

### **3- OVERLOAD CUT-OUT DISCONNECTING SWITCH**

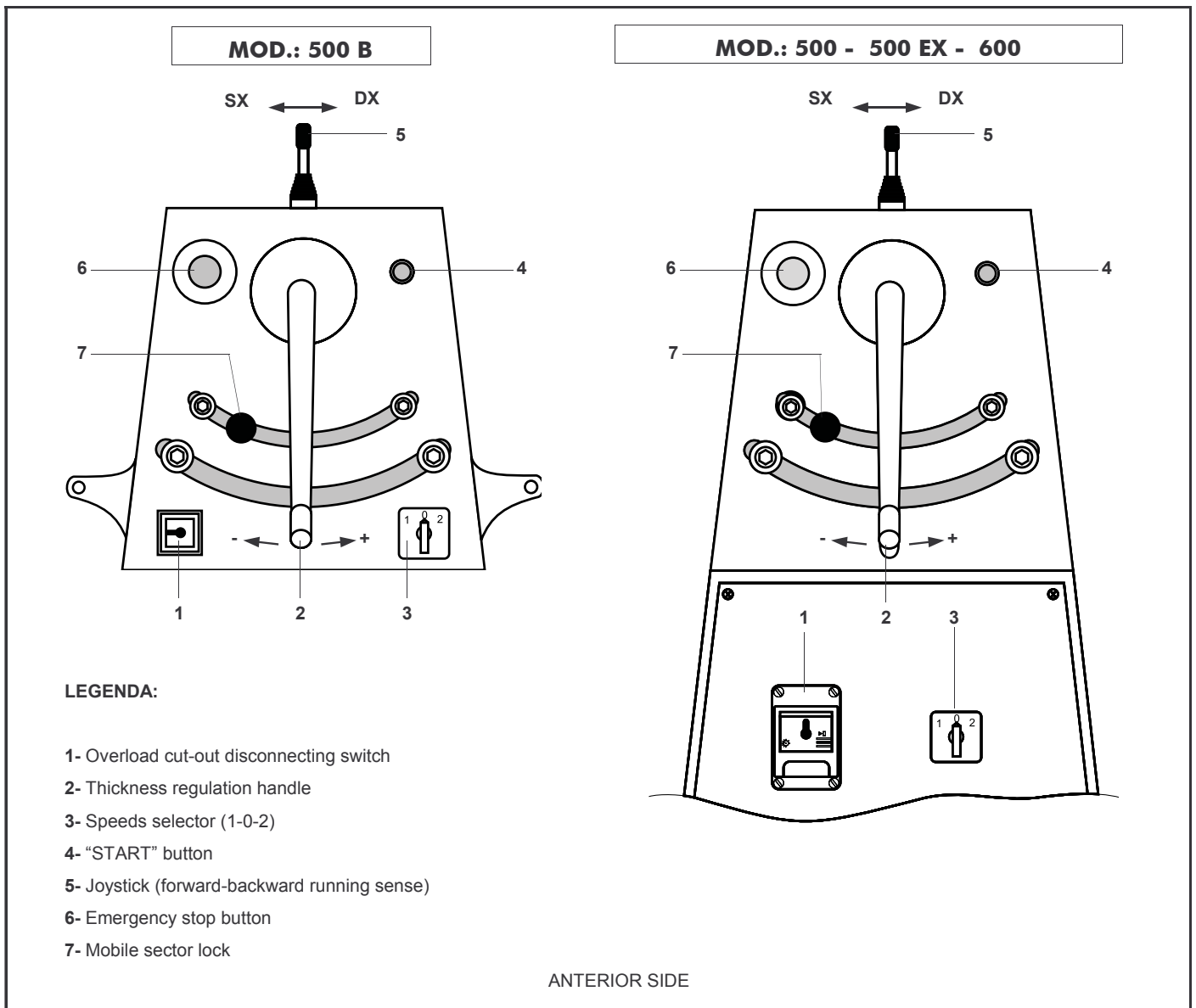
IT IS A MAGNETOTHERMIC SWITCH WHICH IN CASE OF A SHORT-CIRCUIT AND OVERLOAD DISSECTS THE ELECTRIC POWER OF THE MACHINE MOVING AUTOMATICALLY IN "OFF" POSITION.

**IT IS ABSOLUTELY FORBIDDEN TO MANIPULATE (EXCLUDING REMOVAL) ANY SAFETY DEVICE IN THE MACHINE.**

**IT IS ABSOLUTELY FORBIDDEN TO SUBSTITUTE ANY SAFETY DEVICE OR ITS COMPONENTS WITH PART WHICH ARE NOT ORIGINAL.**

## 7.1- CONTROL PANEL

On the control panel , put on the anterior side of the machine (**FIG.8**) , there are all the switches to use the machine



**FIG.8** (Control panel)

## 7.2- OPERATIONS BEFORE PUTTING THE MACHINE IN USE

The operator, according to the type of dough sheeter, has to execute the following operations ,before putting in use the machine :

### MOD.: 500 B (bench model)

1- Unhook by the hooks the **working planes** (SX-DX) (**FIG.2-Rif.5**) and manually and carefully lift them down till the locks (**FIG.2-Rif.23**)

### MOD.: 500 - 500 EX - 600

1- Unhook by supports (**FIG.2-Rif.22**) the **working planes** (SX-DX) (**FIG.2-Rif.5**) and manually and carefully lift them down till their locks (**FIG.2-Rif.23**);

### MOD.: ALL MODELS

2- Lift the **protections** down (SX-DX) (**FIG.2-Rif.4**). For the LMP600BF model push the protections to the back side of the machine to free them from the lock screw.

3- Put the rolling pins (**FIG.2-Rif.8**) on their rolling-pin-holder (**FIG.2-Rif.7**);



- 4- Extract the extensions of the working planes (FIG.2-Rif.9);
- 5- **(Accessory by request)** Connect by the pedal linker (FIG.2-Rif.21) the forward-backward running sense pedal ;
- 6- Be sure the **overload cut-out disconnecting switch** (FIG.8-Rif.1) is in "OFF" position and the **speed selector** (FIG.2-Rif.3) in "0" position;
- 7- Insert the **plug** in the machine electrical connection to the electrical main supply.

### 7.3- MACHINE IN USE

Putting the machine in use can be carried out by an operator respecting scrupulously the following sequence of operations and only after executing the operations before putting the machine in use:

- 1- Give tension to the machine rotating the **overload cut-out disconnecting switch** (FIG.8-Rif.1) in "ON" position ;
- 2- By the **speeds selector** (FIG.8-Rif.3 - 1-2 position) set up the chosen speed ;
- 3- By the **handle** (FIG.8-Rif.2) regulate the thickness of the dough (FIG.8-Rif.2);
- 4- Start the machine pressing the "START" switch (FIG.8-Rif.4);
- 5- By the **joystick** (FIG.8-Rif.5) choose the direction of the conveyor belts joystick (FIG.8-Rif.5);
- 6- Lean the dough on the right-left working plane and start the cold-rolling process (more passages at different thickness);
- 7- Once reach the chosen thickness of the dough , put the **speed selector** (FIG.8-Rif.3) on "0" position (stand-by = the conveyor belts and the cylinders are stopped) **and take the sheet away.**

**N.B.** According to the type and the long of the dough it is possible to roll it up on the rolling pins.

### 7.4- EMERGENCY STOP

The emergency stop can be done by pressing the emergency switch on the control panel (FIG.8-Rif.6).

To avoid dangerous situations the operator has to:

- 1- Press opportunely the **emergency switch** (FIG.8-Rif.6).;
- 2- Switch machine off by turning the **overload cut-out disconnecting switch** (FIG.8-Rif.1) and the **selector speeds** (FIG.8-Rif.3) on "0" position ;
- 3- Point out directly the emergency to the Safety responsible.

### 7.5- MACHINE IN USE AFTER AN EMERGENCY STOP

**N.B.** The sudden breaking in electric feeding of the machine (lacking of current) is to be considered as an emergency stop.

Disconnect the **emergency switch** (manual rearmament) and follow the instructions on PAR.7.3- MACHINE IN USE only and exclusively after removing the causes and after controlling these causes didn't provoke damages to the machine .

### 7.6- MACHINE NOT IN USE

The operator can put the machine not in use following the instructions:

- 1- Switch the machine off turning the **overload cut-out disconnecting switch** (FIG.8-Rif.1) and the **selector speed** (FIG.8-Rif.3) on "0 position";
- 2- **Unplug** from the socket.

## 8.1- GENERAL AND MAJOR MAINTENANCE

Daily:

- Verify the correct running of the protection guards and the emergency switch
- Check the electric feeding cable and the plug.
- Clean generally the dough sheeter (Par.8.2).

- Clean the scrapers (Par.8.2).

**After 100 hours working and yearly :**

-Tighten and grease the transmission chains.

**As required change the conveyor belt.**

**IT IS COMPULSORY OUT ANY MAINTENANCE OR CLEANING OPERATIONS TO UNPLUG FROM THE SOCKET**

**AT THE END OF THE OPERATION CHECK THAT THE PROTECTION PANELS PREVIOUSLY REMOVED ARE ASSEMBLED AND FIXED LIKE ORIGINALLY.**

## **8.2- GENERAL CLEANING**

For the hygiene of the machine it is necessary to clean body of the machine ( external part), so as to prevent from any flour masses or dirty from the surfaces. The products to be used for that cleaning are the usual detergents for domestic usage. Avoid to use water with conveyor belts, cylinders and all inside parts in touch with flour.

## **8.3- SCRAPERS CLEANING**

It is daily necessary clean the external part of the scrapers ,for a correct working of the machine.

It is weekly necessary clean the other parts.

Herewith enclosed how to disassemble the scrapers:

1) LOWER SCRAPERS:

a) lift the working planes (FIG.1-Rif.5) and unhook the anchorage springs which stay under the belts.

b) let down the working planes (FIG.1-Rif.5) and take out the scrapers with its support.

2) UPPER SCRAPERS:

a) put the planes (FIG.1-Rif.5) in the working position and unscrew the 2 knobs which fix the inox steel section;

b) lift the scrapers-unit and take it out from the chromium cylinder

3) SCRAPERS CLEANING:

Clean the scrapers removing the meal and the dough by using not toxic detergent and rinsing abundantly.

4) ASSEMBLE THE SCRAPERS:

Assemble the scrapers, following the inverse procedure.

## **9.1- DEMOLITION**

Observe the prescribed rules/norms in force concerning demolition.

At the time of the demolition of the oven, separate the parts that constitute the oven according to the different types of materials used in construction (plastic, copper , iron, etc.).

It is absolutely forbidden to discharge in the ambient lubricant fluids .

These products must be drained by specialised companies..

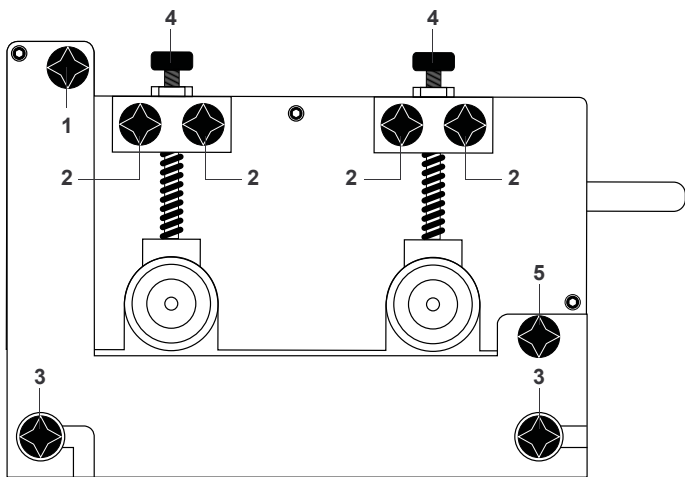
## 10- DISPOSITIVO PER IL TAGLIO CROISSANT SOLO PER MOD 600

-CUTTER DEVICE ONLY FOR 600 MODEL

-DISPOSITIF DECOUPOIR SEULEMENT POUR MOD.600

-VORRICHTUNG FÜR DAS CROISSANT-SCHNEIDEN NUR FÜR 600 MOD

-DISPOSITIVO PARA EL CORTE DE CROISSANT PARA MOD.600



LATO ANTERIORE - (Posizione di taglio) ANTERIOR SIDE - (Cut position)  
 COTE ANTERIEUR - (Position de découpe) VORDERSEITE - (Schnittstellung)  
 LADO FRONTAL - (Posición de corte)

### LEGENDA:

- 1- Manopola di fermo per la posizione di riposo
- 2- Manopola di fissaggio blocchetto dispositivo di regolazione
- 3- Manopola di fissaggio al piano di lavoro
- 4- Manopola di regolazione spessori per rulli
- 5- Manopola di fermo per la posizione di taglio

### LEGENDA:

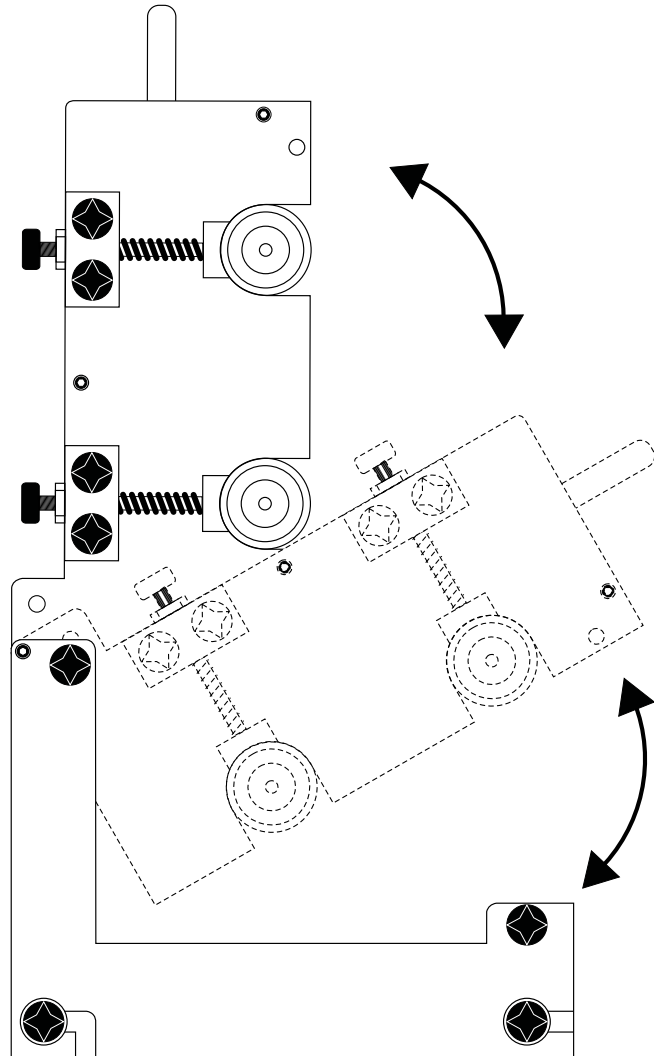
- 1- Lock knob for rest position
- 2- Fixing knob for adjustment device
- 3- Fixing knob to the working plane
- 4- Adjustment knob for cylinders thickeners
- 5- Lock knob for cut position

### LEGENDE:

- 1- Vis d'arrêt pour la position de repos
- 2- Vis de mise en place du bloc dispositif de régulation
- 3- Vis de mise en place au plan de travail
- 4- Vis de régulation épaisseurs pour rouleaux
- 5- Vis d'arrêt pour la position de découpe

### LEGENDE:

- 1- Haltevorrichtungshandgriff für die Ruhestellung
- 2- Handgriff für die Befestigung des Regelungsvorrichtungsendmaßes
- 3- Handgriff für die Befestigung der Arbeitsebene
- 4- Handgriff für die Befestigung der Rollendistanzscheiben
- 5- Haltevorrichtungshandgriff für die Schnittstellung



LATO ANTERIORE - (Posizione di riposo) ANTERIOR SIDE - (Rest position)  
 COTE ANTERIEUR - (Position de repos) VORDERSEITE - (Ruhestellung) LADO FRONTAL - (Posición de reposo)

### LEYENDA

- 1- Sujeción para la posición de reposo
- 2- Fijador bloque dispositivo de regulación
- 3- Sujeción a la superficie de trabajo
- 4- Regulador espesores rodillos
- 5- Sujeción para la posición de corte

**FIG.9** (DISPOSITIVO PER IL TAGLIO -CUTTER DEVICE- -DISPOSITIF DECOUPOIR -VORRICHTUNG FÜR DAS CROISSANT-SCHNEIDEN - DISPOSITIVO PARA EL CORTE)