



CONICAL DOUGH ROUNDING MACHINE INSTALLATION AND USER MANUAL





CONICAL DOUGH ROUNDING MACHINE INSTALLATION AND USER MANUAL

TABLE OF CONTENTS

1 PREAMBLE	7
1.1 Guidance Identification Data	8
1.2 Manual Usage	8
2 CUSTOMER SUPPORT	9
2.1 Worldwide Customer Service	9
2.2 Technical Assistance Request Instruction	9
2.3 After Sales Service	9
2.4 Instruction for Ordering Spare Parts	10
2.5 Service Products	10
2.6 Customer Training	10
2.7 Manufacturer's Identification Data	11
3 USAGE	12
3.1 Proper Usage	12
3.2 Misusage	13
3.3 Security Problems	13
3.4 Limitation of Liability	13
4 MACHINE TESTING AND ACCEPTANCE	14
4.1 Commissioning the Product	14
4.2 WARRANTY	15
4.3 Non Covered by Warranty	16
5 GENERAL SAFETY	17
5.1 Safety Instructions	17
5.2 Operational Safety	18
5.3 Safety And Accidental Prevention	19
5.4 Risks Related to the Machine Type	20
5.5 Electric Shock Risk	20
5.6 Accepted Solutions for Security Issues	20

5.7 Emergency Stop Buttons	21
5.8 Warning And Caution Sign	22
5.9 Personnel Protective Equipment	23
6 TRANSPORTION.....	24
6.1 General Rules for Unpacking the Machine	24
6.2 Load Structure.....	24
6.3 Transportation of the Product	25
6.4 Manufacturing Design	26
7 GENERAL.....	27
7.1 General Warning.....	27
7.2 Rules Regarding the Stocking of the Machine	27
7.3 Equipment and Tools Required for Moving and Lifting the Machine	27
7.4 Mounting the Product	28
7.5 Mounting Instructions.....	28
7.6 Electrical Installation	29
8 REMOTE CONTROL ELEMENTS	30
8.1 Use of the Control Panel.....	30
9 DESCRIPTION OF THE MACHINE	31
9.1 Dough Spinning Process	31
9.2 Product Label	32
9.3 Parts of the Machine	33
9.4 Technical Specifications of the Machine	34
9.5 Dimensions of the Machine	35
9.6 Body Parts List	36
9.7 Spiral Connecting Rods Parts.....	37
9.8 Aluminum Hopper Parts	38
9.9 Rotation System Parts	39
10 MAINTENANCE	40
10.1 Maintenance Instruction	40
10.2 Weekly Maintenance.....	41
10.3 Monthly Maintenance	41
11 CLEANING THE MACHINE	42
11.1 General Cleaning Rules.....	42
11.2 Daily Cleaning.....	42
11.3 Matters to be Considered in the Use of the Product	43
11.4 Care for the Lifetime of the Product.....	43
12 ELECTRIC PROJECT	44



CR CONICAL DOUGH ROUNDING MACHINE INSTALLATION AND USER MANUAL

Manual Version
CR v2.4 - 2022/01 - **EN**

1 PREAMBLE

This instruction manual is for anyone in a position that is responsible /authorized to use or operate the machine to apply. At the same time, it is necessary to carefully read and understand each part of this manual in order to be able to use it for your support in fulfilling some of the existing obligations.

- This manual contains information for the safe installation of the device.
- It must be read completely before installation. If the device is available, it must be delivered to its subsequent operators.
- It should always be accessible to the installer at the installation site.
- It must be stored throughout the life of the device.
- GGM is not responsible for any problems arising from the use of the oven for any purpose other than its own.
- Keep this manual in a dry and safe place where machine operators or maintenance technicians can easily find it. Protect it from factors that may cause it to deteriorate over time.
- Without thoroughly reading this manual or being informed by a GGM "commissioning engineer" do not try to use the machine .
- This manual is completely up-to-date at the time of writing. However, due to continuous improvements due to today's technology diversity, final usage procedures may differ slightly from those described in this manual. This only means that the machine is developed to better meet your necessities. In case of any questions, you can contact GGM for clarification.

1.1 Guidance Identification Data

- The data identification of this manual (version) is indicated in the cover inside.
- This data is required to order other copies of this manual.
- This user manual contains all the necessary information for the installation, operation, cleaning and maintenance of the machine and its components.
- Please take the sufficient time to carefully and thoroughly read the operating instructions before starting or operating the machine or its related components.
- Observe and follow all the information and safety instructions detailed in these operating instructions to ensure safe, accurate and economical operation of the equipment.
- All safety instructions are based on applicable safety, health and legal regulations applicable at the time of printin.

1.2 Manual Usage

- The manual should be consulted before the initial operation, before mounting at work. In order to ensure the correct mounting, the manual should be read from the first paragraphs, take care to read its contents correctly until the last paragraph.

2 CUSTOMER SUPPORT

2.1 Worldwide Customer Service

- The Service Center provides service center telephone support by automatically directing calls to one of the mobile phones of our experienced service engineers during normal working hours.
- This service is provided free of charge to those who have a service contract and to the machines covered by the warranty.

2.2 Technical Assistance Request Instruction

- GGM, is at the customer's service for any questions regarding the installation, use and maintenance of the machine. The company will also provide explanations and recommendations to ensure optimum efficiency of the machine
- Empowers your strength with well - trained, highly skilled quality team and tools for repairs.

2.3 After Sales Service

- Any inquiry or request sent to the after-sales service must come complete with the data of the machine identification plate (especially its serial number).

2.4 Instruction for Ordering Spare Parts

- With time some parts of the machine may need to be replaced as they can get damaged due to a malfunction or wear.
- Original spare parts should always be used to maintain the safety and reliability standards provided by the manufacturer.

The spare parts request must refer to the data of the machine identification platform (especially its serial number) and be sent to the company address.

2.5 Service Products

- The principle of providing service and support packages is not only to increase customers' productivity, but also to improve process quality. These packages will also help ensure smooth maintenance of the machines. Product support engineers at the Service Center provide advice on technical problems.

2.6 Customer Training

- Customer training packages not only improve the operating performance of production personnel, but also improve skills in basic machine maintenance, reducing the pressure on the customer's maintenance team.
- Training can be provided in our Service Center or in the customer's own workplace.

3 USAGE

3.1 Proper Usage

- This machine is designed for professional use only and "Dough Rolling". It can't be used for any other purpose.
- It will be carried out by technical personnel who have been instructed and trained for the special processing and use of machines.

Specifications:

- The machine must be installed properly;
- Parts of the machine (if any; power supply, hydraulic pump, pneumatic pipes, display, etc.) must remain stationary and should not be disassembled.
- Ambient operating and heat conditions must be observed;
- The specified performance (speed, loading capacity, etc.) must be observed;
- The instructions for use, maintenance and cleaning provided in this manual must be followed.
- All norms regarding the safety of humans and machinery must be carefully observed.
- If the machine is connected to another machine or incorporated into a more complex system, the manufacturer of the system, GGM, should be contacted and its approval should be obtained. GGM analyzes and evaluates all kinds of risks arising from formations or combinations.
- If parts of the machine need to be replaced, use only original spare parts upon request.
- When entering into the contract, any derogation of the above mentioned must be decided. Otherwise, the legal and penal liability arising from improper use will be reflected to the customer.

3.2 Misusage

- Any use of the machine in any way that is not described in this manual is deemed "unsuitable" or "unspecified" by the Manufacturer.
- The machine should not be used specifically with unassembled, unedited, intentionally excluded or ineffective safety devices without manufacturer-installed protections.

3.3 Security Problems

- All general safety instructions are defined in the SAFETY section, not repeated in other sections. Therefore, make sure that you fully understand them and do not hesitate to read them again if you have doubts before any action.

3.4 Limitation of Liability

GGM's liability is limited to material or structural defects only, as described in the WARRANTY section

- It disclaims full liability for damages arising directly or indirectly even to third parties..

Furthermore, GGM disclaims full liability for damages or accidents or accidents in the following cases:

- Misuse of the machine or use not provided by the Manufacturer.
- Use of qualified and untrained personnel.
- Use against applicable accident prevention norms.
- Modification of any part of the machine.
- Use of non-original spare parts.
- Inadequate maintenance or use.
- Extraordinary events (earthquakes, lightning, floods, etc.)

4 MACHINE TESTING AND ACCEPTANCE

- The machine was first tested at the production facility (mechanical pre-test) and then unmounting or disassembled to be sent to the customer.
- The installation carried out by the technicians authorized by the manufacturer and the machine at work are retested in the presence of the customer. Finally, a trial process is carried out with the materials provided by the customer and the operation of all security devices is checked.
- The "Service Installation Form" prepared in the presence of the customer is signed for the acceptance of the machine and the machine is received.

4.1 Commissioning the Product

- Installation is carried out by the staff of the manufacturer or by the personnel authorized by the manufacturer.
- The manufacturer is not responsible for the failures in the installation made by unauthorised personnel. Despite the labor guarantee, the manufacturer is not responsible for the failures during the installation by unauthorised personnel.
- The manufacturer cannot be held responsible for the place where the machine was installed and its technical and legal compliance.
- All operations must be carried out in accordance with the directives of a single authorized personnel.
- Operators and people at your disposal must wear protective clothing suitable for the operation.
- The manufacturer is not responsible for accidents, damages and machine failures caused by non-compliance with the rules in this section.

4.2 WARRANTY

- Except for different contractual agreements, GGM is guaranteed to the customer's plant for 2 years from the date of arrival of the machine and guarantees that there are no material or construction defects in the machine from the pre-test carried out at the production facility.
- Attempt to repair or replace all parts previously found to be defective : It is up to the authorized technicians of GGM during the warranty period.
- The warranty does not include parts that may be worn out due to their use.
- Excluding different contractual agreements, the warranty covers the sole cost of the parts to be replaced: therefore, shipping fees will be at the customer's expense. If "After-Sales Service" is required to be interfered with, the relevant costs will be charged to the customer (travel, transfer, accommodation, travel hours, etc.), excluding the working time required for replacement.
- Warranty terms are specified in the machine purchase agreement (Order Confirmation)
- The warranty is only available if the customer complies with the contract or conditions, the installation and use of the machine is in accordance with the instructions in this manual.
- In the case of the use of non-original spare parts, it states that people are exempt from any and all liability for animal harm and any property damage that may occur as a result.
- Any arbitrary modification to the machine exempt the manufacturer from any liability for possible injuries to persons or animals and any property damage that may occur as a result.
- GGM reserves the right to make changes to the machine when deemed necessary to improve operation and efficiency.

4.3 Non Covered by Warranty

- Damage of glass, bulbs and gaskets
- Use of the device against its intended purpose,
- Making renovations or technical changes not authorized by the manufacturer to the device,
- Not using the original parts of the manufacturer,
- Damages caused by mechanical impacts that may occur by the customer in the transportation of the machine by the customer,
- Damages arising from insufficient network supplying the mixer,
- Failures due to user negligence of the machine,
- In case of attempts to repair it by the customer or people not authorized by GGM within the warranty period,
- Due to electrical engine failures,
- Due to malfunctions in all electrical materials,
- In case of non-compliance with the rules specified in the instructions for use,
- In deformations that may occur as a result of cleaning the boiler spiral and blade with metal scrapers,
- In case of mixing and distortion of the settings on the machine.

5 GENERAL SAFETY

5.1 Safety Instructions

The following "General Safety" warnings will help create a more safety-free, trouble-free and optimally productive environment.

- Personnel using this machine must comply with the warnings set out in this section. The employer must provide operators with adequate information and tools, as well as practical training on the safe use of the machine.
- For personnel with long hair, a suitable hair collector and bonnet should always be worn. Do not wear jewellery when using this machine. Manche clothing may pose a danger, they should be tucked in. The operator should only wear clothes with no loose parts on them and should never wear jackets, open shirts, etc.
- The area around the machine should be clean and dry. There should be no obstacles that may cause a fall or injury.
- Follow your company procedures for safe lifting/transporting machine parts. The machine must have solid, safe and non-sliding surfaces around the machine when the operating platforms are used.
- If the ladder is to be used, there must be 2 people in order for one of them to hold the ladder and ensure safety.
- Always keep hand tools and various other parts away from the machine. Do not use the machine as a workbench.
- Do not allow visitors, minors or unauthorized people to enter or even approach the machine when is use.

5.2 Operational Safety

All people operating or maintaining this machine must strictly comply with the following precautions.

- Customer-approved personnel who are informed about safety and all machine functions should only operate this machine as detailed in this manual.
- The customer must be committed to training the staff to a locally (in-house) approved qualification level to operate this machine.
- Must learn the locations of all "Emergency Stop" buttons or "Emergency Stop Wire". Always wait for the machine to come to a complete stop before working on the equipment. Before performing any tasks, press a nearby emergency stop button, turn the power switch OFF and inform all other staff.
- Never attempt to correct any error or malfunction while the machine is in motion. Stop the machine, find and correct the error or notify the responsible person.
- Before attempting any machine function, make sure the staff is in a safe area.
- Always stay away from moving parts.
- Keep all covers and doors closed.
- Never remove the covers and protective devices provided for this machine. Operate the machine only when the covers and protective devices are operational and in position.
- Operating service and maintenance personnel should carefully read, understand and fully comply with all warnings and instruction plates installed on the machine. Do not paint, modify, falsify or remove these plates from the machine. Renew all unreadable plates.
- Report any defects or suspicious locations to your supervisor.
- Be aware of hazardous zones, read and understand all cautions and warnings in this manual before starting the machine.



5.3 Safety And Accidental Prevention

- The machine described in this manual is designed according to the latest information to be used with the highest safety by trained and qualified personnel.
- It is assumed that the personnel have knowledge of general safety norms (in force in the country where the machine is installed) and local ones (applicable at the facility).
- The owner has the decision-making power on the safety matters for the employer who uses this machine and also defines;
- Ensuring that all instructions for the execution of any transaction are known and followed correctly ensure the training and qualifications of the personnel and prevent those who do not have the necessary qualifications from using the machine
- The security employee must first guarantee that the instructions included in this manual are available to all personnel responsible:

Furthermore:

- transporting the machine.
- machine assembly and working environment.
- machine arranging, operating and cleaning.
- machine scheduled maintenance and repair.
- final disassembly of the machine.
- It is assumed that the machine is installed correctly.
- Other uses rather than those described in this manual may cause danger to personnel and/or damage to the machine.
- Other uses rather than those described in this manual may cause danger to personnel and/or damage to the machine.
- If the operator detects an abnormal situation with the machine, it is obliged to notify the supervisor immediately to intervene in a timely manner before it is compromised.
- All repairs must be given to qualified personnel and original spare parts should always be used.
- Follow the instructions provided in the manual regarding the competence required for the execution of maintenance procedures.

5.4 Risks Related to the Machine Type

- For the nature of the operation to be performed, the machine presents some internal risks; if properly known, these risks can be minimized by the correct installation/regulation of the machine and the appropriate behavior of the relevant personnel.

5.5 Electric Shock Risk

Risks of electric shock are possible in case of direct or indirect contact with live components or parts.

- The risk of electric shock is especially present in the electrical cabinet when the machine is running and minutes later or immediately after it is turned off (due to the presence of accumulators in the power supply units, inverter)
- During processing, films may accumulate dangerous voltages due to electrostatic charges.

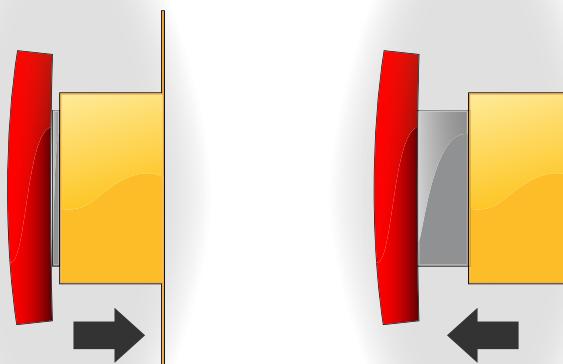
5.6 Accepted Solutions for Security Issues

- The manufacturer carefully assessed the possible risks during the design, and therefore built the machine to combine the health and safety of exposed personnel with functionality and efficiency requirements.
- Is strictly prohibited the removal or tampering of any protections and safety devices, wait for the time when is absolutely necessary provide certain maintenance or repair operations to be carried out. Protections and safety devices must be kept perfectly in place by the Manufacturer to ensure the standard. Periodically, the presence and regulation of fixed guards, all security systems, devices and services (emergency buttons, micro switches, filters etc) and its operation and efficiency.

5.7 Emergency Stop Buttons

The machine is equipped with easily accessible button and sensor for emergency stop.

- There is an emergency stop button on the control panel and a safety sensor integrated on the hopper
- As soon as a dangerous situation arises, do not hesitate to press the nearest emergency button
- Emergency buttons are connected to specific safety circuits: when an emergency button is pressed, the machine stops immediately and the electrical and pneumatic supplies of all controlled devices are cut
- When the emergency button is pressed, it remains mechanically pressed To "reactivate", pull the button when the dangerous situation is over.



5.8 Warning And Caution Sign

Operating instructions, for instructions and steps use the following symbols :

	On this direction	Move with the direction indicated by the arrows facing upwards.
	Fragile	Handle the package carefully.
	Keep Dry	Packaged in such a way that it does not come into contact with open air.
	CE mark	The machine meets the basic safety requirements.
	Balance	Indicates the point where the machine should be lifted.
	Suspension Point	Indicates where the ropes or chains must be attached.
	Caution!	A hazardous situation may result in serious injury or death.
	Fire	Fire danger!
	High voltage	Caution, danger of death!
	High temperature	When the oven is running, the door, glass and its surroundings reach high temperatures.
	Working Spare Parts	Do not perform maintenance and repair operations on moving parts.

5.9 Personnel Protective Equipment



It is mandatory for the operator to wear gloves while handling the dough.



This symbol means that the machine may have a device containing voltage inside the electrical panel. Before turning on the power panel, it is necessary to disconnect the electricity from the main switch or by removing the plug directly from the socket. (For maintenance personnel.)



It should never be interfered with when the machine is running. The operator should never wear loose clothes or ties. It is also mandatory to wear a hair protector (bonnet).

- Do not remove or damage the warning signs.
- It is obligatory to replace the damaged and illegible warning signs. Please contact the manufacturer for new warning signs.
- The manufacturer is not responsible for any work accidents or damage to the machine caused by non-compliance with safety and warning signs or the removal of these signs from the machine.

6 TRANSPORTATION

6.1 General Rules for Unpacking the Machine

- Before unpacking the machine; check for damages that may occur during transportation check for all parts written in the shipment document. If there are missing parts, the manufacturer must be notified within 24 hours.
- When the mounting of the machine is complete, dispose of the packaging material in accordance with applicable legal regulations
- Store the materials used to remove the machine in a suitable place for future use

6.2 Load Structure

The machine can be shipped in the following ways:

- Completely assembled;
- Partially assembled;
- Completely unassembled; the pieces are stacked on a pallet or optionally to any wooden structure.
- The vehicle to which the machine will be transported must have the necessary lifting capacity. (See the machine's technical information table).
- In addition, the minimum loading areas of the vehicle should be as follows.
- The lifting vehicle used to lift must have sufficient lifting capacity and fork length.

The packaging structure of the product is carried out in accordance with the World and European norms.

After the machine control process is finished, it is packaged with bubble wrap, compressed with stretch nylon and placed in the box, which is designed according to the standards, and made ready for the dispatch process.

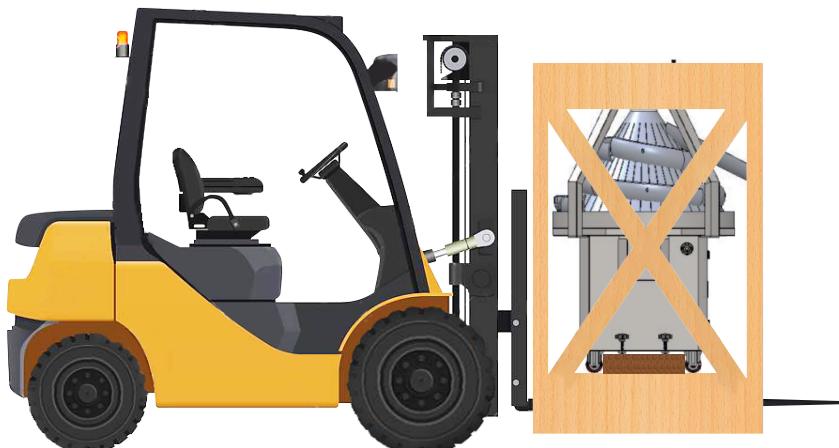
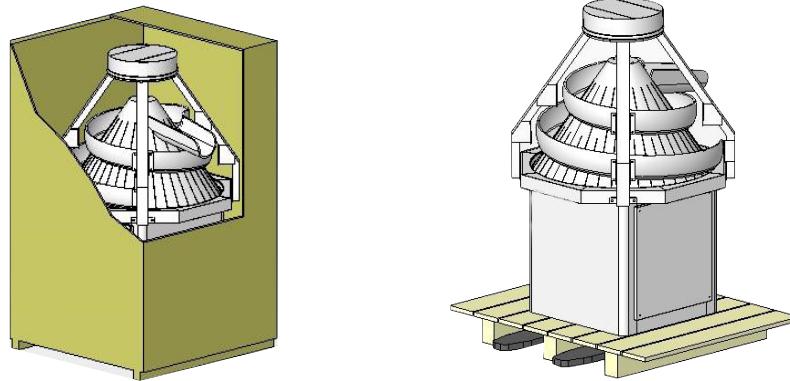
Please check the condition of the packaging carefully while receiving the product.



Do not take the delivery of a package which packging is unmade, damaged, crushed or scratched. Please report this situation to the manufacturer by taking a photo and taking a short note summarizing the situation.

6.3 Transportation of the Product

- The machine is delivered to the customer on a wooden pallet or in a wooden crate.
- Thanks to the wheels on the machine, it can move easily in all directions.
- GGM is not responsible for any problems that may occur during transportation.



6.4 Manufacturing Design

1. In the entire area, when placing manufacturing equipment, gaps should be left in order to allow for inspection and cleaning.
2. When placing the machines, all connection locations must be closed in order not to leave gaps.
3. The floor where the machines are placed must be accessible in terms of cleaning operation or should be completely closed.
4. In cases where the equipment passes through sections such as ceilings, floor, walls, sufficient gaps must be provided between the machine and the wall for cleaning, or the machine must be mounted on the wall so that there wont be any gap.
5. Auxiliary equipment must be detachable and reassembled to facilitate cleaning.
6. The manufacturing base should be covered with hard, smooth, easy-to-clean and non-absorbent material.
7. For insulation, non-absorbent material should be used. These surfaces must be accessible.
8. When storing products, stacking should be carried out on pallets with a distance of at least 100 mm with the floor.
9. The containers used to collect waste products and wastewater must be made of easily cleaned material and must be of sufficient volume.
10. Water and water vapor in direct contact with the products must be of potable quality.
11. Pipes, valves and joints used for liquid materials: Either 'on-site cleaning' programs should be applied for these parts, or systems that can be easily disassembled and assembled.
12. All fixed pipes must be isolated to prevent condensation.
13. The ground slope should be in such a way as to prevent the accumulation of water on the surface.
14. Electrical cables must be fixed (contact with the ground must be prevented).
15. The electrical components of the machines must be switched off to prevent dusting. Water should be prevented from entering the electrical panels.
16. Machine parts such as fans and engines must be amounted in an accessible way.
17. The engine and other auxiliary equipment must be placed in such a way that it does not come into contact with the ground.

7 GENERAL

7.1 General Warning

This manual is an integral part of the machine. The machine has PLC software and control panel. Therefore, before you start using the machine, you need to have read and understood the contents of the manual in particular because in it you will find the necessary information for the safe and correct use of the product.

In the event that the instructions contained in this manual are not followed, the manufacturer will not accept any responsibility and will not be liable for any of them if it causes any malfunction or abnormality.

The manufacturer discerns full liability for any inaccuracy in this manual Printing or transcription errors Also reserves the right to make any changes to the product.

7.2 Rules Regarding the Stocking of the Machine

- The machine should be stored in a closed place away from dust, moisture and heat source
- The media values allowed for storage are as follows:
- Temperature: -5 C to +45 °C
- Maximum humidity: 60%

7.3 Equipment and Tools Required for Moving and Lifting the Machine

If the machine is in a crate or pallet,

1. The forklift must have sufficient carrying capacity Or;
2. The crane and its equipment (ropes, belts or chains) must have sufficient carrying capacity.

7.4 Mounting the Product

- Place the machine on a flat surface.
- The spiral arms may be out of order during transport, tighten them with the help of bolts on the carrier arms. Be careful not to interfere with the adjustment of the arms.
- Move the machine closer to the cutting machine conveyor belt in the operating unit.
- Provide the necessary electrical voltage.
- Activate the machine to move in the direction of the clockwise movement.
- Fill the flour on the machine.

7.5 Mounting Instructions

- The area where the machine will be installed must be safe. The established area must be sufficiently ventilated and illuminated.
- Room temperature should not be less than +5 °C and no more than +40 °C. The humidity should be between 40% and 75%.
- The minimum distance required for wall work, cleaning and maintenance must be observed. This will ensure a safe situation against friction between the wall and the machine.
- The electrical connection must be 380 V AC-220 V AC 50 Hz. Check the compatibility of the panel voltage with the main voltage.

7.6 Electrical Installation

Electrical installations produced in accordance with Turkish standards and European norms add value to your machine, give you and your employees confidence. The electronic systems used are designed to facilitate your work. An easy and comfortable use is aimed with technological facilities.

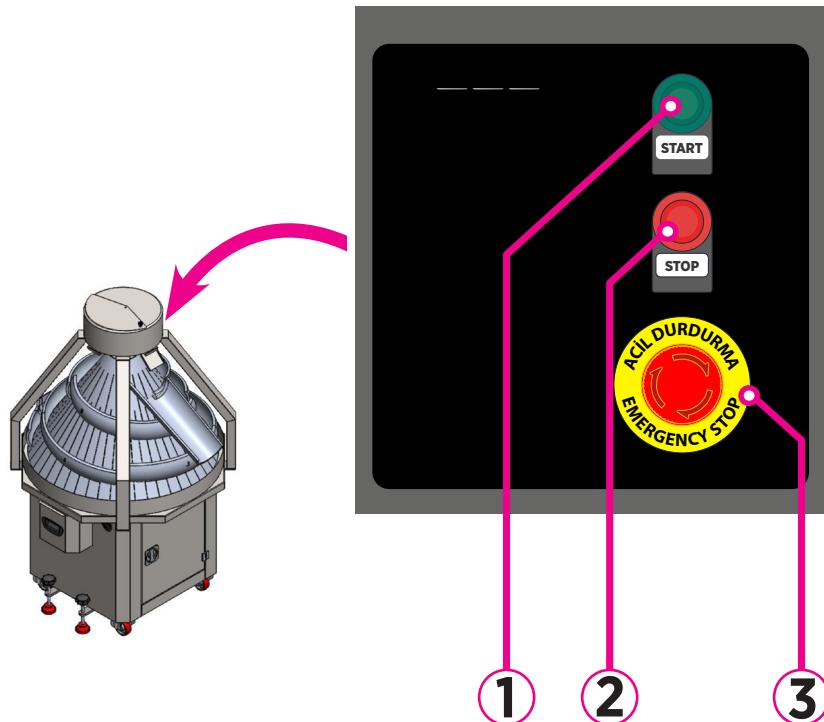
In case of electrical/electronic problems, only authorized persons should be allowed to carry out maintenance and/or repairs, and unauthorized persons should be prevented from causing permanent damage by interfering with the system.

Rules:

- The customer is responsible for the electrical connection process. At the same time, the customer must make the electrical connection according to the laws and the applicable regulations in force.
- Protection of power supply and conductors, as well as a strong and effective grounding system, are the responsibility of the customer.
- The cables used to connect the electrical panel to the power grid must be certified (approved) and must be suitable for operating an installed machine.
- Make sure that the power line is closed before you start an electrical connection.
- Make sure the cables are in a safe place and there is no risk of accidents.
- The terminals must be properly fixed so that they do not affect each other and do not damage the parts inside.
- There must be a breaker or fused switch that supplies electrical energy to the mixer and cooling unit near the user.
- Ventilation of the electrical cabinet is important. Air temperature can rise to levels that will damage the parts.

8 REMOTE CONTROL ELEMENTS

Information about the remote control elements are given below.



8.1 Use of the Control Panel

1. **START**: Start Button.
2. **STOP**: Stop Button.
3. **EMERGENCY**: Emergency Stop Button.

The emergency stop button is used when any functional malfunction or emergency is encountered. The function of the button is to stop all the working functions of the machine and cut off the control energy of the electrical panel. To operate it again, the button is pulled up and the "Start" button is pressed.

9 DESCRIPTION MACHINE

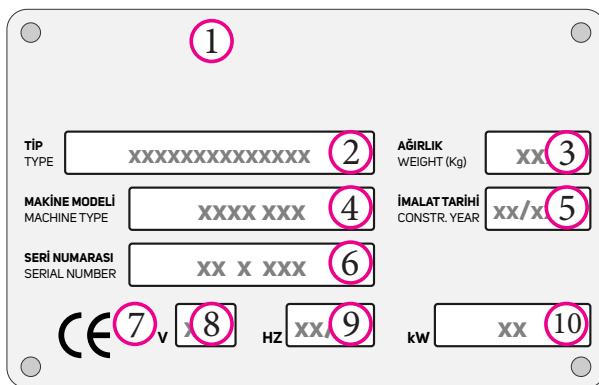
9.1 Dough Spinning Pro

- The Conical Dough Roun machine delivers the dough from the cutting-weighing machine to the intermediate resting machine by giving a round shape.
- The rolling process begins with the loading of the dough onto the felt covered carrying arms.
- The loaded doughs are made from bottom to top thanks to the aluminum funnel and carrying arms rotating in the direction of the watch hand, while flouring thanks to the flour on the machine. The floured dough is loaded into the intermedi resting machine from the



9.2 Product Label

The following identification label is fixed on the machine:

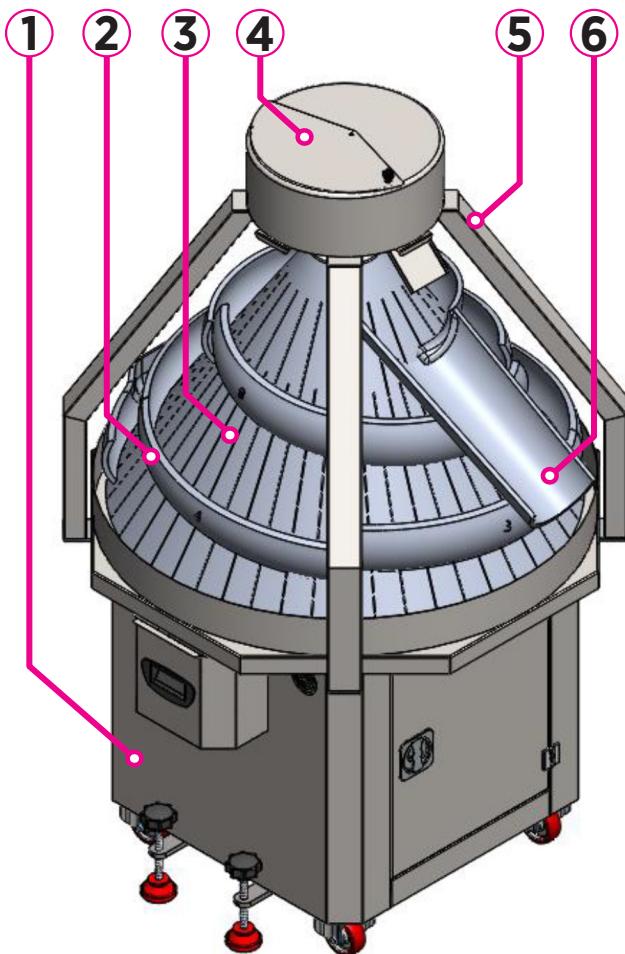


1. Manufacturer information
2. Machine type
3. Machine weight
4. Machine model
5. Date of manufacture
6. Serial number
7. CE mark
8. Operating voltage
9. Operating frequency
10. Operating power

- The customer should ensure that the license plate is not lost and that the data is always legible.
- When spare parts or After-Sales Service interventions are required, it is necessary to mention the identification data of the machine, especially the serial number.

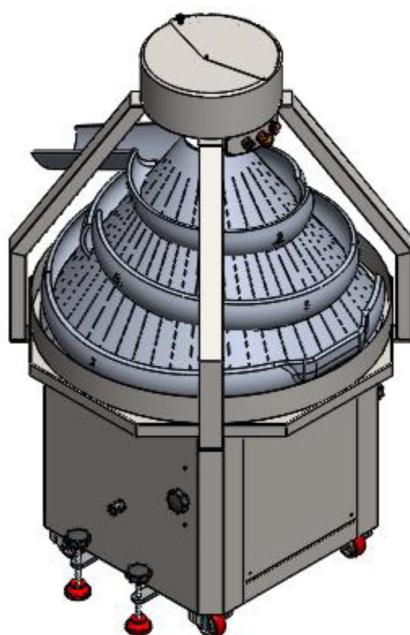
9.3 Parts of the Machine

1. Body
2. Spiral Arms
3. Aluminum Cone
4. Flour Cup
5. Control Panel
6. Exit Groove



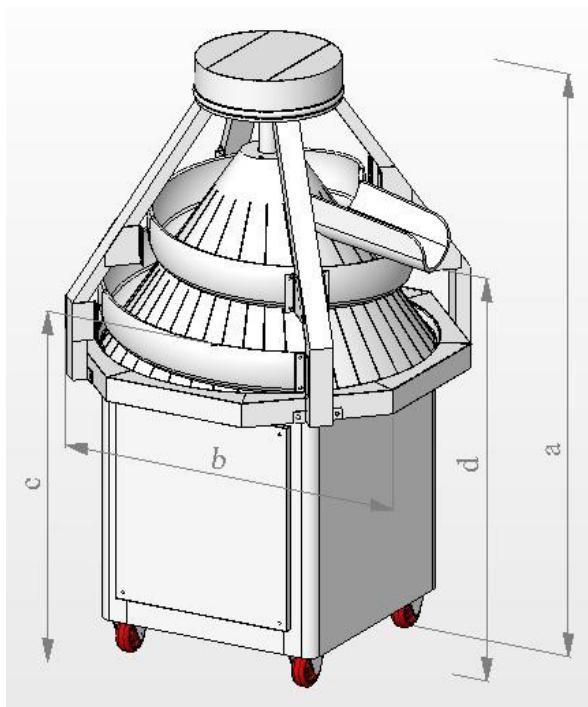
9.4 Technical Specifications of the Machine

		KRM240
Capacity		2.500 Pieces/Hour
Shaping Range		100 - 600 gr
Electric power		1.5 kW
Weight		230 Kg



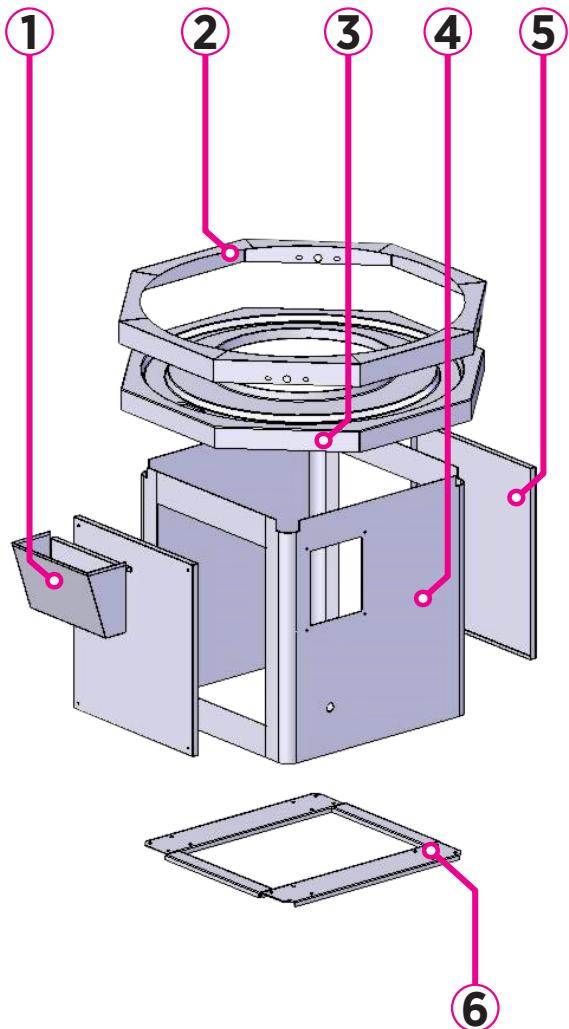
9.5 Dimensions of the Machine

		KRM240
Machine Height	(a)	150 cm
Machine Width	(b)	100 cm
Dough Entry Height	(c)	95 cm
Dough Output Height	(d)	125 cm



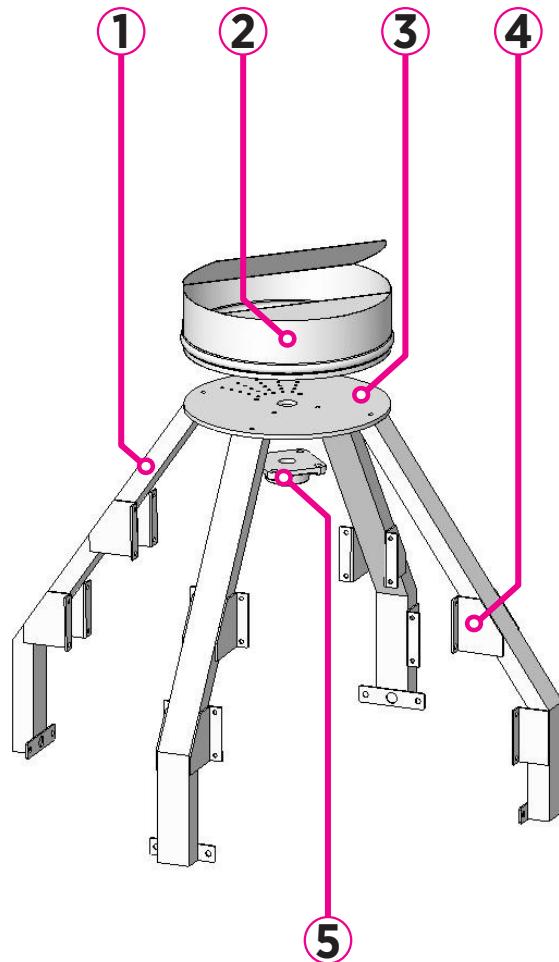
9.6 Body Parts List

1. Flour Pocket
2. Octagonal Table
3. Fiberglass Table
4. Body
5. Side Covers
6. Wheel Connection Plates



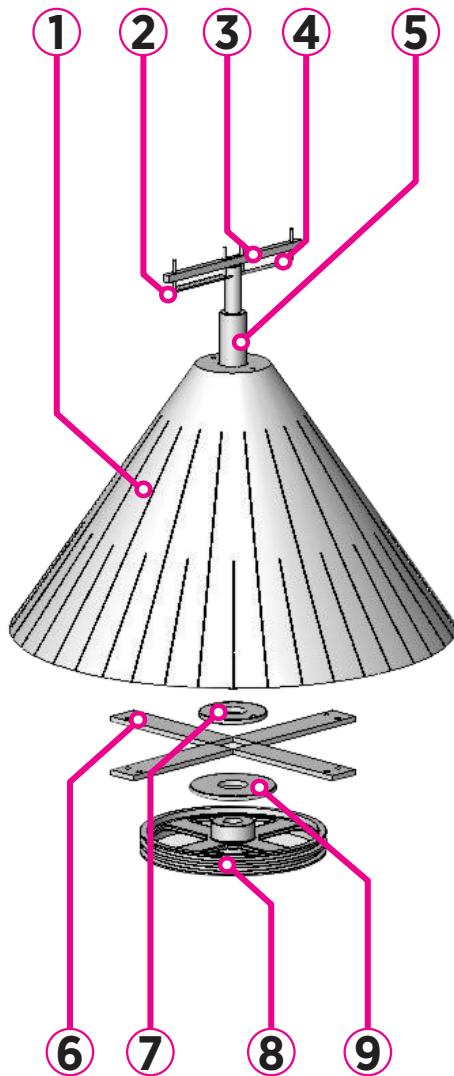
9.7 Spiral Connecting Rods Parts

1. Spiral Connection Profiles
2. Flour Assembly
3. Title
4. Spiral Connection Sheets
5. Roller Bearing (UCF 206)



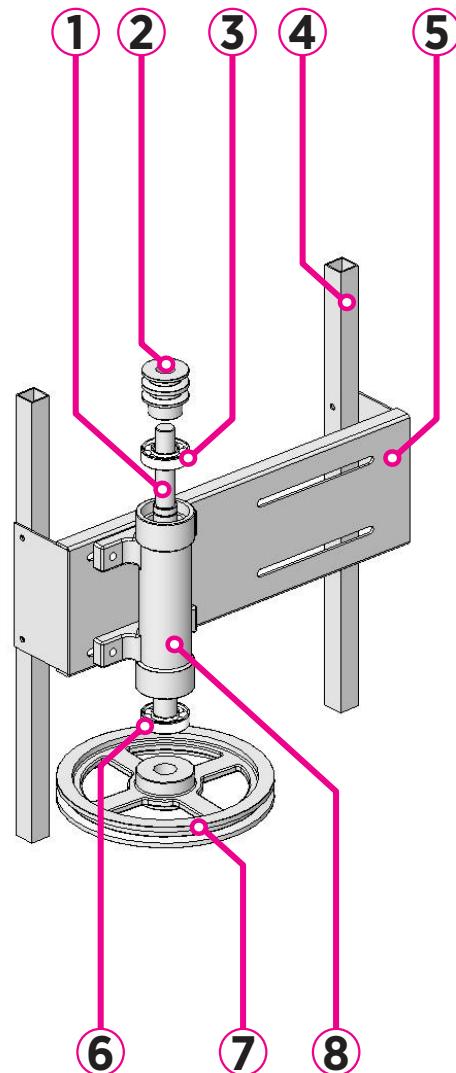
9.8 Aluminum Hopper Parts

1. Aluminum Hopper
2. Flour Brush
3. Flour Square Spindle
4. Flour Mixer
5. Aluminum HopperShaft
6. Hopper Connection Blades
7. Hopper Connection Flange 1
8. Casting Pulley
9. Hopper Connection Flange 2



9.9 Rotation System Parts

1. Steel shaft
2. Small Pulley
3. Bearing (6206 ZZ)
4. Engine Base Link. Profiles
5. Engine Plate
6. Bearing (6206 ZZ)
7. Big Pulley
8. Casting Bed

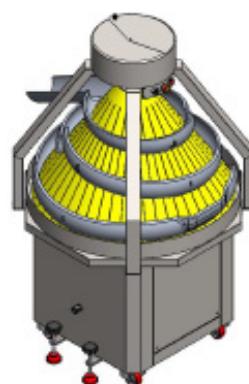


10 MAINTENANCE

10.1 Maintenance Instruction

Before starting the machine after any maintenance, the operator must:

1. Clean the aluminum cone and spiral arms at the end of each work.
2. Never use metal scrapers during the cleaning process.
3. Clean the exterior parts of the machine as well.
4. Maintenance and repairs should only be carried out by authorized qualified personnel.
5. Unless otherwise stated, maintenance must be carried out after the machine is turned off and all electrical sources are powered.
6. If the machine needs to operate during maintenance or adjustment, the operator must keep unauthorised personnel at a safe distance.
7. Before taking any action, place the "MAINTENANCE IN PROGRESS" warning sign in a visible place.
8. For all operations, check the periodic maintenance chart in this user manual.
9. Always wear protective goggles, gloves and masks when using compressed air for cleaning. Make sure that compressed air or hot air does not come directly into contact with human skin and eyes.
10. Do not use a corrosive or toxic chemicals. To the dough and wear protective gloves when in contact with oils.
11. It should be checked that there are no foreign objects in the machine.
12. Safety required to start the machine safely precautions should be taken.



10.2 Weekly Maintenance

1. Make sure the machine is not working
2. Remove the lower covering sheets of the machine
3. Using a vacuum cleaner, clean the flour and dust collected on the motor, pulley, fan, etc.

10.3 Monthly Maintenance

4. Check the tension of the "V" belts every 3 months
5. When pressed with the finger, if the "V" belt stretches more than 25 mm, tighten the "V" belts by sliding the engine on the chassis
6. Check the oil on the bearings on the turning cone shaft. If necessary, press the solid oil from the lubricating nipple.



Attention: Our company will not be responsible for any damage that may occur as a result of the intervention of unauthorized persons to the machine.

11 CLEANING THE MACHINE

11.1 General Cleaning Rules

1. The machine is manufactured in accordance with the food regulation in force at the time of shipping by the manufacturer company. When you see a sign that is deteriorating in any of the parts of the machine (dough, ground, water, etc.), replace the part immediately with a new one.
2. The manufacturer cannot be held responsible for deterioration/wear on parts due to incorrect or not proper cleaning of the machine.
3. Cleaning operations should be carried out after the machine is secured.
4. CAUTION! : Do not use alcohol-containing solvents and liquids that are flammable/combustible substances. Only use plastic brushes or scrapers for stubborn stains. Use a soft cloth or vacuum appliances to remove dust.
5. Do not use compressed air to clean internal electronic parts. Use vacuum devices.

11.2 Daily Cleaning

1. Rounding cones and grooves should be cleaned after each working day. During cleaning, perform the following operations in order.
2. Start the machine.
3. Take a long-armed plastic scraper.
4. Hold the scraper by the handle and press the cone in the opposite direction of rotation. In this way, wait until the cone is cleaned. Do not place your hand between the cone and the channel carrier profiles during cleaning.
5. Stop the machine when cleaning is finished.
6. Wipe the cone and rolling grooves with a dry cloth or plastic brush.
7. After use, keep the machine constantly cleaned of flour and dough particles. To do this, clean the machine once a week with a soft-wire brush and cloth.
8. Wipes should be carried out with a wet cloth, pressurized water should never be used.

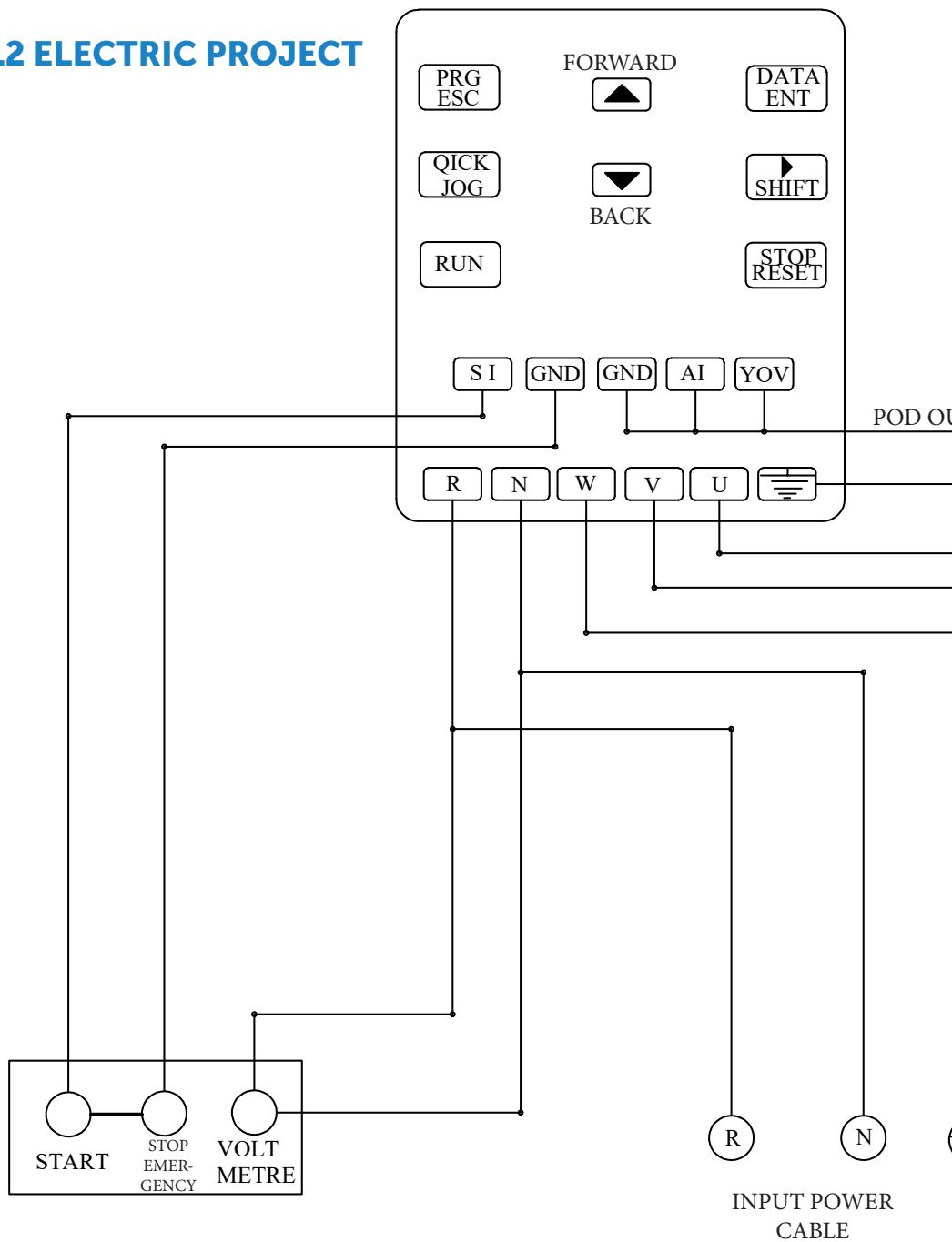
11.3 Matters to be Considered in the Use of the Product

- Clean the flouring mechanism regularly. Keep the flour full at all times.
- Ensure that the dough falls properly from the cutting machine to the carrying arms.
- Always clean the hopper surface and dough that sticks to the carrier arms.
- Never interfere with machine failures without stopping the machine.

11.4 Care for the Lifetime of the Product

- Clean the flour at the end of the work.
- Clean the hopper and carrier arms at the end of the work. Do not use hard metal scrapers during the cleaning process.
- Regularly clean the channels on the hopper.
- Renew the felt coatings on the 1st and 2nd carrier arms in case of wear.
- Clean the air blowing system elements after the end of the work.
- Lubricate the roller bearings and bearings regularly.
- Regularly check the machine belt pulley system.
- Clean the machine externally at the end of each work.

12 ELECTRIC PROJECT



POD OUTSIDE

