ERIKA RECORD

BAKING EQUIPMENT

Semi RH Divider/Rounder

OPERATIONS MANUAL

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Technical Specifications

Erika Record Semi RH (Removable Head) Series dough divider/rounder, designed to divide and round uniform pieces of dough.

Selected	Knife Head (Machine Type)	Divisions (Parts)	Weight Range	Rounding Plate Model No.
	8/251 RH	7	9 - 21 oz. | 255 - 595g	47
	6/151 RH	15	5.4 - 9.5 oz. | 153 - 269g	415
	7/71 RH	20	2.5 - 7.1 oz. | 71 - 201g	420
	4/41 RH	30	1.4 - 4.3 oz. | 40 - 121g	45
X	11/31 RH	36	1 - 4 oz. | 29 - 113g	46
	10/25 RH	36	0.9 - 3.3 oz. | 26 - 93g	336
	9/21 RH	36	0.74 - 2.5 oz. | 21 - 70g	326
	5/18 RH	50	0.6 - 1.5 oz. | 18 -42g	50
	MINI	56	0.28 - 0.56 oz. | 8 - 16g	12
	10 Q2	10	4.125 - 15 oz. | 117 - 425g	10 Q2
	15 Q2	15	2.75 - 10 oz. | 78 - 284g	15 Q2
	30 Q2	30	1.375 - 5 oz. | 39 - 142g	30 Q2
	9 Q3	9	4 - 18 oz. | 113 - 510g	9 Q3
	12 Q3	12	3 - 13.5 oz. | 85 - 383g	12 Q3
	18 Q3	18	2 - 9 oz. | 57 - 256g	18 Q3
	36 Q3	36	1 - 4.5 oz. | 29 - 128g	36 Q3

Serial Number	XXXXX

Year	XXXX

Working Dimensions	Net Weight	Shipping Dimensions	Shipping Weight
28.5" x 25.5" x 78.75" *(724 x 648 x 2,000 mm)*	770 lbs | 350 kg	31" x 33" x 63" (788 x 839 x 1601 mm)	880 lbs | 399 kg

Electrical Connections		0.75 KW		
380V *3 PH, 50 Hz, 2.2 A*	**200/220V** *3 PH, 60 Hz, 4.0 A*	**220V** *3 PH, 50 Hz, 2.8 A*	**480V** *3 PH, 60 Hz, 2.1 A*	**200V** *3 PH, 50/60 Hz, 4.0 A*
	X			

Sound Level	LwA = 69.61 dB

Sound Emission	LpAec = 50 dB(A)

*The owner and all employees who may come in contact with this machine **MUST READ** and familiarize themselves with the operational instructions and safety procedures outlined in this **MANUAL** prior to usage or servicing.*

Required Tools

The following tools are required for proper installation of your Erika Record Divider/Rounder.

- ☐ Box Cutter
- ☐ Canvas Straps (1,000 lb. capacity) - QTY. 2
- ☐ Crowbar
- ☐ Fork Lift
- ☐ Hammer
- ☐ Pliers
- ☐ Staff (2 - 3 person team, with at least 1 certified forklift operator)
- ☐ Wrench (10 mm)
- ☐ Wrench (17 mm)
- ☐ Wrench (19 mm)
- ☐ Wrench (Adjustable)

Owner Responsibilities & Safety

• The owner and all employees who may come in contact with this machine must read and familiarize themselves with the operational instructions and safety procedures outlined in this manual prior to usage or servicing.

• Those operating and servicing this machine must also familiarize themselves with all safety labels affixed to the machine prior to use/service.

• The owner is responsible for ensuring that all employees have a clear understanding of operation, cleaning, maintenance, and safety protocols outlined in this manual prior to initial use. This also includes training and supervision.

• The owner is responsible for translating this manual into any additional language for non-English speaking customers.

• The owner is responsible for ensuring that all operating, managerial, and maintenance staff members are observing the instructions mandated in this manual.

• The owner is responsible for ensuring that the machine operates properly during the initial operation.

• The owner is responsible for ensuring that this manual and included tools are readily accessible to all employees for future

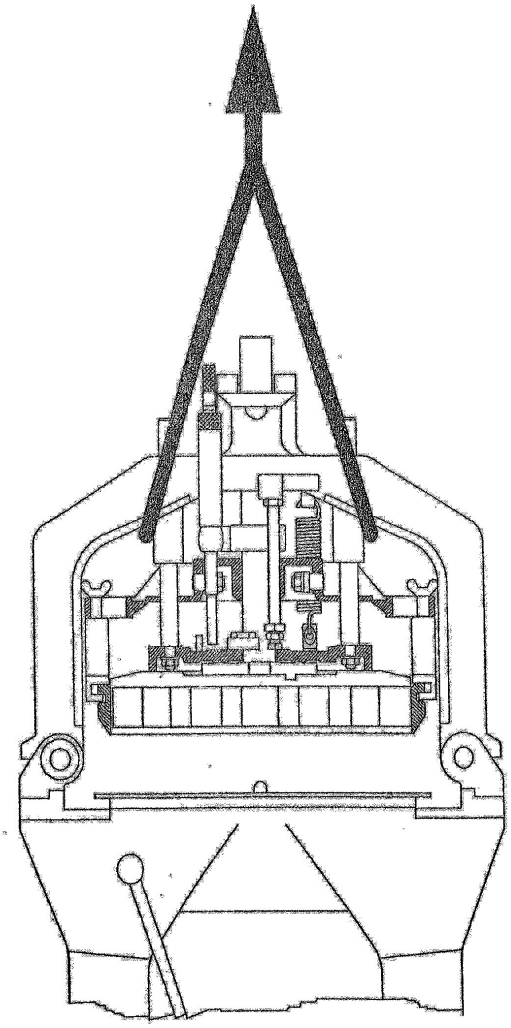
reference and use.

• The owner is responsible for ensuring that installation of this machine conforms to all applicable codes, rules and regulations (local, state, and federal) including OSHA, and electrical codes.

• The owner of this machine will not hold Karl Schmidt GMBH, Erika Record LLC, and its affiliated distributors responsible for any injuries or damages sustained during the installation process, improper installation, operational misuse, or improper maintenance.

Pallet Removal Tips

Here are some helpful tips when removing your Erika Record Divider/Rounder from the shipping pallet.



• Machine ships bolted to a wooden pallet, wrapped in a protective plastic sheathing and encased in a wooden crate.
• To move the pallet, you must place the forks of the forklift in the wooden runners maintain proper balance.

• To lift the machine off the pallet, you must first remove the two bolts that secure the machine to the pallet. This is achieved by removing the side covers of the machine's base, included oil, and tools, while proceeding to loosen each bolt located in two corners of the machine.

• Proceed to remove the two plastic head covers located on top of the machine.

• Now use two heavy-duty canvas straps (1,000 lb. capacity) around the machines arch as depicted in the diagram. These cords should then be secured to the forks of the forklift.

• With the straps in place, proceed to raise the machine off of the pallet and gently lower the machine onto the floor, into the permanent place of installation.

Installation

• After removing the sides of the wooden crate, the machine must be removed from the wooden pallet. The machine is secured to the pallet via two bolts located inside the base of the machine.

• With the sides of the crating removed, proceed to remove any plastic sheathing encasing the machine (the entire machine including the base should be exposed).

• Locate the operation manual and feeler gauge, hanging on the right hand side in clear transparent bag. This manual and feeler gauge must remain readily accessible at all time by the operating and maintenance staff.

• Proceed to remove the rear base cover from the machine.
• With the cover removed, locate the oil container as well additional tools within the base of the machine. This includes:
    - Bottle brush
    - 6mm Allen T-Wrench

• Remove the oil container. Ensure this oil is accessible for use a bit later during the installation process.

• With the oil container removed from the base, proceed to locate the two bolts that secure the machine to the base. These bolts are located in two corners of the machine's base.

• Using a wrench, proceed to loosen each nut from the bolts located at the base of the machine. Upon removing the nuts from each bolt, you may also opt to drive the bolts through the pallet using a hammer.

• With the bolts loosened, proceed to remove any included tools and accessories form underneath the knife head assembly. Begin by loosening the string and wood piece that secure these accessories for shipment. This includes:

- White installation plate (S066/12) - QTY. 1
- Red Rounding Plate (Varies based on model)- QTY. 3
- Pressure Lever (S030)

• With the accessories removed, proceed to remove both the front and back Knife Head Assembly covers (S009/B and S009/F).

• Using a forklift and 2 - 3 person team (which includes one certified fork life operator), proceed to remove the machine from the pallet. **DO NOT** attempt to remove the machine from the pallet by yourself, doing so could result in serious damage or injury. ***Please see "Transportation Tips" for additional guidance.***

• With the pallet removed from the base of the machine, proceed to position the machine into its final install location:

- ***If opting to use casters for enhanced mobility,*** you must use original OEM sourced casters. These casters are engineered to provide adequate support and prevent the machine from tipping or causing injury during operation.
- ***If opting to rest the machine directly on the floor***, it must be properly bolted in all four corners of the machine's base. Once secured, the gap between the machine's base and floor must be sealed to prevent water, flour, etc. from entering the base. We recommend using a waterproof silicone based caulk.

• ***The default electrical configuration for this machine is*** **220v | 3 PH | 60 Hz** unless otherwise specified. The machine must be connected to the power supply by a qualified electrician. Prior to

connecting, ensure that the power supply has the proper voltage. You will also have to check for proper polarity during the initial operation, ***please see "Initial Operation" for further guidance.***

• The machine should be installed on a level surface with adequate working space surrounding the machine. This includes space for both operation and general maintenance.

• Once the machine is in position, it must be bolted to the floor with appropriate anchors; using the four corners of the machine that were used to secure it to the pallet during shipping.

• Once bolted, the gap between the base of the machine and the floor must be sealed with a silicon grade caulking to prevent entry of dust, flour, water, etc. into the base of the machine.

• This step can be omitted if the machine has been fitted with OEM factory installed casters.

- **NEVER INSTALL** stock casters underneath the machine, as it is top heavy. All casters must be OEM provided as they have been engineered to minimize the risk of tipping when in operation.

Oil Reservoir

• Oil must be added to machine prior to being put into operation.

• The required oil was pulled from the machine's base during the installation process. If needing to refill your machine after servicing, ***you must source 2 quarts of SAE #40 motor oil***. It is extremely important to use this specific grade of oil, using any other grade will cause the oil to foam and spill from the reservoir. ***You may also use SAE #30 motor oil, non-detergent formula***.

• Depending on the manufacture date of your machine, there are two difference methods for installing oil into the machine.

Semi RH Divider/Rounders Built 1999 & Earlier

• Remove the front and rear plastic head covers (S009), then remove the disconnecting pin (S036) and tilt the machine head assembly to one side.

• In the center of the rounding table (S042), there is a large slotted flathead screw, remove it by turning counterclockwise with a large screwdriver.

• Pour the oil into the reservoir through the hole (it is advisable to use a small funnel).

• Reinsert the large slotted flathead screw into the hole, and fasten it with the screwdriver, turning it clockwise until firmly tightened.

• Return the machine head assembly back to the working position. This includes inserting the disconnecting pin through the pillow block and arch; and installing the front and rear plastic covers.

Semi RH Divider/Rounders Built After 2000

• The filler plug is located on the top rear, right-hand side of the base of the machine, it is a black hexagonal plastic plug.

• Remove the plug by turning it counterclockwise. Then pour the oil into the opening (it is advisable to use a small funnel to pour the oil into the reservoir).

• Take the black hexagonal plastic plug and insert it in the hole, fasten it by turning it clockwise, being sure to only hand tighten.

NOTICE

The owner is responsible for ensuring proper installation and operation of this machine. Operation of this machine without the specified oil will be labeled as abuse and misuse of equipment. Karl Schmidt GMBH, Erika Record LLC, and its affiliated distributors will not honor any warranty for parts and labor that are related to this improper usage.

Initial Cleaning

• The machine ships with a protective grease that prevents oxidation during transit. The grease must be cleaned prior to the machine being put into commission.

• Remove the front and rear plastic head covers (S009), and the dough ring, then remove the disconnecting pin (S036) and tilt the machine head to one side.

• Clean the grease from the machine head and rounding table using paper towels or a soft cloth.

• Bring the machine back to its original resting position, by gently lowering the head back into place.

• Reinstall the disconnecting pin, dough ring, and head covers.

• With the grease wiped from the machine, use the first two – three batches of dough to perform a final cleaning. This will ensure all grease has been removed from the machine. **DO NOT** consume this dough.

Settings & Configuration

• The adjustment screw (S032) sets the height of the rounding chamber of each dough piece.

Adjustment Screw Position

• If the adjustment screw (S032) is in the "**up**" position (turned **counterclockwise**), it will accommodate a large piece of dough.

• If the adjustment screw (S032) is in the "**down**" position (turned **clockwise**), it will accommodate a small piece of dough.

In general, the larger the number on the adjustment screw setting, the larger the piece of dough that will fit into the rounding chamber. Total amounts may vary depending on your dough type and product.

Troubleshooting

• If the operator does not choose the right setting, the dough will not be well rounded when processed.

• The same settings that work for one dough type, may not work for a different product, due to changes in both dough density and overall composition.

Flat Dough Balls

• **Issue**: When there is not enough space within the rounding chamber, the dough will appear to be more flat than round.

• **Solution**: Turn the adjustment screw (S032) in a **counterclockwise** position to raise the space within the rounding chamber.

Nippled Dough Balls

• **Issue**: When there is too much space within the rounding chamber, the dough will appear to have a nipple in the center of the doughballs.

• **Solution**: Turn the adjustment screw (S032) in a **clockwise** position to decrease the space within the rounding chamber. Optimal adjustments typically occur after 1 – 2 revolutions of the adjustment screw.

Professional Tip

• Once you have achieved the optimal settings, be sure to write those settings down for future reference.
• **Remember** settings will vary across different dough types.

Initial Operation

• Ensure that the electrical connection to the machine is properly configured. This is done by making sure the rounding table (S042) is rotating in a **counterclockwise** direction. (This is the same direction as the arrow on the front of the machine, located directly underneath rounding table).

• If the rounding table (S042) is rotating in a **clockwise** direction, your machine will not function properly. **Please call an electrician** to reverse the rotation of electrical motor. This is accomplished by reversing the polarity of either the electrical plug or outlet.

Dough Scaling

To properly process dough in your machine, you must ensure that dough is properly scaled and portioned onto your red rounding plate.

1. Scale your dough to the total appropriate weight range for your product. To calculate the total amount of dough needed for scaling, simply take the weight per roll and multiply it by the number of cutting knife (S074) divisions. The number of divisions can also be indicated on the accompanying red rounding plates (S066).

Example

If seeking to produce a roll with a weight of 3.1 oz. using a rounding plate (S066) with 36 divisions, you would need 7lb. of dough

3.1 oz. x 36 divisions = 7lb. of dough

Formula:
Individual Roll Weight x Rounding Plate Divisions = Total Weight Range

2. Spread your scaled dough evenly around the rounding plate (S066) in a circular fashion.

3. Ensure the dough extends to middle band of outer circles on the rounding plate (S066).

4. Depending on your dough type, you may choose to dust the top of the dough with flour prior to processing. **Never** put dusting flour between the rounding plate (S066) and dough.

Machine Operation

Dividing & Rounding

1. Prior to commissioning the machine into operation be sure to follow the procedures outlined in the **"Initial Operation"** section of the manual. Remember the initial batches of dough should be ran until you no longer see any discoloration in the dough and the product zone is completely clean.

2. Prepare your dough for processing according to procedures outlined in the **"Dough Scaling"** section of the manual.

3. Insert the rounding plate into the machine for processing. Ensure there are no dough scraps on the bottom of the plastic rounding plate (S066). The rounding plate should rest on top of a peg (S067) that is inserted near the handle of the rounding plate when properly placed. Failure to properly insert the rounding plate (S066) into the machine can cause damage to both the plate and cutting knives.

4. With the rounding plate (S066) and dough inserted, proceed to lower the pressure arm (S030) using a strong downward force. The will help ensure the dough is evenly compressed.

5. Slightly raise the pressure arm (S030) and release the cutting arm (S010) by pushing it to the right.

6. Ensure the pressure arm (S030) is once again completely lowered onto the rounding plate (S066) and proceed to move the rounding handle (S050) to the left. This will begin the rounding process.

Professional Tip

Optimal rounding time is typically 3 – 5 seconds and can vary based on your dough type.

7. The operator can round the dough for as long as desired. The rounding sequence ends once the rounding handle (S050) is released. Once rounding is finished, release the handle and proceed to raise the pressure arm (S030) into its original position.

8. With the pressure arm (S030) returned to the resting position, remove the rounding plate (S066) to reveal rounded dough balls. Be sure to inspect the quality of the finished dough balls, and if necessary, perform any required adjustments.

Dividing

1. Insert one red rounding plate (S066) into the machine face down onto the rounding table (S042).

2. Using a different red rounding plate (S066) prepare your dough for processing as outlined in the **"Dough Scaling"** section of the manual.

3. Proceed to dust the top of the dough with flour and place that second rounding plate (S066) onto the rounding table (S042) for processing. Both rounding plates should be stacked on top of one another and resting on a peg (S067) near the handle of the rounding plates (S066).

4. Lower the pressure arm (S030) and release the cutting arm (S010). **DO NOT ENGAGE THE ROUNDING HANDLE**.

Adjusting V-Belts

• With continued use, the v-belts located in the base of the machine will begin to wear and stretch.

• These belts can be adjusted by loosening the motor bolts and moving the motor on its railing until the belts are tight again.

• Once the belts are tight, proceed to retighten the motor bolts.

Dough Entrapment Ring

Periodically, the dough entrapment ring (S007) will need to be removed from your machine. This achieved through the following steps:

Dough Entrapment Ring Removal

1. Ensure both the front and rear head covers (S009) are removed.

2. Insert the white installation plate (S066-12) onto the rounding table (S042) and lower the pressure arm (S030) completely until the knife head assembly (S025) is resting on the installation plate.

3. Turn the dough ring (S007) **clockwise** until the large indents of the dough ring are aligned with the hook screw/dough ring mount (S081).

4. With the dough ring (S007) properly aligned with the hook screw (S081), you may now raise the pressure arm (S030).

5. With the knife head assembly (S025) raised and the pressure arm (S030) returned to the resting position, you may now slide the dough ring (S007) out from underneath the knife head assembly.

Professional Tip

*When cleaning the dough ring (S007), **NEVER** use metal scrapers or sharp objects to clean the ring. The ring should only be cleaned with a cloth or paper towels using mild detergent and luke-warm water.*

Dough Entrapment Ring Replacement

1. Begin remounting the dough ring (S007) by aligning the large indents of the dough ring with the hook screw (S081). The knife head assembly (S025) should be raised with the pressure arm (S030) in the resting position.

2. With the dough ring (S007) properly aligned, lower the pressure arm (S030) so that the knife head assembly (S025) lowers into the dough ring.

3. With the knife head assembly (S025) lowered and the pressure arm (S030) remaining down, turn the dough ring (S007) **counter-clockwise** until the pin located on top of the dough ring is aligned to the right.

4. The pin located on top of the dough ring (S007) should rest directly against the front of hook screw (S081) when properly re-aligned.

5. With the dough ring (S007) secured, proceed to raise the pressure arm (S030) in to resting position.

6. When finished replace both the front and rear knife head assembly covers (S009).

Adjusting Knives

The adjusting screw (S037) determines the clearance the knives have from the rounding plate once they are released from the knife head assembly via the cutting arm (S010). This is accomplished by limiting

the travel of the pressure arm (S030). The clearance is also referred to as the knife head adjustment.

Adequate clearance is achieved when measured thickness around the entire circumference has a measured specification 0.5mm between the released knives and the rounding plate.

Clearance should be verified during both initial setup and when replacing a knife head assembly.

The following outlines steps for verifying and adjusting the knife clearance/height:

1. With both the front and back head covers as well as the dough entrapment ring (S007) removed; proceed to place a rounding plate (S066) upside down into the machine. For guidance on removing the dough entrapment ring, please see the **"Dough Entrapment Ring"** section of the manual.

2. Verifying the dough entrapment ring (S007) is removed, proceed to lower the knife head assembly via the pressure arm (S030) onto the reversed rounding plate (S066) and release the cutting arm (S010).

3. With the knife head assembly still lowered onto the rounding plate (S066), trace underneath the entire perimeter of the knife head assembly with a 0.5-millimeter (mm) feeler gauge. The feeler gauge should not get stuck or pass too freely underneath the knife head assembly.

4. Should the feeler gauge either get stuck or pass too freely, the knife height adjustment screw (S037) located on the top of the machine must be adjusted.

Troubleshooting

Feeler Gauge Gets Stuck

If the feeler gauge gets **stuck** when tracing the perimeter of the

knife head assembly, the knife height **must be raised**. This is achieved by turning the knife height adjustment screw (S037) **counter-clockwise**.

Feeler Gauge Passes Too Freely

If the feeler gauge gets **passes too freely** when tracing the perimeter of the knife head assembly, the knife height **must be lowered**. This is achieved by turning the knife height adjustment screw (S037) **clockwise**.

Knife Head Assembly

This machine comes with an interchangeable, removable knife head assembly system. This system enables you to easily swap knife head assemblies (S025) for either different weight ranges or cleaning.

Knife Head Assembly Removal

1. Ensure both the front and rear head covers (S009) are removed.

2. Follow the procedure for removing the dough entrapment ring (S007) as outlined in the **"Dough Entrapment Ring"** section of the manual.

3. With the dough ring (S007) removed, make sure the white installation plate (S066-12) is placed onto the rounding table (S042). When properly inserted the plate will rest on a peg (S067) through a port near the plate's handle. The plate will be used for transporting the knife head assembly (S025).

4. Lower the pressure arm (S030) so that knife head assembly (S025) is resting directly onto the installation plate (S066-12).

5. With the knife head assembly lowered onto the plate, loosen both the front and back knife head assembly bolts (S023) until they are able to move freely, yet remain in place.

6. With the bolts (S023) loosened, proceed to loosen the 6mm allen

wrench compression screw with the included allen wrench. The compression screw port will be located on the right of the knife head assembly.

7. With the compression screw loosened, raise the pressure arm (S030). The knife head assembly (S025) should remain resting on the white installation plate (S066-12).

8. Remove the knife head assembly (S025) from the machine.

Knife Head Assembly Replacement

1. With the old knife head assembly (S025) removed, insert your new knife head assembly into the machine onto the white installation plate (S066-12).

2. With the knife head assembly (S025) resting on the white installation plate (S066), be sure to align the red index mark on the knife head assembly with the “0” index mark on the installation plate.

3. Lower the pressure arm (S030) so that the Gear Bar (S029) passes through the center (S005) of the knife head assembly.

4. Tighten the 6mm allen wrench compression screw with the included allen wrench. The compression screw port will be located on the right of the knife head assembly.

5. Tighten both the front and back knife head assembly bolts (S023) until they are secure.

6. Follow the procedure for replacing the dough entrapment ring (S007) as outlined in the **“Dough Entrapment Ring”** section of the manual.

7. When finished replace both the front and rear knife head assembly covers (S009).

Cleaning & Maintenance

Routine cleaning and maintenance must be performed after every work shift.

Rounding Plates

Rounding plates (S066) must be cleaned after every work shift using lukewarm water and mild dish detergent. **NEVER** place your rounding plates in a commercial dishwasher, these must be hand washed.

Preferred Cleaning Method

1. Follow the steps for removing the knife head assembly (S025) as outlined in the **"Knife Head Assembly"** section of the manual.

2. Insert the knife head assembly into a pan washer for deep cleaning.

3. Wipe the rounding table (S042) with a damp cloth to remove any excess flour or dough buildup.

4. Once dry, replace the knife head assembly (S025) as outlined in the **"Knife Head Assembly"** section of the manual.

Alternate Cleaning Method

1. Remove both the front and back head covers (S009).

2. Follow the procedure for removing the dough entrapment ring as outlined in the **"Dough Entrapment Ring"** section of the manual.

3. Turn the height weight adjustment screw (S032) counter clockwise, until the number 10 is visible. This will completely expose the knives from the head chamber to facilitate cleaning.

Professional Tip

Prior to adjusting the height weight adjustment screw (S032) for cleaning, be sure to mark the original placement for easier reset post cleaning.

4. Replace the front and rear head covers (S009).

5. Remove the large disconnecting bolt (S036) that secures the yoke (S027) to the base of the machine.

6. Gently life the yoke (S027) into the open position. Using excessive force may cause damage or personal injury.

7. Clean the underside of the knife head assembly (S025) with a clean cloth or paper towel.

8. Lower the pressure arm (S030) and release the cutting arm (S010) to expose the knives.

9. Carefully clean between the cutting knives and chamber with a damp cloth and bottlebrush.

10. When finished cleaning, raise the pressure arm (S030), this will raise the cutting knives back into the knife head assembly (S025).

11. Gently lower the yoke (S027), using excessive force may cause damage and or personal injury.

12. Insert the large disconnecting bolt (S036) that secures the yoke (S027) to the base of the machine.

13. Remove both the front and back knife head covers (S009).

14. Follow the procedure for replacing the dough entrapment ring (S007) as outlined in the **“Dough Entrapment Ring”** section of this manual.

15. Replace both the front and back knife head covers (S009).

Replacement Parts

When ordering replacement parts for your machine please have the following information available.

- Machine Serial Number
- Machine Model Number
- Part Numbers (be sure to identify part numbers using our parts breakdown)
- Photos (photos of parts that need replacing)

Order requests should be sent in writing either via fax or e-mail.

Erika Record Baking Equipment

Toll-Free: 800.682.8203
Local: 973.614.8500
Fax: 973.614.8503

URL: www.erikarecord.com
E-mail: support@erikarecord.com

Recommended Spare Parts

Below is a list of recommended spare parts we advise customers have on hand.

Part Number	Part Description	Quantity	Key	Average Stock
Electrical Spares				
S102-USA	New Style ESG circuit breaker	1		In Stock
Mechanical Spares				
S006	Small spring	3		In Stock
S070	Motor drive V-belt	3		In Stock
S033	Small spring	2		In Stock
S054	Small spring	1		In Stock
S066/xxxx	Rounding Plates (Model Specific)	**		In Stock
Saftey Items				
S009/x	Cover Front, (Model Specific)	1	*	In Stock
S009/x	Cover Rear, (Model Specific)	1	*	In Stock
S069	Knob (knife release handle)	1		In Stock
S052	Knob (rounding lever)	1		In Stock

Color Key	
The chart below indicates the ability of the machine to continue to function should one of the recommended parts need replacement.	
	Will not inhibit machine function
	Impending machine failure
	Machine will not function

*	*The absecene of the part will not effect the machine's ability to function, however, these parts are mandated by OSHA. Removal of these parts and/or failure to main these parts in an operationational status could pose a safety risk to both the operator and other staff members.*

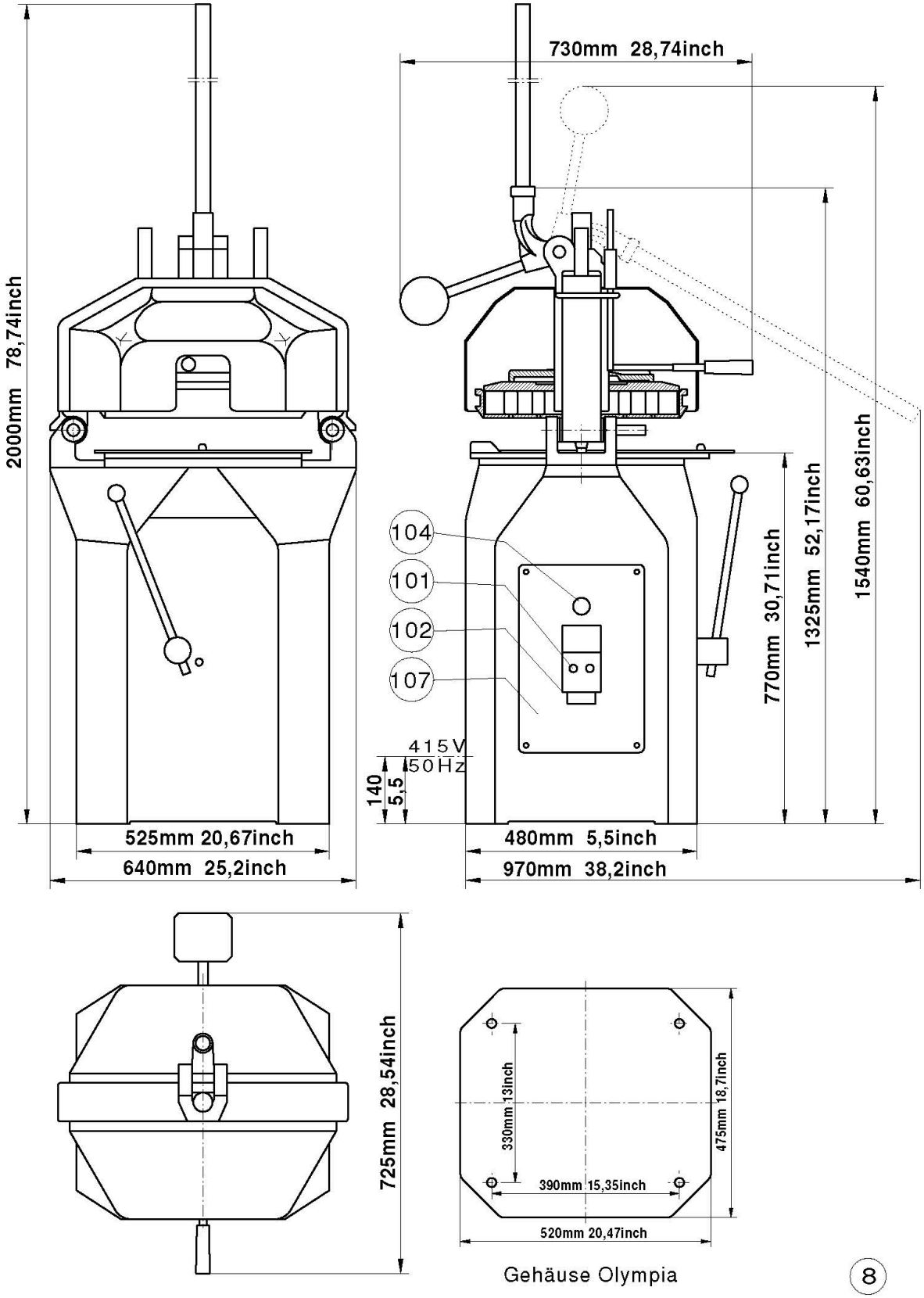
Parts Breakdown

Diagram	Part Number	Description
1	S-001	Stop
2	S-002L	Latch Left
2	S-002R	Latch Right
3	S-003	Latch Pivot
4	S-004	Fork Casting with Curve
5	**S-005**	**Ring Guide**
5	S-05A	Ring Guide Type 10/25 + 11/31
5	S-05B	Ring Guide Type 2/36 + 9/21
6	S-006/078	Pull Spring
7	**S-007**	**Dough Ring**
7	S-07A	Dough Ring Type 11/31
7	S-07B	Dough Ring Type 5/18
7	S-07C	Dough Ring Type 2/36 + 9/21
7	S-07D	Dough Ring Type 10/25
8	S-008	Yoke for S-004
9	**S-009V**	**Cover Front**
9	S-09A	Cover Front, Round Type 9/21 + 10/25 + 11/31
9	S-09B	Cover Front, Square Type 9/21 + 10/25 + 11/31
9	S-09C	Cover Front, Type 2/36
9	**S-009H**	**Cover Rear**
9	S-09D	Cover Rear, Round Type 9/21 + 10/25 +11/31
9	S-09E	Cover Rear, Type 2/36
9	S-09F	Cover Rear, Square Type 9/21 + 10/25 + 11/31
10	S-010	Cutting Arm
11	S-011	Bearing Cover
12	S-012	Bolt
13	S-013	Counter Weight
14	S-014	Latch Bow
15	S-015	Straight Pin
16	**S-016**	**Adjusting Screw**
16	S-16A	Adjusting Screw, Type 9/21 + 2/36
16	S-16B	Adjusting Screw, Type 10/25 + 11/31
17	S-017	Angle Arm Bolt
18	S-018	Pin
19	S-019	Connection Bar
20	S-020	Bolt
21	S-021	Snap Ring
23	S-023	Flange Screw
24	**S-024**	**Flange**

24	S-24A	Flange, Type 10/25 + 11/31
24	S-24B	Flange, Type 2/36 + 9/21
25	**S-025/074/082**	**Piston with Knife Head Assembly**
25	S-25A	Piston With Knife Head Assembly, Type 11/31
25	S-25B	Piston With Knife Head Assembly, Type 10/25
25	S-25C	Piston with Knife Head Assembly, Type 9/21 + 2/36
25	S-25D	Piston with Knife Head Assembly, Type 7/71
25	S-25E	Piston with Knife Head Assembly, Type 6/151
25	S-25F	Piston with Knife Head Assembly, Type 5/18
25	S-25G	Piston with Knife Head Assembly, Type 4/41
25	S-25I	Piston with Knife Head Assembly, Type 8/251
26	S-026	Clevis Pin
27	**S-027**	**Cast Iron Yoke**
27	S-27A	Yoke Round, Type 10/25 + 11/31
27	S-27B	Yoke Round, Type 9/21
27	S-27C	Yoke, Type 2/36
27	S-27D	Yoke, Type 10/25 + 11/31
27	S-27E	Yoke, Type 9/21
28	S-028	Gear Segment
29	**S-029**	**Gear Bar**
29	S-29A	Gear Bar Type, 4/41 + 6/151
29	S-29B	Gear Bar Type, 10/25 + 11/31
29	S-29C	Gear Bar Type, 2/36 + 9/21
30	S-030	Pressure Arm
31	S-031	Segment Bolt
32	**S-032**	**Adjusting Screw**
32	S-32A	Adjusting Screw, Type 10/25 + 11/31
32	S-32B	Adjusting Screw, Type 2/36 + 9/21
33	S-033	Pull Spring
34	S-034	Support Screw
35	**S-035**	**Pillow Block**
35	S-35A	Pillow Block, Type 9/21 + 10/25 + 11/31 + 2/36
36	S-036	Disconnecting Bolt
37	S-037	Adjusting Screw
38	S-038	Roller Bearing
39	S-039	Angle Lift
40	S-040	Bushing
41	S-041	Bearing Housing
42	**S-042**	**Pressure Plate**
42	S-42A	Pressure Plate, Type 9/21 + 10/25 + 11/31 + 2/36
43	S-043	Ball Bearing
45	S-045	V-Belt Pulley
46	S-046	Motor/V-Belt Pulley F. Motor

47	S-047	Snap Ring
48	S-048	Gate
49	S-049	Gate Bearing
50	S-050	Moulding Level Cpl.
51	S-051	Flange Bearing
52	S-052	Knob
54	S-054	Pull Spring
55	S-055	Self Aligning Bearing
56	S-056	Bearing Housing
57	S-057	Connecting Arm
58	S-058	Lever
59	S-059	Push Bolt
60	S-060	Connecting Rod
62	S-062	Drain Plug
63	S-063	Oil Filler
64	S-064	Taper Pin
66	**S-066**	**Moulding Plate**
66	S-66/1	Moulding Plate, Type 10/25 - 36 Parts | #336
66	S-66/2	Moulding Plate, Type 11/31 - 36 Parts | #46
66	S-66/3	Moulding Plate, Type 2/36 - 36 Parts | #26
66	S-66/4	Moulding Plate, Type 4/41 - 36 Parts | #45
66	S-66/5	Moulding Plate, Type 5/18 - 50 Parts | #50
66	S-66/6	Moulding Plate, Type 6/151 - 15 parts | #415
66	S-66/7	Moulding Plate, Type 7/71 - 20 parts | #420
66	S-66/8	Moulding Plate, Type 9/21 - 36 parts | #326
66	S-66/9	Moulding Plate, Type 3/31 - 30 parts | #35
66	S-66/10	Moulding Plate, Type 2/25 - 30 parts | #25
66	S-66/11	Moulding Plate, Type 8/251 - 7 parts | #47
67	S-067	Fixing Pin
68	S-068	Cotter Pin
69	S-069	Knob
70	S-070	V-Belt
71	**S-071**	**Motor**
71	S-71A	Motor - Single Phase, 0,75 kw
72	S-072	Spring Bolt
73	S-073	Sleeve
75	S-075	Spring Bolt Short
76	S-076	End Stop
77	S-077	Counter Nut
79	S-079	Spring Bolt
80	S-080	Pin Rod
81	**S-081**	**Hook Screw**
81	S-81A	Hook Screw, Type 11/31

81	S-81B	Hook Screw, Type 9/21 + 10/25 + 2/36
82	**S-082**	**Cross Piece**
82	S-82A	Cross Piece, Type 11/31
82	S-82B	Cross Piece, Type 10/25
82	S-82C	Cross Piece, Type 9/21 + 2/36
83	S-083	Gate Pin
84	S-084	Gate Piece
85	S-085	Roller Gate Piece
86	S-086	Housing
87	S-087	Spring Bolt
88	S-088	Counter Nut
89	S-089	Support
90	S-090	Snap Ring
91	S-091	Stop
92	S-092	Motor Support
93	S-093	Locking Pressure Plate
96	S-096	Pivotblock
99	S-099	Fastening For Cover
100	S-100	Roller Connecting Rod
101	S-101	Circuit Breaker
102	S-102	Box F.Circuit Breaker
103	S-103	Registration Lamp
104	S-104	Registration Lamp (Old)
105	S-105	Roller (Transport)
107	S-107	Covering Plate
108	S-108	Screen (German Model)
109	S-109	King Bolt Yoke
113	S-113	Detent (QUADRO Model)
128	S-128	Protection



Gehäuse Olympia

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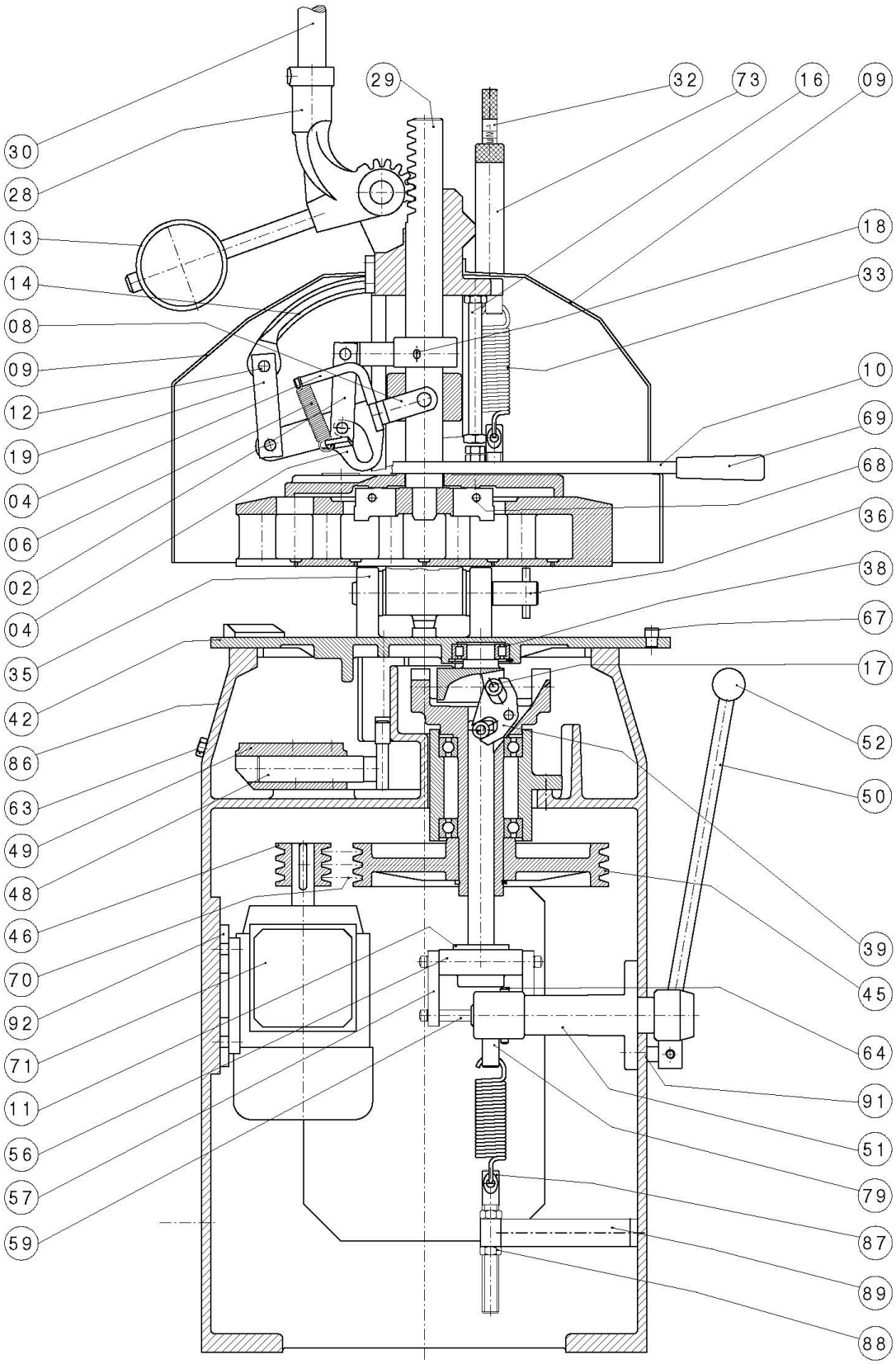
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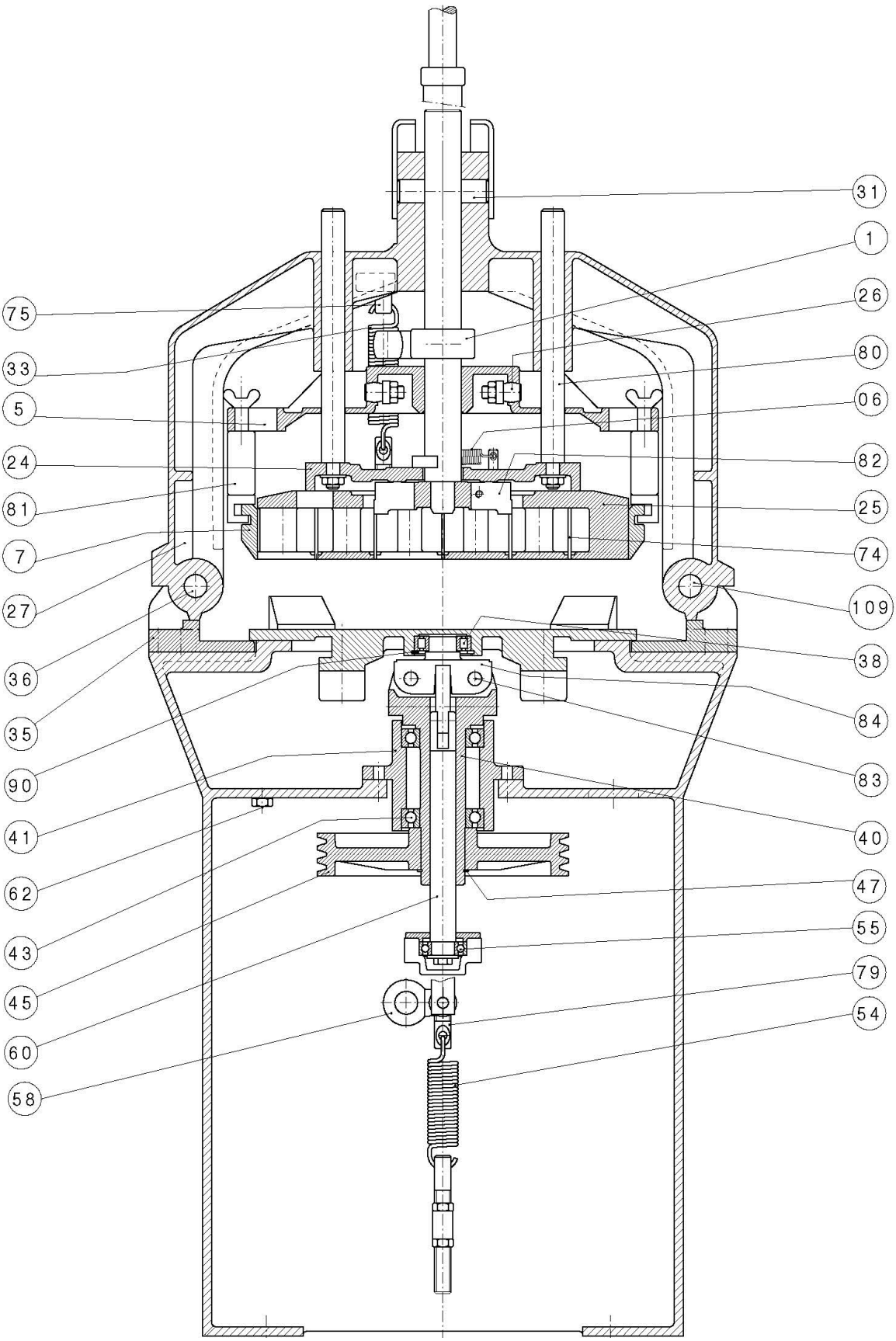
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Presskolben.-und Messerwechsel: change the knife and piston:

-Ring ausbauen(siehe unten)	-remove ring (M-2007,see below)
-Wechselteller einlegen	-put in plate (white)
-mit Handhebel abwärts fahren	-with pressure arm move down
-Kolben① und Messer② lösen	-loosen piston① and knife②
Schrb. für Kolben ganz herausnehm.	and move screws for piston
-mit Handhebel aufwärts fahren	-with pressure arm move up
-Kolben mit Messer entnehmen	-take piston with knife

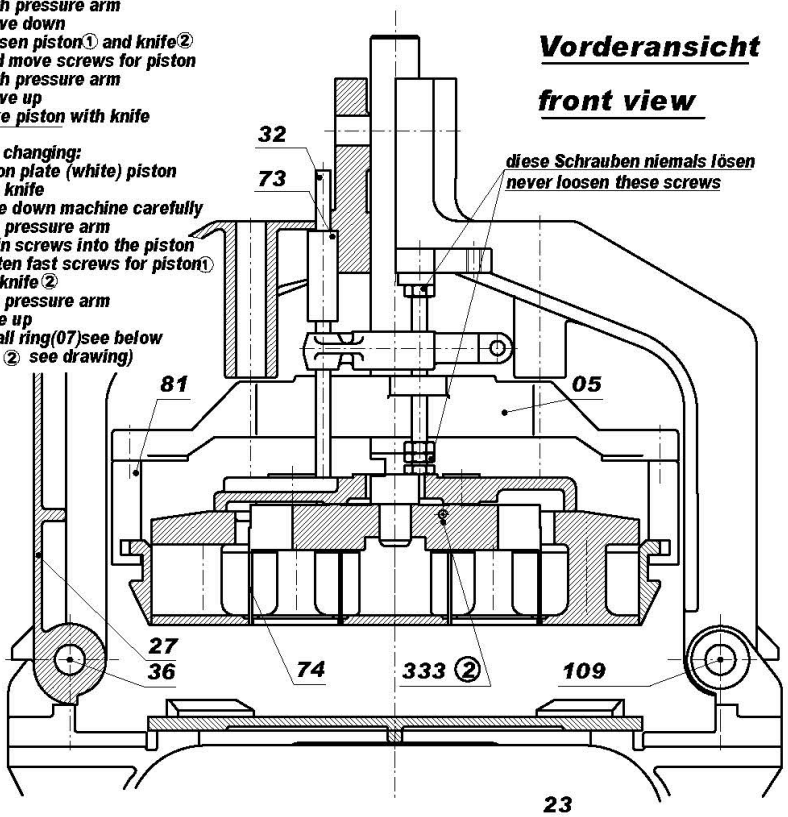
nach dem Wechsel:
-Presskolben mit Messer auf Wechselteller positionieren
-Maschine mit Handhebel vorsichtig abwärts fahren
-Schrauben in Kolben eindrehen
-Schr. für Kolben① und Messer② fest anziehen
-mit Handhebel aufwärts fahren
-Ring einbauen(07)siehe unten

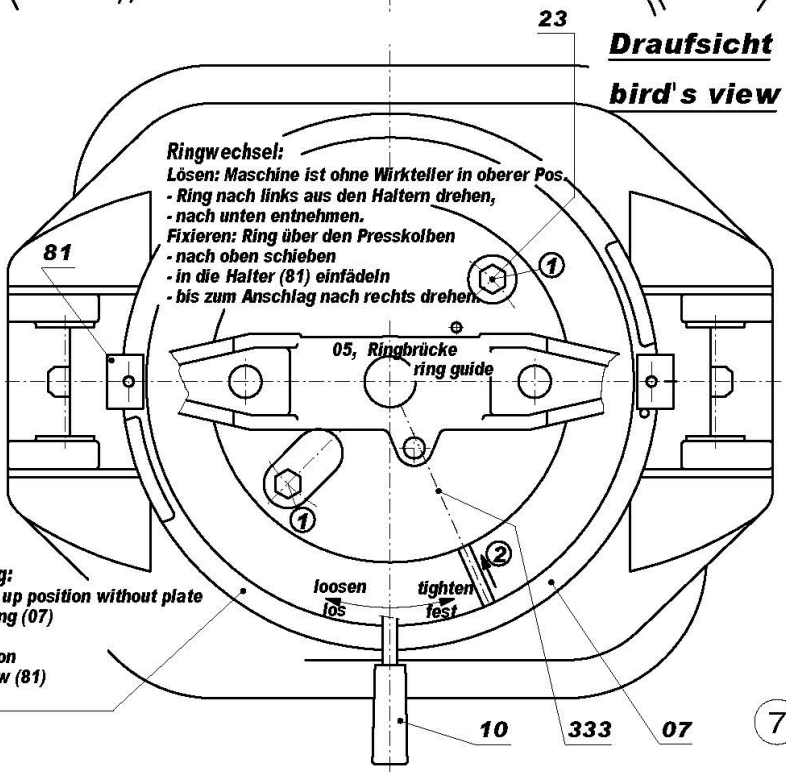
(① ② siehe Zeichnung)

after changing:
-put on plate (white) piston with knife
-move down machine carefully with pressure arm
-put in screws into the piston
-tighten fast screws for piston① and knife②
-with pressure arm move up
-install ring(07)see below
(① ② see drawing)

Reinigung:
-Ring ausbauen(siehe unten)
-Griffbolzen entfernen(36),Bügel kippen
-mit Handhebel in Endlage abwärts fahren
-Schneidhebel entriegeln
-Reinigung vornehmen
-mit Handhebel aufwärts fahren
-Bügel zurückschwenken
-Griffbolzen und Ring einbauen

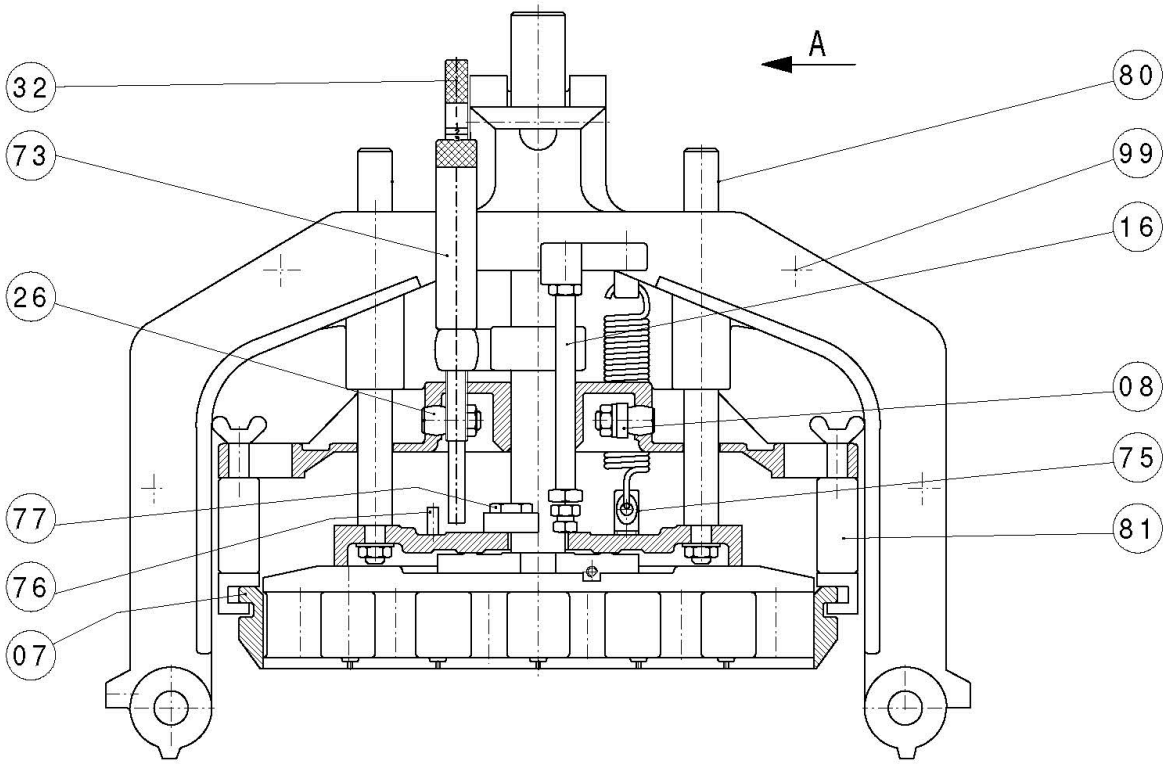
cleaning:
-remove ring (07,see below)
-pull out bolt (36)
-turn over yoke (27)
-with pressure arm move down to the end
-unlock cutting arm
-cleaning
-with pressure arm move up
-turn back yoke
-insert bolt and ring





ERIKA RECORD RH

change of moulding ring:
loosen: machine is in the up position without plate
- turn left the moulding ring (07)
- take it out
fix: ring is above the piston
- push it up into hook-srew (81)
- turn right to the end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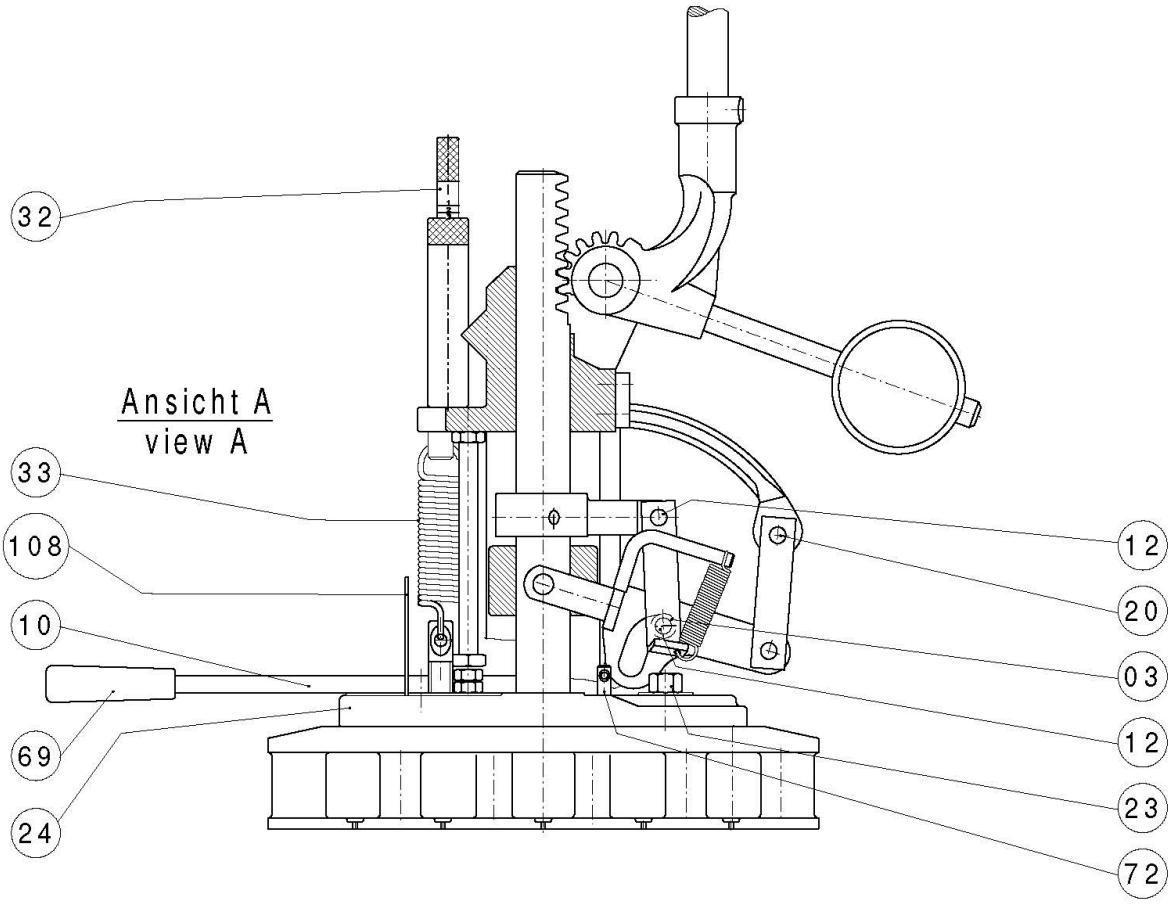
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