CONICAL ROUNDER



INSTRUCTION MANUAL

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MACHINE PARTS

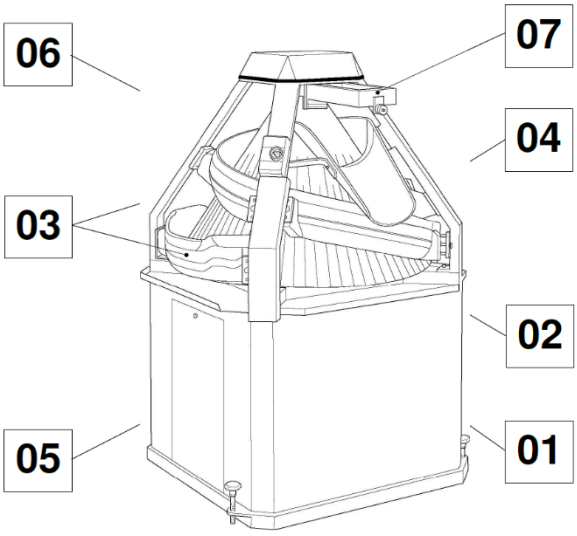


Figure 1. Machine parts.

1. Structure.
2. Cone.
3. Rounding channels.
4. Exit ramp.
5. Motor (inside).
6. Controls.
7. Flour duster.

1. OVERVIEW

This machine is a conical rounder, designed to work with bread dough, with a water content between 55% and 65%. The range of weights it can produce is from 100 to 2000g.

2. INITIAL INSTALLATION

2.1 TRANSPORT AND UNPACKING

The machine is delivered fully assembled. For the transport of the machine, it is placed on a wooden pallet and covered with wooden packaging.

Use a forklift to lower the machine from the truck. Once the machine is on the ground it can be moved with a manual lift.

To unpack the machine, all the nails from the wooden box that attach it to the pallet must be removed. Once the wooden box has been removed, the machine must be lifted from the pallet and the wheels must be assembled, which are sent disassembled for transport.

2.2 FIRST CONNECTION

The machine is powered by single-phase current at 220V**. The two motors of the machine (cone and flour duster) are controlled by 2 frequency inverters, so the direction of rotation will always be correct.**

3. INSTRUCTIONS FOR USE

3.1 CONTROL PANEL



1. Emergency stop: If the machine is pressed, it stops and cannot be restarted until the button is released.

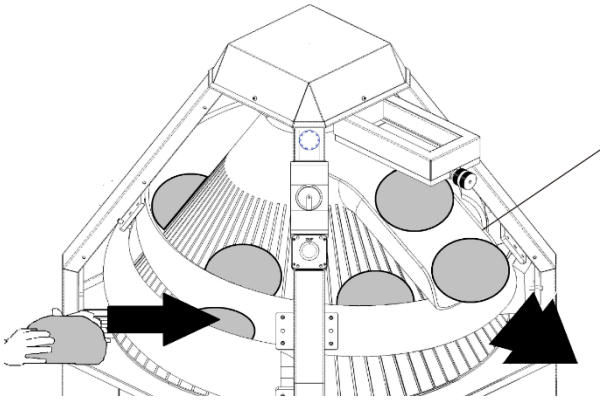
2. Stop button (red button): when pressed, the machine stops.

3. Gear button (green button): when pressed, the machine starts up.

4. "Cone" potentiometer: allows you to adjust the speed of rotation of the cone.

5. "FLOUR" potentiometer: allows you to adjust the amount of flour that is dropped on the exit ramp, if it is set to "0" the flour duster will not work.

3.2 USE AND ROUNDING



The machine can be used individually or can also be operated in combination with other machines.

The dough must be fed through the entrance area and the rounded products will exit through the exit ramp.

It is important to note that if there is an accumulation of too many pieces at the same time, the speed could be reduced to prevent overexertion of the engine.

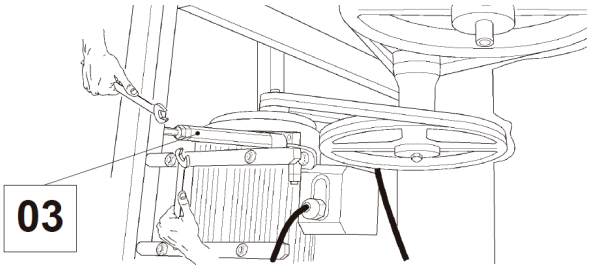
The quality of rounding that can be obtained with this machine will depend on the properties of the dough, normally a dough that is too hard will not be rounded well, if the dough has the appropriate consistency the rounding will be much better.

4. MAINTENANCE

4.1 BELT TENSION

The belts are factory adjusted with the right tension, usually it will not be necessary to touch up this tension for a few years. However, if you notice that the dough pieces are not advancing, then it might be necessary to adjust the tension of the belts. But you should always keep in mind that excess stress can damage the bearings and shorten the life of the belts.

To adjust the tension of the belts you first need to disconnect the machine from the power, remove the lid and then adjust the tensioning rod as seen in this figure:



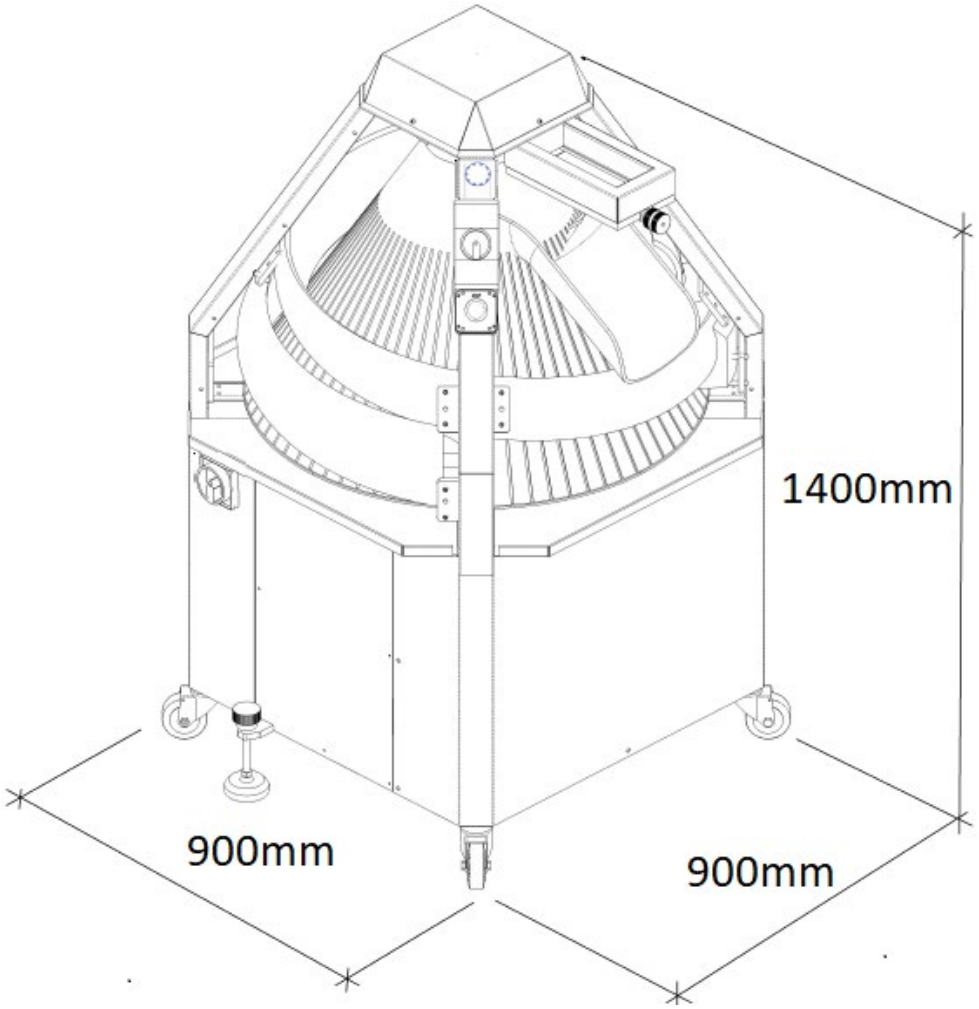
4.2 CLEANING

The machine is easy to clean, when the work is finished, just clean the flour residues with a cloth damped with soft water.

5. TROUBLESHOOTING

The machine won't start
-Verify that the machine is correctly connected and that it receives power from the network. -Verify that the emergency shutdown is not there. -Verify that the residual current circuit breaker is not activated (inside the electrical panel).

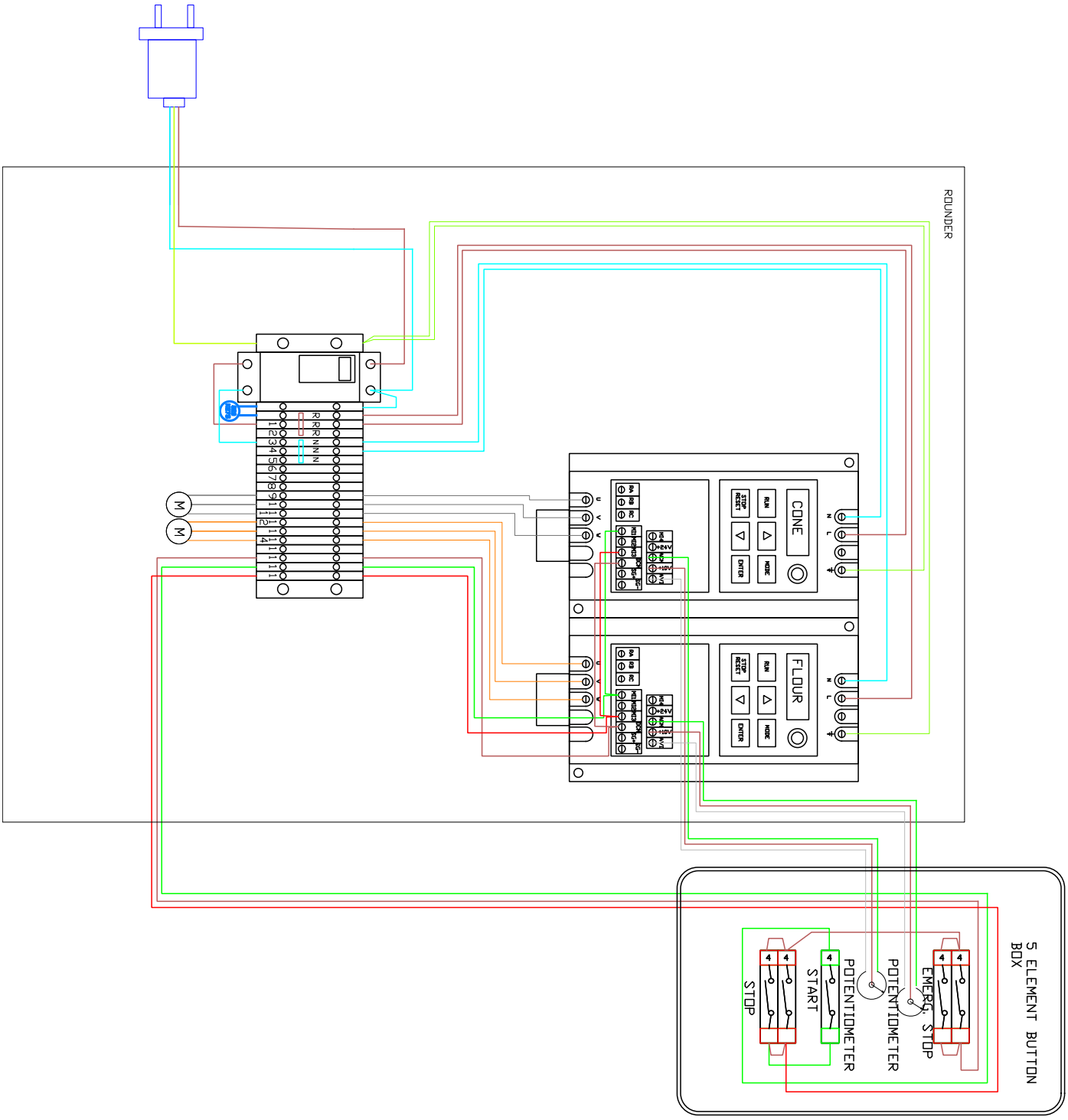
6. MACHINE DIMENSIONS



7. MACHINE SPECIFICATIONS

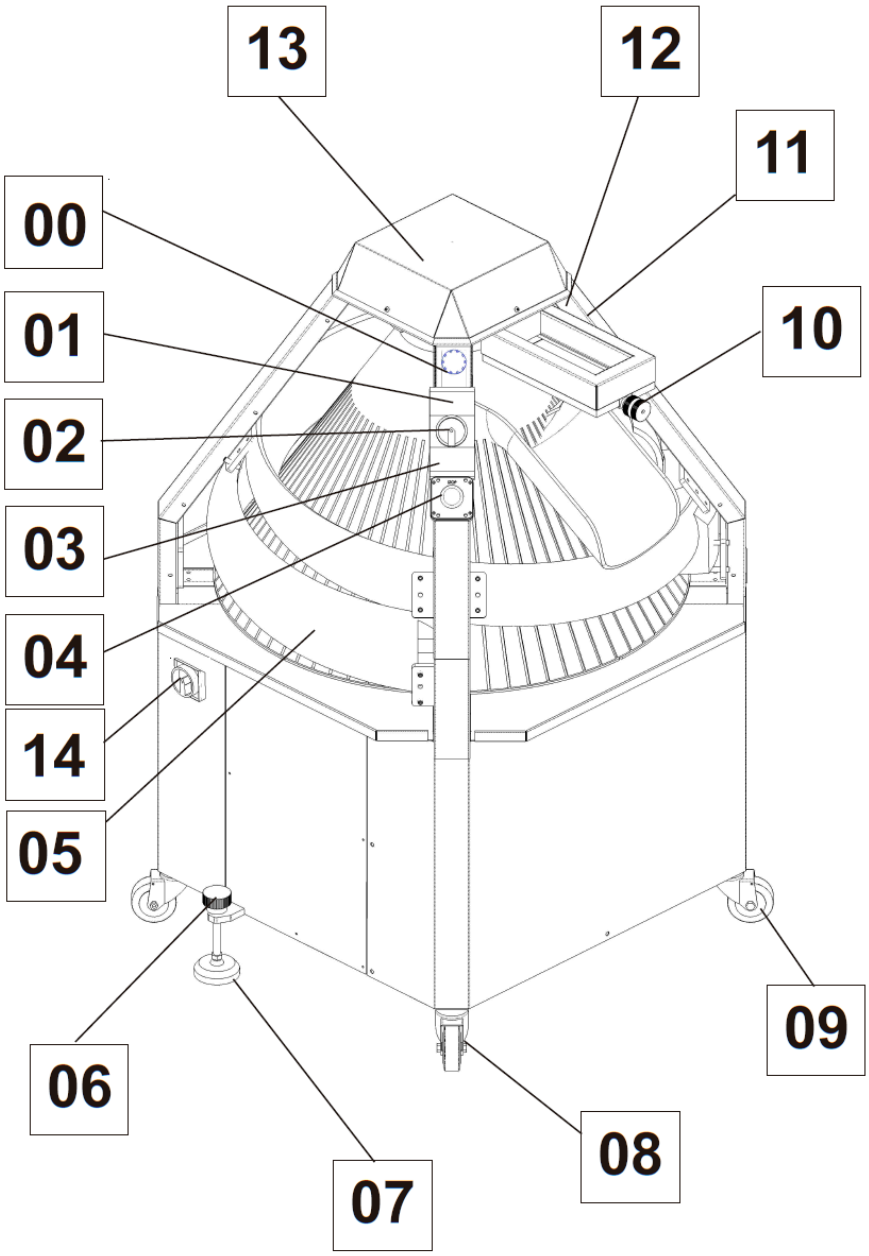
Weight (KG)	**350**
Power (KW)	**1,0**
Voltage (V)	**220 Single Phase**
Production (pieces/hour)	**Up to 2400 (1200 for large parts)**
Noise level (dB A)	**<65**

8. ELECTRICAL SCHEME



9. EXTERNAL COMPONENTS

00	FCC04A2	1 Thermostat
01	CI-PKZO-GRM	1 Housing
02	PKZMO-4A	1 Protection 2,5 4/A
03	U-PKZO	1 Minimum Coil 400V/50HZ
04	PQ01R4N	1 Emergency off_switch 40MM
05	PL 18137-P22137	1 Woollen Cloth
06	2802	2 Hand-wheel
07	40200730	2 Fixing foot
08	RU21	2 Wheel D.80
09	RU21F	2 Brake wheel D.80
10	80010217	2 Washer
11	40010056	1 Spring
12	60030233	1 Nylon bushing
13	UCF208	1 Support D. 40
14	C0120003R001	1 Switch 3P 12A



10. INTERNAL COMPONENTS

14	40010050	1 Cone pulley SPA2-355
15	TL 2517-35	1 Bushing
16	A48	2 Driving belt
17	40010051	1 Pulley 50 A2
18	UNI2222/8	2 Tensioner
19	M07	1 Motor GR80 0,75KW 4P B3
20	A43	2 Driving belt
21	40010052	1 Cone pulley SPA2-315
22	TL 2517-20	1 Bushing
23	6204 2RS1	2 Bearing
24	40010053	1 Cone pulley SPA2-71
25	TL 1108 - 20	1 Bushing
26	40010201	1 Shaft

