
Semi-Automatic Dough Divider & Rounder
(CM-30AC · 30BC · 36BC)
INSTRUCTION MANUAL AND PARTS LIST

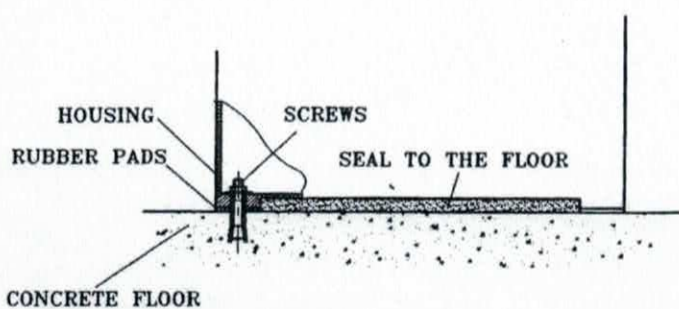
INSTRUCTION MANUAL FOR ROUNDER / DIVIDER

To ensure best performance, high efficiency, long life on the machine, please read this manual before operation.

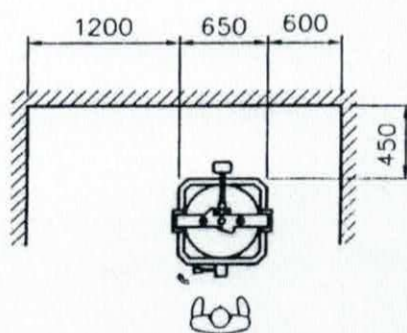
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- It is essential to ask professional engineer to make installation and test-run.
- The equipment has already been filled with adequate oil upon test-run, if there is any leakage during transportation, please check the oil content of slide bearing No.60 again with procedures as; take off the clamping lever No.3, pull up the top of machine, use two hands to pick up the moulding plate No.10, the oil content should be 5mm higher than both convex sides for normal operation.
- It will be very helpful to enlarge the operation and it's life if you select a smooth plain position for fixing the machine.
- To meet the hygiene standard, all gaps on the bottom of the machine to the floor must be thoroughly sealed with silicone after fixing.



INSTALL VIEW



WORKSTATION

7. Operation and Safety Instruction

Pre-Cleaning:

- Clean the rust preventive oil on the knife No.6, moulding plate No.10, and the check ring.
- Before formal production, please use about 2kg dough to repeatedly operate the machine to ensure it can be well clean and better operation afterwards.

Operation:

- Turn on the power switch No.5 to the right for starting it.
- Try to press the moulding lever No.12, the moulding plate No.10 should to counter-clockwise direction.
- Prepare the dough and plastic plate No.36 to practice the procedures for a couple times to ensure you can be familiar with the procedures. To completely stir a big piece of dough which enough to be divided into 22, 30 or 36 pieces and smoothly put it on the plastic plate No.36 after has to rest a short time. When the plastic plate No.36 is put onto the moulding plate No.10 of machine. It must be fixed steadily without moving.
- To adjust the height of moulding space to be referred the weight of dough and the indication on the scale. Such as the carve of 60 refers to 60 grams per piece of dough. It is required to securely fix the sleeve nut No.70 again to prevent from losing. As it will damage the surface of dough and make it plain if the carve is too small and it will not be as round as you expect if the carve is too big.

- E) To pull down the pressing lever No.6 to have the dough pressed tightly and using left hand to push the cutting handle and press the pressing lever No.6 to divide the dough.
- F) Depress fully the moulding lever No.12 slowly. Have rounding moulding plate No.10 for 3-5 seconds and shift it back gradually.
- G) Lift the pressing lever No.6 to stop position and remove the plastic plate No.36 with rounded pieces from the machine.

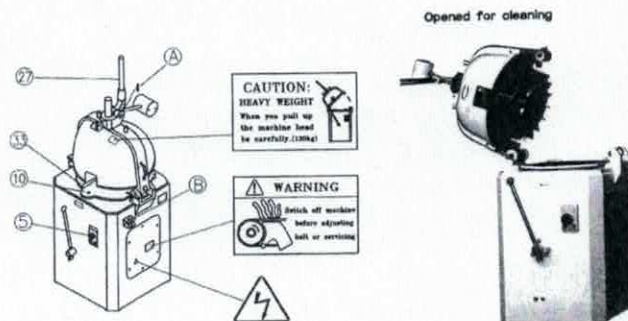
Safety Instruction:

- A) Keep people off the machine upon operation and the operator also should keep himself (herself) off the machine.
- B) When using it for dividing and rounding, the total weight should be less than 3kg or 3.6kg.
- C) It will damage the cutting equipment if any metal and hard materials mixing into the dough.
- D) User has to wear adequate food processing clothes and body covers.

8. Cleaning and Maintenance

Cleaning(The parts should be cleaning daily after operation)

- A) Turn off the power switch No.5, using pin (a) to fix the pressing lever in the vertical position then pull out the clamping lever before storage at the position of (b) and pull up the top of machine (**Caution: The weight of the top is around 120kg, please be careful when you pull up the top of machine. Remove the dough check ring clockwise.**), weight down the pressing lever No.27 and push the cutting handle No.33. (**Caution: Be carefully, the spring might rebound.**) Emerging cutting knife must be used brush & air gun to clean and the knife No.6, knife-head, dough check ring, moulding plate No.10 can not use water, too. (**Caution: put on grease or lubricants-Phillips 66 after cleaning it up. Don't use salad oil.**)
- B) It's very important to keep the opposite side of the moulding plate No.10 and the plastic plate No.36 cleaning.
- C) After brushing, please dry up the plastic plate No.36 by nature but can't be roasted, frozen or placed it at random, it will be deteriorated.
- D) For maintaining the machine hygiene, it must be seriously inspected to clean and disinfect monthly.
- E) Ultraviolet ray must disinfect plastic moulds. Attention: It can't be disinfected in high temperature.

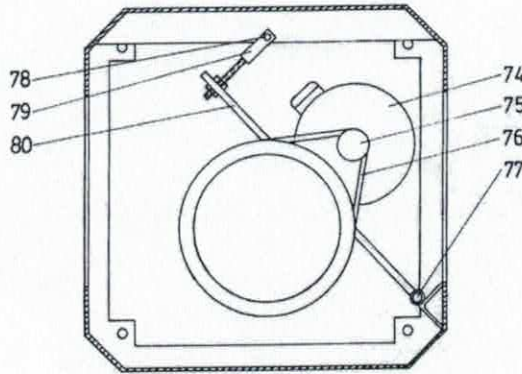


Maintenance

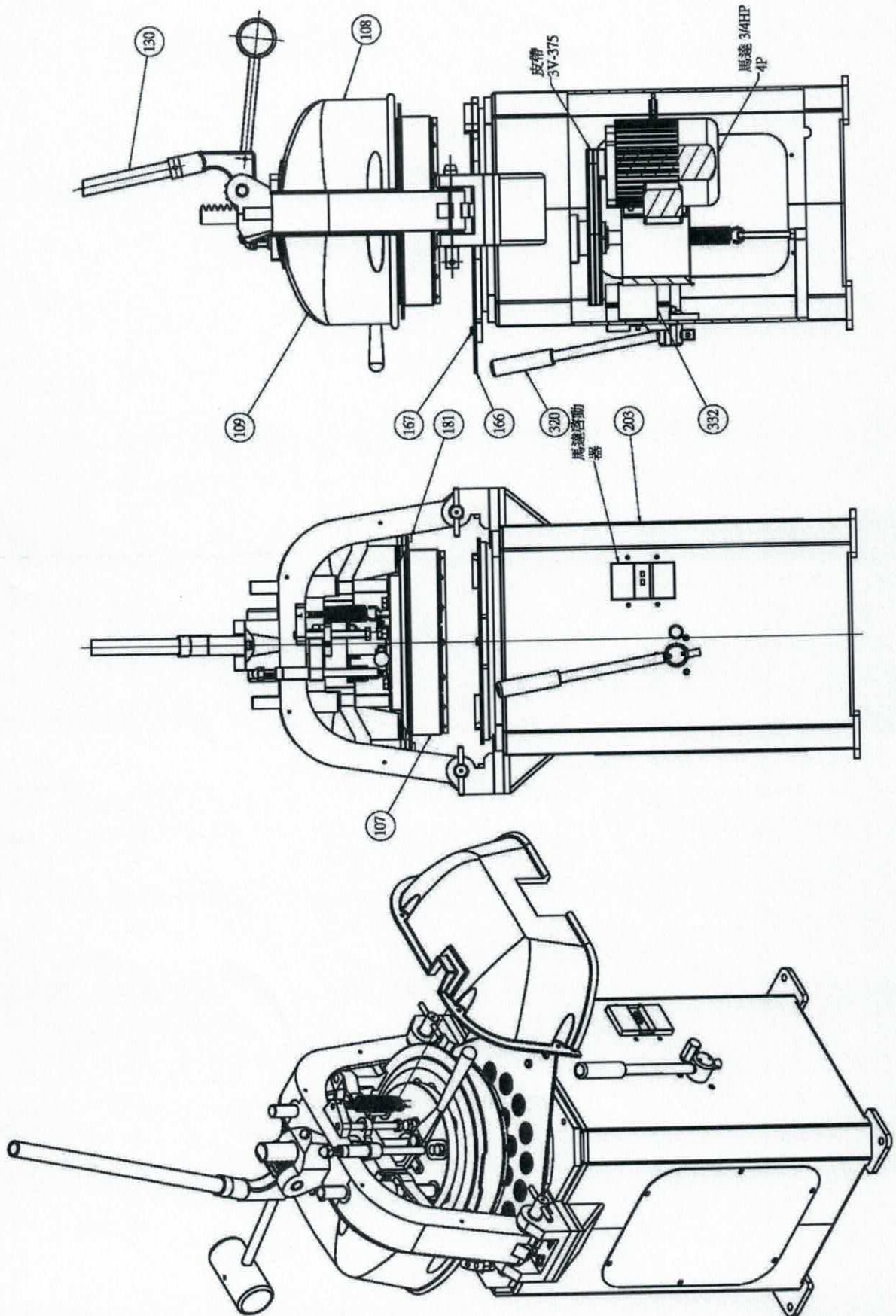
- A) If the rounder works slower, it means the belt is loose after using for a couple years. Please adjust it

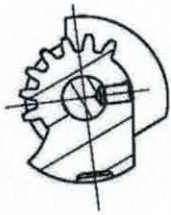
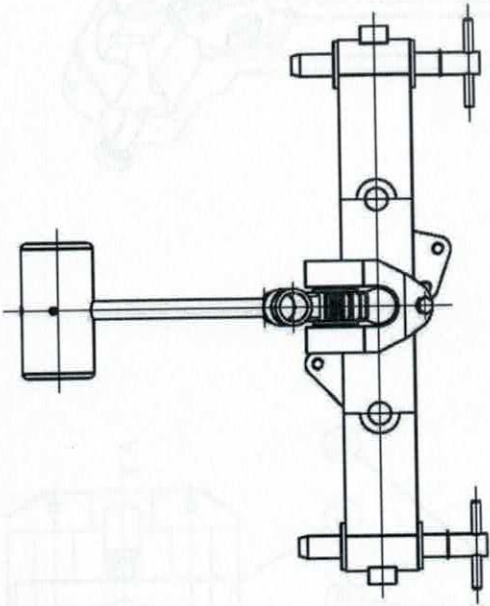
by tighten the screws No.79.

- B) Using lubricant oil such as a360b lubricant or Philip PF food oil for maintenance. It is definitely prohibited to us general oil or food oil to do maintenance.
- C) Please check the sufficiency of the oil content of slide bearing no.60 every year When refilling over 5 mm. Please add medium circulation R68 oil as the same time.

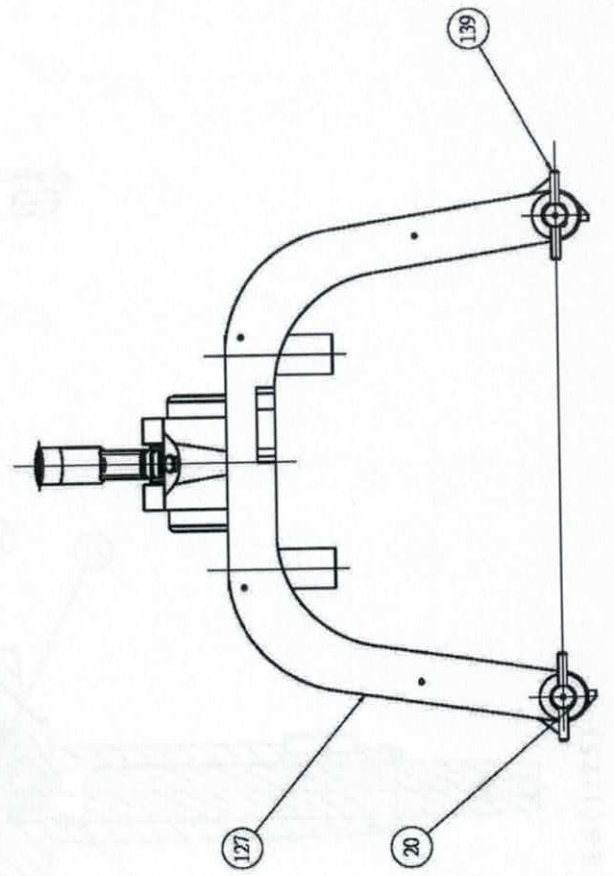
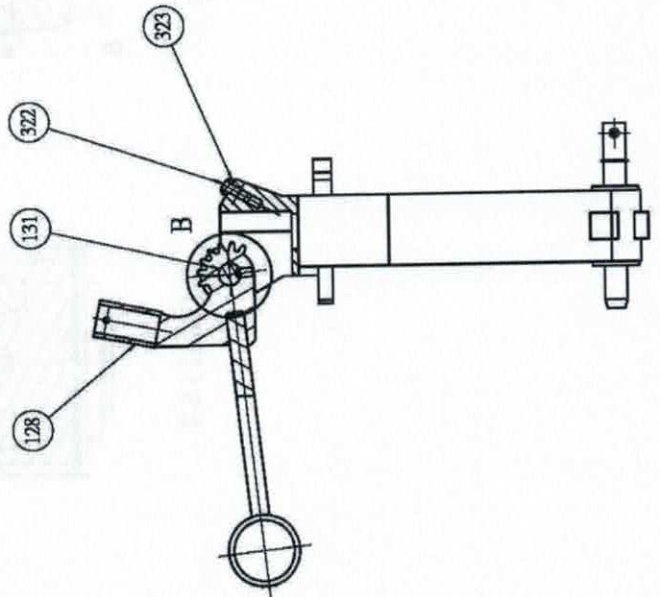


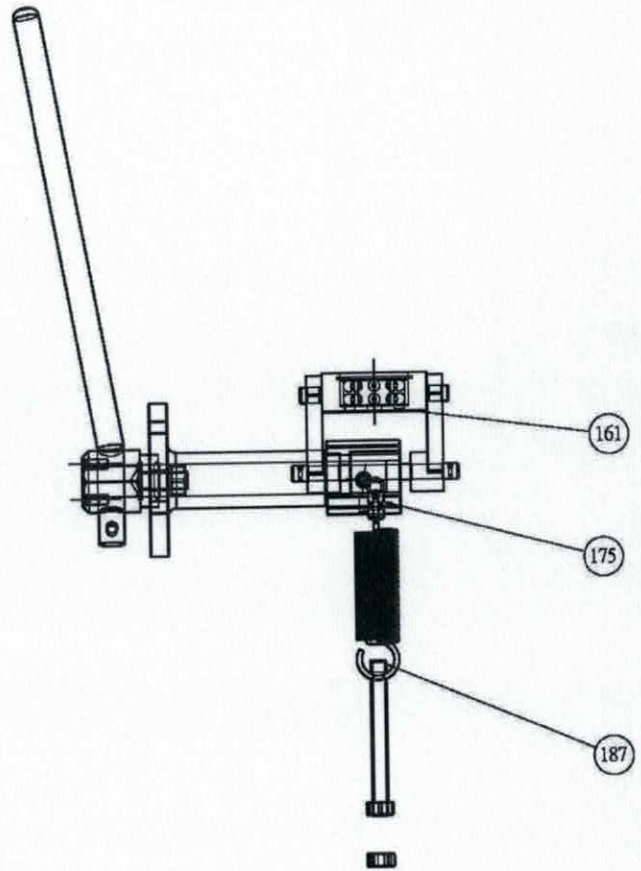
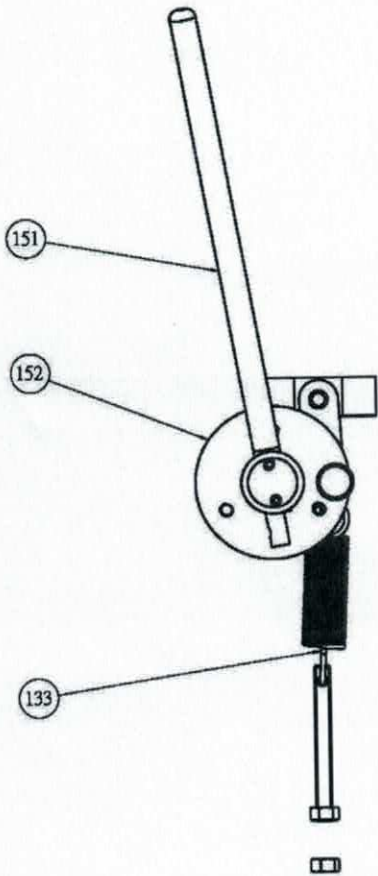
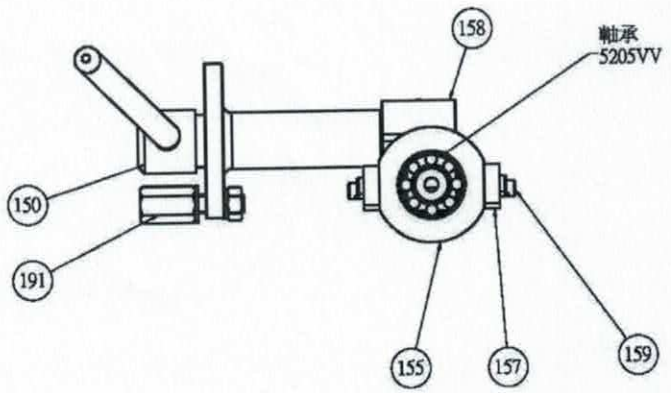
Drawing

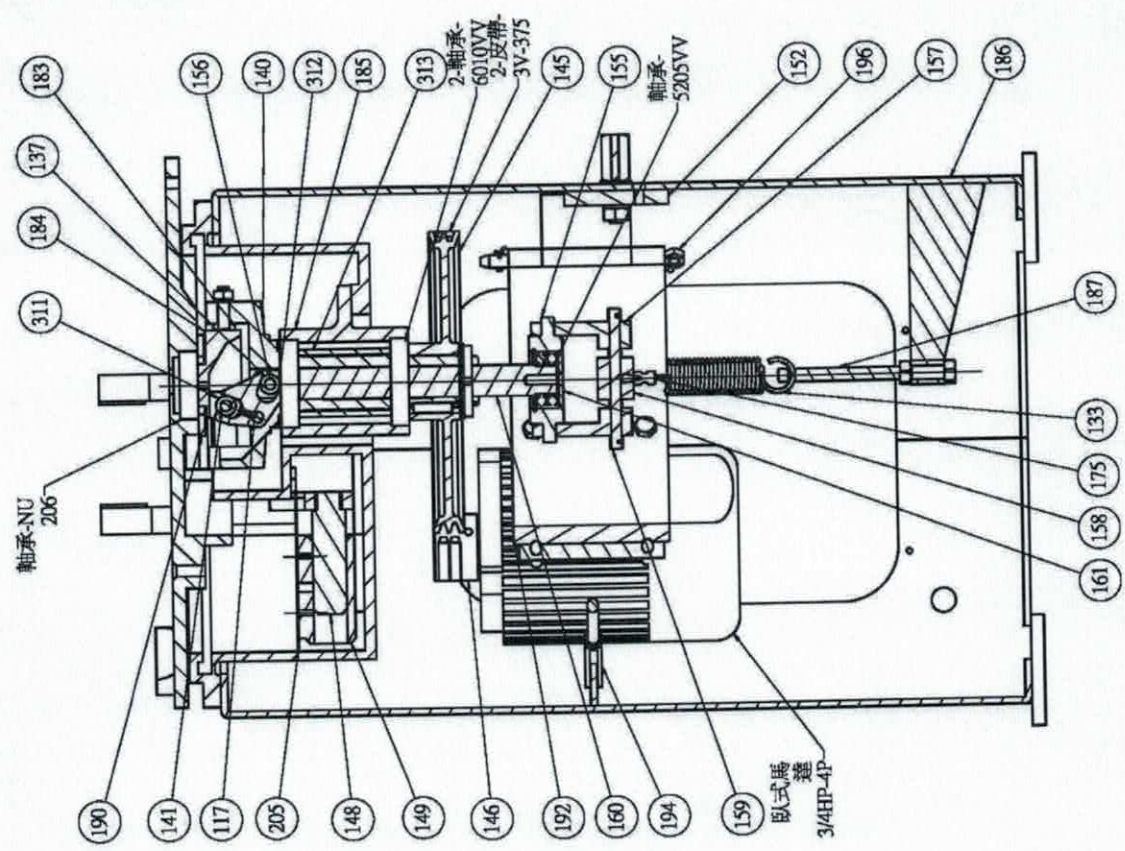
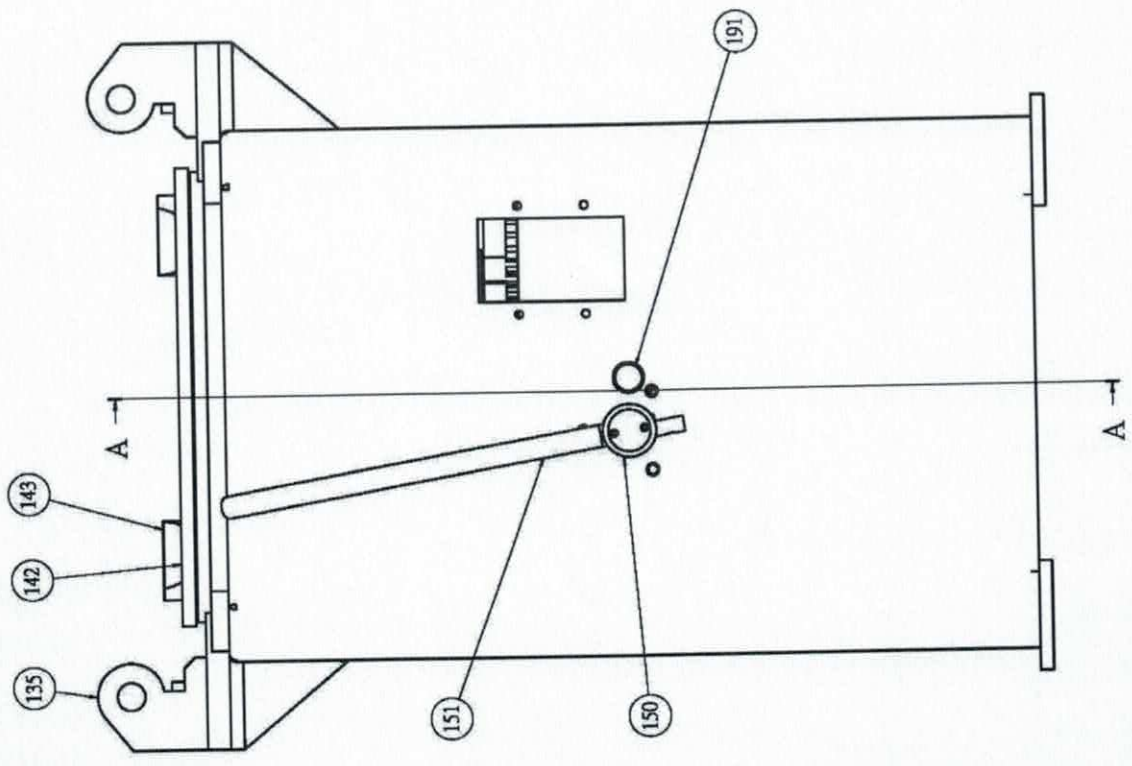




B (1:3)





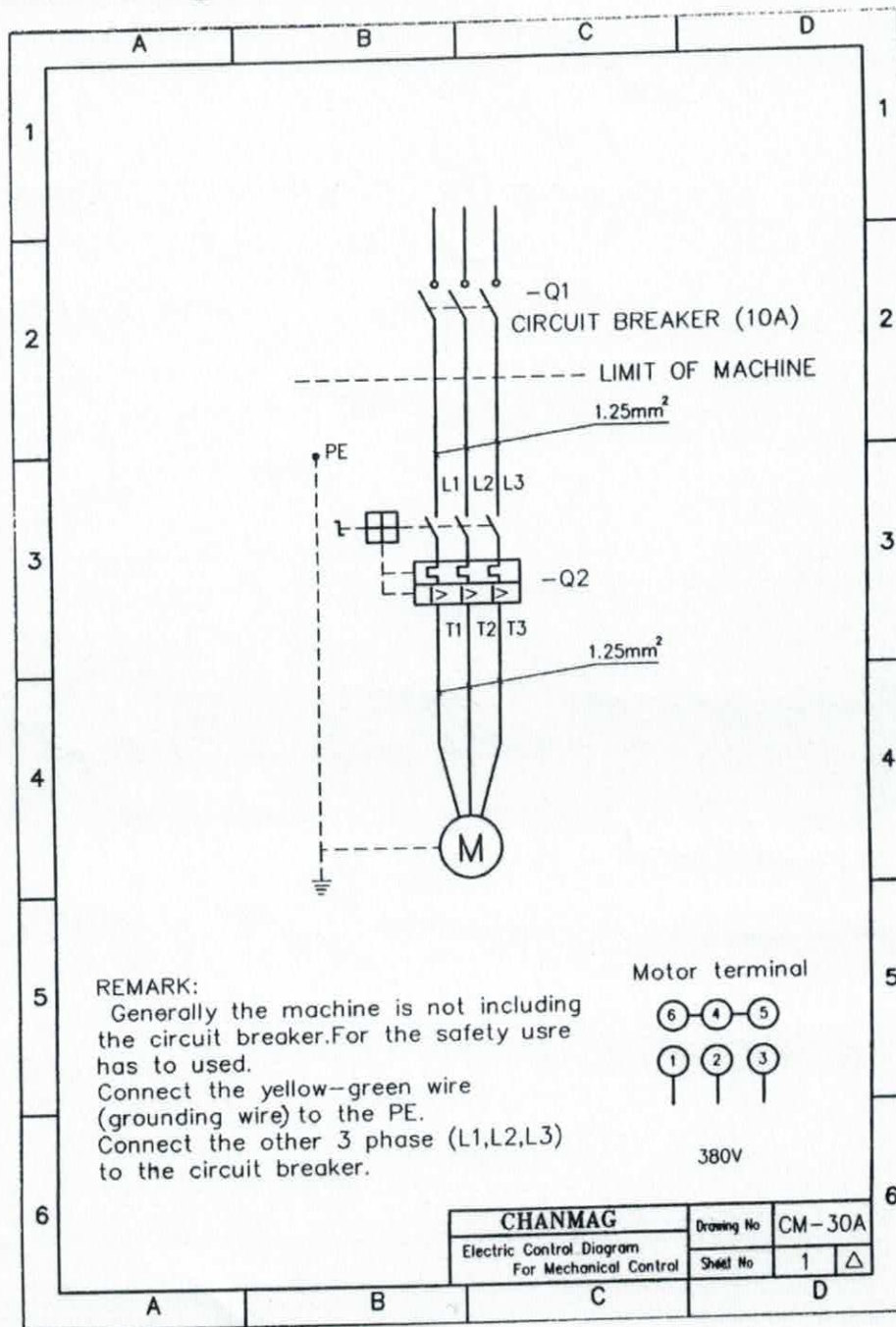


A-A (1:5)

Parts list

| No. | Description | No. | Description | No. | Description |
|-----|---------------------------------|-----|-------------------------------|-----|-----------------------------|
| 107 | Flour frame | 142 | Rounding plate | 166 | Plastic plate |
| 108 | Safety guard (rear) | 143 | Fasten black of plastic plate | 167 | Ball shape bolt |
| 109 | Safety guard (front) | 145 | Transmission belt pulley | 175 | Tension spring screw |
| 113 | Weight unit | 146 | Motor belt pulley | 181 | Clamp frame rack |
| 117 | Rolling axle | 148 | Slide plate | 183 | Guiding axle |
| 118 | Link bar | 149 | Slide shaft base | 184 | Rotary base |
| 127 | Arch base | 150 | Control bar axle | 185 | Lower slide bearing unit |
| 128 | Partial gear | 151 | Control bar | 186 | Lower machine body welding |
| 130 | Hand hold press tube | 152 | Socket | 187 | Tension spring adjust Screw |
| 131 | Axle | 155 | Pendulum holder | 191 | Fasten bolt |
| 133 | Tension spring | 156 | Up, down moving bar pin | 203 | Side cover |
| 135 | Positioning base | 157 | Lever twin edges moving base | 311 | Rotary base socket |
| 136 | Support rack pin | 158 | Lever base | 312 | Movable bar socket |
| 137 | Finish shape slide block | 159 | Lever axle | 322 | Adjusting screw |
| 139 | Support rack pin with Accessory | 160 | Up, down moving bar | 323 | Adjusting nut |
| 140 | Rotary base outer base | 161 | Washer | 332 | Start button fasten base |
| 141 | Pin | | | | |

10. Electric control diagram & Parts list



Parts list

| NO. | ITEM | Description REF. To document | Technical Data |
|-----|------|------------------------------|------------------------------|
| 1 | -Q1 | Molded Case Circuit Breaker | 3P-10A or same level product |
| 2 | -Q2 | Manual Motor Starter | |
| 3 | -M1 | Motor | 1HP, 1/3PH, 50/60HZ |