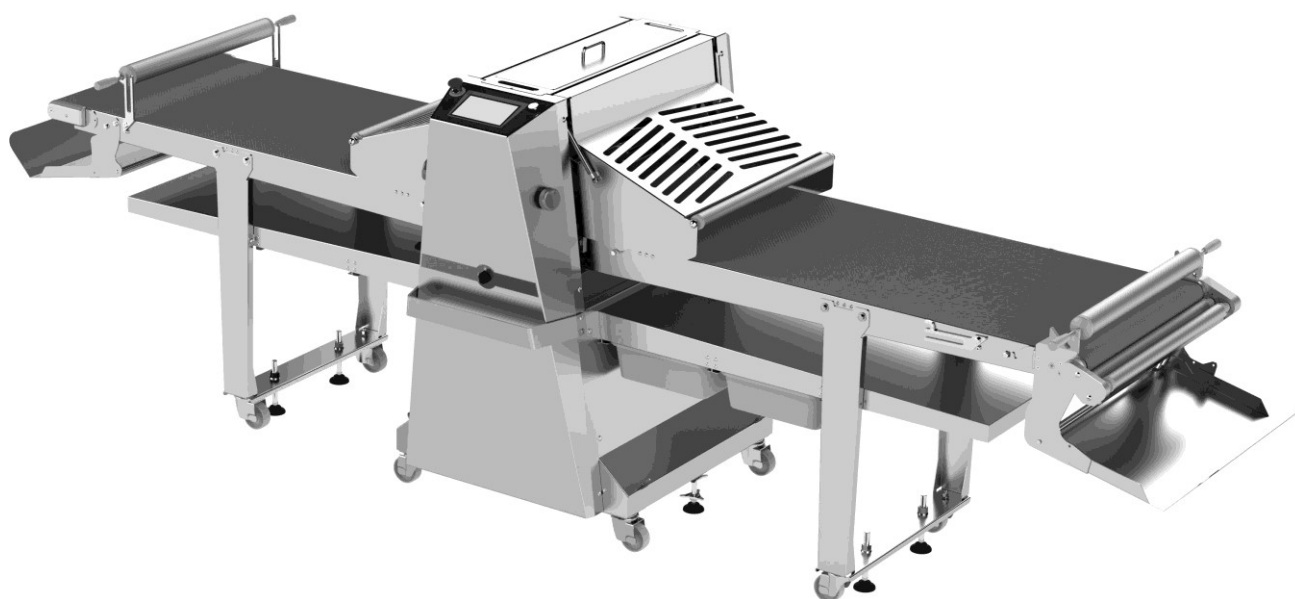




USER AND MAINTENANCE MANUAL



AUTOMATIC DOUGH SHEETER R65AXP

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1 INTRODUCTION

1.1 FOREWORD

This user and maintenance manual is to be consulted by anyone who may be appointed to, charged with and authorized to use the machine; the term "use" refers to any phase of the machine's working cycle (from assembly and transport to maintenance operation to dismantling). It is also intended for the employer, the managers and any officer within the company where the machine is used; they will have to read it thoroughly and understand it fully so as to use it to comply with the applicable rules and regulations on health and safety in the workplace, established by the laws and standards in force. **The employer**, at whose plants the machine is operating, as well as the managers and any officer within the company, must provide any operators with suitable training and information (all information must be simple and comprehensible, according to the foresight which can be reasonably expected of the intended recipient) on its correct and safe use as well as on general and specific risks in the workplace and/or inherent to the job itself. During the fulfilment of such delicate tasks, this manual can be a valid support even if it cannot be considered exhaustive since it is not strictly related to the machine itself.

The manual consists in a number of sections, each of which has its specific purpose, and in particular:

2 Machine features

3 Installation and Use

4 Maintenance

5 Safety

6 Dismantling

The word **machine** will hereafter indicate the item to be used by the purchaser and for which this manual is written and given to the purchaser, so that he may use it in a correct and safe manner.

Before carrying out any operation on the machine (transport, installation, connections to utilities, adjustments, operation, repair work, part replacement, dismantling, etc.) as well as before allowing anyone to use the machine, usually laymen, **carefully read** the general and specific instructions contained in this manual and ensure that its purposes and meaning are clear, so as to acquire the necessary knowledge to correctly operate and maintain the machine, as well as to understand and become familiar with the safety devices it is provided with, and finally the residual risks it presents, and therefore to use it in a correct and safe manner.

Keep this manual and any attached document in a safe place (drawings, diagrams, etc.).

Should the manual be lost or worn out immediately request a copy to the manufacturer clearly stating the identification details of the machine (year of construction, model, serial number, etc.).

This manual reflects the state of the art at the time the machine is launched into the market and cannot be considered unsuitable just because it has been subsequently updated following newly acquired experience or new technical solutions.

The manufacturer is not responsible for the suitability of the place where the machine is used nor for any complementary service, regardless of the fact that instructions on correct installation are given herein. The company reserves the right to update machines and manuals, but is not obliged to update machines and/or manuals previously manufactured/drawn up.

This manual is an integral part of the machine and must accompany it should it be transferred or sold for whatever reason.

ATTENTION! Before start-up and operation ensure that the machine is compliant with the purchasing order and complete with all the devices described in this manual and in any commercial documentation, especially any safety devices.

ATTENTION! The machine described in this manual is for producing sheets from bread, pastry and pizza dough by making the dough go through calibrating cylinders that feature alternating forward and backward movement. This machine cannot be used for any purposes other than those described above.

The manufacturing company will not be held responsible for any damage to properties and/or injury to people or animals due to an incorrect use of the machine.

1.2 GENERAL INSTRUCTIONS AND WARNINGS

The manufacturing company declines any responsibility for damages to people, animals or properties caused by the failure to comply with the instructions contained in this manual and by the failure to comply with the following indications:

- **Do not tamper with** the guards and safety devices installed in the machine;
- **Do not tamper with** the guards **nor disable** the safety devices installed in the machine;
- **Reposition** all the protections **and reset** all the safety devices as soon as the reason why they were removed/disabled is resolved;
- **Do not use** the machine for purposes and/or with loads and/or in a way that does not correspond to that indicated by the manufacturer
- **Only use** bread, pastry and pizza dough
- **Carry out** daily checks on safety devices, level and state of technical fluids, if present, as well as checks on the general state of the machine
- **Carefully clean** the machine on a daily basis
- **Adopt** the necessary measures and precautions when carrying out adjustments, cleaning and maintenance operations, etc. so that the machine or its components cannot be started by other people, not even by accident
- **The location where the machine is to be installed must comply with European Directives as well as with the laws and regulations in force in the country where the machine is installed and used**
- **Respect any limit regarding climate conditions** (see paragraph 2.2 TECHNICAL FEATURES) and permitted use
- **The employer**, at whose production sites the machine is installed, must guarantee that operators are suitably informed and trained on their specific tasks, on safe and correct use of the machine and on general and specific risks in the workplace and/or job-related; this manual can be a useful support tool but cannot be considered exhaustive
- **Any manager who allows third parties to use the machine** (for example the employer, and so forth) must ensure that the machine is in good conditions, whole and fully functioning, especially as regards safety equipment; should this not be the case, he must not allow it to be used and must therefore put it out of service
- During maintenance and cleaning operations (and any other such operation) **operators must wear** snug clothes free of loose parts; they may not wear aprons, jackets, unbuttoned shirts, etc. nor are they allowed to wear jewels (bracelets, necklaces, etc.) that may unhook or become entangled in protruding parts; should they have long hair, they must use hairnets.
- Should it be necessary to replace any parts, **use original spare parts only** by ordering them from the manufacturing company; should non-original spare parts be used, the manufacturing company relieves itself of any and all responsibilities for any resulting damages to people, properties and/or animals
- **Any arbitrary modification to the machine, relieves the manufacturer of any and all responsibility for any resulting damages to people, animals and/or things**

1.3 MAIN CASES FOR WHICH THE COMPANY DECLINES ANY RESPONSIBILITY

The manufacturing company declines any responsibility for damages to people, animals and properties as well as for missed production due to:

- **Use of the machine not in compliance** with the intended use or with products different from those expressly declared in this manual
- **Installation not in compliance** with the procedures illustrated in this manual
- **Use of the machine by inadequately informed and instructed personnel** and, where foreseen, inadequately trained on correct and safe use of the same
- **Maintenance, adjustments, settings, parts replacement, cleaning operations carried out** by inadequately informed and instructed personnel **and, where foreseen, inadequately** trained on how to safely and correctly carrying out interventions
- **Use of a power supply** that is different from, or not suitable according to, the specifications given in this manual
- **Poor quality or a lack of maintenance, cleaning, inspection and other procedures** specified in this manual, will free the manufacturing company from any responsibility
- **Failure to comply or partial compliance with** the instructions given in this manual
- **Arbitrary modifications** to the original features and standard equipment of the machine, without prior formal authorisation by the manufacturing company
- **Damages caused by** tools, equipment, or other components both installed and not installed on the machine, **not supplied or in any case not foreseen or authorized by the manufacturing company**
- **Failure to comply with the laws and regulations in force** in the country where the machine is to be used
- **Exceptional events or force majeure** not ascribable to the manufacturing company

1.4 TERMINOLOGY

To better understand this manual, we hereby illustrate some of the terms used herein:

MANUFACTURER, PRODUCER: Machine manufacturer.

CLIENT, BUYER: physical or juridical person who has bought a machine that is either new or in such conditions to be considered as new (that is complete with these original instructions and with the original copy of the EC Declaration of Conformity)

USER: whoever is legally responsible for machine use; in most cases the client and the buyer are the same person.

OPERATOR: any person appointed to use the machine; the term "use" refers to any stage of the standard machine life cycle.

MACHINE: the object for which this manual is written and given to the purchaser, so that he may use it in a correct and safe manner.

MACHINE USE: all the operations that can be reasonably connected to the machine during its whole life in relation to its intended use as stated in this manual.

DOUGH: preparation for bread, pastry and pizza, previously mixed using the appropriate mixer.

ORDINARY MAINTENANCE: any and all operations necessary to correctly operate and keep the machine, which do not require any special training or professional expertise due to their basic nature and can therefore be carried out by the operator.

EXTRAORDINARY MAINTENANCE: operations that are necessary to correctly operate and keep the machine which, due to their complexity and/or hazardous nature, require the intervention of specialized, expert and suitably trained personnel who possesses the necessary technical and regulatory knowledge to carry out state-of-the-art interventions in safe conditions.

DANGER AREA: any area within and/or around the machine where the presence of an exposed person is a risk for the health and safety of such person.

EXPOSED PERSON: any person totally or only partially inside a danger area.

WARNING: extremely important information for ensuring the health and safety of the operator.

IMPORTANT: important information to avoid damaging the machine and/or its components.

2 MACHINE FEATURES

2.1 INTENDED USE AND DESCRIPTION

The machine described in this manual is to be used by an operator who has been trained to use it for producing sheets from bread, pastry and pizza dough by making the dough go through calibrating cylinders that feature alternating forward and backward movement.

The machine may be used only after it has been positioned in its final location and stability is ensured.

The machine may only be used in closed and protected environments; under no circumstance should the machine be used outdoors or in areas exposed to the elements.

It is forbidden to use the machine in marine environments (on the coast, on ships, offshore platforms, etc.).

It is forbidden to use the machine in spaces open to the public for purposes and/or with products or in a way that are different from what is stated in this manual.

It is forbidden to use the machine before all connections to the utilities present in the installation site have been carried out, as provided for by this manual.

It is forbidden to use the machine in environments where there is a risk of fire and/or explosion and/or of accidents, as provided for by the laws in force; moreover, the machine cannot be used in case of high humidity levels and/or in wet environments or in areas where there is excessive water vapour and/or oil vapours and/or dust, or if there are corrosive substances and/or gases

It is forbidden to use the machine in case of anomalous vibrations and or impacts

For safety, hygiene, health reasons and for guarantee purposes, the machine cannot be used for any purpose other than that herein declared. Any use that is deviates from the one declared herein is to be considered incorrect, non-compliant and not contemplated by the manufacturer and is therefore potentially dangerous for the health and safety of the people exposed, as well as for animals and/or properties.

IMPORTANT! The operator must have read and understood the instructions and indications given in this manual before starting or using the machine; therefore, when the machine is started-up, started and used, the user implicitly accepts all and any public and criminal liability for damages to people, animals and properties that may occur following failure to respect such instructions and indications, even if partially.

IMPORTANT! The machine was designed and built for "standard" use. Standard use means intermittent use over work shifts.

Model	Work table length
16	1,600 mm
18	1,800 mm
20	2,000 mm

In addition to the main structure, the standard R65AXP machine consists of (Figure 1):Figure 1

1. Front/back guard
2. Flour duster (optional lid)
3. Mobile guards with safety microswitch
4. Belt
5. Rolling pin to manually process the dough
6. Dough collecting tray
7. Work table
8. Legs with wheels
9. Swivel wheels
10. Stabilising feet
11. Main cut-out switch
12. Electric board
13. Flour collection drawer with safety microswitch
14. Cycle start/stop push-buttons
15. Locking/unlocking knob for scrapers
16. Touch screen
17. Lower roller scraper
18. Lower roller
19. Upper roller
20. Upper roller scraper
21. Shelf with trays
22. Dough reeler
23. Trays

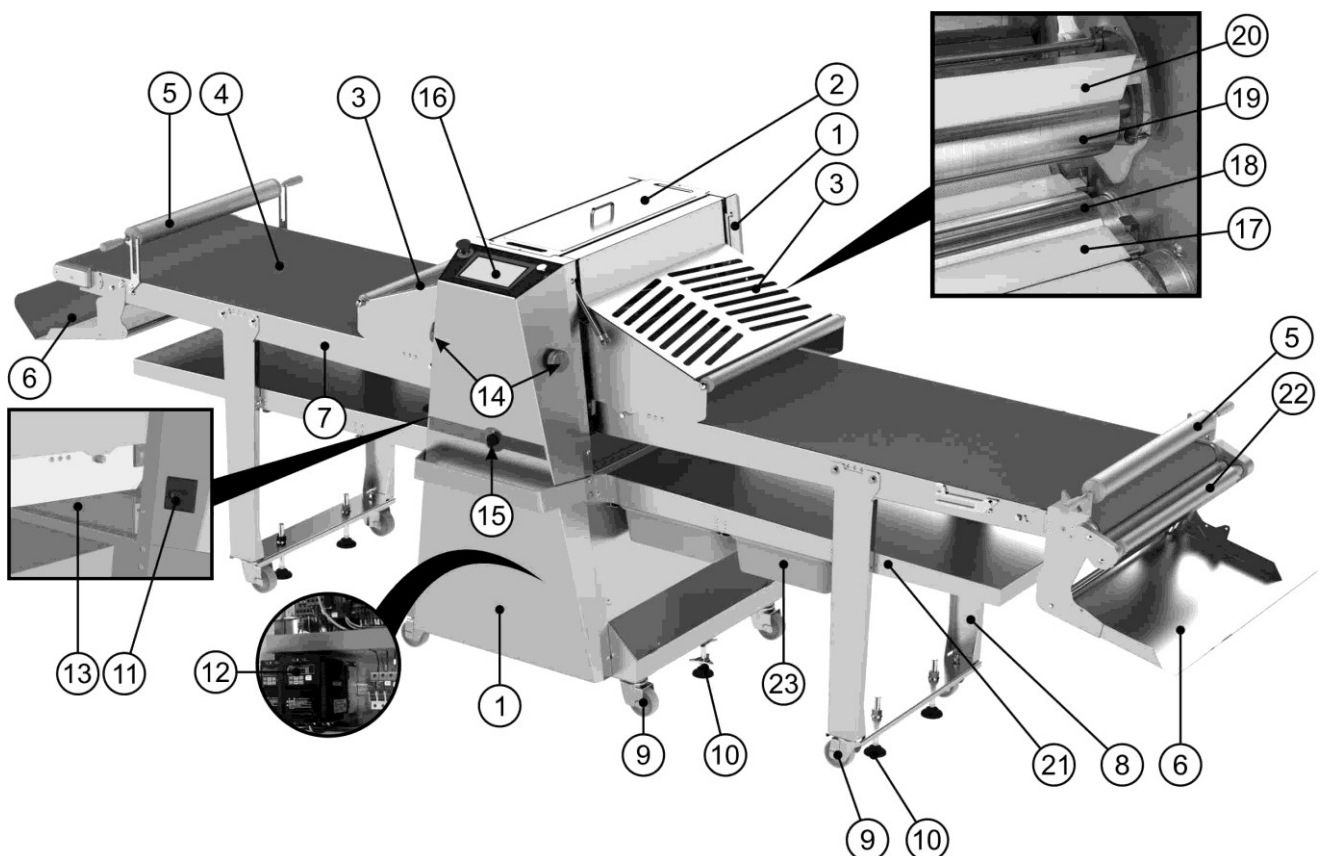


Figure 1

The models with cutting station, to cut the dough and make products such as croissants, etc., differ from the standard model and are equipped with (Figure 2):

1. Cutting knives lifting / lowering levers
2. Knife quick release system
3. Knife pressure adjustment knobs
4. 1st knife (option)
5. 2nd knife (option)
6. Knife front guard
7. Mobile guard with safety microswitch
8. Legs with wheels and with knife holders (optional)
9. Shelf with trays

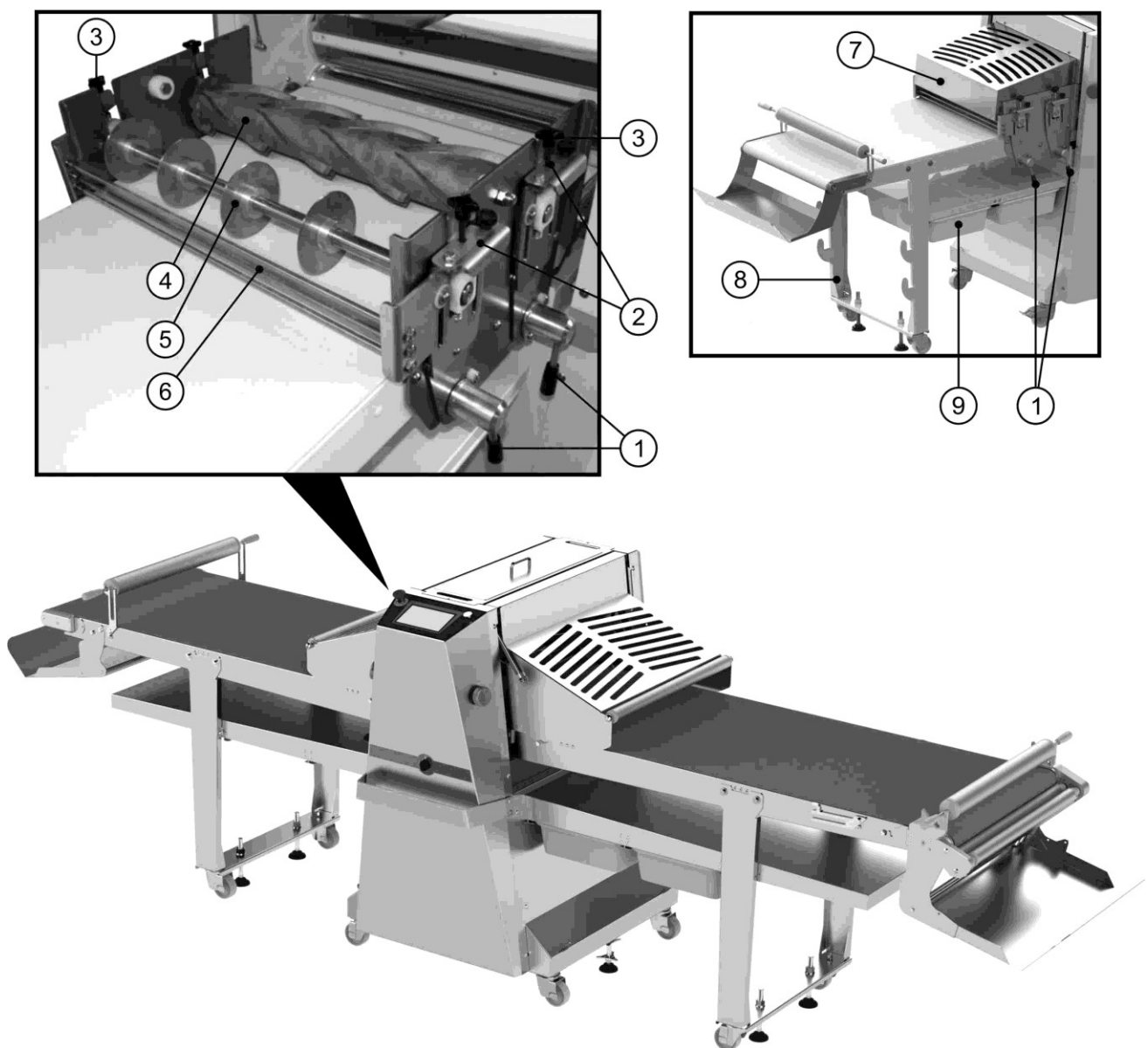


Figure 2

2.2 TECHNICAL FEATURES

R65AXP		
CYLINDER LENGTH	mm	660
CYLINDER DIAMETER	mm	Ø 84
CYLINDER OPENING	mm	0-60
TABLE LENGTH	mm	1600-1800-2000
TABLE WIDTH	mm	650
WEIGHT OF THE MACHINE BODY WITH THE FLOUR DUSTER	kg	
TABLE WEIGHT: 1600 with fixed leg	kg	
TABLE WEIGHT: 1800 with fixed leg	kg	
TABLE WEIGHT: 2000 with fixed leg	kg	
TABLE WEIGHT: 1600 with fixed leg and dough reeler	kg	
TABLE WEIGHT: 1800 with fixed leg and dough reeler	kg	
TABLE WEIGHT: 2000 with fixed leg and dough reeler	kg	
RATED VOLTAGE / FREQUENCY (THREE-PHASE) *Admissible tolerance: +/- 10%	V/Hz	400*; 230* / 50; 60
RATED VOLTAGE / FREQUENCY (SINGLE-PHASE) *Admissible tolerance: +/- 10%	V/Hz	230* / 50; 60
NO. OF ELECTRICAL PHASES	-	3/2~ + PE
MIN/MAX ROOM TEMPERATURE	°C	-5 / +40
MAXIMUM AVERAGE ROOM TEMPERATURE OVER A PERIOD OF 24 HOURS	°C	35
MAXIMUM RELATIVE ROOM HUMIDITY (WITH T<40 °C)	%	50
MAXIMUM ALTITUDE ABOVE SEA LEVEL	m	2000

⁽¹⁾ (COMPLETE WITH DOUGH COLLECTION TRAYS - ROLLING PIN NOT INCLUDED)

NB: sizes and weights can vary depending on product and accessories update

2.3 OVERALL DIMENSIONS

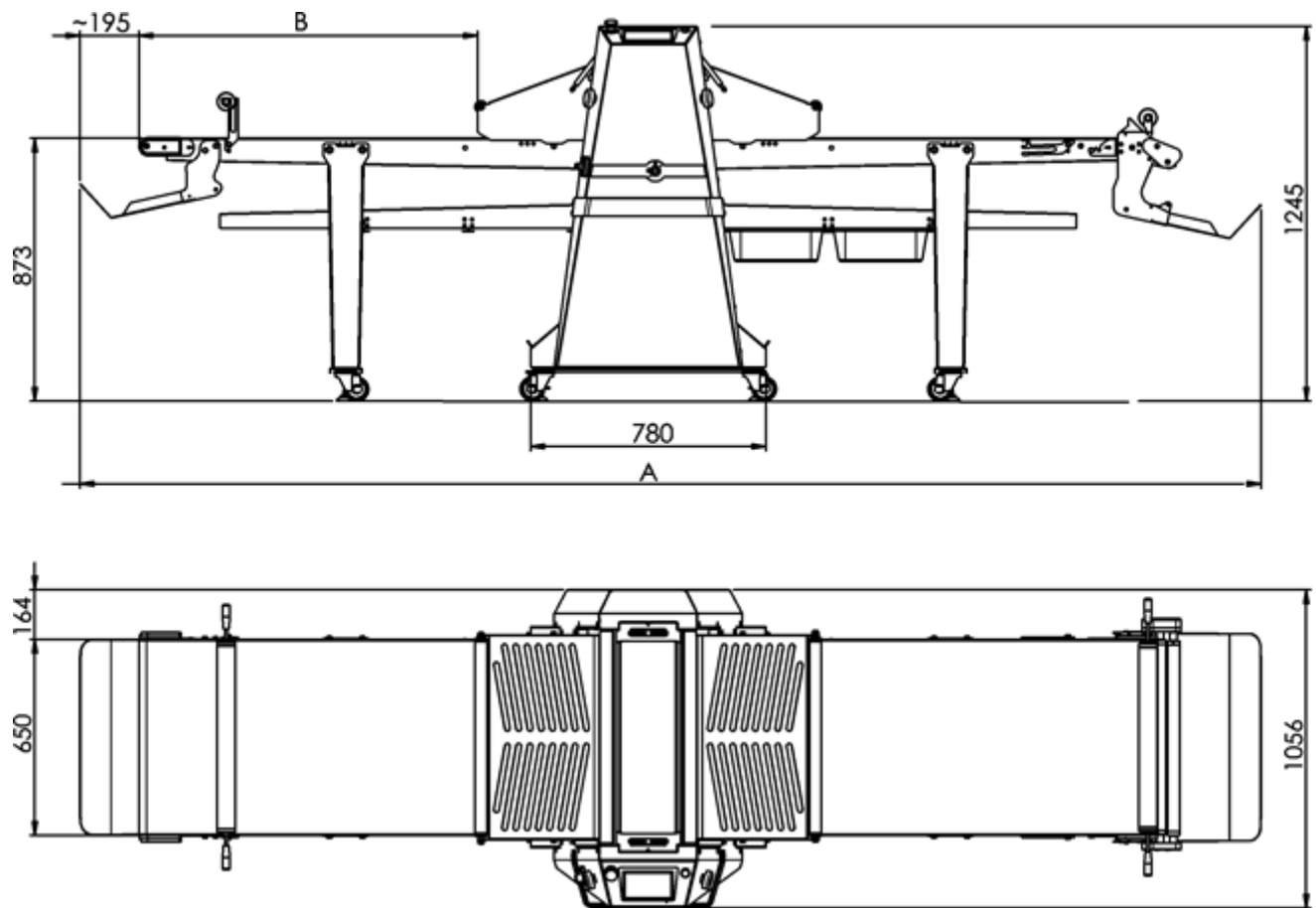


Figure 3

Model	Work table length	A	B
16	1,600 mm	3930	1124
18	1,800 mm	4330	1324
20	2,000 mm	4730	1524

2.4 CONTROL AND ADJUSTMENT DEVICES

As illustrated in Figure 4, the machine is supplied as standard with the following control and adjustment devices:

1. Main power switch; **O = OFF, I = ON**
2. Flour collection drawer closing control microswitch
3. Mobile guards closing control microswitch
4. **EMERGENCY STOP** push-button (red mushroom on yellow background)
5. 7" Touch screen
6. Push-button to enable operation with a pilot light that indicates the operating status (fixed blank light → power present; flashing white light → machine ready)
7. Cycle start and pause push-buttons (see the Programming manual)

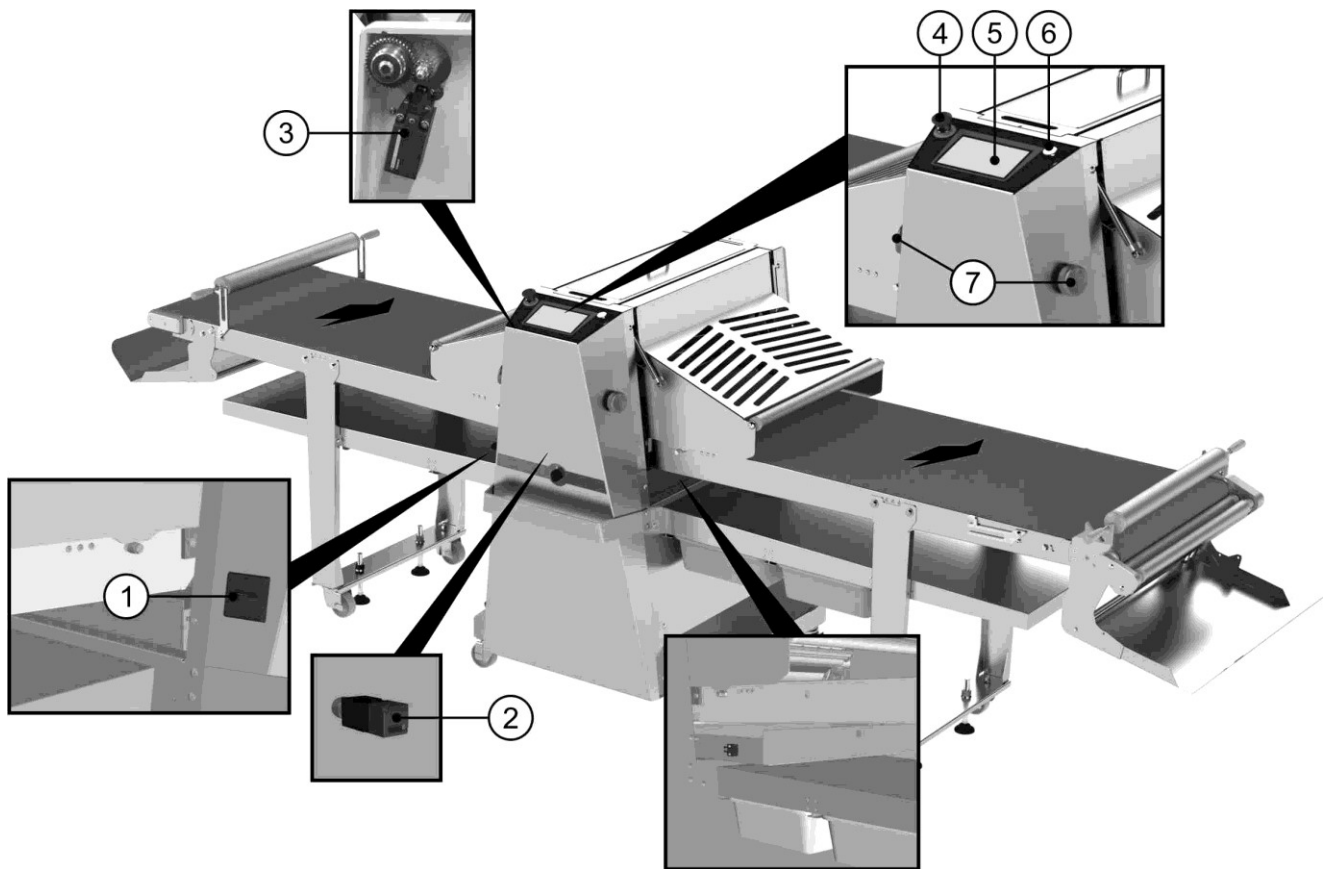


Figure 4

2.5 IDENTIFICATION PLATE

The identification plate Figure 5 is affixed on the back of the machine and shows the CE marking, the manufacturer details, the machine model, the serial number, the year of manufacture, the weight, the essential electrical data. All such data are permanently printed on the plate.

		CE 	
MODELLO / Model			
MATRICOLA / Serial Number			
ANNO COSTRUZIONE / Year	PESO / Weight		
VOLTAGGIO / Voltage			
POTENZA / Power			
AMPERE / Ampere			
OPTIONAL / Optional			

Figure 5

3 INSTALLATION AND USE

3.1 WARNINGS ON INSTALLATION SITE

The room where the machine is to be installed must comply with the laws and regulations in force.

3.2 INSTRUCTIONS FOR LIFTING, TRANSPORT AND POSITIONING OPERATIONS

The location where the machine is to be kept, stored and/or used must comply with the laws and regulations in force as well as ensure machine stability along with suitable protection from possible damages and from the elements.

If the machine is not used for long periods of time, it must be stored in a closed, dry place inaccessible to unauthorized personnel, where it is safe from any damage; it must also be protected using waterproof sheets. The machine is shipped in one single package consisting of machine body and disassembled work table. The manufacturer positions and fixes the machine on a pallet and, if provided for in the contract, in a thick cardboard box or wooden cage before shipment.

When handling and/or transporting the machine, take any precaution to avoid or reduce as much as possible any hazard to people, animals and properties.

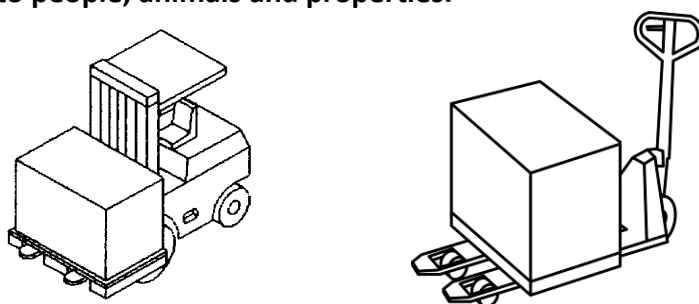


Figure 6

Loading/unloading operations onto/from the means of transport are usually carried out using a forklift truck/pallet truck of suitable capacity whose arms must be inserted in the spaces provided at the base of the pallet, as illustrated in Figure 6.

Remove any packing; check the state of the machine; separate the different materials that make up the packing (cardboard, plastic, wood, etc.) and put them in the relative collection places that should be accessible only to authorized personnel, before giving them to a company specialized in waste disposal.

Wooden joists and pallets must be taken to the dedicated collection area.



Respect for the environment is an obligation provided for by the law.

Ensure that there is enough space around the machine to operate comfortably and to correctly carry out any cleaning, adjustment and/or maintenance operations. Brake the wheels by lowering the dedicated levers (Figure 7) and fasten the feet to increase the stability of the machine.

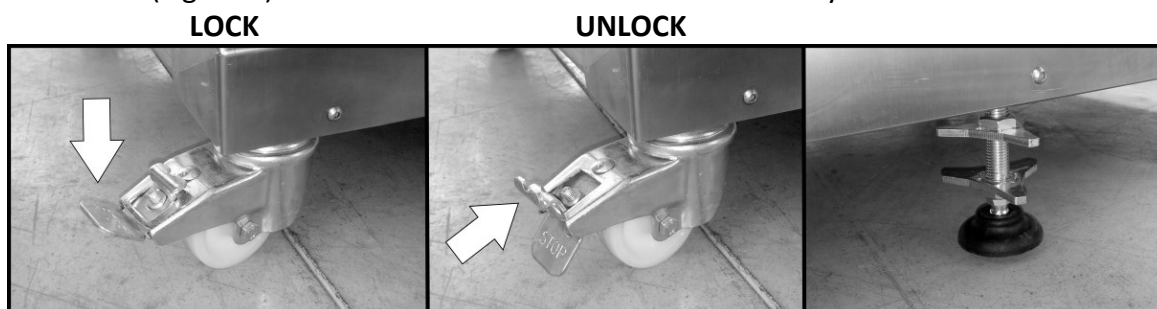


Figure 7

3.3 ELECTRICAL CONNECTION

Ensure that line voltage corresponds to that declared by the machine manufacturer and indicated in the identification plates (see paragraphs 2.2 TECHNICAL FEATURES). Connection to the site's electrical system must be carried out in compliance with the laws and regulations in force, with reference to the data and indications given in this manual. The machine is supplied complete with cable and three-phase/single-phase plug, with earth pole. Electrical connection must be carried out by a qualified engineer.

ATTENTION! A magnetothermic device must be fitted downstream the power socket so as to ensure disconnection from the electric grid; the minimum opening distance between contacts is 3 mm.

Should the power voltage fluctuate with intervals that exceed tolerance values, as specified in the table (see par. 2.2), it will be necessary to adopt a stabilizer.



The manufacturer declines any responsibility in case of missing or non-conforming earthing system.

IMPORTANT! Check phase connection before starting up the machine. Start the machine in manual mode (see the programming manual), then press the start push-button (Ref. 1. 1 Figure 8) on the right: the belt should start moving from right to left (as illustrated in the figure)

ATTENTION: if the belt moves in the opposite direction, disconnect the power and invert one phase in the plug.

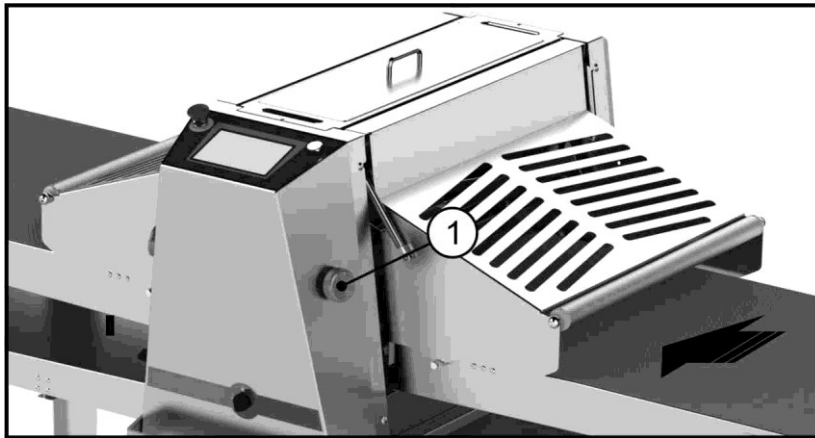


Figure 8

3.4 OPERATION AND USE

ATTENTION! VERY IMPORTANT!

The machine can only be used if the conditions illustrated in par. 2.1 are present. Only one operator can run the machine at any given time. Anyone who does not possess the qualifications illustrated in this manual is not allowed to carry out any operation on/with the machine. These conditions are necessary, albeit not sufficient, to safely use the machine.

The machine must be used only by adequately trained and informed personnel that has been expressly authorized; it is the employer's duty to appoint suitable people to use the machine and to provide them with the necessary information and training.

The Manufacturer declines any and all responsibility for damages to people, animals and properties due to failure to comply with the provisions contained in this manual.

The operator using the dough sheeter for production purposes should position himself in front of the machine, on the controls side.

3.4.1 PRECAUTIONS AND PRELIMINARY CHECKS

- Before using the dough sheeter, ensure that all the wheels fitted with brakes are blocked (see Figure 7) and that the feet are correctly positioned
- **At the beginning of each working day and/or working shift** follow the instructions given in par. 5.2.3 to ensure that all the safety devices are efficient.

3.4.2 GENERAL INFORMATION ON NORMAL OPERATION

Before starting to use the dough sheeter, please consider the following information:

- Every time the machine is switched on, press the push-button Ref. 6 Figure 4 to enable machine operation. This procedure must be carried out any time the machine is stopped following the triggering of a safety device (when a guard is opened or the emergency push-button is pressed)
- After pausing for 90 seconds the machine enters the "stand-by" mode: the display is switched off and any operation is inhibited. Touch the display to resume machine operation and follow the commands on the screen.
- Switch off the machine at the end of each working day or shift: turn the main switch to O (OFF) and disconnect the power plug.

3.4.3 STARTING AND OPERATION

- Use the plug (if provided) to connect the machine to the power socket
- Make sure that all the guards are closed Ref. 3 Figure 1 (if not, the machine won't work)
- Make sure that the flour collection drawer is correctly located in its position on the side of the machine (if not, the machine won't work)
- Make sure that the emergency stop push-button Ref. 4 Figure 4 is disabled (if not, reset it)
- Position the main switch to **I (ON)** Ref. 1 Figure 4
- The push-button that enables operation, Ref. 6 Figure 4 will light up to indicate the presence of power (fixed white light)
- Press the push-button: if the procedure was successfully carried out, the white light will flash

3.4.4 OPERATING AND USING THE MACHINE

After switching on and enabling the machine as described in par.3.4.3, it is possible to start working:

- Load a program (recipe) as described in the **PROGRAMMING MANUAL**
- Put the dough on the work table on the side indicated on the display
- Press one of the two cycle start push-buttons Ref. 14, figure 1.
- The machine will autonomously complete the sequences memorised in the recipe being used

3.4.5 FLOUR COLLECTION DRAWER

The machine is fitted with an excess flour collection drawer (Ref.1 Figure 9). There is a safety microswitch (Ref. 2 Figure 9) on the machine body that inhibits operation if the drawer is pulled out (for example, to empty it and/or clean it). The microswitch is enabled/disabled using the key present in the drawer (Ref. 3 Figure 9).

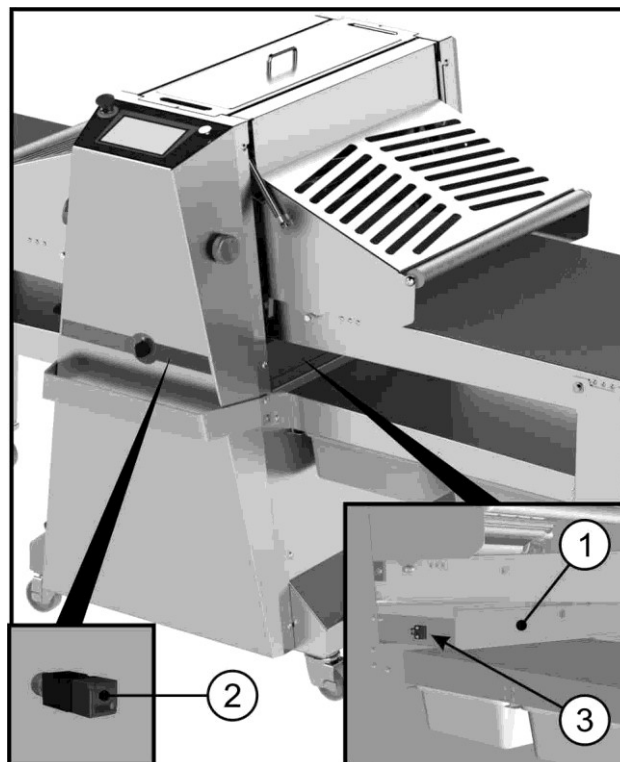


Figure 9

3.4.6 ASSEMBLING AND DISASSEMBLING THE WORK TABLES

Before assembling or disassembling the work tables, take the main switch to O (OFF) and unplug the power plug, to prevent the machine from starting

To correctly assemble the tables, two people must operate as described hereafter and in accordance with Figure 10 and Figure 11:

DISMANTLING:

- Remove the two trays, Ref.1 Figure 10
- Slightly loosen the two screws that fasten the intermediate table, Ref.2 Figure 10
- Disconnect the switch, Ref. 3 Figure 10
- Loosen and remove the two screws that fasten the intermediate table to the legs, Ref. 4 Figure 10
- Remove the intermediate table, Ref.5 Figure 10, inclining it vertically to facilitate its removal
- Lift the relative guard, Ref.6 Figure 10
- Use a wooden or plastic bar as a lever, pulling externally to unhook the table, Ref. 7, while

another operator firmly holds the table level, Ref. 8 Figure 10, and rotates it in the direction of the arrow

- Completely remove the table and place it in a safe place, paying attention to the grease on the two pins

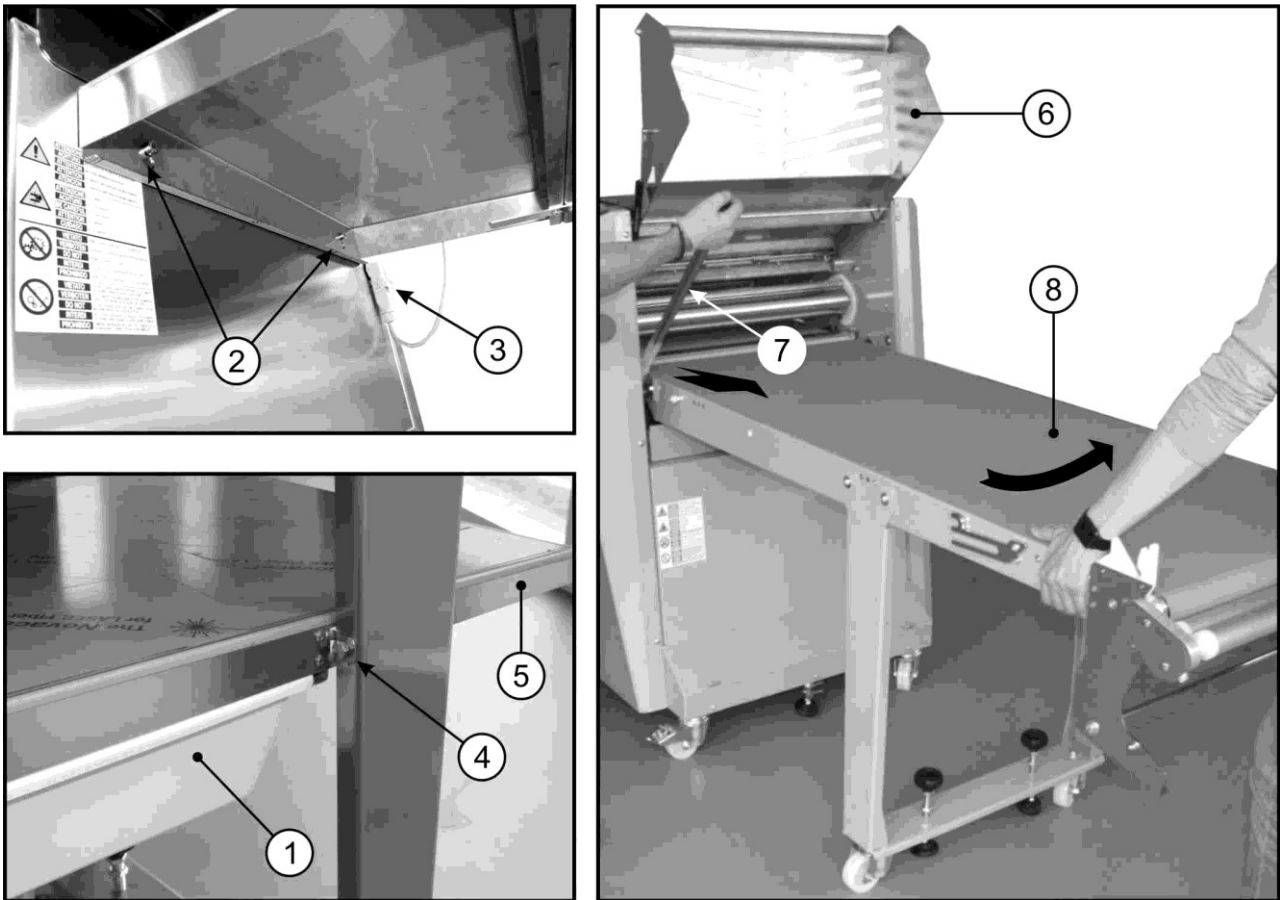


Figure 10

INSTALLATION:

- Move the table closer checking that the coupling is properly inserted into the slot, Ref. 2 Figure 11.
- Follow the instructions given for the disassembly procedure, but in the reverse order.
- Move the belt forwards and backwards in the direction of the arrow, Ref. 1 Figure 11, so as to correctly insert it inside the slot, until you hear a clicking sound and the belt locks in position.

Refer to 2.2 TECHNICAL FEATURES for the specific weight of each table.

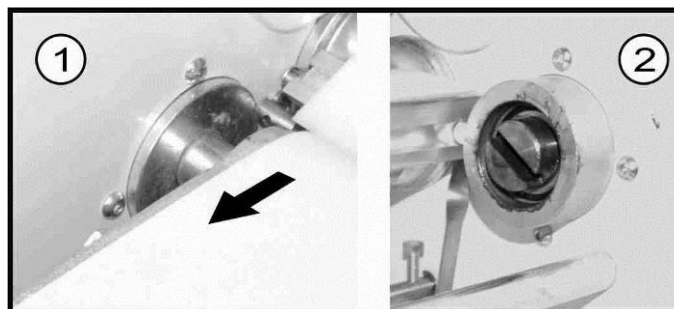


Figure 11

3.4.7 CUTTING STATION

The following instructions refer to the models fitted with a cutting station: for this accessory, it is possible to remove / replace the cutting disks and adjust their working pressure.

Follow these instructions to assemble / disassemble the knives (Figure 12):

- Use lever (Ref. 1) to lift the knife support (rest position)
- Loosen the knob (Ref. 2) and rotate the knife-release system (Ref. 3)
- Grab the knife by the nylon side guides (Ref. 4), using both hands, and insert the guides into the appropriate slots on the machine shoulders.
- Close the knife quick-release system (Ref. 3) and fasten it using the knob (Ref. 2).
- Rotate the lever (Ref. 1) clockwise to put the knife back in its work position
- If the dough is not cut correctly, manually adjust the cutting pressure of the knives using the knob (Ref. 5) on both sides of the table. To do this, loosen the locking nut, slightly tighten the knob and, hence, test the result of the cutting operation. Proceed a little at a time until the required pressure has been reached, then fasten the nut. **ATTENTION! If the pressure of the knife is excessive, the knife may cut the belt.**

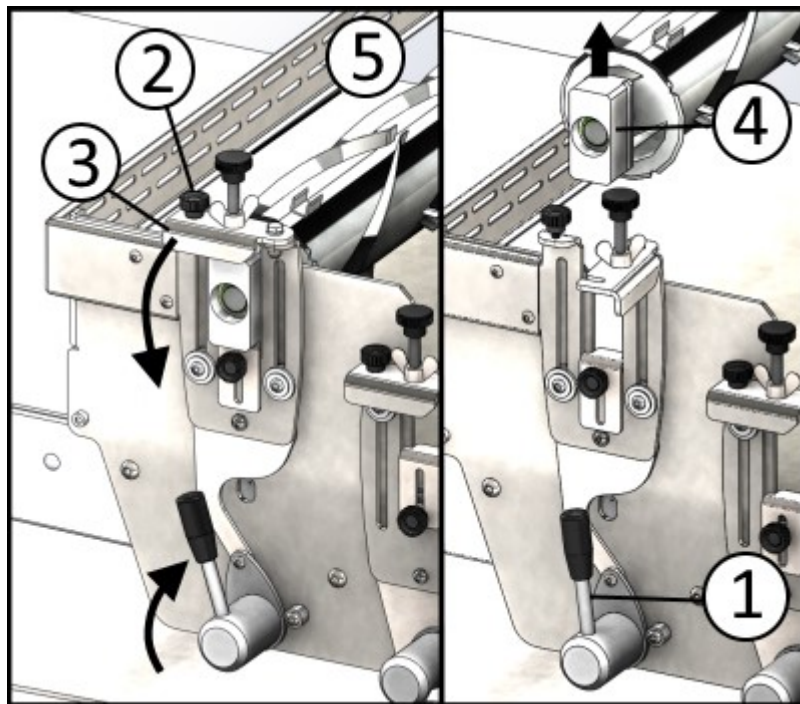


Figure 12

3.4.8 FLOUR DUSTER

Use the flour duster in the following manner (refer to Figure 13):

- Remove the lid Ref. 1 (optional) and evenly fill the hopper with flour (max. capacity: about 6 kg)
- It is possible to limit the width of the dusting area by adjusting the dividers Ref. 2. To dust over the whole width of the belt, the dividers must be fully open (pull in the direction indicated by the arrow)
- Adjust the quantity of flour to be dusted, by modifying the rotation speed of the motor (refer to the PROGRAMMING MANUAL).

WARNING: we recommend not to use flour with a high humidity level

- The flour duster can operate in manual or automatic mode: in manual mode, the icon on the touch screen activates the flour duster and it is also possible to adjust the speed of rotation of the motor at the same time. In automatic mode, the flour duster is activated according to the settings in the recipe.

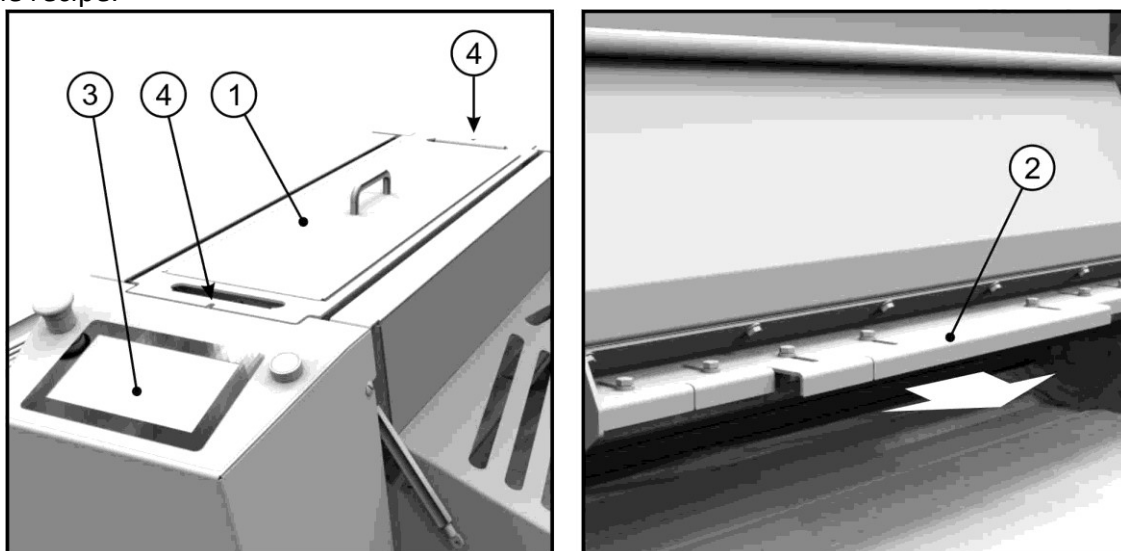


Figure 13

The flour duster hopper can be quickly removed to clean it or carry out maintenance operations. Before assembling or disassembling the work tables, take the main switch to O (OFF) and unplug the power plug, to prevent the machine from starting. To correctly disassemble the tables, two people must operate as described hereafter and in accordance with Figure 14:

- Remove the lid Ref. 1 (if present) and unscrew the two screws Ref. 4 Figure 13
- Close all the dividers Ref. 2 by pushing them to their stop (this operation prevents the flour from coming out after having removed the hopper)
- The two operators, standing facing each other at the two sides of the machine, must lift the flour duster using the corresponding handles, until it comes out from the head
- At this point it is possible to pour out any flour from the hopper and clean it
- Assemble the hopper by following the instructions given for disassembling, in the reverse order

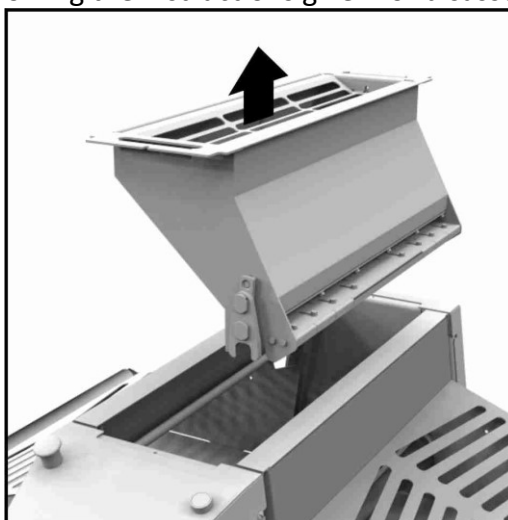


Figure 14

ATTENTION! When transferring the flour from the package to the hopper, handle it carefully, taking care to avoid any dispersion. If necessary, wear suitable respiratory protective devices while manually loading the powdered ingredients.

3.4.9 DOUGH REELER

While the dough is being processed, the dough reeler must be in the rest position A (as illustrated in Figure 15), and the rolling pin must rest on its support Ref. 1.

If the current program requires the dough to be reeled, the machine will automatically perform the following operations:

- At the last programmed step, the actuator rotates the dough reeler upwards to its work position, Ref. 2 Figure 15, and the rolling pin comes down onto the table
- The system reduces the belt speed so that the dough sheet can be rolled around the pin, and then increases it again until the dough sheet has been completely rolled around
- Once the rolling operation has been completed, after a few seconds, the system moves the dough reeler to its rest position A (Figure 15)

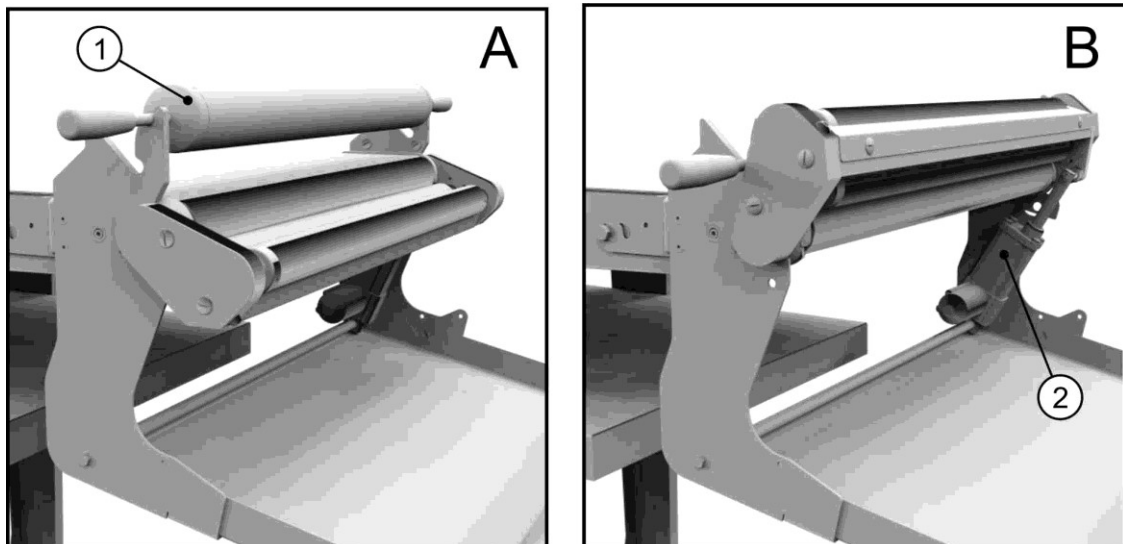


Figure 15

Refer to the PROGRAMMING MANUAL for a more detailed description of both the process and the procedure for setting a program that includes the rolling operation.

4 MAINTENANCE

4.1 FOREWORD

Over time, the machine may need some maintenance operations that can be divided in:

- **Ordinary maintenance:** periodical and/or occasional operations necessary to ensure that the machine is in a good and efficient state and that do not require the intervention of expert personnel; these **may be carried out by unskilled personnel with a basic knowledge of the machine**, as long as the instructions given in this manual are followed.
- **Extraordinary maintenance:** periodical and/or occasional operations necessary to ensure the machine is in a good and efficient state that require preparation and/or professional expertise and/or specific knowledge; **these must be carried out by skilled and professionally qualified personnel** (where required by the laws and regulations in force) who possess the necessary technical and regulatory knowledge to carry out state-of-the-art interventions.



ATTENTION! Unless otherwise provided for in this manual, **every maintenance and/or cleaning operation**, even the simplest one, **must be carried out only after having positioned the main switch to O (OFF) and after having disconnected the power plug** so as to avoid starting the machine. Should an intervention require the removal of a guard and/or the disabling of a safety device make sure that all measures are taken so that thirds are not exposed to any consequent risks. All guards must be repositioned and locked using the corresponding fastening devices and all safety devices must be reset as soon as the reason for their removal/disabling has stopped.

4.2 PERIODICAL MAINTENANCE (ordinary maintenance)

- **At the end of each working day or shift, clean the machine thoroughly**, following the instructions given in par.4.8
- **At the beginning of each working day or shift** make sure that all safety devices are efficient, by carrying out the checks illustrated in par 5.2.3.

4.3 BELT TENSION

Over time and with use belts tend to overstretch. Should the belts slip around the pulling roll or not be correctly aligned, it will be necessary to stretch them as illustrated in Figure 16. Loosen the side screw Ref. A and use an Allen wrench on the screw Ref. B until the tension and/or alignment is obtained. This operation must be carried out on both sides of the belt until it is perfectly balanced.

At this point, fasten the side screws Ref. A.

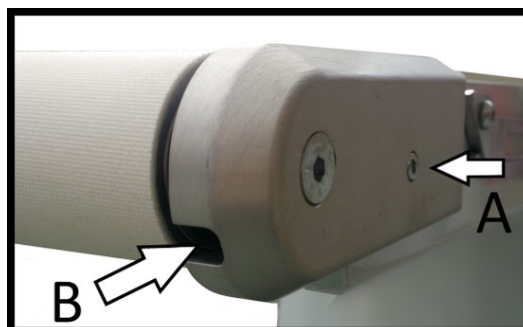


Figure 16

4.4 CHAIN TENSIONING (EXTRAORDINARY MAINTENANCE)

This intervention must be carried out by specialized engineers with experience in the field of mechanical assembly.

To adjust the tension of the chain Ref. 3, proceed as follows, referring to Figure 17:

1. Remove the back guard from the machine
2. Loosen the four fastening screws Ref. 1
3. Push the support downwards Ref. 2
4. Once the adjustment has been carried out, fasten the screws Ref. 1
5. Assemble the back guard on the machine

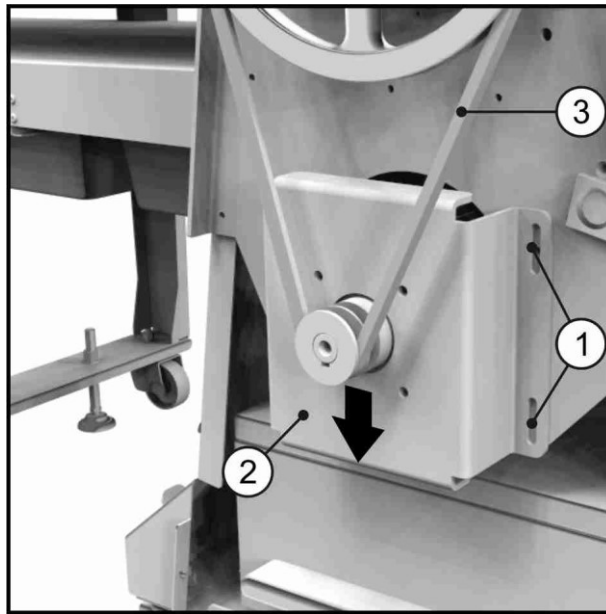


Figure 17

4.5 CHAIN REPLACEMENT (extraordinary maintenance)

This intervention must be carried out by specialized engineers with experience in the field of mechanical assembly.

To replace the chain, proceed as follows (refer to Figure 17):

1. Remove the back guard from the machine
2. Loosen the four fastening screws Ref. 1
3. Lift the support Pos. 2 and remove the worn-out chain
4. Replace the belt, positioning it correctly in the groove of the pulley
5. Push the support downward Ref. 2
6. Once the adjustment has been carried out, fasten the screws Ref. 1
7. Assemble the back guard on the machine

4.6 POSSIBLE FAILURES AND/OR FAULTS

We illustrate hereafter some anomalous conditions that may occur during machine operation.

Any intervention following a failure or a fault must be carried out in compliance with the instructions, where given, and in any case **after having switched off the machine and disconnected it from the power.**

Problem	Possible causes	Solutions
The machine doesn't start (push-button not illuminated)	• No power	- make sure the machine is plugged in completely; - check the guards of the electric line in the work room and reset them, if necessary
	• Protection fuses triggered	-replace them (extraordinary maintenance)
The machine doesn't start (push-button illuminated but not flashing)	• The machine is not enabled for operation	- Press the operation button Ref. 6 Figure 4 (see paragraph 3.4.3)
	• One emergency push-button has been pressed *	-reset the emergency push-button
	• The mobile guards are not correctly closed *	-make sure that the guards are closed
	• The flour collection drawer is not correctly inserted *	-make sure the drawer is inserted
	• Faulty controls *	- request intervention by the manufacturing company
The machine is very noisy	• Dirty scrapers	- see par. 4.8.3 CLEANING THE SCRAPERS
The machine operates inconsistently	• Unsuitable motor chain tension	-the belt as described in par. 4.4 (extraordinary maintenance)

* ALARMS VISIBLE ON THE DISPLAY (see the PROGRAMMING MANUAL)

4.7 ELECTRICAL MAINTENANCE



Before accessing any powered part, disconnect the plug from the power socket. The plug must be visible at all times, so that it is possible to see that the "machine is not powered".

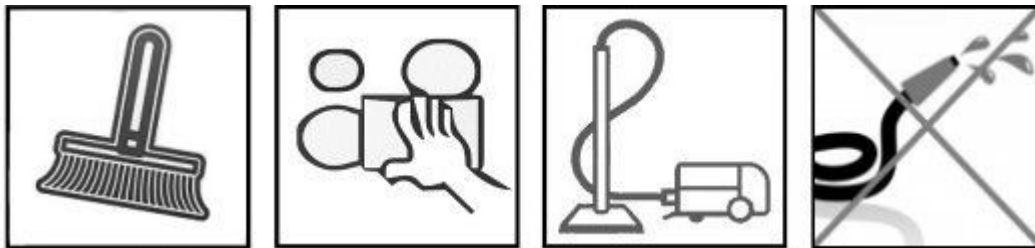
Any intervention carried out directly or indirectly on the machine's electrical components **must be carried out by specialized engineers who have been professionally trained, possess the necessary technical and regulatory knowledge to carry out state-of-the-art interventions and have been expressly appointed to carry out such interventions, and who have read this manual before working on the machine.**

The wiring diagram is given with the manual and is an integral part of the same.

The electric board is on the left side of the machine

4.8 CLEANING THE MACHINE

Empty the flour collection drawer (see par. 3.4.5) and clean it, both inside and outside; slide it back in position. To clean the machine, use a Hoover with a thin nozzle together with brushes to remove residues from areas that are difficult to reach.



Wet a clean cloth, and add some neutral detergent if necessary, to remove any stain from the machine.

Do not spray water jets against the machine.

Do not use abrasive sponges or cloths.

Do not use metal objects, especially with sharp tips or sides **in order to avoid damaging any part.**

Do not use alcohol or solvents in general.

4.8.1 CLEANING THE PHOTOCELL

Dough presence photocells should be cleaned daily using a clean cloth, Ref. Figure 18, to remove any flour residue.

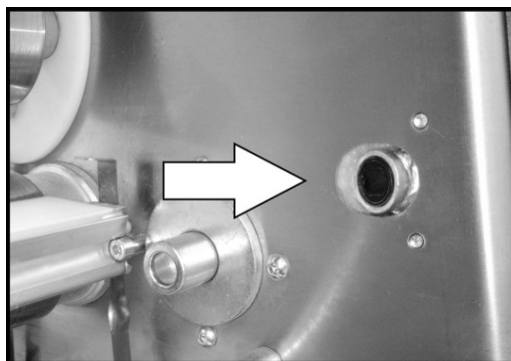


Figure 18

4.8.2 CLEANING THE BELTS AND THE WORK TABLES

The machine is fitted with a quick de-tensioning system that makes cleaning the tables and belts easy.

Before assembling or disassembling the work tables, take the main switch to O (OFF) and unplug the power plug, to prevent the machine from starting

To carry out this operation, refer to the following procedure and to Figure 19:

- Remove the safety screws Ref. 1 (after the first cleaning operation the screw is no longer necessary)
- Rotate the head Ref. 2; at this point it is possible to clean the work tables under the belt, as well as both sides of the belt itself
- After cleaning the machine, follow the same procedures in the reverse order so as to take the machine back to the state it was before

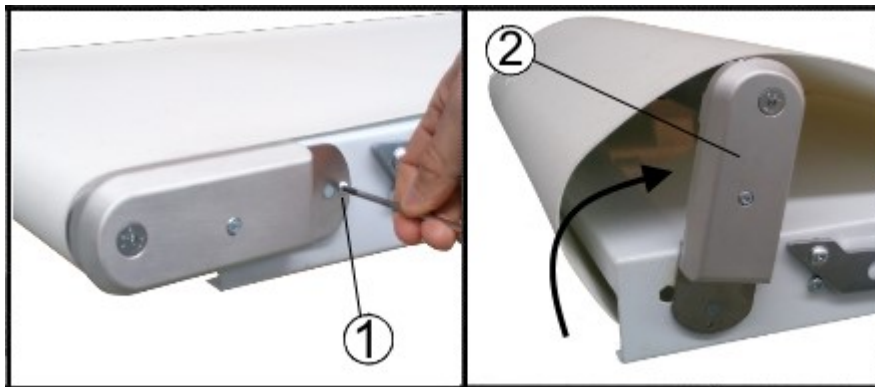


Figure 19

4.8.3 REPLACING THE BELTS

Before replacing the belts, disassemble the work table, as illustrated in paragraph 3.4.6. Remove the fixed leg Ref. 1 Figure 20, after having loosened and removed the screws Ref. 2 Figure 20. Loosen the tensioning screws completely as described in chapter 4.3 and push the resting roller on the table (Ref. 3. Figure 20).

Position the cutting table by resting it on one of the two sides and remove the old belt Ref. 4 Figure 20, by pulling it upwards and out and then insert the new one (these operations must be carried out by two people). Reposition the table horizontally, tension the belt once again and restore the machine to its working condition.

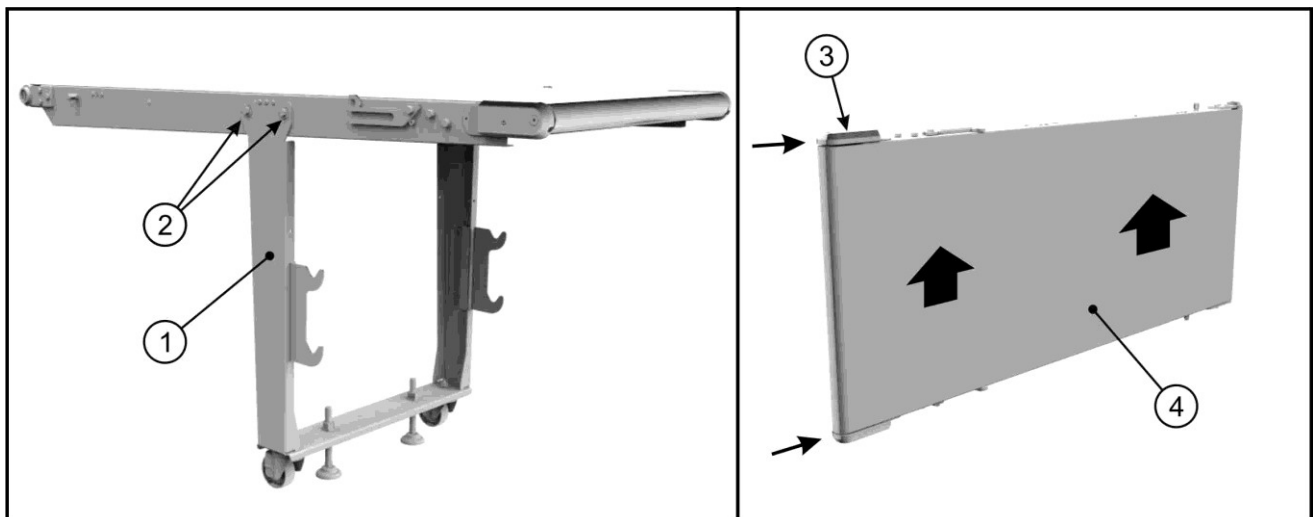


Figure 20

4.8.3 CLEANING THE SCRAPERS

UPPER ROLLER SCRAPER

Before assembling or disassembling the work tables, take the main switch to O (OFF) and unplug the power plug, to prevent the machine from starting

To carry out this operation, refer to the following procedure and to Figure 21:

- Open the mobile guards Ref. 3 Figure 1
- Completely remove the central safety wing nut
- Grab the body of the scraper and push it against the roller until it slides into position so that the head of the screw reaches the widened eyelet
- The scraper is now free, and it is possible to remove it and clean it

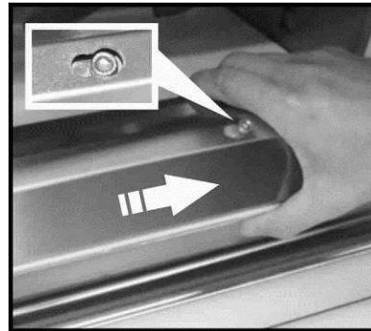


Figure 21

- After cleaning it, take the machine back to its original condition

LOWER ROLLER SCRAPER

To carry out this operation, refer to the following procedure and to Figure 22:

- Enter the manual mode, open the cylinder as far as it will go (see the programming manual)
- Switch off the machine by turning the main switch to O (OFF) and unplug the power plug, to prevent the machine from starting.
- Open the mobile guards Ref. 3 Figure 1
- Rotate the knob that locks the scrapers Ref. 15 Figure 1 anti-clockwise
- Remove the two scrapers by lifting them using the relative side flaps
- To reposition the scrapers, correctly insert them between the pins fastened to the machine shoulders and the lower roller: the recess (Ref. 1 Figure 22) must be on the opposite side of the cylinder. **WARNING: the scraper must be inserted so that the two side blades are located as vertical as possible** (see Figure 22).
- Rotate the knob (Ref. 15 Figure 1) clockwise to lock the scrapers in place

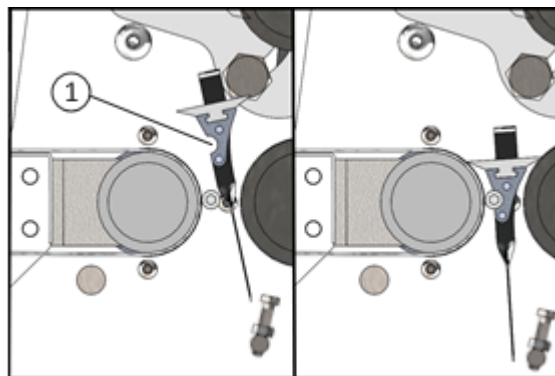


Figure 22

- After cleaning it, take the machine back to its original conditions

4.10 LONG STOPS OR SERVICE DISCONTINUATION

In case of long stops or service discontinuation, disconnect the machine from the electric grid; clean it thoroughly and cover it using clean and waterproof sheets to protect it from the agents, dust, insects, rodents, etc. Adopt any measure to prevent the machine from being hit, tampered with, damaged, manhandled, etc.

Before using it again, carry out a thorough check to ensure it is still whole and complete and after that proceed as if it were a first start-up.

5 SAFETY

5.1 FOREWORD

The description of risks and any remarks contained in this chapter are based:

- On the knowledge of the normal condition and the intended use of the machine.
- On the assumption that the machine is used for professional use (if only for cleaning, maintenance, etc.) the operators have been suitably informed and instructed on specific and general risks in the workplace, in compliance with the laws and regulations in force.
- On the assumption that the professional user meticulously complies with the instructions affixed directly onto the machine.

VERY IMPORTANT!

Before starting up the machine and/or operating it, the user must have read and understood the instructions and indications given in this manual; consequently, anyone who uses the machine and/or allows its use implicitly accepts all and any public and criminal liability for damages to people, animals and properties that may occur following failure to respect such instructions and indications, even if partially.

5.2 HAZARDS, SAFETY DEVICES AND RESIDUAL RISKS

In compliance with Directive 2006/42/CE we hereby provide clear and concise information on the dangers that characterize the machine and on the corresponding risks, along with the measures that have been adopted to eliminate them or reduce them; where it proved to be impossible to completely eliminate a risk, we provide information on the relative residual risk and on any further measure to be adopted to further limit its seriousness.

5.2.1 DANGERS AND CORRESPONDING RISKS THAT CHARACTERIZE THE MACHINE

The machine is characterized by the following risks:

Mechanical

- **Crushing, cutting, gripping, pulling** due to contact with moving mechanical components

Electrical

- **Electrocution** due to direct or indirect contact with powered parts or due to external factors affecting the electrical equipment.

The corresponding risks have been eliminated or reduced as much as possible.

5.2.2 SAFETY DEVICES AND REMARKS

With reference to Figure 23 we hereby indicate the safety devices present on the machine:

- Mobile guards Ref. 1 with safety microswitch Ref. 2 (to prevent access to the cylinders)
- Flour collection drawer with safety microswitch Ref. 3
- Emergency switch Ref. 4

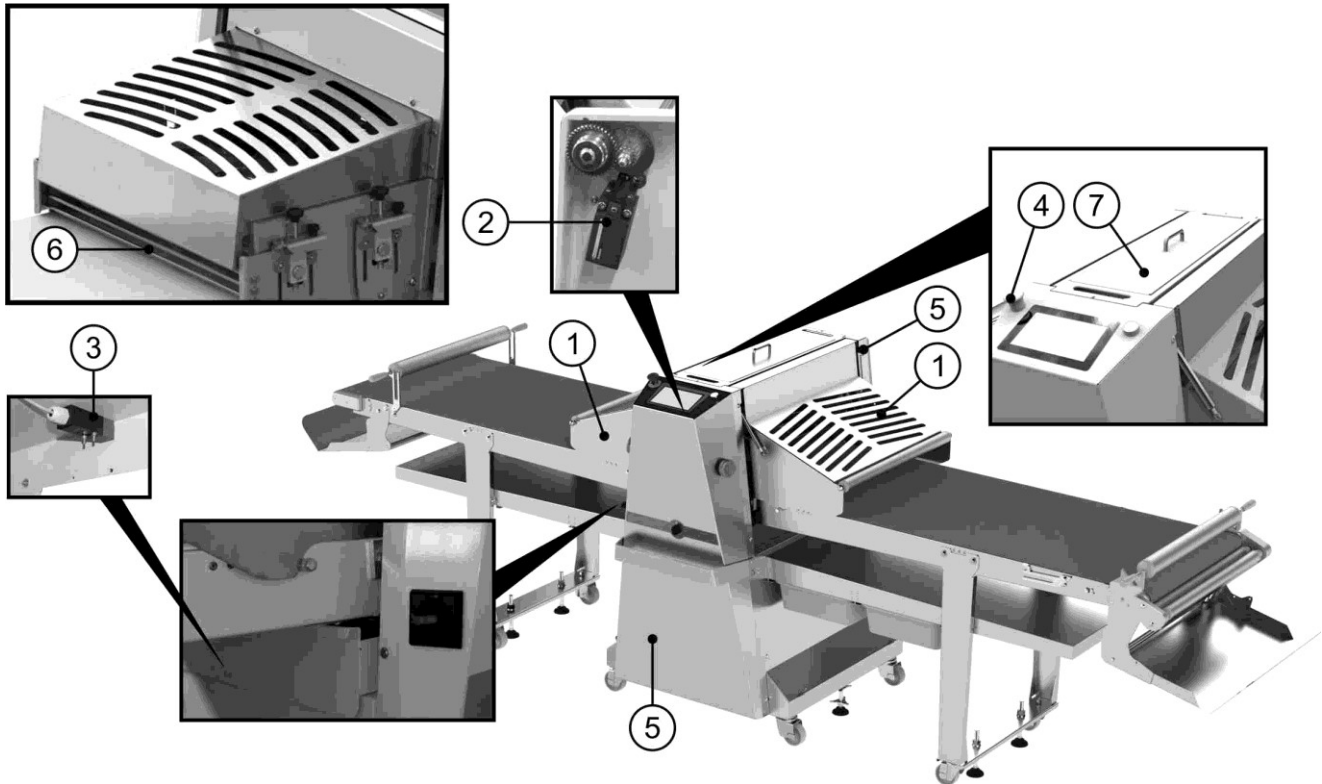


Figure 23

Fixed guards. They are all the protections that are fastened to the machine and that require the use of at least one tool to remove them. With reference to Figure 23 we are mainly referring to the following items already described in this manual:

- Front and back guards Ref. 5 (to prevent access to the drive components)
- Fixed guard for the cutting station Ref. 6 (to prevent access to the knife working area)
- Flour duster Ref. 7 (to prevent access to the cylinders)

ATTENTION

It is strictly forbidden to open and/or remove the guards and/or disable the safety devices unless it is absolutely necessary to carry out some operations and this is only possible after all measures have been adopted to highlight the presence of consequent risks. These operations should only be carried out if strictly necessary and should be limited in time; they must be carried out only and exclusively by expert, trained and expressly authorized personnel. The safety devices must be reset and the protections put back in place and fastened using any of the supplied tools as soon as the reason for their removal/disabling has been eliminated.

5.2.3 CHECKING THE EFFICIENCY OF THE SAFETY EQUIPMENT

Any check mentioned in this paragraph must be diligently carried out on a daily basis by operators who are able to use the machine and have been trained and informed on the residual risks that characterize it; the machine may not be used, and use of the same by thirds must be prevented, if even one of such checks gives a negative result. In this case, request the intervention of a specialized and expert engineer who is intimately familiar with the safety regulations in force. With reference to the safety equipment described in par. 5.2.2, and to any remarks on the matter, the following checks must be carried out at the beginning of each working day and/or shift:

1. Visual check to make sure that all fixed guards are in perfect conditions, free from corrosion, dents, etc. and fastened using the provided parts (screws)
2. Check that all mobile guards are integral and not bent.
3. the interlocking devices of the mobile guards Ref. 1 Fig. 23 as provided for by the standard UNI EN 1674:2015, paragraph 5.2.1.1. Use a 105 mm high gauge block and slide it between the belt and the cylinder-shaped guard: the microswitch must trigger when the guard is lifted. Make sure that the alarm message is correctly displayed when the safety microswitch is triggered (see the paragraph "ALARMS" in the programming manual).
4. Open the flour collection drawer Ref. 3 Fig.23 and make sure that the message appears that the safety microswitch has been triggered (see the paragraph "ALARMS" in the programming manual).

5.2.4 RESIDUAL RISKS OF MECHANICAL ORIGIN

DURING MAINTENANCE OPERATIONS (handling, maintenance, cleaning operations, etc.), if the machine is used in compliance with the instructions herein, **the machine is characterized by the following residual risks**, already described in previous paragraphs, and hereunder briefly summarized for your reference:

Risk of fingers becoming trapped, in slots, openings, fissures, etc. that may become accessible once certain components are disassembled to allow maintenance operations.

During professional use of the machine, **all the residual risks** described here, which are extremely limited, **can be reduced even further if**:

- the employer provides the operators with suitable information and training on how to correctly and safely using the machine, based on specific work procedures and demands that the latter are strictly complied with.
- the operator scrupulously complies with all the instructions given by the employer and by this manual, remains concentrated on his/her task and refrains from doing any unusual movement and/or action.

5.2.5 RESIDUAL RISKS OF ELECTRICAL ORIGIN

The risk is connected to possible accidental contact with powered parts, for example during maintenance operations.

ATTENTION! Before disassembling/opening any guard or component that may allow access to powered parts (or to dangerous parts in general), and/or before carrying out any operation on powered parts, the appointed engineer must disconnect the plug from the power socket and position the plug so that it is visible at all times and thus verify that the machine is not powered. There are no reasonably foreseeable reasons why an engineer should operate directly on powered parts.

The expertise of engineers who are requested to carry out such operations should guarantee against the risks; anyhow, we remind you that **all electrical operations must be performed by skilled and professionally qualified operators able to perform state-of-the-art interventions and who are familiar with the legal provisions on this matter.**

5.3 INFORMATION ON NOISE



On the basis of sound measurements carried out on the machine using a Class 1 sound level meter and a microphone positioned on the front part of the machine, that is where the operator should normally stand, (at approximately 200 mm horizontally from the front part of the machine and at 1.6 m from the floor), while working without load and in normal conditions, the equivalent continuous A-weighted sound pressure (LAeq) level is lower than 70 dB(A), even when considering a maximum error equal to + 2.0 dB(A).

5.4 SAFETY SIGNS

The safety signals illustrated in Figure 24 is affixed on the machine:

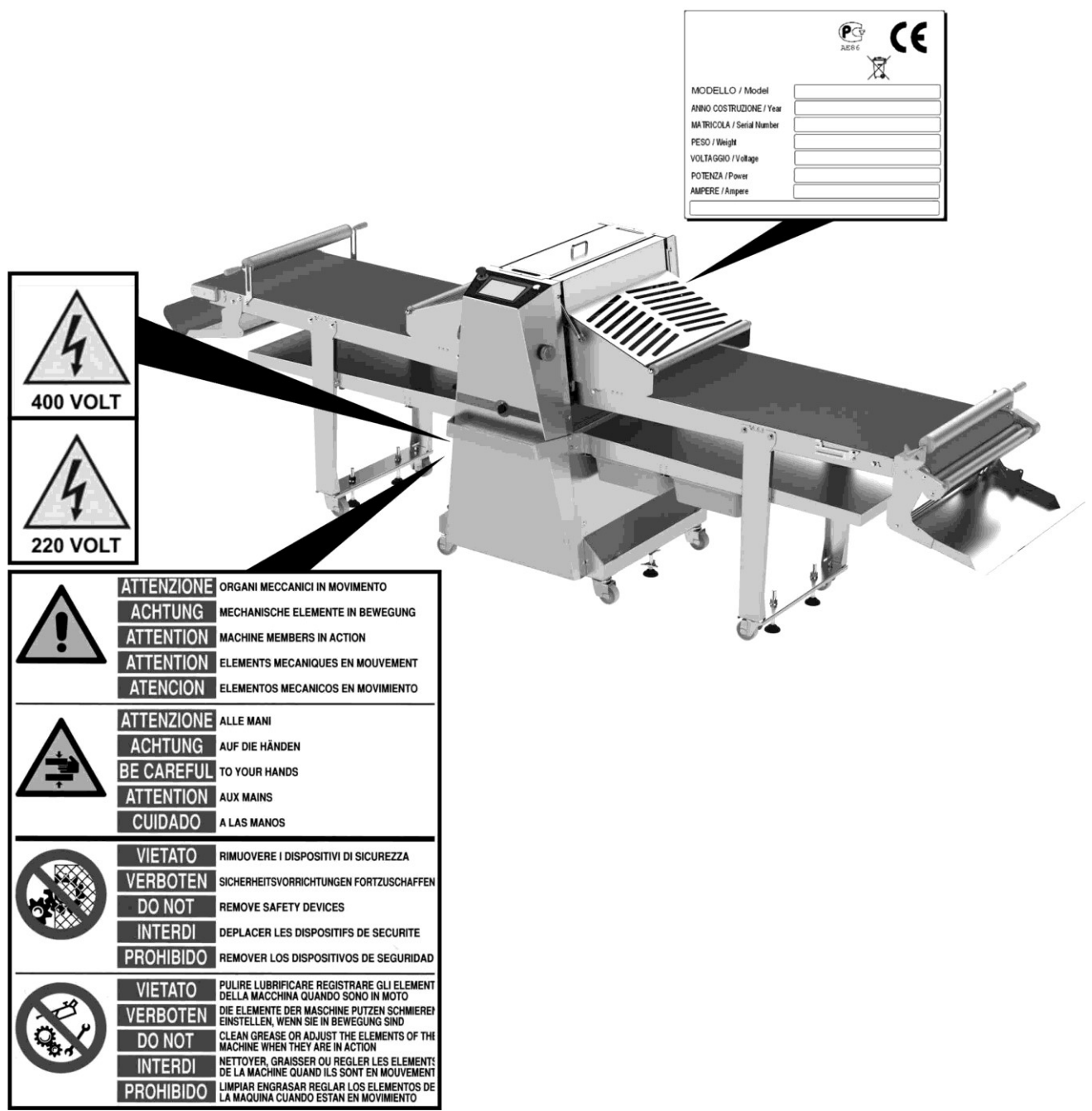








Figure 24

 	Danger: voltage at 400 / 220 Volt
	Danger: moving mechanical parts
	Danger: possible crushing of upper limbs
	Do not remove the safety devices
	Do not clean, lubricate and adjust any machine components while they are moving

Ensure that all images and colours on the signals are in perfect conditions; immediately inform the appointed operator and/or supervisor who will adopt the necessary measures.

6 DISMANTLING

Should the machine be dismantled, separate the different components according to the material they are made of and dispose of them in compliance with the current laws and regulations. Remove any lubricant that must be disposed of separately.

Contact companies that are specialized in waste disposal.

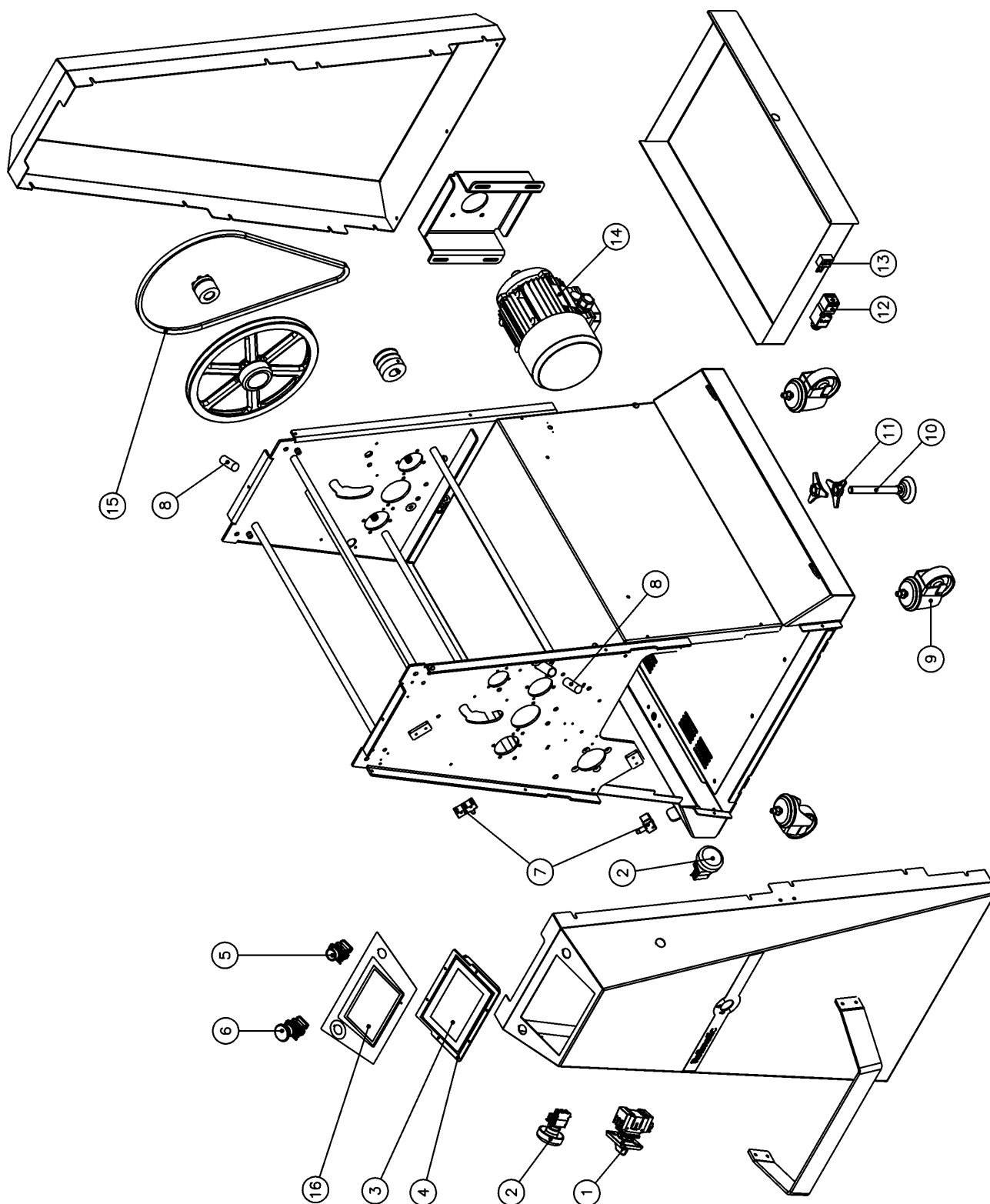
Varnished steel Fe:	machine shoulders, lower crossbars
Stainless steel:	machine structure, mobile guards, front and rear guards, dough collection trays, flour tray, work tables.
Plastic, rubber:	wheels, scrapers.
Miscellaneous material:	electrical components, motors (copper coils).

The symbol on the equipment illustrated here indicates that it must not be disposed of as urban waste, but must be taken to the appropriate WEEE collection centres to be treated in compliance with the regulations on disposal of electrical and/or electronic devices.

Incorrect or inappropriate disposal of the equipment or of any parts may produce negative and potentially dangerous effect on the health and the environment.



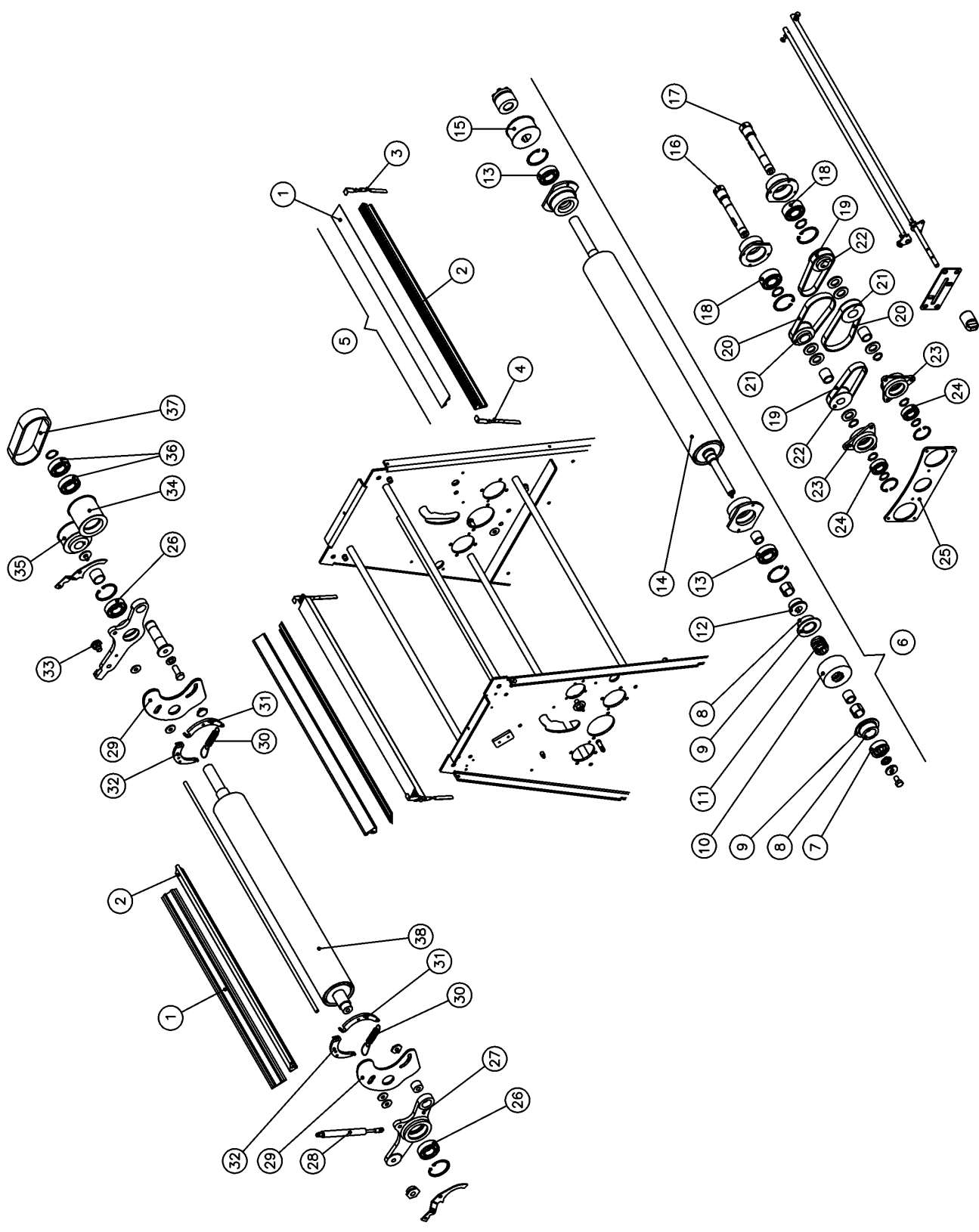
Sfogliatrice - Dough Sheeter	ELENCO PARTI DI RICAMBIO SPARE PARTS LIST	ALLEGATO 1	
R65 AXP		17/07/2019	Rev. A



Sfogliatrice - Dough Sheeter	ELENCO PARTI DI RICAMBIO SPARE PARTS LIST	ALLEGATO1	
R65 AXP		17/07/2019	Rev. A

POS.	COD. R65S-AXP	DESCRIZIONE - DESCRIPTION
1	S00912	INTERRUTTORE GENERALE - MAIN SWITCH
2	S00646	PULSANTE INVERSIONE - REVERSAL BUTTON
3	S00911	DISPLAY TOUCH SCREEN 7"
4	D05050	GUARNIZIONE - GASKET
5	S00647	PULSANTE ABILITAZIONE - CONSENT BUTTON
6	S00055	PULSANTE DI EMERGENZA - EMERGENCY BUTTON
7	S00041	MICROINTERRUTTORE - MICROSWITCH
8	S00913	SENSORE PRESENZA PASTA – DOUGH SENSOR PRESENCE
9	C00443	RUOTA PIVOTANTE D.80 – SWIVEL WHEEL
10	C00367	PIEDINO DI APPOGGIO – ADJUSTABLE FEET
11	D02387	VOLANTINO A LOBI - LOBE KNOBS
12-13	S00441	MICRO VASSOIO FARINA + AZIONATORE SNODATO – CYLINDER FLOUR TRAY MICRO – JOINTED ACTUATOR
14	C00348	MOTORE - MOTOR
15	C00836	CINGHIA XPA 1332 – BELT XPA 1332
16	S00683	ETICHETTA - LABEL

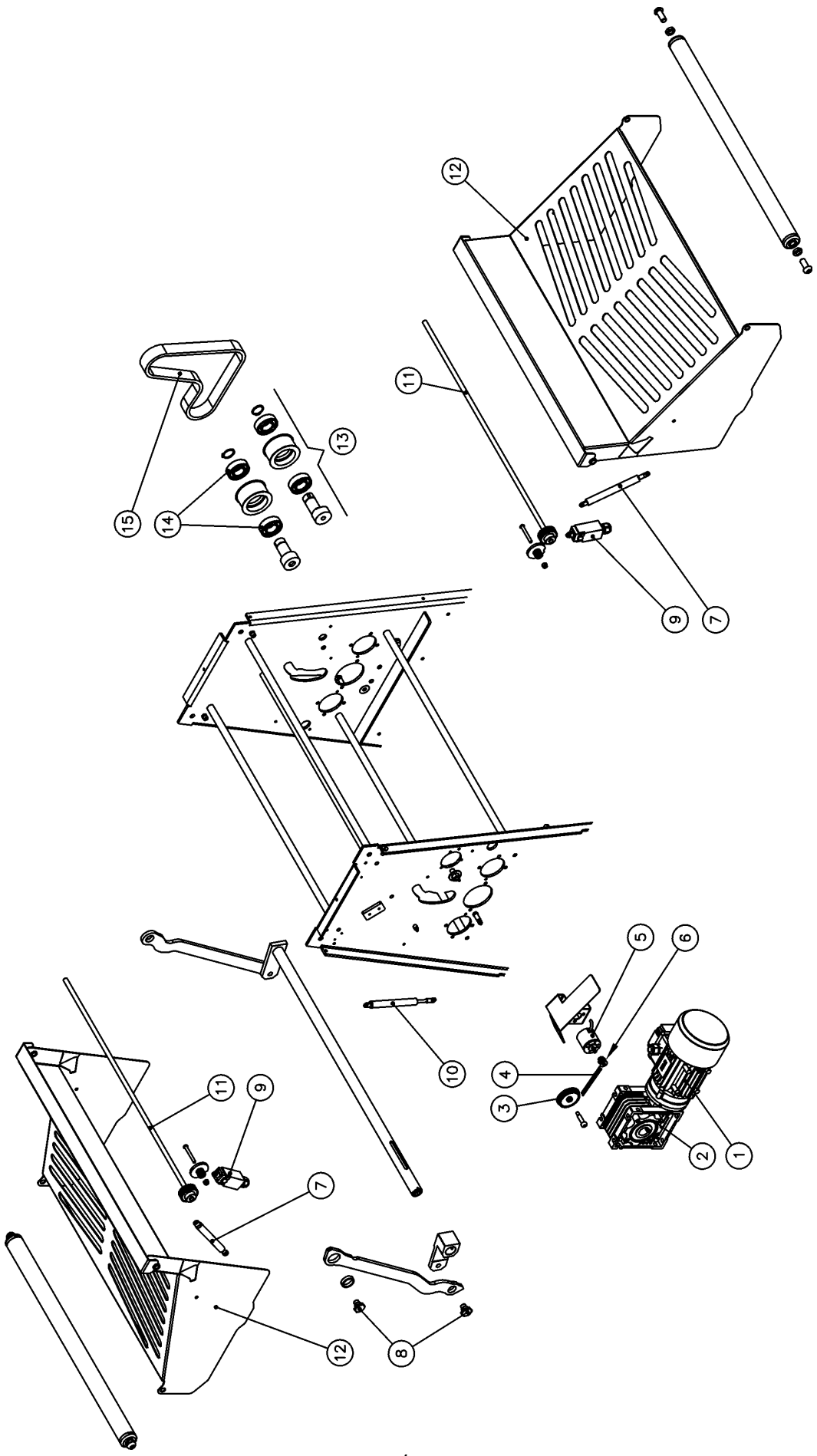
Sfogliatrice - Dough Sheeter R65 AXP	ELENCO PARTI DI RICAMBIO SPARE PARTS LIST	ALLEGATO 1	
		17/07/2019	Rev. A



Sfogliatrice - Dough Sheeter	ELENCO PARTI DI RICAMBIO SPARE PARTS LIST	ALLEGATO1	
R65 AXP		17/07/2019	Rev. A

POS.	COD. R65S-AXP	DESCRIZIONE - DESCRIPTION
1	D03750	RASCHIATORE INFERIORE – LOWER SCRAPER
2	D03751	SUPPORTO RASCHIATORE – SCRAPER SUPPORT
3	D03506	MOLLA RASCHIATORE DX - SCRAPER SPRING
4	D03787	MOLLA RASCHIATORE SX - SCRAPER SPRING
5	G00561	RASCHIATORE COMPLETO - ASSEMBLY SCRAPER
6		CILINDRO INFERIORE COMPLETO – COMPLETE LOWER CYLINDER
7	D01813	RONDELLA D.45xSP.15,5 - CYLINDER COVER
8	D01184	PULEGGIA Z28 – PULLEY Z28
9	D01185	FLANGIA PULEGGIA Z28 – PULLEY FLANGE
10	D01148	PULEGGIA Z48 – PULLEY Z48
11	D01149	VITE BRONZO D35 - BRONZE SCREW D35
12	D01808	DISTANZIALE CILINDRO - CYLINDER SPACER
13	C00531	CUSCINETTO 6205 – BEARING 6205
14	D01117	CILINDRO INFERIORE - LOWER CYLINDER
15	D01122	PULEGGIA DENTATA - TOOTHED PULLEY
16	D01152	ALBERO TRASMISSIONE SX - TRANSMISSION SHAFT
17	D01153	ALBERO TRASMISSIONE DX - TRANSMISSION SHAFT
18	C00165	CUSCINETTO UNI 3205 - BEARING UNI 3205
19	C00137	CINGHIA DENTATA 350 RPP5 15 - TOOTHING BELT 350 RPP5 15
20	C00138	CINGHIA DENTATA 400 RPP5 15 - TOOTHING BELT 400 RPP5 15
21	D01154	PULEGGIA Z36 - PULLEY Z36
22	G00321	PULEGGIA SU RUOTA LIBERA CON CUSCINETTO- PULLEY ON FREE WHEEL WITH BEARING
23	D01192	FLANGIA - FLANGE
24	C00168	CUSCINETTO UNI 6004 - BEARING UNI 6004
25	D01156	PIASTRA ALBERO - SHAFT PLATE
26	C00531	CUSCINETTO 6205 – BEARING 6205
27	D01128	BIELLA ANTERIORE - FRONT CONNECTING ROD
28	C00297	MOLLA A GAS – GAS SPRING
29	D01142	PROTEZIONE LATERALE – SIDE PROTECTION
30	D01212	MOLLA RASCHIATORE - SCRAPER SPRING
31	D01133	ATTACCO RASCHIATORE SUPERIORE - UPPER SCRAPER HOLDER
32	D01127	PERNO FISSO BIELLA - CONNECTING ROD FIXED PIN
33	D01829	PERNO BIELLA - CONNECTING ROD PIN
34	D01123	PULEGGIA DENTATA - TOOTHED PULLEY
35	D01116	PULEGGIA DENTATA - TOOTHED PULLEY
36	C00139	CINGHIA DENTATA 408 RPP8 30 - TOOTHING BELT 408 RPP8 30
37	D01129	BIELLA POSTERIORE - REAR CONNECTING ROD
38	D01118	CILINDRO SUPERIORE - UPPER CYLINDER

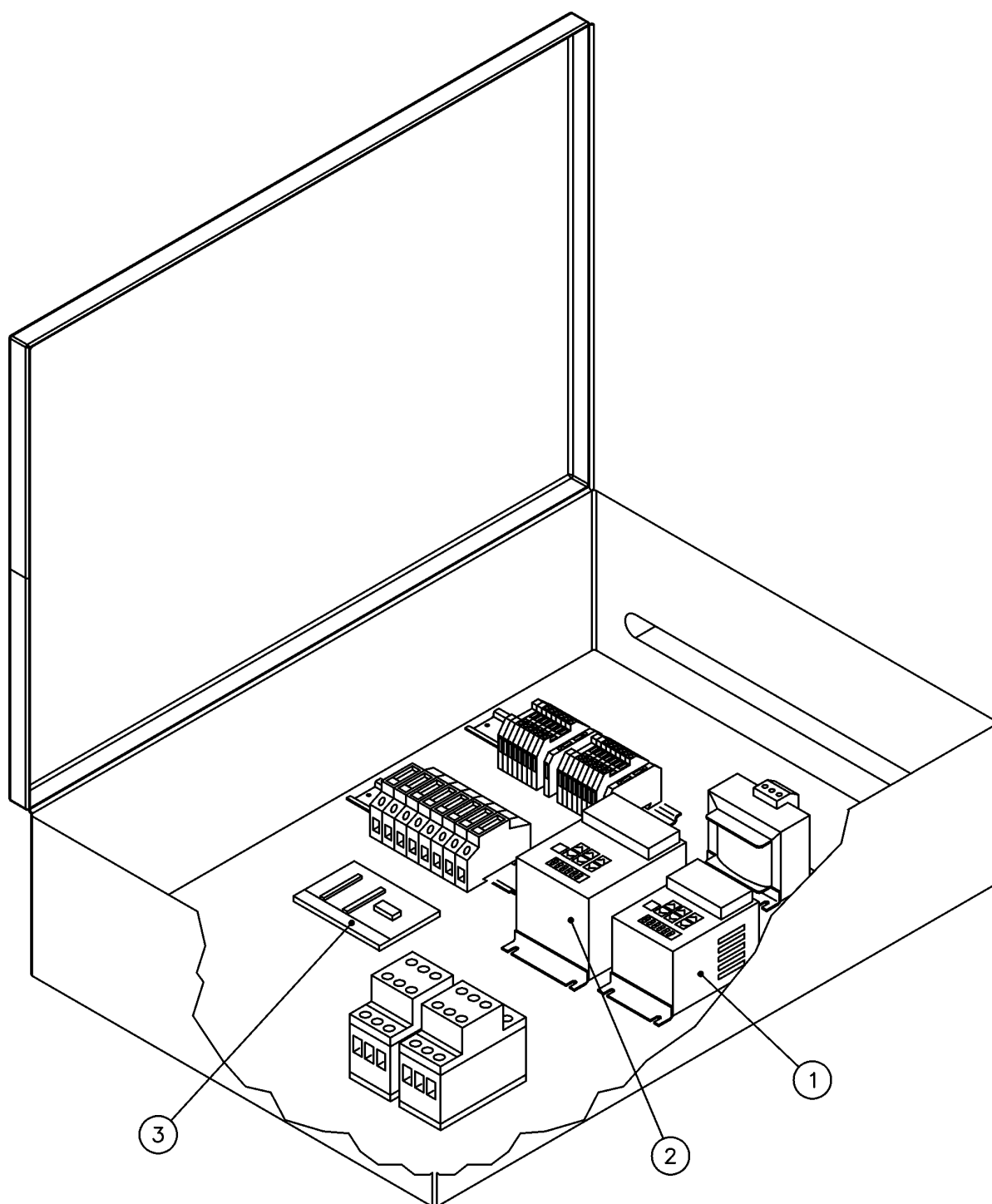
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		17/07/2019	Rev. A



Sfogliatrice - Dough Sheeter	ELENCO PARTI DI RICAMBIO SPARE PARTS LIST	ALLEGATO1	
R65 AXP		17/07/2019	Rev. A

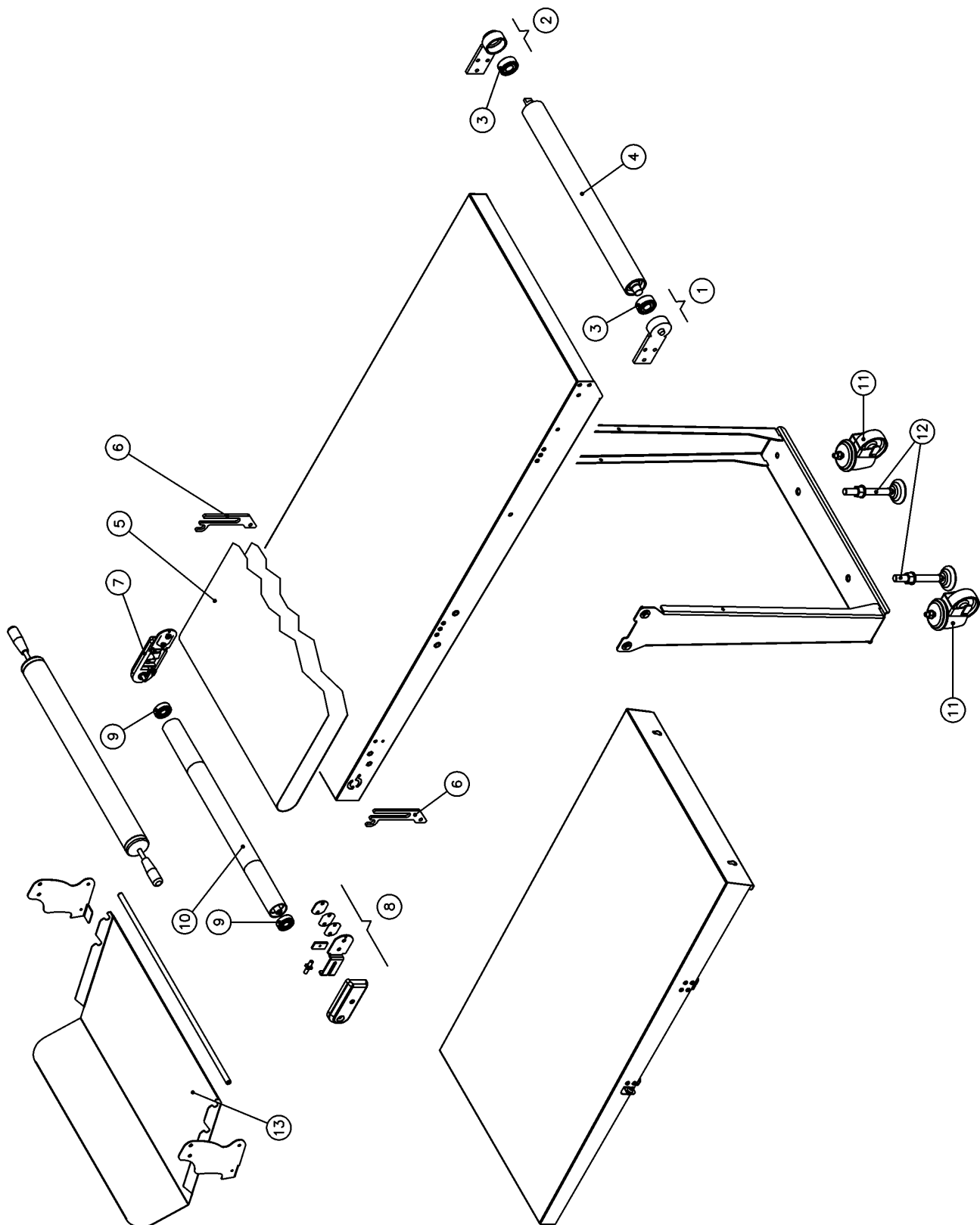
POS.	COD. R65S-AXP	DESCRIZIONE - DESCRIPTION
1	C00319	MOTORE - MOTOR
2	C00414+C00400	RIDUTTORE E PRECOPPIA - GEARBOX AND REDUCTION PAIRS
3	C00710	PULEGGIA - PULLEY
4	C00712	CINGHIA 1120 MXL 025 Z140 - BELT
5	S00012	ENCODER - ENCODER
6	D04114	PULEGGIA - PULLEY
7	C00298	MOLLA A GAS – GAS SPRING
8	D01829	PERNO BIELLA – CONNECTING-ROD STUD
9	S00043	MICRO RIPARI – SAFETY COVER MICRO
10	C00297	MOLLA A GAS – GAS SPRING
11	D03655	PERNO RIPARO – PIN GUARDS
12	D05001	RIPARO INTERBLOCCATO – INTERLOCKING GUARD
13		
14	C00531	CUSCINETTO 6205 – BEARING 6205
15	C00140	CINGHIA DENTATA 840 RPP8 - TOOTHING BELT 840 RPP8
16		

Sfogliatrice - Dough Sheeter	ELENCO PARTI DI RICAMBIO SPARE PARTS LIST	ALLEGATO1	
R65 AXP		17/07/2019	Rev. A



POS.	COD. R65S-AXP	DESCRIZIONE - DESCRIPTION
1	S00901	INVERTER SOLLEVAMENTO CILINDRI – CYLINDER LIFTING INVERTER
2	S00902	INVERTER TAPPETI – BELTS INVERTER
3	S00906	SCHEDA DI CONTROLLO – CONTROL BOARD

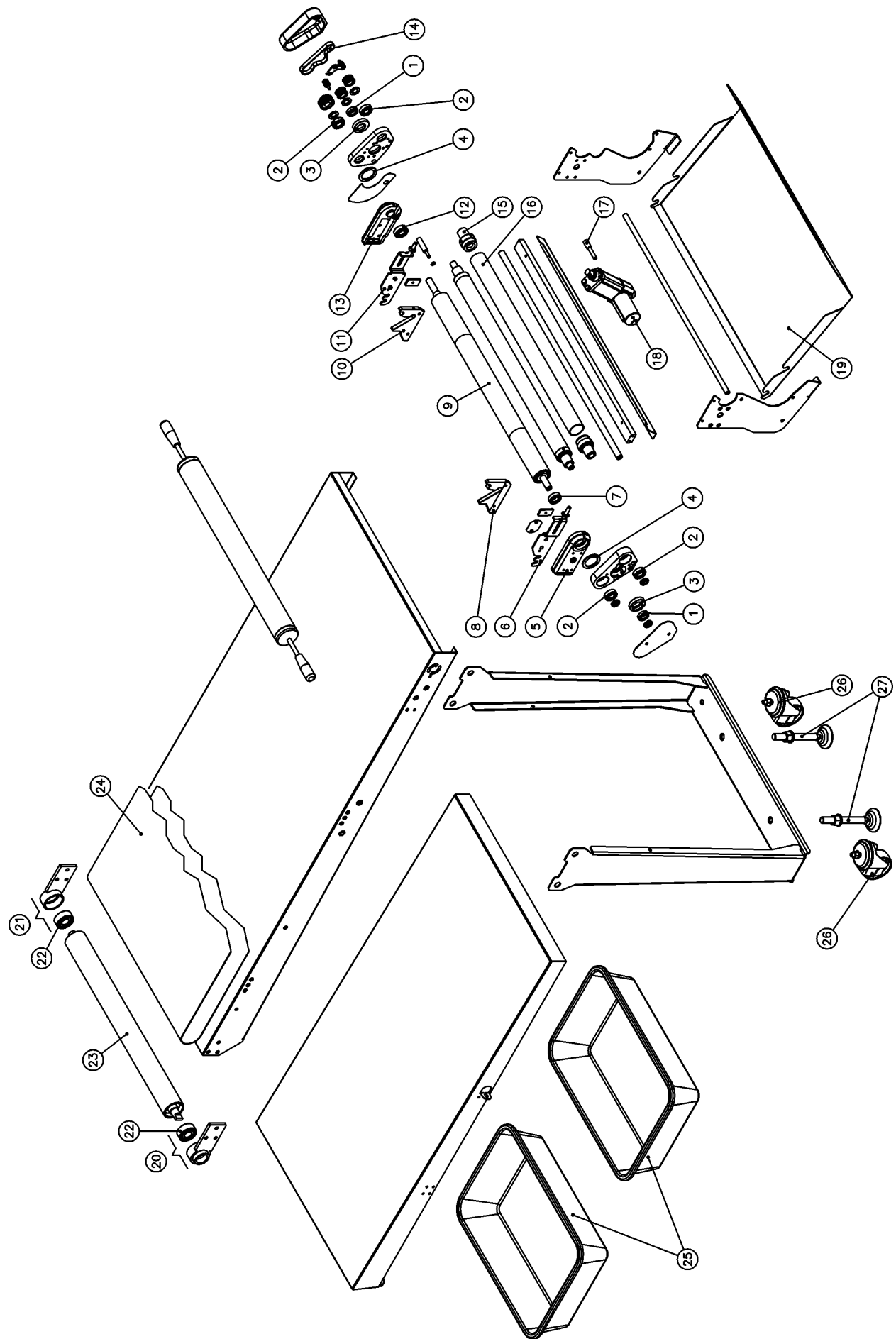
Sfogliatrice - Dough Sheeter R65 AXP	ELENCO PARTI DI RICAMBIO SPARE PARTS LIST	ALLEGATO1	
		17/07/2019	Rev. A



Sfogliatrice - Dough Sheeter	ELENCO PARTI DI RICAMBIO SPARE PARTS LIST	ALLEGATO1	
R65 AXP		17/07/2019	Rev. A

POS.	COD. R65S-AXP	DESCRIZIONE - DESCRIPTION
1	G00254	SUPPORTO CON PERNO E CUSCINETTO - SUPPORT WITH PIN AND BEARING
2	G00255	SUPPORTO CON CUSCINETTO - SUPPORT WITH BEARING
3	C00164	CUSCINETTO 2204 – BEARING 2204
4	D01119	CILINDRO TRAZIONE TAPPETO – BELT DRIVING CYLINDER
5	S00805	TAPPETO 1600 mm (BLU) – BELT (BLU)
5	S00806	TAPPETO 1800 mm (BLU) – BELT (BLU)
5	S00844	TAPPETO 2000 mm (BLU) – BELT (BLU)
6	D01831	SUPPORTO MATTARELLO – REELER SUPPORT
7	G00535	GRUPPO TENDITAPPETO SX - LEFT BELT TIGHTNING GROUP
8	G00534	GRUPPO TENDITAPPETO DX - RIGHT BELT TIGHTNING GROUP
9	C00184	CUSCINETTO 6302 – BEARING 6302
10	D01120	RULLO TAPPETO – BELT FREE ROLLER
11	C00443	RUOTA PIVOTANTE D.80 – SWIVEL WHEEL
12	C00367	PIEDINO DI APPOGGIO – ADJUSTABLE FEET
13	D04043	PROLUNGA SOTTOPIANO - DOUGH TRAYS

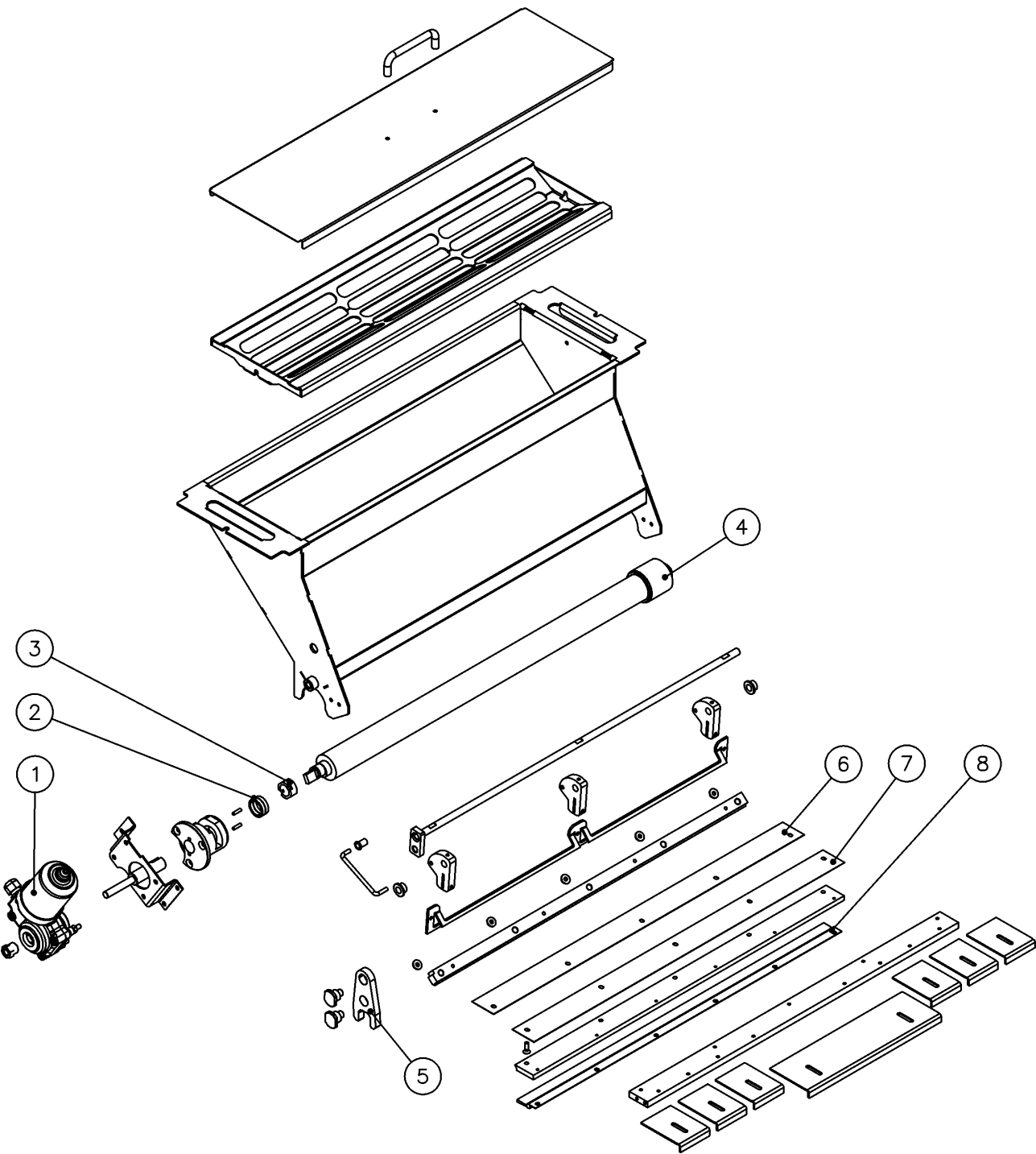
Sfogliatrice - Dough Sheeter	ELENCO PARTI DI RICAMBIO SPARE PARTS LIST	ALLEGATO 1	
R65 AXP		17/07/2019	Rev. A



Sfogliatrice - Dough Sheeter	ELENCO PARTI DI RICAMBIO SPARE PARTS LIST	ALLEGATO1	
R65 AXP		17/07/2019	Rev. A

POS.	COD. R65S-AXP	DESCRIZIONE - DESCRIPTION
1	C00731	CUSCINETTO 61902 2RS - BEARING
2	C00715	CUSCINETTO 6002 2RS - BEARING
3	D04192	BUSSOLA ECCENTRICA - ECCENTRIC BUSHING
4	D04062	DISTANZIALE - SPACER
5	D04076	PIASTRA TENDI TAPPETO SX - BELT TENSION PLATE
6	D04601	PIASTRA ROTAZIONE SX - LEFT REINFORCED PLATE FOR REELER
7	C00827	CUSCINETTO ORIENTABILE UNI 1202 - BEARING
8	D04058	PORTA MATTARELLO SX - REELER SUPPORT
9	D04051	CILINDRO TENDITAPPETO - REELER BELT TENSIONING ROLLER
10	D04059	PORTA MATTARELLO DX - REELER SUPPORT
11	D04602	PIASTRA ROTAZIONE DX - RIGHT REINFORCED PLATE FOR REELER
12	C00827	CUSCINETTO ORIENTABILE UNI 1202 - BEARING
13	D04075	PIASTRA TENDI TAPPETO DX - BELT TENSION PLATE
14	C00716	CINGHIA DENTATA - TIMING BELT
15	D04060	TAPPO PER RULLO - PLUG FOR ROLLER
16	D03542	RULLO PER AVVOLGITORE - ROLLER FOR REELER
17	D04067	PERNO FISSAGGIO ATTUATORE - ACTUATOR FIXING PIN
18	S00003	ATTUATORE - ACTUATOR
19	D04056	PROLUNGA SOTTOPIANO - REELER DOUGH TRAY
20	G00255	SUPPORTO CON CUSCINETTO - SUPPORT WITH BEARING
21	G00254	SUPPORTO CON PERNO E CUSCINETTO - SUPPORT WITH PIN AND BEARING
22	C00164	CUSCINETTO 2204 - BEARING 2204
23	D01119	CILINDRO TRAZIONE TAPPETO - BELT DRIVING CYLINDER
24	S00805	TAPPETO 1600 mm (BLU) - BELT (BLU)
24	S00806	TAPPETO 1800 mm (BLU) - BELT (BLU)
24	S00844	TAPPETO 2000 mm (BLU) - BELT (BLU)
25	C00689	BACINELLA - BASINS
26	C00443	RUOTA PIVOTANTE D.80 - SWIVEL WHEEL
27	C00367	PIEDINO DI APPOGGIO - ADJUSTABLE FEET

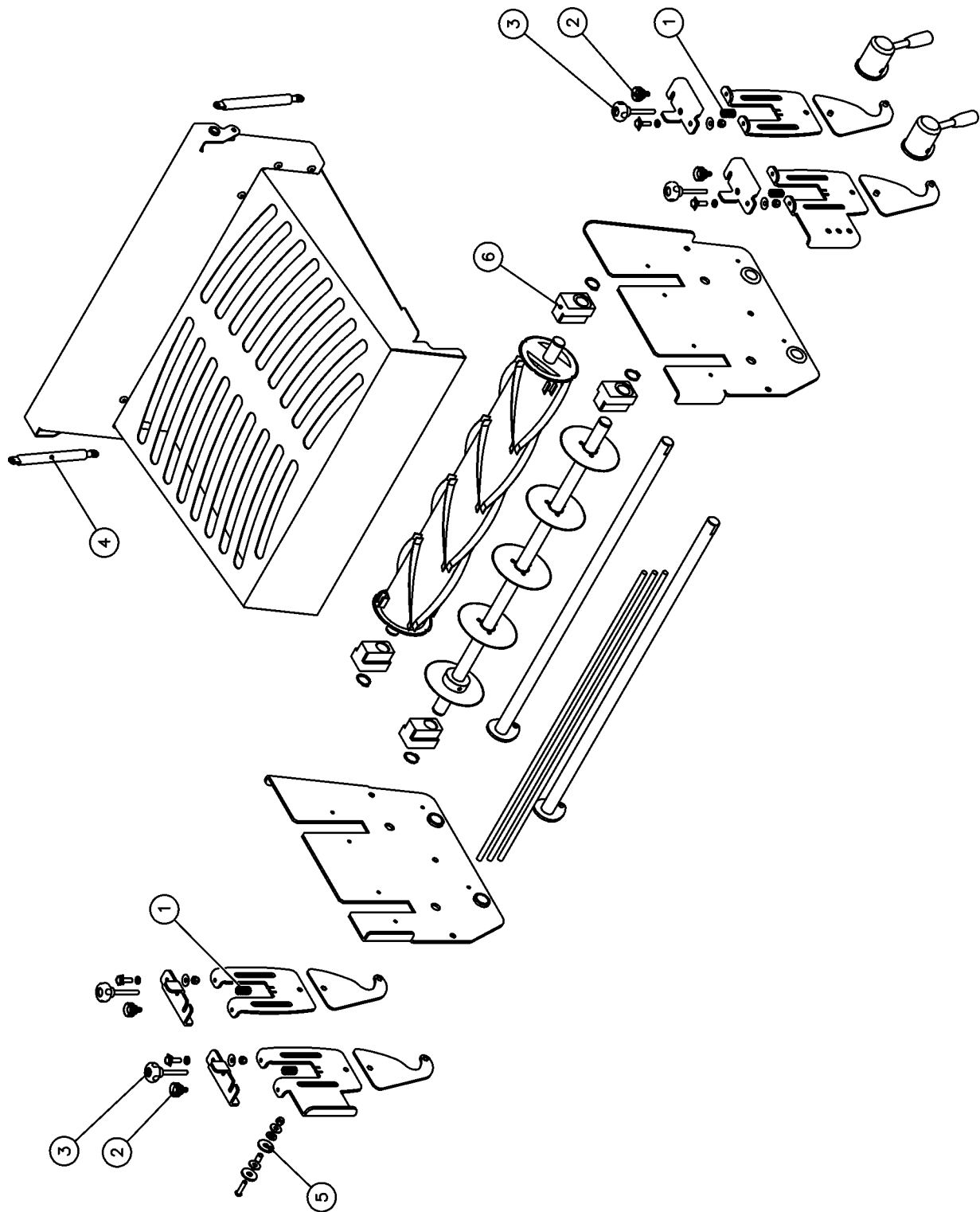
Sfogliatrice - Dough Sheeter	ELENCO PARTI DI RICAMBIO SPARE PARTS LIST	ALLEGATO1	
R65 AXP		17/07/2019	Rev. A



Sfogliatrice - Dough Sheeter	ELENCO PARTI DI RICAMBIO SPARE PARTS LIST	ALLEGATO1	
R65 AXP		17/07/2019	Rev. A

POS.	COD. R65S-AXP	DESCRIZIONE - DESCRIPTION
1	C00719	MOTORE - MOTOR
2	D04196	BUSSOLA ECCENTRICA - ECCENTRIC BUSHING
3	C00022	BUSSOLA - BUSHING
4	D01941	RULLO ZIGRINATO - KNURLED ROLLER
5	D03840	BIELLA - CONNECTING-ROD
6	D03863	RASCHIATORE - SCRAPER
7	D04756	RASCHIATORE PER SPAZZOLA - SCRAPER FOR FLOUR DUSTER BRUSH
8	D04749	SPAZZOLA - FLOUR DUSTER BRUSH

Sfogliatrice - Dough Sheeter	ELENCO PARTI DI RICAMBIO SPARE PARTS LIST	ALLEGATO 1	
R65 AXP		17/07/2019	Rev. A



Sfogliatrice - Dough Sheeter	ELENCO PARTI DI RICAMBIO SPARE PARTS LIST	ALLEGATO1	
R65 AXP		17/07/2019	Rev. A

POS.	COD. R65S-AXP	DESCRIZIONE - DESCRIPTION
1	C00688	MOLLA - SPRING
2	C00061	VOLANTINO ø21 - HANDWHEELS
3	C00064	VOLANTINO ø26 - HANDWHEELS
4	C00298	MOLLA A GAS – GAS SPRING
5	C00428	RONDELLA IN PLASTICA – PLASTIC WASHER
6	D02700	GUIDA RULLO – ROLLER GUIDE
7		

0	1	2	3	4	5	6	7	8	9
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B									
C									
D									
E									
F									

Dati Tecnici/Technical Data		CEI EN 61439-1 e 2	
Tensione nominale/Nominal Voltage (Un)	VAC P+PE		
Tensione tenuta ad impulso/Surge Voltage (Uimp)	8kV		
Tensione nominale isolamento/Rated insulated Voltage (Ui)	800VAC		
Frequenza nominale/Nominal Frequency (fn)	50/60HZ		
Corrente nominale/Nominal Current (InA)	6A		
Corrente di cortocircuito/Short circuit current (Icc)	10kA		
Potenza nominale/Nominal Power	1.7kW		
Tipo di messa a terra/Type of grounding	TT		
Grado di protezione/International protection	IP54		
Tipo di installazione/Installation type	INSIDE		
Fattore contemporaneita'/Contemporaneity factor (RDF)	0.4		
Cliente: Customer:			

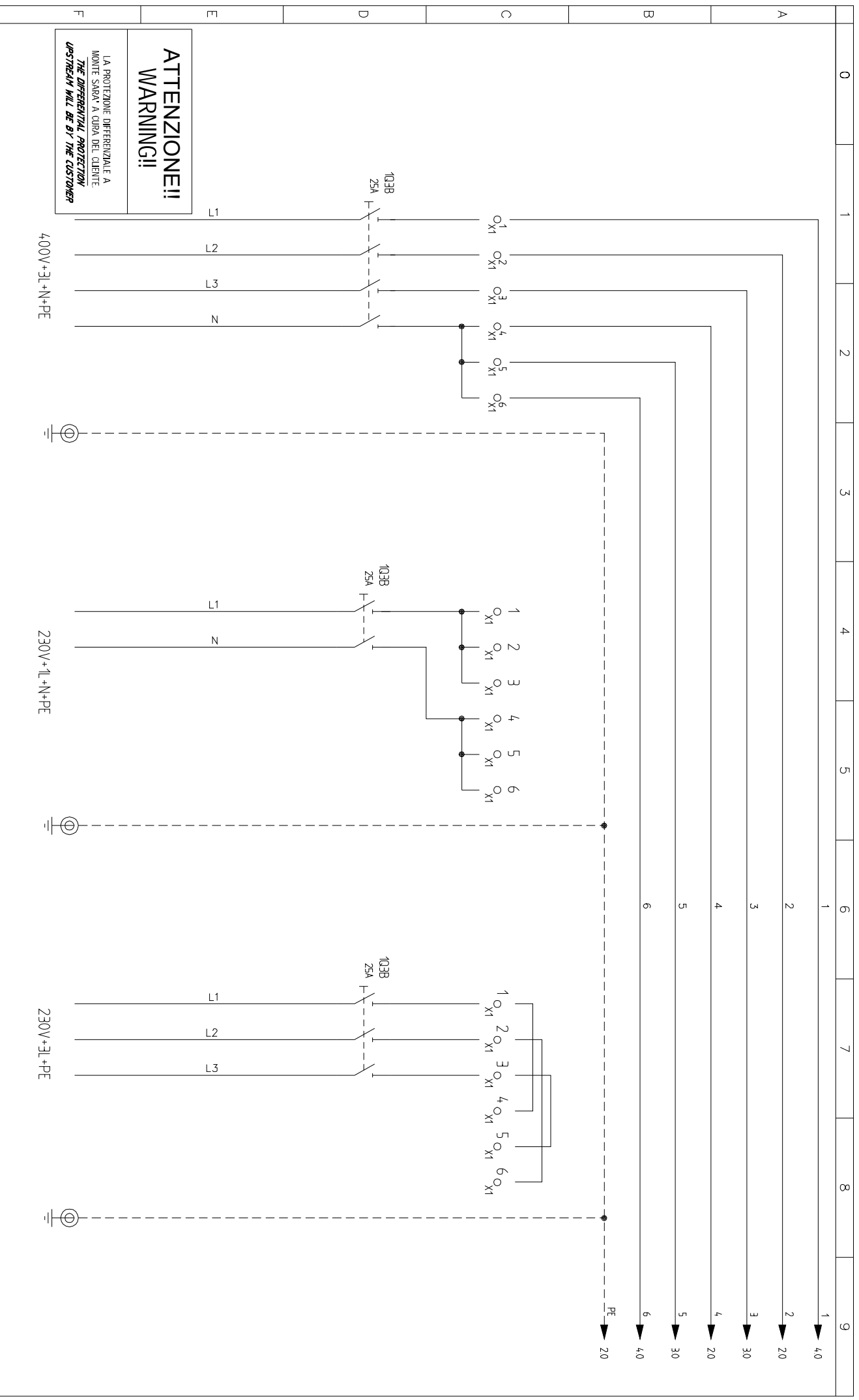
Dis. N.		Impianto		Ordine		FOGLIO	
CAD	SPAC	ROLLMATIC SFOGLIATRICE		Compresso		1	
Nome File		INTESTAZIONE		Esecutore TIZIANO		SEGUE 2	
Data	01/10/2018						

SCHEMA
ELETTTRICO

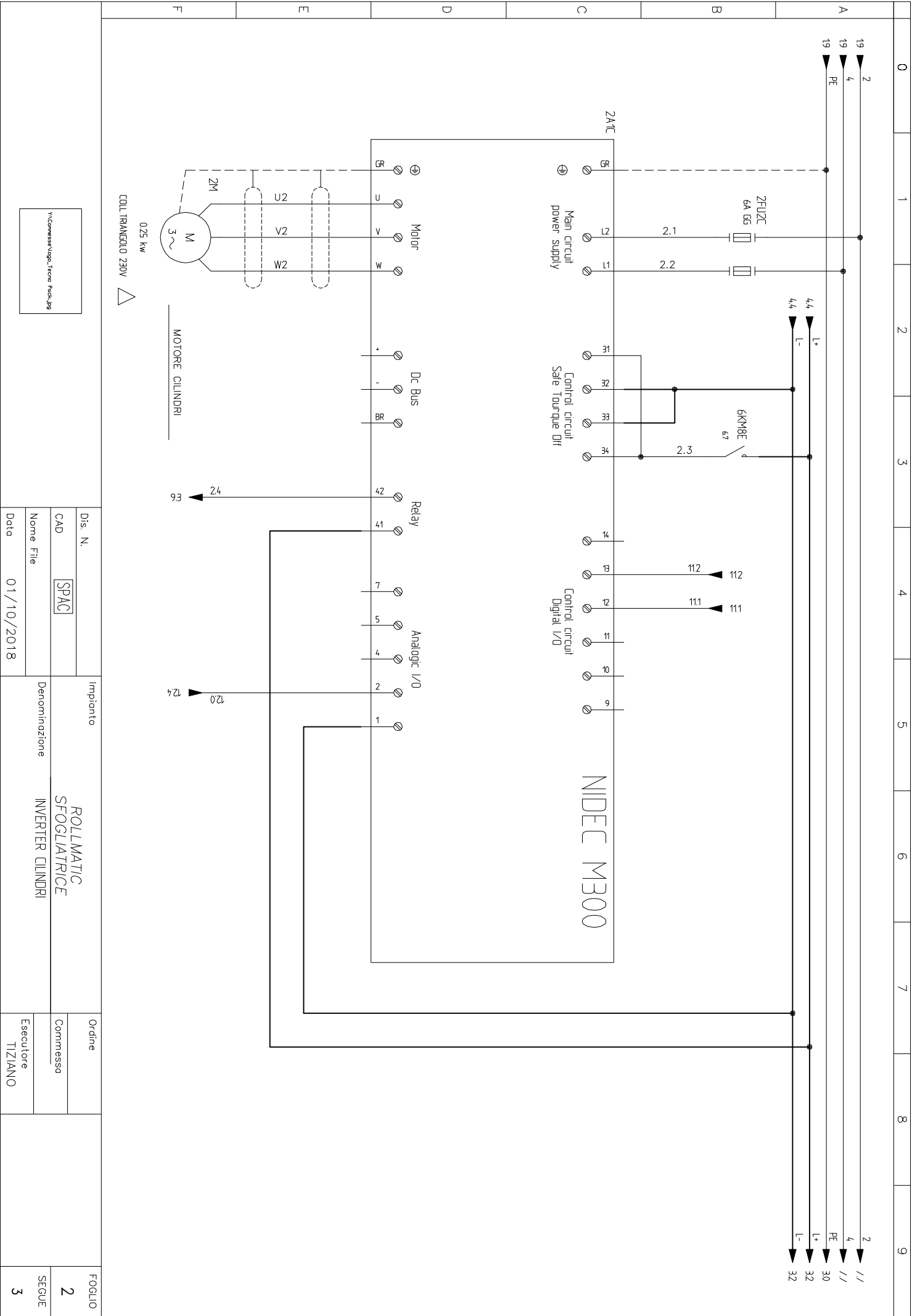
ELECTRIC
DIAGRAM

	0	1	2	3	4	5	6	7	8	9			
A	<div>INITIALING SYMBOLS</div>					<div>COMPONENTS LOCATION</div>							
B	<div>SHEET /PRECODE/COORDINATE</div>					<div><div><div>20KM</div><div><div><div>1</div><div>A</div></div><div><div>09</div><div>BI</div></div></div></div></div> <div>identify where the component is installed :</div> <div>QG general board BM machine board PANN panel CARIC feeder</div>							
C	<div><div><div><div>SHEET xxx FOLLOWS</div></div></div><div>identify type of symbol example.:<div>KA relays KM contactors U inverter SB buttons SA selectors QF automatic switches</div></div><div><div><div><div>A</div><div>B</div><div>C</div><div>D</div><div>E</div><div>F</div></div><div><div>0</div><div>1</div><div>2</div><div>3</div><div>4</div><div>5</div><div>6</div><div>7</div><div>8</div><div>9</div></div></div></div></div>					<div>identify relevant coordinates</div>							
D	<div>PAGING</div>					<div>NOTES:</div>							
E	<div>sheets: contents:</div> <div>G1-Gxx general 1-xx electric diagram 100-1xx terminal board 200-2xx connectors 250-25x LAY OUT 300-3xx COMPONENTS LIST</div>												
F													
<div><div><div>Dis. N.</div><div>CAD</div></div><div>Nome File</div><div>Data</div></div>					<div>Impianto</div> <div>ROLLMATIC SFOGLIATRICE LETTURA SCHEMA</div>					<div>Ordine</div> <div>Commissa</div> <div>Esecutore TIZIANO</div>		<div>FOGLIO</div> <div>SEGUE</div>	

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LISTA FOGLI \ INDEX																									
A	Foglio Sheet	Descrizione Description	Revisione \ Revision										Foglio Sheet	Descrizione Description	Revisione \ Revision										
			0	1	2	3	4	5	6	7	8	9			0	1	2	3	4	5	6	7	8	9	
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			2																						
			3																						
			1																						
			2																						
			3																						
			4																						
			5																						
C	6	CATENA SICUREZZE																							
	7	LAYOUT PLC																							
	8	ALIMENTAZIONE PLC																							
	9	INGRESSI DIGITALI																							
	10	INGRESSI DIGITALI																							
D	11	USCITE PLC																							
	12	USCITE ANALOGICHE																							
	13																								
	14																								
E																									
F																									
Note :																									
<div><div></div><div>ivComasset\Logo_Tecnico_Pack.jpg</div></div>										Dis. N.		Impianto		Ordine						FOGLIO					
CAD		SPAC				ROLLMATIC SFOGLIATRICE		Commissa				3													
Nome File				Denominazione		LEGGENDA		Esecutore TIZIANO				SEGUE		1											
Data		01/10/2018																							



		Foglio	
Dis. N.		1	
CAD		SEGUE	
Nome File		2	
Data		01/10/2018	
Impianto		Ordine	
CAD		Commissa	
Nome File		Esecutore	
Data		TIZIANO	
Denominazione		Ingresso Linea	
Dis. N.		Foglio	
CAD		1	
Nome File		SEGUE	
Data		2	
Impianto		Ordine	
CAD		Commissa	
Nome File		Esecutore	
Data		TIZIANO	
Denominazione		Ingresso Linea	



7

5

4

2

1

Analogic I/O

U2

V2

W2

2M

M

3

0,25 kW

MOTORE CILINDRI

COLL. TRIANGOLO 230V

△

Dis. N.

CAD

Nome File

Date

Impianto

Denominazione

Ordine

Esecutore

FOGLIO

2

3

SPAC

01/10/2018

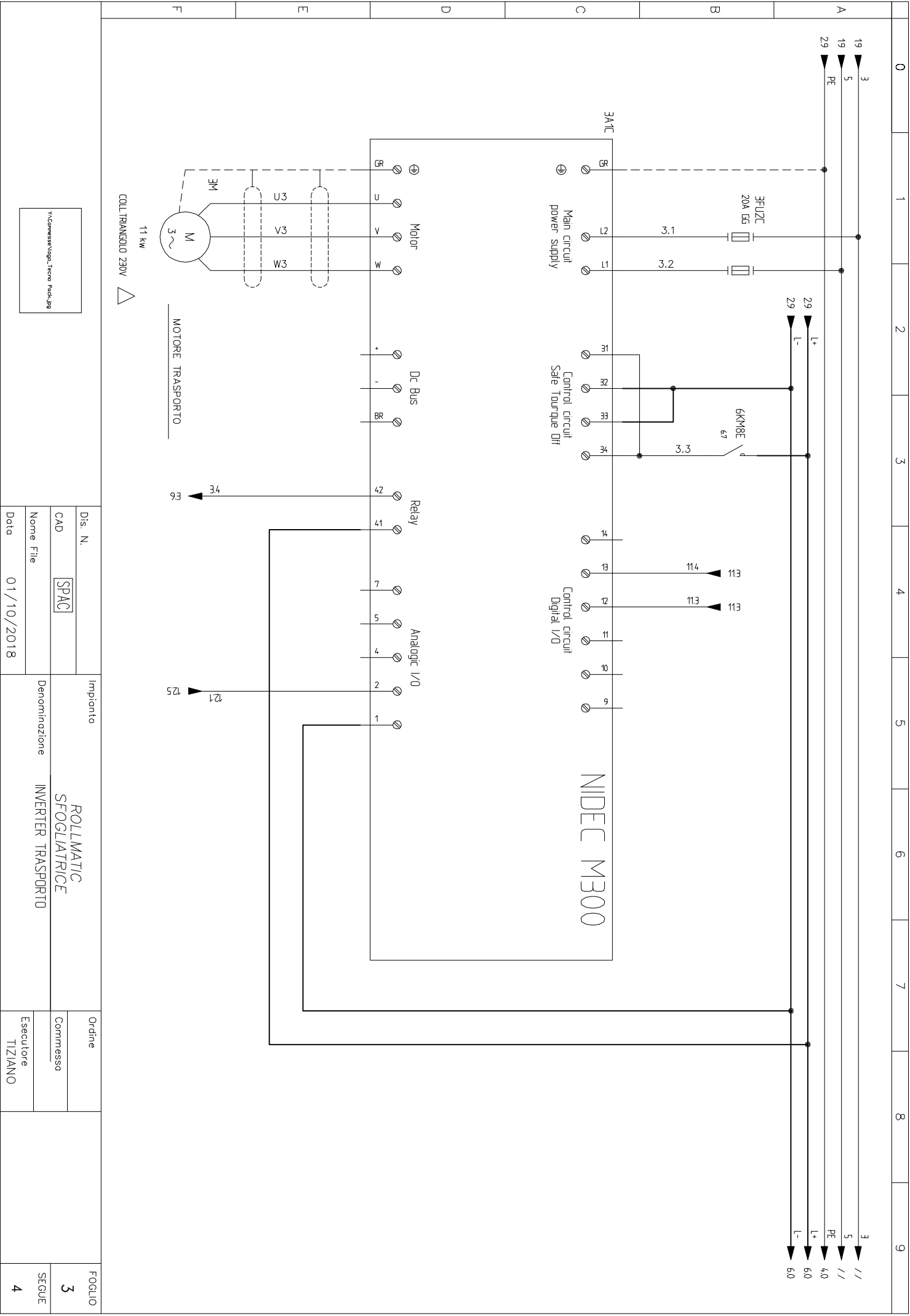
ROLLMATIC
SFOGLIATRICE
INVERTER CILINDRI

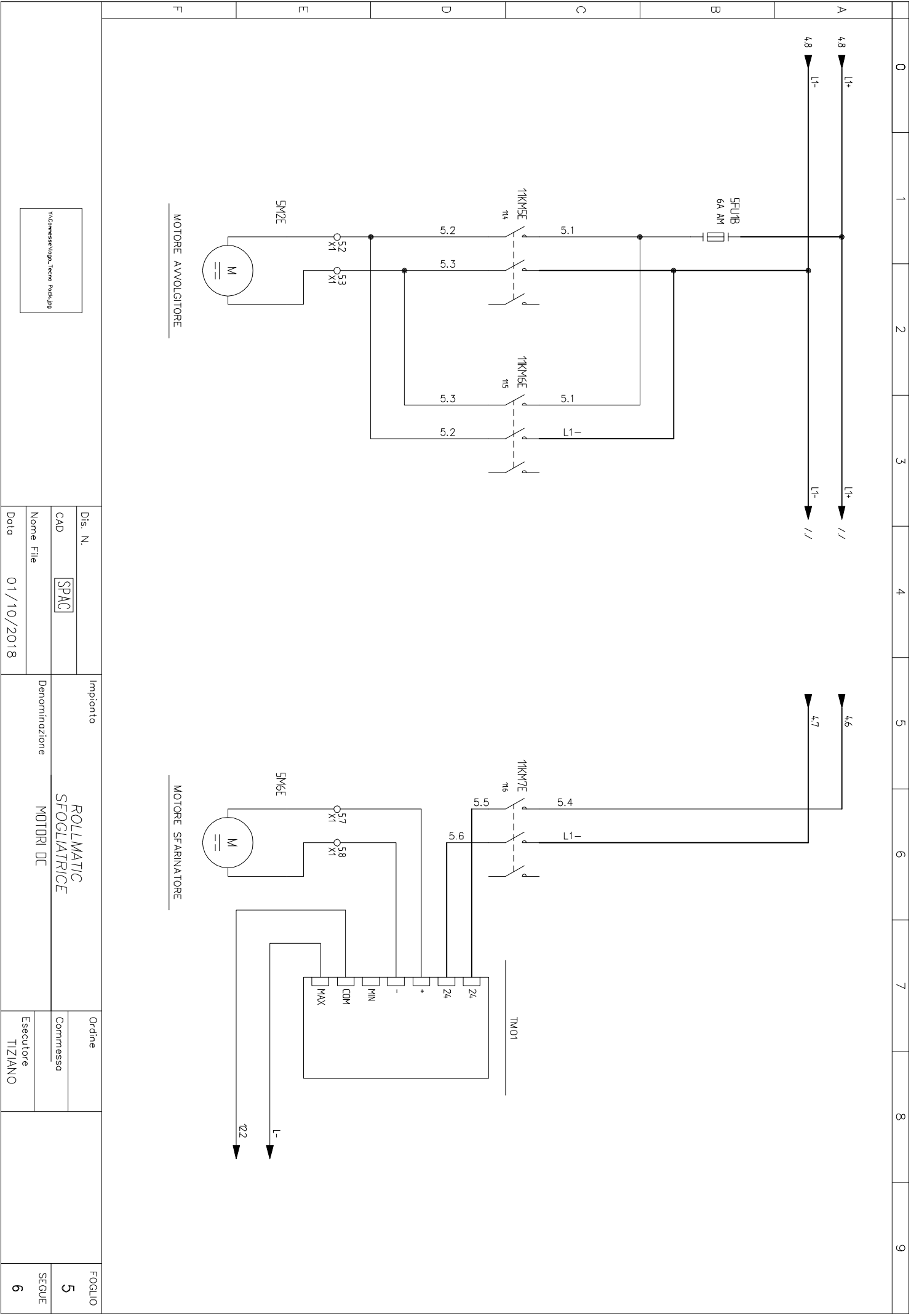
Commissio

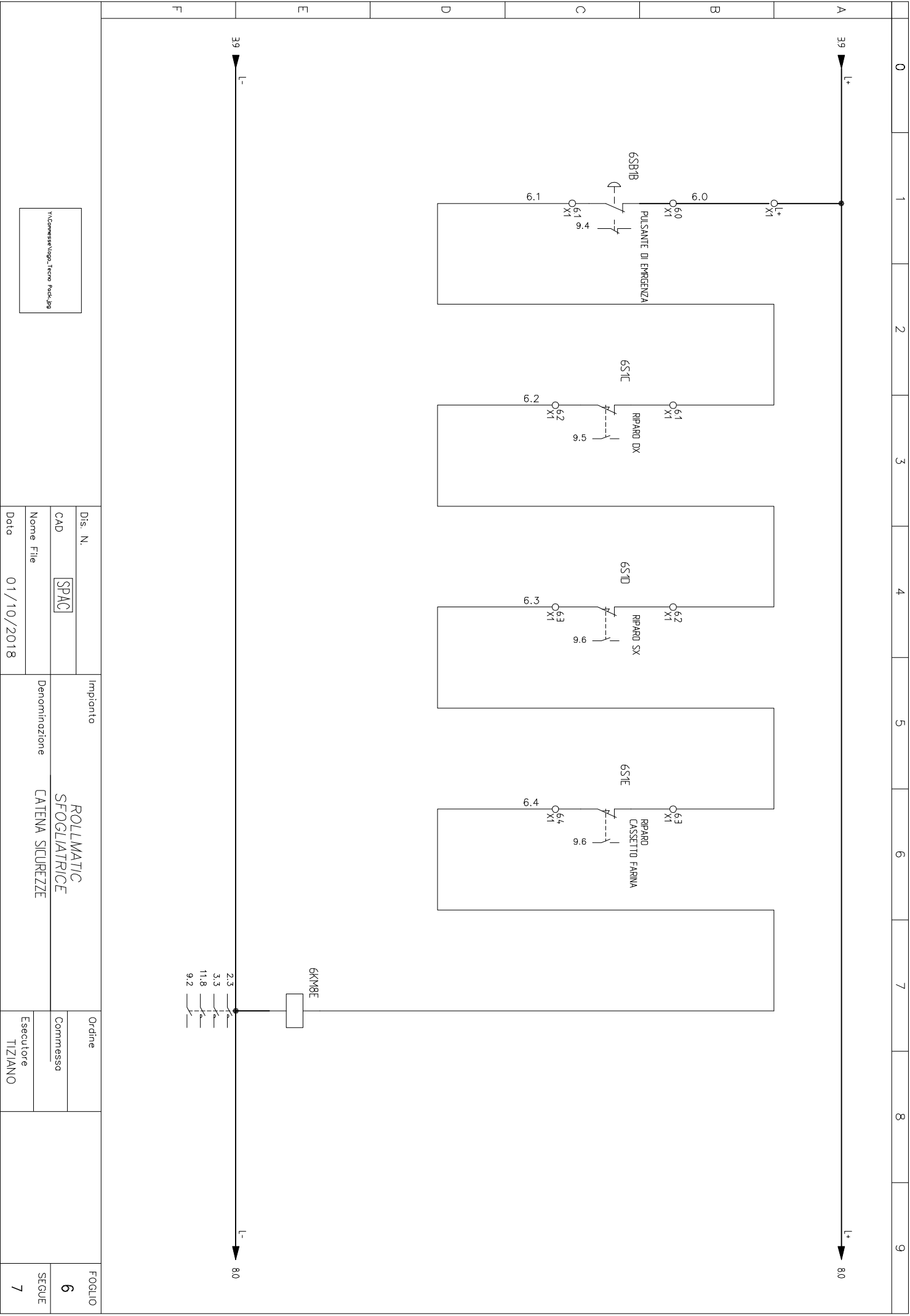
TTIZIANO

2

y:\Commesse\Nidex_Tecno_Pack.jpg







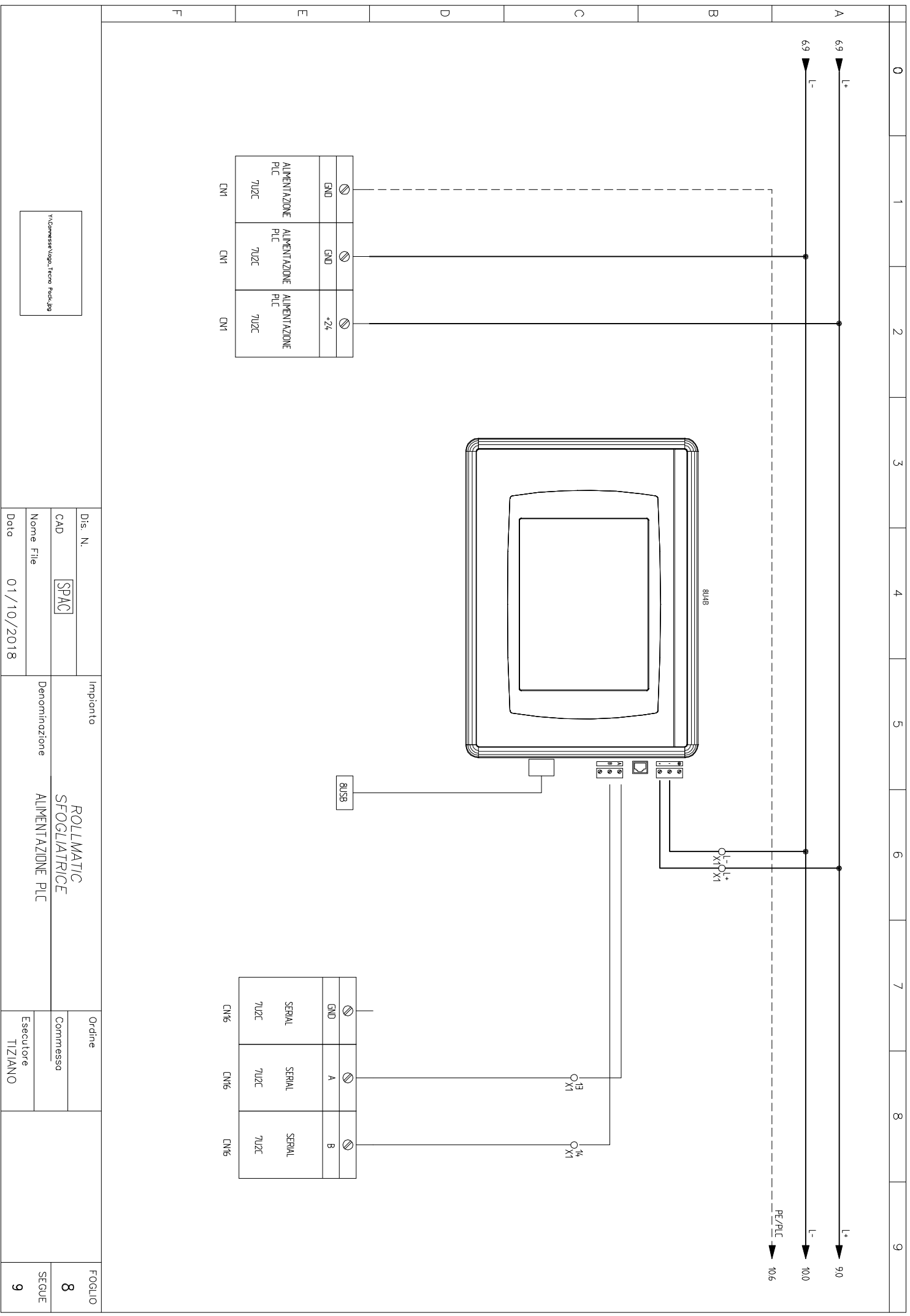
	0	1	2	3	4	5	6	7	8	9
A										
B										
C										
D										
E										
F										

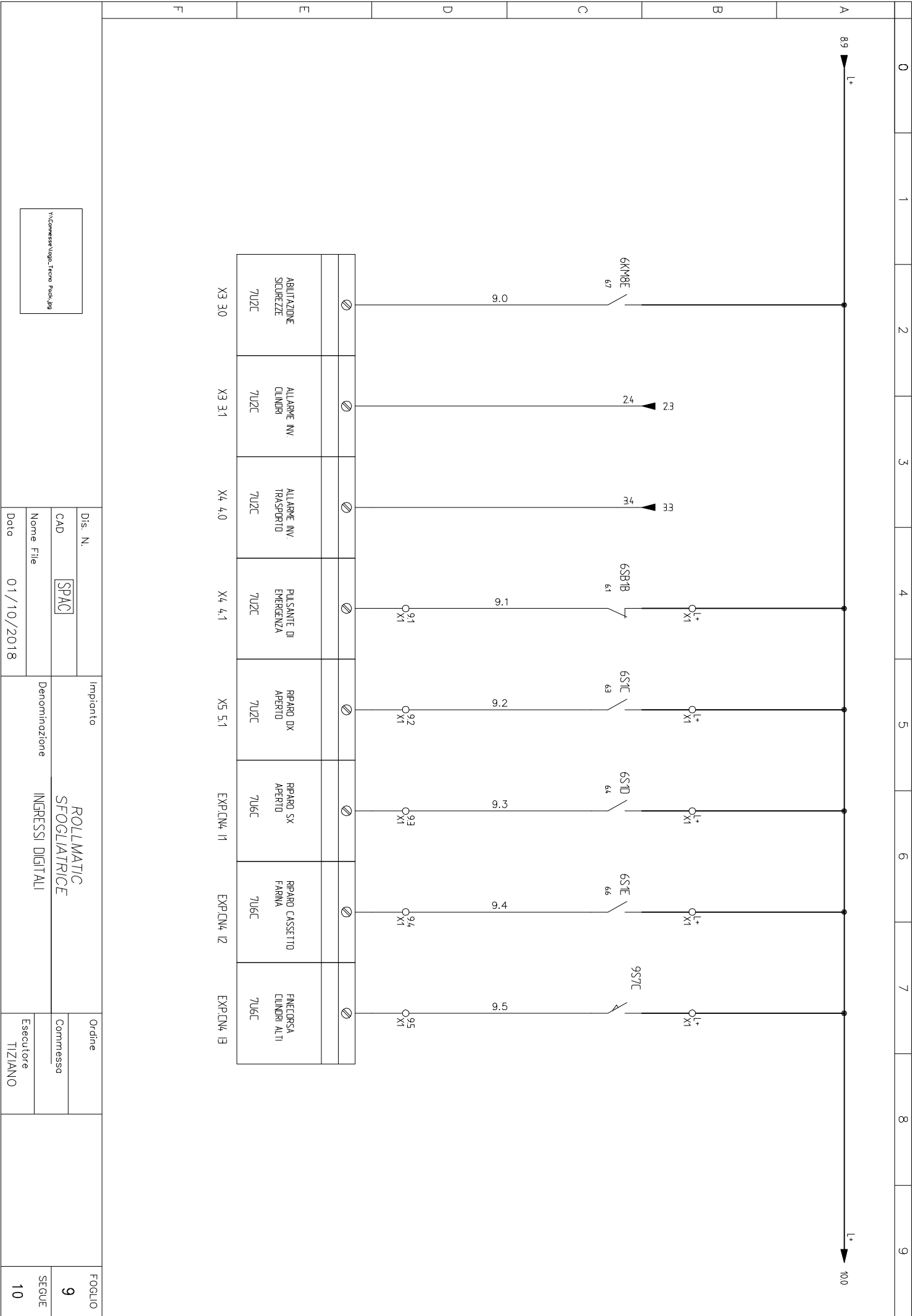
7U2C

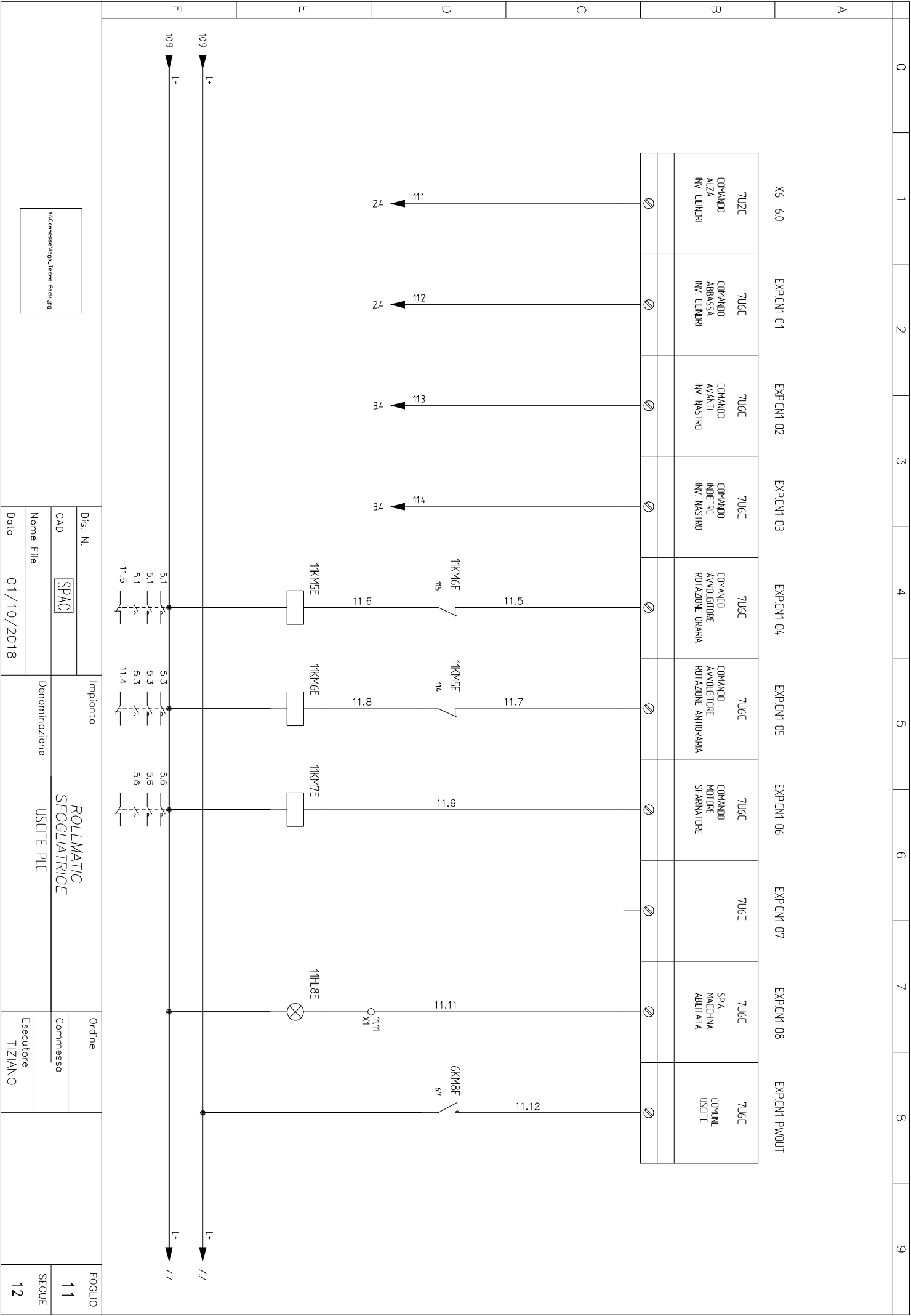
7U6C

Dis. N.		Impianto		Ordine		FOGLIO 7 SEGUE 8
CAD		<i>ROLLMATIC SFOGLIATRICE LAYOUT PLC</i>		Compresso		
Nome File				Esecutore TIZIANO		
Data		Denominazione				

V:\Compress\Logo-Terco-Pack.dwg







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A	<div><div><div><div><div>7U2C</div><div>VELOCITA' INVERTER CILINDRI</div></div><div><div>7U2C</div><div>VELOCITA' INVERTER TRASPORTO</div></div><div><div>7U2C</div><div>VELOCITA' SFAIATOIRE</div></div></div><div><div><div>120</div><div>25</div></div><div><div>121</div><div>35</div></div><div><div>122</div><div>35</div></div></div></div></div>									
B										
C										
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<div><div><div><div>Dis. N.</div><div>CAD</div><div>Nome File</div><div>Date</div></div><div><div>Impianto</div><div>Denominazione</div><div></div></div><div><div><div>Ordine</div><div>Commissa</div><div>Esecutore</div></div><div><div>TIZIANO</div><div></div></div></div><div><div>FOGLIO</div><div>12</div><div>SEGUE</div></div><div><div>13</div></div></div><div><div>viGommesaVugpo_Tecno_Produ.jpg</div></div></div>										

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<div><div>Dis. N.</div><div>CAD</div><div>Nome File</div><div>Date</div></div>					<div><div>Impianto</div><div>Denominazione</div><div></div></div>					<div><div>Ordine</div><div>Commesso</div><div>Esecutore</div><div>TIZIANO</div></div>	<div><div>FOGLIO</div><div>13</div><div>SEQUE</div><div>14</div></div>

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<div><div>Dis. N.</div><div>CAD</div><div>Nome File</div><div>Data</div></div>					<div><div>Impianto</div><div>Denominazione</div></div>					<div><div>Ordine</div><div>Commissa</div><div>Esecutore</div></div>	<div><div></div><div></div></div>	<div><div>FOGLIO</div><div>14</div><div>SEQUE</div><div>/</div></div>
					ROLLMATIC SFOGLIATRICE LAYOUT QUADRO							

IT - GARANZIA

Garanzia

- La parte venditrice garantisce l'attrezzatura nuova e in perfette condizioni estetiche e funzionali al momento della spedizione.
- La parte venditrice garantisce l'attrezzatura fornita nelle normali condizioni d'uso e secondo le specifiche tecniche del prodotto per un periodo di 12 mesi.
- Durante il periodo di garanzia la parte venditrice si impegna, a sua discrezione, a riparare o a sostituire le parti riconosciute difettose ma non al ritiro dell'attrezzatura.
- La parte acquirente deve denunciare immediatamente l'errata consegna o gli eventuali difetti della merce e trasmettere le riserve a mezzo fax, e-mail o raccomandata, unitamente ad idonea documentazione comprovante il motivo del reclamo. Trascorsi **7 gg.** dal ricevimento della merce stessa, la parte venditrice considererà la fornitura approvata dalla parte acquirente.
- Il ritardato o mancato pagamento, anche di una parte del totale dovuto, sospende ogni diritto alla garanzia fino al momento della regolarizzazione del pagamento, fermo restando l'originario termine di scadenza della garanzia stessa.

Esclusioni e limitazioni della garanzia

- Sono esclusi dalla garanzia le parti di normale consumo, i danni alla verniciatura, i danni avvenuti durante il trasporto, i danni causati da errato montaggio e installazione, i danni derivanti da manomissione da parte del compratore o di terzi, i danni causati da un uso non conforme al manuale e la merce sprovvista del marchio della parte venditrice
- Salvo provati vizi occulti sono escluse dalla garanzia parti elettriche ed elettroniche
- La garanzia decade in caso di utilizzo improprio dell'attrezzatura, ad es. applicazioni che non siano quelle per le quali è stata progettata, oppure in caso di un utilizzo "non normale", ad es. un uso prolungato e ripetitivo sotto sforzo (per utilizzo normale si intende un utilizzo ad intermittenza su un turno di lavoro)
- La modifica dell'attrezzatura comporta l'automatico decadimento della garanzia
- La restituzione alla parte venditrice delle parti ritenute difettose è condizione necessaria per la sostituzione delle stesse. I costi di trasporto per la restituzione di parti ritenute difettose e per la spedizione di parti in garanzia sono a carico della parte acquirente.
- I costi sostenuti dalla parte acquirente per la sostituzione delle parti difettose non sono riconosciuti, così come eventuali danni indiretti causati da guasti o disfunzioni dell'attrezzatura.

EN – WARRANTY

Warranty

- The seller guarantees that at the moment of dispatch the equipment is in perfect functional and aesthetic condition.
- The seller guarantees the equipment supplied for a time of 12 months for normal conditions of use and according to the product's technical specifications.
- During the warranty period, the seller undertakes at his discretion, to repair or replace parts found to be faulty but not to collect the equipment.
- The buyer must immediately report a wrong delivery or any defects found in the goods and send his reserves by fax, e-mail or registered letter, together with suitable documentation proving the reason for the complaint. When **7 days** have elapsed from receipt of the goods, the seller shall consider the supply approved by the buyer.
- A delay in payment or non-payment, even only of a part of what is due, suspends all rights to the warranty up until payment is settled, it being understood that the original expiry date of the warranty still remains.

Warranty limitation and exclusions

- Parts subject to normal wear, damage to the paintwork, damage occurred during transport, damage caused by an incorrect assembly and/or installation, tampering by the buyer or third parties and goods without the seller's mark are not covered by the warranty.
- Except for proven hidden flaws, none of the electrical and electronic parts are covered by the warranty.
- The warranty will be void in case the equipment is used incorrectly, e.g., for applications which are different than the ones it has been projected for, or in case of an "abnormal" and prolonged use under stress (a "normal" use is an intermittent use on a working shift)
- Tampering of the equipment would void the warranty
- It is mandatory for all parts deemed faulty to be returned to the seller for replacing. Transport costs for returning the parts deemed faulty and for shipping parts covered by the warranty shall be borne by the buyer
- Costs borne by the buyer for replacing faulty parts will not be refunded, likewise any indirect damages caused by failures or malfunctions of the equipment

ES - GARANTÍA

Garantía

- La parte vendedora garantiza los equipos nuevos y en perfectas condiciones estéticas y funcionales al momento de la expedición.
- La parte vendedora garantiza los equipos suministrados en condiciones normales de uso y según las especificaciones técnicas del producto por un período de 12 meses.
- Durante el período de garantía, la parte vendedora se compromete, a su discreción, a reparar o sustituir las partes reconocidas defectuosas pero no al retiro de los equipos.
- La parte compradora debe denunciar inmediatamente la errata entrega o los posibles defectos de la mercancía y transmitir las reservas por fax, e-mail o carta certificada, junto con la adecuada documentación que demuestren el motivo del reclamo. Transcurridos **7 días** desde la recepción de la mercancía, la parte vendedora considerará la entrega aprobada por parte del comprador.
- El retraso o la falta de pago, también de una parte del total adeudado, suspenderá todo derecho a la garantía hasta el momento de la regularización del pago, sin perjuicio de la fecha de vencimiento original de la garantía.

Exclusiones y limitaciones de la garantía

- Se excluyen de la garantía las partes del normal consumo, los daños a la pintura, los daños ocurridos durante el transporte, los daños causados por erróneo montaje e instalación, los daños derivados de la manipulación por parte del comprador o de terceros, los daños causados por un uso no conforme al manual y la mercancía desprovista de la marca del vendedor.

- Salvo probados defectos ocultos son excluidos de la garantía las partes eléctricas y electrónicas.
- La garantía decae en caso de la utilización impropia de los equipos, por ejemplo: aplicaciones que no sean para las cuales se creó, o en caso de un uso "no normal", por ejemplo un uso prolongado y repetitivo bajo esfuerzo (por uso normal se entiende un uso intermitente durante un turno de trabajo)
- La modificación del equipo implica la extinción automática de la garantía
- La devolución al vendedor de las piezas que se consideran defectuosas es una condición necesaria para la sustitución de las mismas. Los gastos de envío para la devolución de las piezas que se consideran defectuosas y el envío de las piezas en garantía son responsabilidad del comprador
- Los gastos contraídos por el comprador para la sustitución de las partes defectuosas no son reconocidos, así como los posibles daños indirectos causados por fallos o mal funcionamiento del equipo.

FR - GARANTIE

Garantie

- Le vendeur garantit l'équipement neuf et en conditions esthétiques et fonctionnelles parfaites au moment de l'expédition.
- Le vendeur garantit l'équipement fourni dans les conditions d'utilisation normales et selon les spécifications techniques du produit pendant une période de 12 mois.
- Pendant la période de garantie le vendeur s'engage, à sa discrétion, de réparer ou de remplacer les pièces retenues défectueuses mais pas au retrait de l'équipement.
- L'acheteur doit signaler immédiatement la livraison erronée ou les éventuels défauts de la marchandise et transmettre les protestations par fax, e-mail ou recommandée, uniment à une documentation se rapportant à la raison de la réclamation. Après **7 j.** de la réception de la marchandise, le vendeur considèrera la fourniture approuvée par l'acheteur.
- Le retard ou le non-paiement, même d'une partie du total dû, élimine tout droit de garantie jusqu'au moment de la régularisation du paiement, étant entendu la date limite de la garantie à l'origine.

Exclusions et limitations de la garantie

- Sont exclues par la garantie les pièces soumises à usure normale, les dommages à la peinture, les dommages advenus pendant le transport dérivant de la manipulation de la part de l'acheteur ou de tiers, les dommages causés par une utilisation non conforme au manuel et la marchandise dépourvue de la marque du vendeur.
- Sauf défauts testés cachés, les pièces électriques et électroniques sont exclues.
- La garantie tombe en cas d'utilisation improprie de l'équipement, par ex. des utilisations qui ne sont pas celles pour lesquelles il a été conçu, ou bien en cas d'une utilisation "anormale", par ex. un usage prolongé et répétitif sous effort (pour utilisation normale on entend une utilisation alternée sur un roulement de travail)
- La modification de l'équipement comporte automatiquement l'annulation de la garantie
- La restitution au vendeur des pièces retenues défectueuses est une condition nécessaire pour le remplacement de ces dernières. Les frais de transport pour la restitution des pièces retenues défectueuses et pour l'expédition des pièces sous garantie sont à la charge de l'acheteur.
- Les frais soutenus par l'acheteur pour le remplacement des pièces défectueuses ne sont pas reconnus, tout comme les éventuels dommages indirects causés par des pannes ou des dysfonctionnements de l'équipement.

RU - ГАРАНТИЯ

Гарантия

- Продающая сторона гарантирует новое оборудование в отличном внешнем и рабочем состоянии на момент отправки.
- Продающая сторона предоставляет гарантийный срок на поставленное оборудование в обычных эксплуатационных условиях и согласно техническим требованиям продукта продолжительностью 12 месяцев.
- В течение гарантийного периода продающая сторона обязуется на свой выбор выполнять ремонт или замену признанных дефектными частей, но не возврат оборудования.
- Покупаящая сторона должна немедленно заявить о неправильной поставке или о дефектах товара и отправить претензии по факсу, электронной почте или заказным письмом вместе с соответствующей документацией, что подтверждает причину претензии. По истечении **7 дней** с даты получения товара продающая сторона считает поставку одобренной покупателем стороной.
- Задержка или отсутствие оплаты, в том числе и частичной, прекращает любое право на гарантию до момента выплаты всей суммы. При этом остается неизменным изначальный срок прекращения действия гарантии.

Исключения и ограничения гарантии

- Под действие гарантии не подпадают части, подверженные обычному износу, повреждения лакокрасочного покрытия, повреждения во время транспортировки, ущерб от неверной сборки и установки, ущерб из-за вмешательства покупателя или третьих лиц, ущерб, причиненный вследствие применения, не соответствующего руководству, а также товар, не имеющий торгового знака продающей стороны.
- За исключением подтвержденных скрытых дефектов, из гарантии исключаются электрические и электронные части.
- Действие гарантии прекращается в случае ненадлежащего применения оборудования, например, в целях, которые отличаются от тех, для которых оно разработано, а также в случае "ненормальной" эксплуатации, например, длительное и постоянное применение под нагрузкой (под нормальной эксплуатацией понимается эксплуатация в течение одной рабочей смены).
- Изменения в оборудовании ведут за собой автоматическое прекращение действия гарантии.
- Необходимыми условием замены дефектных частей является их возврат продающей стороне. Расходы на транспортировку по возврату частей, признанных дефектными, а также по отправке гарантийных запчастей несет покупаящая сторона
- Расходы покупаящей стороны по замене дефектных частей не подлежат возмещению, а также не подлежит возмещению косвенный ущерб от поломок или неисправностей оборудования.