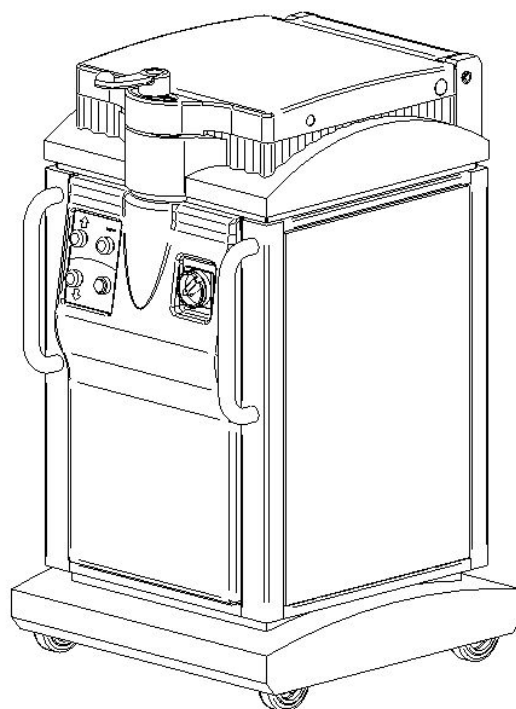
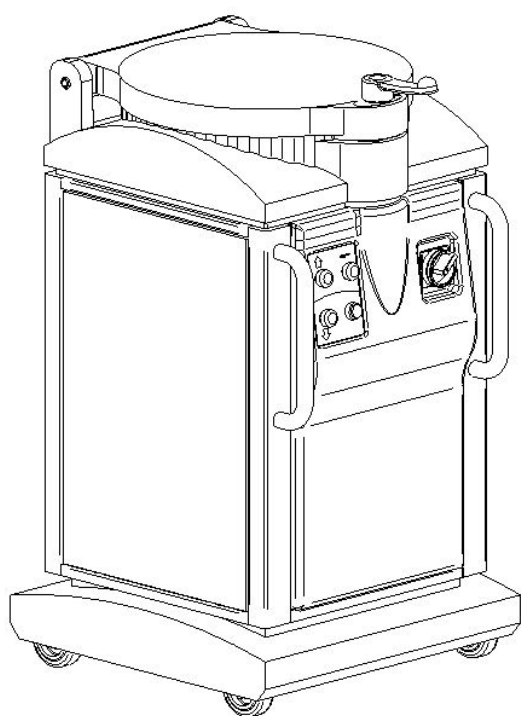


Daub Bakery Machinery B.V.	Manual Date: 05-06-2012 Version: 6
ROBOCUT <sup>2</sup> Automatic	English



Daub Bakery Machinery B.V.	Manual Date: 05-06-2012 Version: 6
ROBOCUT <sup>2</sup> Automatic	Page 2 of 18

1	GENERAL .....	3
2	PRODUCT INFORMATION .....	4
3	EXPLANATIONS .....	5
	3.1 Warnings .....	5
	3.2 Qualified employees .....	5
	3.3 Machine part description .....	6
	3.4 Notifications on control panel .....	6
4	SAFETY .....	7
	4.1 Safety regulations .....	7
	4.2 Dangers because of mechanical components .....	7
	4.3 Dangers because of electrical components .....	7
	4.4 Dangers because of lack of hygiene .....	7
5	TRANSPORT AND UNPACKING .....	8
	5.1 Transport .....	8
	5.2 Unpacking .....	8
6	INSTALLATION .....	9
	6.1 Placing and maintenance .....	9
	6.2 Conditions .....	9
	6.3 Electrical connection .....	9
	6.4 Disposal of materials .....	10
	6.5 Taking out of operation .....	10
7	PRODUCT DESCRIPTION .....	11
	7.1 Machines purpose .....	11
	7.2 Inadmissible use of the machine .....	11
	7.3 Hydraulic system – how it works .....	11
8	WORKING OF THE MACHINE .....	12
	8.1 Using the machine .....	12
	8.2 Description of the control board .....	12
	8.3 Working of the control board .....	13
	8.4 Working with the machine .....	13
9	JUDGING THE RESULTS .....	15
10	MAINTENANCE .....	16
	10.1 Cleaning .....	16
	10.2 Hydraulic pressure .....	17
11	FAULT FINDING .....	18

Daub Bakery Machinery B.V.	Manual Date: 05-06-2012 Version: 6
ROBOCUT <sup>2</sup> Automatic	Page 3 of 18

## 1 GENERAL

It is important to read this manual and to comply with the suggestions, recommendations and / or regulations when unpacking, installing, using and maintaining the machine. If the machine is sold on, this manual should be handed over to the new owner.

Only employees who have been instructed concerning the use of this machine and who have read this manual may operate this machine.

Daub Bakery Machinery B.V. will accept no liability for defects which have occurred because of the incorrect use of the machine. Neither will Daub Bakery Machinery B.V. be held responsible for any damage or injuries to operators or to third persons if deemed to be caused by the incorrect use of the machine.

No part of this publication may be reproduced, duplicated or distributed without the prior written permission of the manufacturer.

Daub Bakery Machinery B.V. can not be held responsible for any mistakes and / or misprints in this manual.

It is recommended that you keep this manual close to, or with the, machine at all times.



Daub Bakery Machinery B.V.	Manual Date: 05-06-2012 Version: 6
ROBOCUT <sup>2</sup> Automatic	Page 5 of 18

### 3 EXPLANATIONS

#### 3.1 Warnings

The following signs warn the operator of possible danger due to mechanical (figure 3-1) or electrical components (figure 3-2).



Figure 3-1

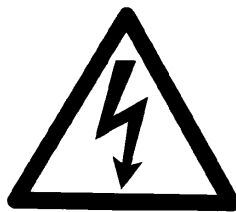


Figure 3-2

Figure 3.1 is a sticker which is used on the machine indicating a position where caution must be taken to avoid mechanical crushing in the machine.

Figure 3.2 is a sticker which is used on the machine indicating where electrical power is present.

Before using the machine, you should carefully read this manual and follow the instructions. Make sure that the warning stickers remain in good condition, and if necessary replace them. When you use the machine for the first time, follow the instructions in this manual carefully, so that you are familiar with the machine.

Do not allow unqualified employees to operate this machine.



Only qualified employees may operate the machine.



Make sure the machine is switched off during cleaning, maintenance and lubrication.

After maintenance of the machine do not forget to replace the safety covers and close the door at the rear of the machine.

All repairs, mechanical as well as electrical, may only be completed by qualified employees.

#### 3.2 Qualified employees

Means: persons who are familiar with the installation, assembly, installation and operation of the machine and who have the correct qualifications.

Daub Bakery Machinery B.V.	Manual Date: 05-06-2012 Version: 6
ROBOCUT <sup>2</sup> Automatic	Page 6 of 18

### 3.3 Machine part description

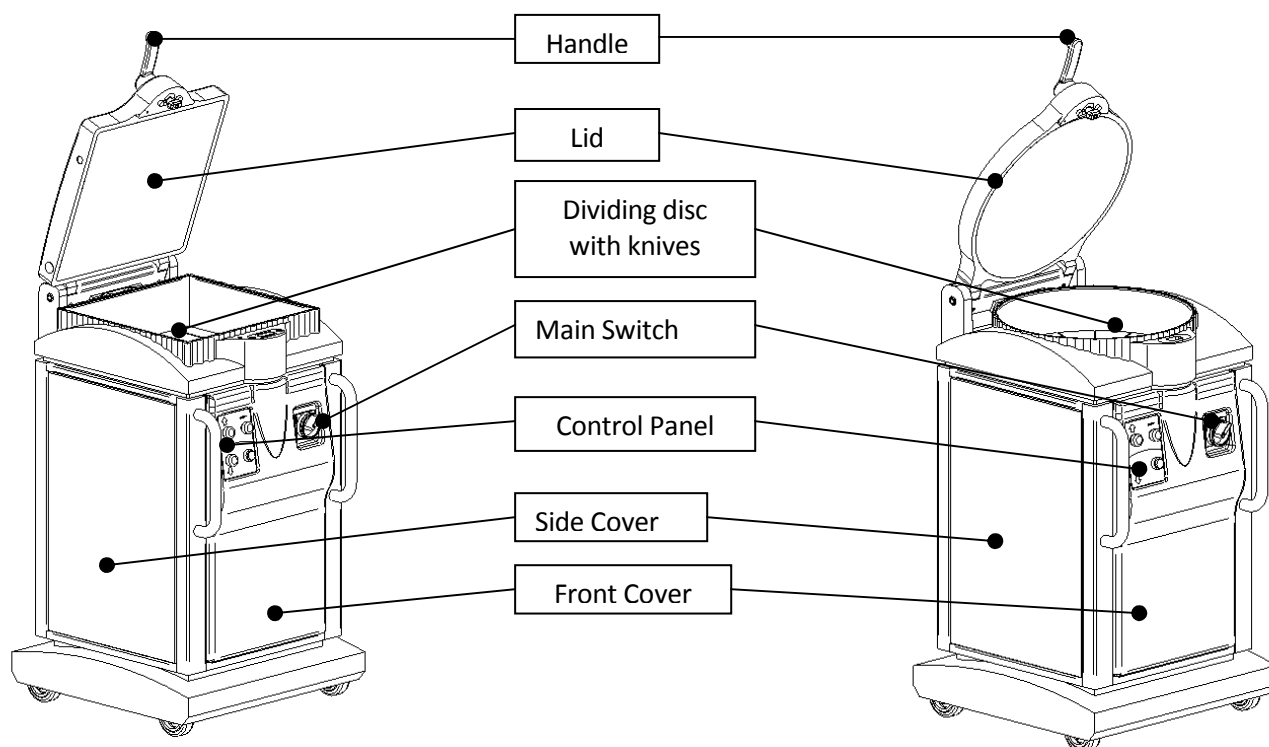


Figure 3-3

### 3.4 Notifications on control panel

The control light on the panel can indicate the following:

Continuous light:	Hydraulic unit is running during normal operation.
Continuous light but no production:	Hydraulic unit is still running Thermal overload hydraulic motor
Flashing light:	Oil temperature of hydraulics too high



Do not use the machine when above notifications appear. First read chapter 11 to learn more about the error and what to do!

Daub Bakery Machinery B.V.	Manual Date: 05-06-2012 Version: 6
ROBOCUT <sup>2</sup> Automatic	Page 7 of 18

## 4 SAFETY

### 4.1 Safety regulations



Remove the plug from the power supply when cleaning and/or maintaining the machine.



Only qualified or well instructed employees can do repairs of mechanical or electrical nature.



Never put your hands underneath the lid while closing.



Only one person may use the machine.



Keep covers in place when operating the machine.



Do not use the machine when certain notifications (mentioned in chapter 3.4) appear in the display. Read first chapter 11 to learn more about the error and what to do!

### 4.2 Dangers because of mechanical components

With proper use of the machine as described in chapter 8 no danger will occur.



When closing the lid, fingers could be injured if fingers are caught between the lid and the machine.



If the lid is closed and there is still dough in the machine, a lot of pressure can be created by fermentation of the dough. A lot of pressure can be created on the lid. Be careful when opening the lid.



When maintaining the machine not respecting the safety regulations and/or incorrect maintenance, could result in injury.  
Therefore all operators must be familiar with the current safety regulations.

### 4.3 Dangers because of electrical components

These dangers will not occur, as the machine is protected.

### 4.4 Dangers because of lack of hygiene

These dangers can occur if the measures such as described in chapter 10 ("Maintenance") are not followed correctly.

Daub Bakery Machinery B.V.	Manual Date: 05-06-2012 Version: 6
ROBOCUT <sup>2</sup> Automatic	Page 8 of 18

## 5 TRANSPORT AND UNPACKING

### 5.1 Transport

The machine must be transported in its original packaging. During transport the packaging must be secured against sliding and tipping. The machine should be moved with the correct lifting equipment.

Transport damage caused by not having followed above mentioned regulations, can not be claimed. Moreover the transport of goods is always at the buyer's risk, unless explicitly agreed otherwise.



Do not stack anything on top of the packing.



The machine should always be transported in an upright position.

### 5.2 Unpacking

Leave the packing upright and remove the box vertically.

Unpack the machine carefully and check if there are any signs of transport damage. Should you find any, please inform your transport agent immediately. We advise you to take photographs of the damage.

Remove the machine from the pallet by means of a (fork) lift truck or other suitable lifting equipment.

By putting the forks of a (fork) lift truck under the foot of the machine, it can be removed from the pallet.



The weight of the machine is approximately 360 kg.



Out of safety considerations it is advisable to keep a safe distance when lifting the machine.



Daub Bakery Machinery B.V.	Manual Date: 05-06-2012 Version: 6
ROBOCUT <sup>2</sup> Automatic	Page 9 of 18

## 6 INSTALLATION

### 6.1 Placing and maintenance



Only qualified employees are allowed to install the machine.



The machine can only be used for its purpose.



Guarantee can not be claimed if changes have been made to the machine without the manufacturers' permission and/or not-original parts are used.

Place the machine on a flat floor and free from surrounding parts like walls, other machines etc.

### 6.2 Conditions

Temperature: 15° C to 40° C

Relative humidity: 20% tot 95%

### 6.3 Electrical connection

A qualified engineer must carry out the installation and an electrician should connect the machine to the main power supply. Always check first if the voltage and the phases of the electrical connection are in accordance with those of the machine (see machine plate). If this is not the case, please contact your supplier.

Be aware the machine contains electronic components, so a stabilised power supply is needed as we recommend that the power supply is also surge protected.

Check the direction of rotation of the machine (motor). If the rotation is not correct, an electrician should switch the two phases in the plug!

Daub Bakery Machinery B.V.	Manual Date: 05-06-2012 Version: 6
ROBOCUT <sup>2</sup> Automatic	Page 10 of 18

#### 6.4 Disposal of materials

When disposing of a complete machine, parts or only the packaging, you should comply with the applicable legal regulations. Specifications concerning parts material can be requested at the manufacturer.



#### ***Correct disposal of this product***

This marking shown on the product or its literature indicates that it should not be disposed with other household wastes at the end of its working life. To prevent possible harm to the environment or human health from uncontrolled waste disposal, please separate this from other types of wastes and recycle it responsibly to promote the sustainable reuse of material resources.

Household users should contact either the retailer where they purchased this product, or their local government office, for details of where and how they can take this item for environmentally safe recycling.

Business users should contact their supplier and check the terms and conditions of the purchase contract. This product should not be mixed with other commercial wastes for disposal.

#### 6.5 Taking out of operation

Switch off the machine by turning the main switch to “0”. Then clean it and check the lubrication points as described in chapter 10 “Maintenance”. Protect the machine from outside influences and store it in a closed, dry room.

Daub Bakery Machinery B.V.	Manual Date: 05-06-2012 Version: 6
ROBOCUT <sup>2</sup> Automatic	Page 11 of 18

## 7 PRODUCT DESCRIPTION

### 7.1 Machines purpose

The machine is intended to divide dough from  $\pm 4$  kg to 18 kg into equal pieces. Sprinkle the dough with a little flour to minimise sticking of the dough.

### 7.2 Inadmissible use of the machine

The hydraulic divider is only meant for the activities as described in chapter 7.1.

The machine should only be cleaned with cleaning products which are approved for use in the food industry. Never use corrosive products!

The machine should only be used when all the safety guards are placed.

Only use original spare parts.

### 7.3 Hydraulic system – how it works

The hydraulic system consists of:

- Hydraulic unit
- High-pressure tubes
- Couplings
- Telescopic cylinder

The hydraulic unit is set at 45 bars. The high-pressure tubes resist dynamic pressures of 160 bar, the couplings 240 bar.

Daub Bakery Machinery B.V.	Manual Date: 05-06-2012 Version: 6
ROBOCUT <sup>2</sup> Automatic	Page 12 of 18

## 8 WORKING OF THE MACHINE

### 8.1 Using the machine

Check if the machine has been placed correctly, as described in chapter 6 “Installation”.

Check if it is necessary to clean the machine due to potential transport dirt.

Also check if the voltage on the machine plate is in accordance with that of your main power supply.

You can now proceed with the first test.

### 8.2 Description of the control board

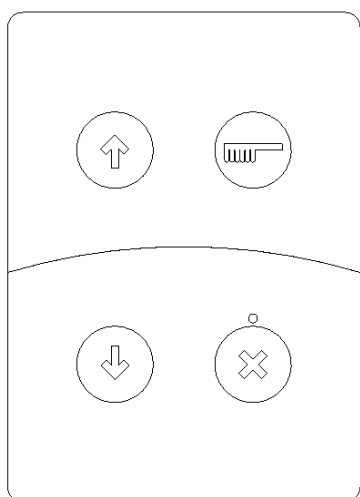


Figure 8-1

#### Position

#### Description



Raise button; pressing and releasing dough



Cleaning button for releasing knives (optional)



Cycle time reduction button, light machine running



Lower button; returning dividing disc to start position

Daub Bakery Machinery B.V.	Manual Date: 05-06-2012 Version: 6
ROBOCUT <sup>2</sup> Automatic	Page 13 of 18

### 8.3 Working of the control board

Numbers refer to figure 8-1

With the raise button (1) the dividing head and the knife can be moved upwards. A timer regulates the upward movement of the dividing head and knife. The machine presses until the adjusted pressure has been reached. Now the second position of the cylinder which is connected to the knives will cut into the dough.

Button 3 can be used to stop the pressing cycle when you want, i.e. before the timer or full pressure is reached.

With the lower button (4) the dividing head and the knives can be moved downwards. Also a timer regulates the downward movement of the dividing head and knives.

Optional:

With the button for cleaning the knife (2), only the knife can be moved upwards. The movement works only if you keep pressing the button.

### 8.4 Working with the machine



Only qualified persons older than 16 years may operate the machine.

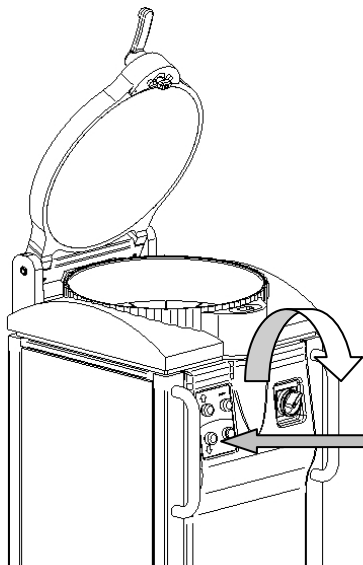


Figure 8-2

Before working with the machine, first turn the main switch (figure 3-3) to position "1" (=on). After use, switch off the machine by turning the switch to "0" (=off). See figure 8-2

- A) For dividing use dough pieces from 4 to 18 kg.
- B) Make sure that the dividing head/pressure plate is in its lowest position by pressing the lower button (4).
- C) Put the dough/butter piece into the machine.



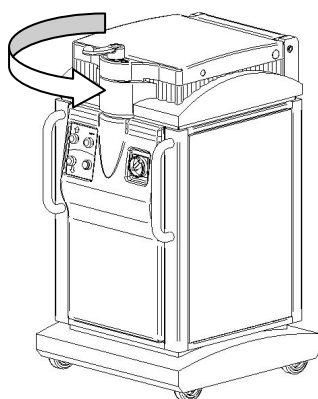
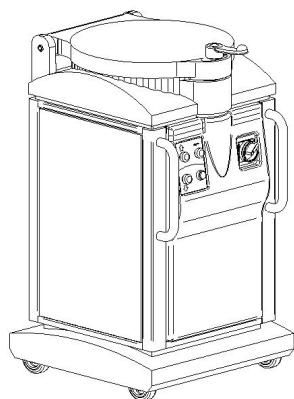
Sprinkle a little flour on the dough piece to minimise sticking.

Daub Bakery Machinery B.V.	Manual Date: 05-06-2012 Version: 6
ROBOCUT <sup>2</sup> Automatic	Page 14 of 18

# WARNING



Make sure that the lid is closed by turning the handle a quarter turn to the right (See figure 8-3).



D) Close the lid and turn the handle a quarter turn to the right so that the machine is properly closed, see figure 8-3.

E) Push the raise button. The dough will be pressed and cut. It will take approximately 5 seconds.

F) Open the lid.

G) Push once more the raise- button. The dividing head will rise automatically until the head is as high as the frame of the machine. Now the dough can be removed.

H) Repeat the cycle as from B.

I) Using the cycle stop button (4) will end the cycle during pressing. Once activated, continue as before from point F.

Daub Bakery Machinery B.V.	Manual Date: 05-06-2012 Version: 6
ROBOCUT <sup>2</sup> Automatic	Page 15 of 18

## 9 JUDGING THE RESULTS

The following information will help you to obtain the best possible result:

- A) The dough pieces do not have the same weight.  
The dough is not fully pressed.  
If the dough is too tough, let it rise for approximately 15 minutes.  
The pressure of the system should be increased.
- B) The dough has not been cut.  
The knife does not rise to meet the lid (see section fault finding).
- C) The dough sticks to the lid or the dividing head.  
Sprinkle the dividing head and the dough piece with some flour.



For the best results please observe the weight range of the machine. Eventually check also the machine plate. The table on page 4 shows the weight ranges for the different models of machines



The weight range is dependent on dough consistency.

Daub Bakery Machinery B.V.	Manual Date: 05-06-2012 Version: 6
ROBOCUT <sup>2</sup> Automatic	Page 16 of 18

## 10 MAINTENANCE

### 10.1 Cleaning

The numbers in the text refer to figure 3-3 and 8-1



Always turn the main switch to “0” (off) before starting any kind of maintenance especially when the side covers are open.



Never clean the machine with water. The use of water will cause oxidation and electrical problems.



Only qualified employees may clean the machine. Other persons should keep their distance.

#### Weekly:



When cleaning the machine do not use sharp products especially on the dividing disc.

- Clean weekly the working area of the dividing head, the cover and the inside of the machine.
- Clean the knife crown.
- Cleaning button:  
By pushing the cleaning button the knife crown will raise automatically, this is button number 2; see section 8.2, figure 8.1



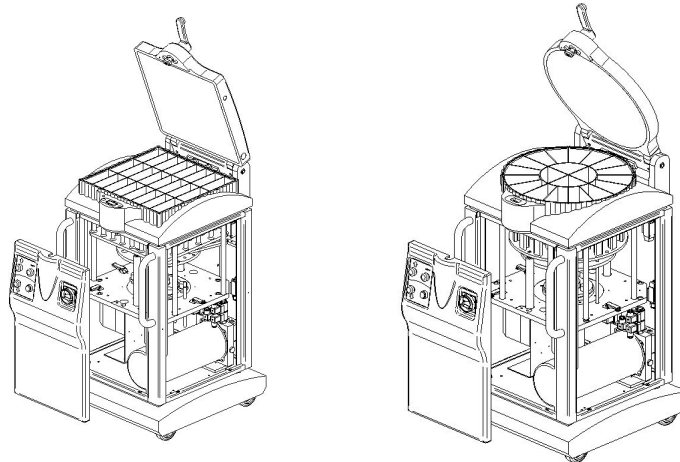
During the automatic movement of the knife crown do not close the lid.

- After cleaning, lubricate the dividing head and knife crown with **non resin**, edible oil.
- Retract the knives by pushing the “lower button”; see section 8.2, figure 8.1



Daub Bakery Machinery B.V.	Manual Date: 05-06-2012 Version: 6
ROBOCUT <sup>2</sup> Automatic	Page 17 of 18

#### Monthly:



- Clean the inside of the head.
- Put the knife crown in its upper position (see description weekly). Open the door at the rear of the machine (using the tool provided) and remove all side covers.
- Clean the inside of the head with the supplied brush and / or external compressed air.
- Clean the piston bar of the telescopic cylinder.
- Check the oil level on the gauge on the unit

#### 10.2 Hydraulic pressure

The figures in the text refer to the figures in the separate Technical Manual



Only qualified maintenance staff may adjust the machines hydraulic pressure.  
Other people should keep their distance from the machine.

The hydraulic unit is set to 45 bars. An external manometer can read the pressure; (this can be ordered by your supplier). The manometer must be connected correctly. The pressure can be adjusted, please contact your supplier.



Do not forget to lock any adjustments made by using the locking nuts.

We advise that you use hydraulic oil according to DIN-51525, with a viscosity according to ISO VG 32.

Daub Bakery Machinery B.V.	Manual Date: 05-06-2012 Version: 6
ROBOCUT <sup>2</sup> Automatic	Page 18 of 18

## 11 FAULT FINDING

If required please contact your supplier and/or the technical manual

If the divider refuses to start, check the following:

- The main switch must be turned to position “1” (on)
- The motors thermal relay is activated. Reset it by pushing the blue button of the concerned relay in the control box; contact your supplier for advice on this.
- The fuses on the PCB in the switch box have blown.
- The direction of rotation of the motor is wrong.
- Check the pressure.

The machine does not divide:

- Check if the knife crown has become dirty, bent or otherwise damaged.
- Check if the height adjustment of the knife crown with the knife bolts. The knife crown must just touch the lid in its most upward position.

The dough has not been pressed out enough:

- The pressure of the unit is too low. See chapter 10.2.

The dividing head does not rise:

- Check the pressure clock and solenoid on the hydraulic unit.
- Check the switch and all connections.

The dividing head does not return back:

- Check the return valve and solenoid on the hydraulic unit.
- Check the switch and all connections.

The lid will not stay open:

- Check if the spring is broken. If the spring is not broken, tension the spring by turning the adjusting ring (see technical manual).

The dividing disc gradually lowers over time

- This is normal, the machine, when not in use, should be kept with its dividing disc in the lowest position. Should the dividing disc gradually lower whilst the disc is in its uppermost position and the machine is not being used just push the raise button (number 1 in figure 8-1) and it will return to its uppermost position.