

Operating manual

Econom

STM513

STM514

SSO514

Edition BD519402

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Technical specification subject to change without notice

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EC Declaration of conformity for machinery

(Machinery Directive 2006/42/EC, Annex II., sub. A)

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Name and address of the person authorised to compile the technical file:
RONDO Burgdorf AG, Heimiswilstrasse 42, 3400 Burgdorf, Switzerland

Herewith we declare that the dough processing machine:

Dough sheeter	Econom
Table model	STE51
Table model	STM51
„A“ framed base model	SSO51

- is in conformity with the relevant provisions of the Machinery Directive (2006/42/EC)
- is in conformity with the provisions of the following other EC-Directives:
 - Directive EMC 2004/108/EC.

And furthermore, we declare that

- the following (parts/clauses of) European harmonised standards have been used:
 - EN 1674: Food processing machines – Safety and Hygiene requirements
 - 1935/2004: Materials, intended to come into contact with food
 - EU 10/2011: Plastic materials and articles intended to come into contact with food
 - EN 60204-1: Safety of machinery – Electrical equipment – Part 1
 - EN 12100-1: Safety of machinery – General principles – Part 1

Burgdorf, 29.01.2016

Werner Mathis
Manager R&D

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Hint for operating manual: The numbers of the illustrations (Ex. — 1) are numbered chapterwise.

1 Safety information

1.1 Explanation of symbols



All the sections in this operating manual containing safety instructions which absolutely must be observed are marked with this symbol and with a number.



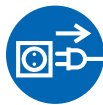
All the sections in this operating manual containing information which absolutely must be observed are marked with this symbol.

1.2 Explanation of warning signs



Sign indicating prohibited activity

Reaching under the closed safety guard is prohibited!



Instruction and information signs

Make sure to disconnect the mains plug before opening!



Danger warning sign

Danger warning.



High-Voltage warning sign

Warning against electrical shock.
Disconnect mains plug before opening.

1.3 Safety elements

1.3.1 Safety guards



Operation

The safety guards fulfill a dual purpose:

1. The safety guards protect the operator against inadvertent contact with the rollers.
2. The machine is stopped by lifting up the safety guard. Raising the safety guard even just slightly will cause the machine to discontinue operation.

1.4 Safety instructions and information which must be followed

Before putting the machine into operation the operating manual must be read!



The machine of RONDO is exclusively built for sheeting, booking and final sheeting of dough or marzipan sheets for the food industry.

However, the machine is not suitable for the processing of other products (e.g. modelling clay or other types of mouldable masses which are not dough products).

Any other use of these units is not in accordance with the purpose for which they are built. Therefore, the manufacturer will not be liable for any accidents or damage arising as a result of unauthorized use; the risk in any such instance will be borne solely by the user.



Authorized use also means that the user must follow all instructions prescribed by the manufacturer in respect of operation, maintenance and service.



Any work on the electrical components of the machine, in particular the correct professional electrical connection, may only be carried out by qualified personnel who are familiar with the prescribed safety instructions.

The maximum permitted fuse of the mains is specified in the enclosed electro circuit diagram or on the sign "Electrical connected loads".

The machine may only be connected to the mains using the mains plug! No permanent electrical installation may be made using, for example, terminal screws. The mains plug is used as a disconnecting device, and must always be clearly visible and easily accessible.



Protective covers over the electrical controls and the mechanical moving parts may only be removed by professionally qualified personnel and must be remounted before the machine is put back into operation.



Any unauthorized changes made to the machine, and in particular, to the safety devices on the machine will automatically exclude any liability on the part of the manufacturer for accidents or damage sustained as a result of such changes.



Defective cables and mains plugs must be immediately replaced by qualified personnel.



The machine may only be connected to the mains using the mains plug and be operated once it has been fully assembled.



Before beginning any repairs, service or cleaning work on the machine, the electricity supply to the machine must be interrupted (pull out mains plug).



Safety devices on the machine may not be adjusted, shorted-out or expanded.



Operation of the machine when any of the safety devices is out of order is prohibited.



Defective safety devices must be replaced immediately with new original parts from RONDO.



Machine parts located in the area in which the dough is being processed, and whose surface coating becomes worn (e.g. chrome plate worn off) must be replaced.



The machine may not be lifted on the machine base (SSO) when being moved. The machine should be fastened and transported on a pallet. The safety guard should be fastened in the upper position.



Reaching under the closed safety guard is prohibited!



The machine may only be operated with the machine tables mounted!



Ensure that conveyor belt tension is correctly adjusted!



Do not deposit any loose objects such as knives, tools, articles of clothing, etc. in the area where the dough is located.



Table models (STM) must be placed so as to rest properly over the whole work table!



Check to ensure that there are no loose screws in the area where the dough is located.



The machine may not be operated without the use of a scraper.



Flour dust can cause respiratory tract difficulties and allergies. Limit the use of flour to a minimum.

The use of compressed air for cleaning the machine is not permissible.

The use of a dust extraction system in the bakehouse is recommended.



Any disposal of the machine must be carried out in accordance with environmentally-accepted practices. The operators are fully responsible for ensuring that such practices are followed.



This machine is not designed to be used in explosive ambient.



Defective parts must be replaced with new original parts by RONDO.



After every use, the machine has to be cleaned thoroughly. Not thoroughly cleaned machines can be a health-hazard for the consumer.



The machine must never be cleaned using spray water, high-pressure cleaners or a steam-cleaning machine.



All still existing protective foils on the machine must be removed.



Prior to the first starting-up, the complete machine must be thoroughly cleaned.



Non-ionising radiation is not intentionally produced but only given off for technical reasons by electric equipment (e.g by electric motors). In addition the machine has no strong permanent magnets. By keeping a safe distance (the distance from the source field to the implant) of 30 cm, interference with active implants (e.g. pacemakers, defibrillators) can be excluded with a high degree of probability.

RONDO will not accept liability when any of the above safety instructions / notes have not been complied with!

2 Transporting, setting up, connecting, dismantling, storing

2.1 Machine delivery



The machine is delivered in its original packaging.

- Report any claims for damage caused as a result of transportation directly to the freight handlers (see the packaging: The delivery documentation is found on the outside of the packaging)

2.2 Transportation

When transporting the machine must be packed in the original packaging or in accordance with the instructions of the manufacturer to guarantee stability.

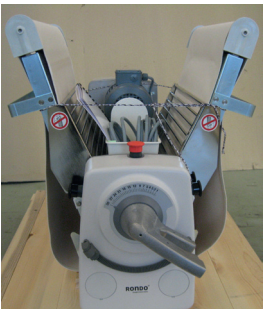


When being transported, the machine must be fastened onto a pallet.

The machine tables must be dismantled and the safety guards fastened in the upper position.

STM

SSO



The machine must not be tipped over.
(For machine weight, see 9.1 Technical data Econom)

2.3 Unpacking the machine

The machine must be set up on a level, even floor surface (SSO).

For further information regarding the ambient conditions required for the machine, see 3.1 General information

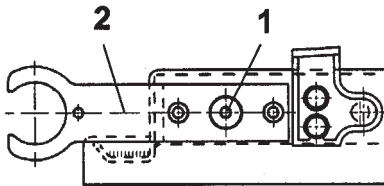
- Unpack tables and attachments
- Check all items received against the delivery slip to ensure completeness

2.4 Setting up the machine

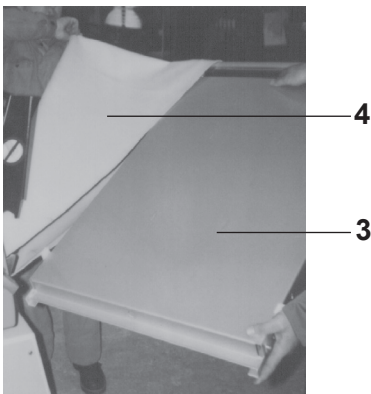


Two people are required to set up the machine.

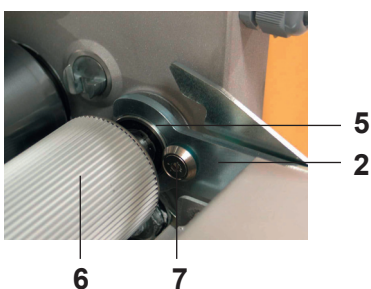
2.4.1 Installing the machine tables (SSO514 / STM514)



- Unscrew the screws (1) using a hexagon socket screw key
- Dismount the front and rear lateral bracket (2) on the machine table



- Lift the machine table (3) with the aid of a second person
- Put the machine table (3) between the conveyor belt (4)



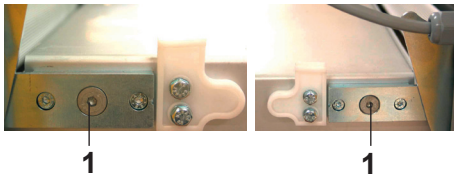
- Place the lateral brackets (2) on the supports (5) of the roller drive (6)



Lateral bracket with lock nut (7) must absolutely be at the rear!

front side

rear side



- Mount the lateral brackets (2), tighten the screws (1) using a hexagon socket screw key



Lifting the machine tables

1. Bring the safety guard in the lower position.
2. Lift the machine table until the plastic material supports (22) (front and rear) lock on the safety guard.

Notice!

The plastic material supports must not be damaged!



Unhinging the machine tables

1. Push the machine table up, until the safety guard is locked.
2. Lower the machine table carefully.
3. Lower the safety guard by pushing the safety guard backwards.

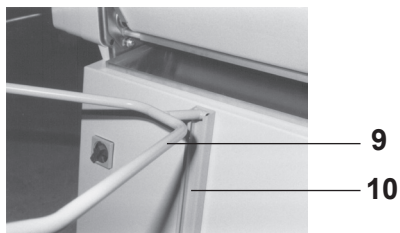
Caution!

Against accidental unhinging of the machine tables!

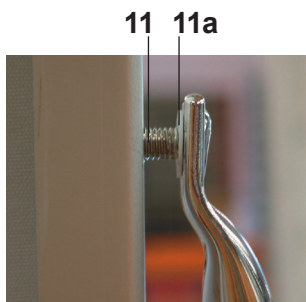
2.4.2 Mounting the forked supports (SSO)



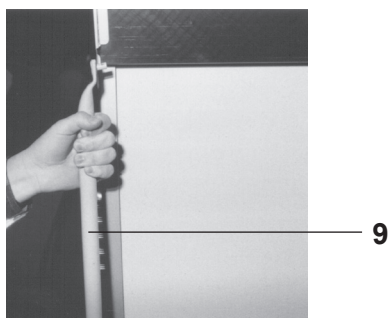
- Lift table (3) up until it is inserted into the safety guard (8)
The machine table is now secured



- Push forked support (9) into the support guide (10)



- Insert catch plug (11) of the forked support, with fitted washer (11a), into one side of the table



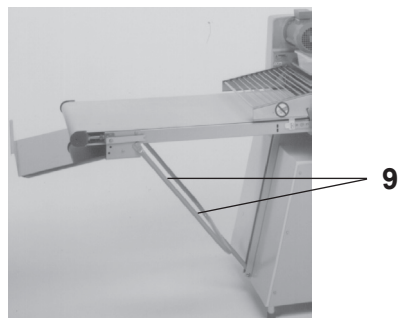
- Bend up the forked support (9) and secure it to the opposite side of the table (washer fitted on the catch plug)



- Fit the second washer on both sides on the inside, afterwards screw down the cap nut (11b)

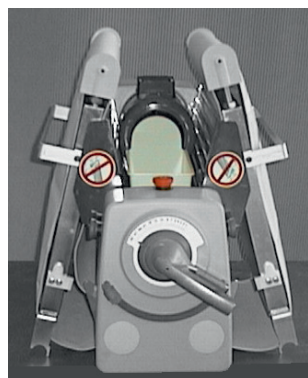


Attention: The conveyor belt has to be placed below the cap nut.

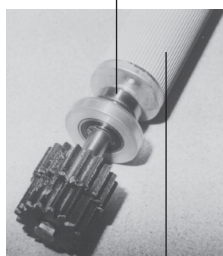
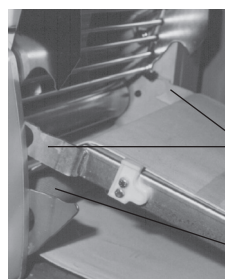


Position of the forked support (9) when the machine table is hinged down.

2.4.3 Installing the machine tables (STM513)



- Set the machine on a level work table
(Make sure that the working height for the operator is correctly set)

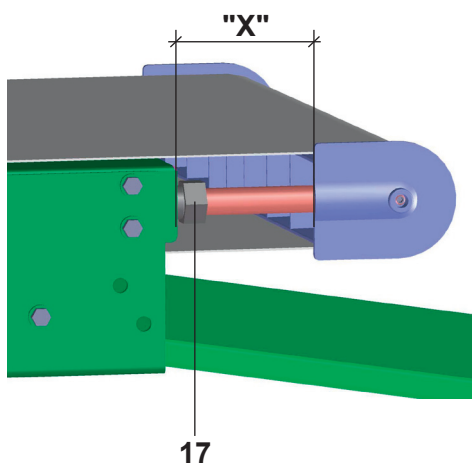


- Place the forked supports (12) in the drive roller (14) mounting (13)
(Do not dismount drive rollers)
- Tension the conveyor belts slightly in order to secure the table
(see 2.4.4 Tensioning the conveyor belts)



- Place machine tables (15) in upright position
- Secure machine tables (15) to the safety guards (16)

2.4.4 Tensioning the conveyor belts



Tense the conveyor belts only enough so that the heaviest pieces of dough (max. 4 kg) can still be moved along the belt without the conveyor belt dragging.

Proceed as follows:

- Retighten the left and right tension nuts (17) so that they are even and parallel
- Remeasure distance „X“ on both sides using a millimeter measuring instrument
Distance „X“ must be identical on both sides
- Switch on the machine (see 4 Putting the machine into operation / 3.5.4 Start push-button)
- Observe both the left and right running movement of the conveyor belt

If the belt runs off toward one side, proceed as follows:

- Retighten the side where it runs off using a tension nut
- or
- Loosen on the opposite side using a tension nut
 - Monitor the belt, and if necessary, correct it until it runs exactly in the middle of the table

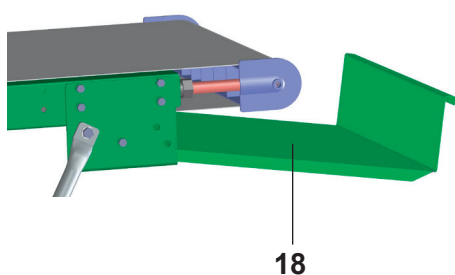
Repeat this procedure several times, if necessary. Routinely monitor the belt during the initial hours that the machine is operational, and if necessary, correct again.

Tensioning and adjusting the conveyor belts demands patience!

Prior to carrying out each further correction, allow the machine to run for at least 30 seconds.

Before putting the machine into operation, the conveyor belts must be rubbed lightly with flour in order to prevent the dough from sticking to the belt.

2.4.5 Mounting the dough catch pans (SSO)



- Remove the protective foil on the dough catch pan (18)
- Push in the dough catch pan on both sides

Option:

- Attach the flour catch pan (19) to the holder (20)

2.5 Requirements for putting the machine into operation



Power supply and frequency at the mains circuit to which the machine is connected must be in accordance with specifications contained on the sign “Electrical connected loads” (This sign is found on the cable lead-through on the machine base).



Direct connection without a plug is prohibited! Ensure that the connection is made by professionally qualified personnel and that it is carried out in accordance with local regulations (An electrical schematic is delivered with every machine and it is to be found next to the electrical control in the rear of the machine housing).



Connect the machine plug to the power supply.



The machine may only be operated with tables mounted.



All still existing protective foils on the machine must be removed.

2.6 Moving direction test



Monitor to ensure that the belts are properly tensioned.



19

- Press the start (19) (only impulse)
The conveyor belts must move from left to right.



If the belts are moving in the wrong direction:

- Exchange two phases in the plug

2.7 Moving the machine (SSO)



20

- Lift the machine on the roller gap adjusting mechanism (20)

The front conveyor (21) will snap down.



21

Once the machine's permanent location is selected:

- Using both hands, tightly grip the roller gap adjusting mechanism (20)
- Gently lift up the machine
- Using one foot, push the pedal for the front conveyor belt (21)
- Gently lower the machine to the floor surface, do not let it "drop"

3 General data about the machine

3.1 General information

3.1.1 Authorized use of the machine



The machine of RONDO is exclusively built for sheeting, booking and final sheeting of dough or marzipan sheets for the food industry.

However, the machine is not suitable for the processing of other products (e.g. modelling clay or other types of mouldable masses which are not dough products).

This product is a technical working tool which is designated to be used exclusively for work.

Persons handling the product must be instructed accordingly and at least 16 years of age.

Booking

Booking in fat. Through sheeting to a thickness of approx. 6 - 11 mm and a subsequent folding of the dough there is a resulting formation of layers of fat and dough. A repetition of this process yields many thin layers.

Final sheeting

Includes sheeting the piece of dough to the necessary final thickness required for further processing.

3.1.2 Noise values

The emission value at place of operation is less than "70 dB(A)".

The accuracy class of the acoustic emission measurement corresponds to class 2 (± 2.5 dB) according to:
DIN EN ISO 11201 / DIN EN ISO 11202 /
DIN EN ISO 11203 / DIN EN ISO 11204

3.1.3 Temperatures

The ambient temperatures permissible for the machine:
+5 °C to +40 °C

Permissible temperatures for storage of the machine:
-25 °C to +55 °C, for brief periods of time up to +70 °C

3.1.4 Ambient humidity

The ambient humidity permissible for the machine lies in the area of 30 % - 95 %, relative humidity, uncondensed (for the dusting flour in the flour container, the relative humidity should not exceed 60 %).

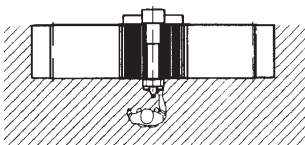
3.1.5 Machine weight

Total weight of STM513: approx. 80 kg,
 STM514: approx. 85 kg,
 SSO514: approx. 140 kg

(compare 9.1 Technical data Econom)

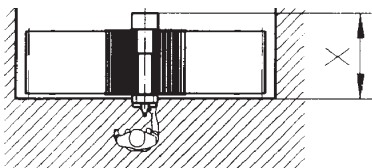
3.1.6 Working area for the operating personnel

SSO



The hatched area shows the work area designated for the operating personnel.

STM



On the STM model, the machine must cover the whole width of "X" on the work table!

3.2 Maschine models

3.2.1 STM513 / STM514



Table models
(see 9.1 Technical data Econom)

3.2.2 SSO514



Socle model
(see 9.1 Technical data Econom)

3.3 Prerequisites

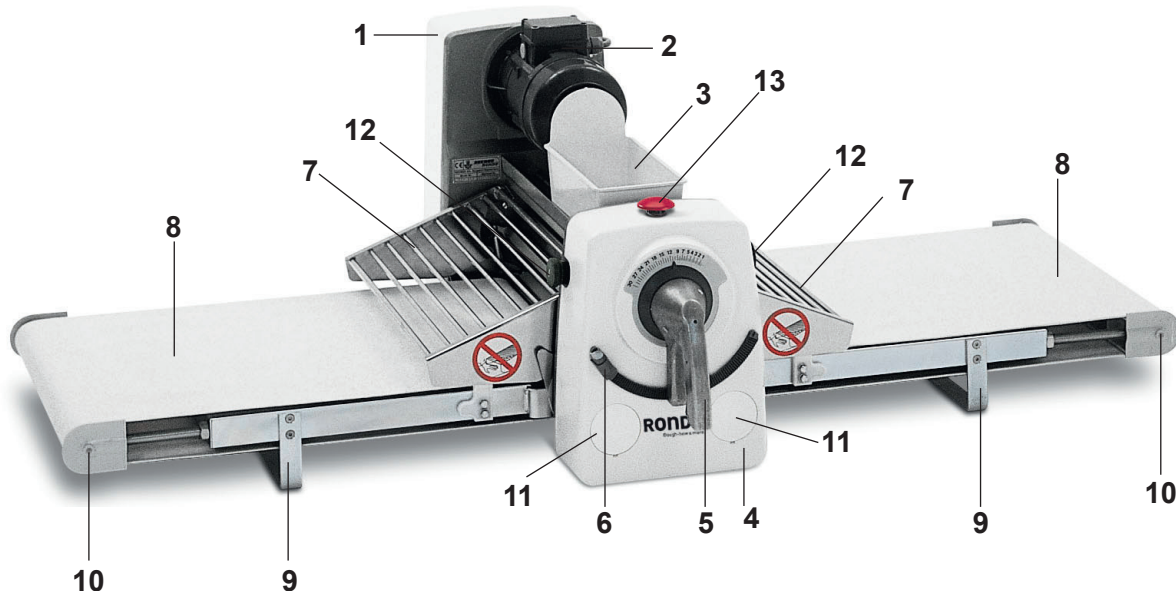
In order for the dough to be sheeted by the machine, the following prerequisites must be fulfilled:



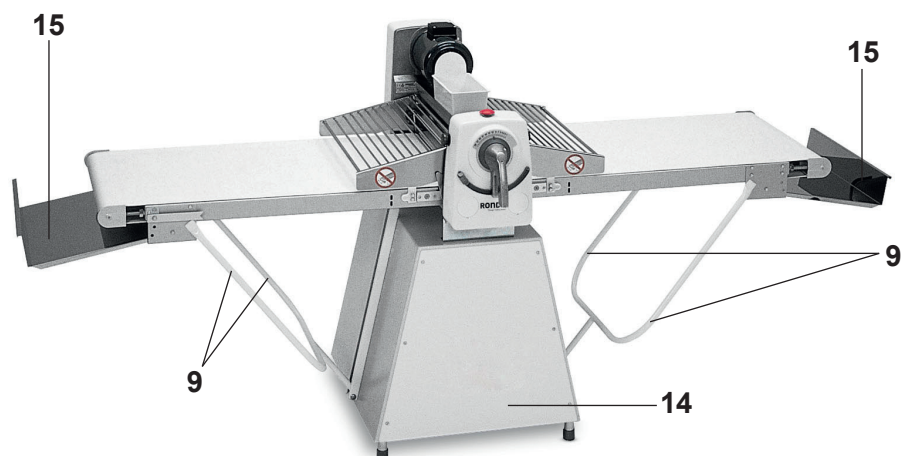
- Max. dough piece weight 4 kg
- Flour the dough pieces

This will serve to prevent the dough from sticking to the rollers and scrapers.

3.4 Complete view of the machine

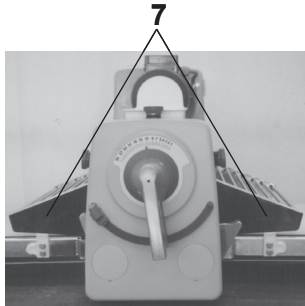


- 1 Rear housing
- 2 Motor
- 3 Flour container
- 4 Front housing
- 5 Roller gap adjusting mechanism
- 6 Roller gap limit stop
- 7 Safety guard
- 8 Conveyor belt
- 9 Forked support
- 10 Idle roller
- 11 Cover
- 12 Start push-button
- 13 Stop push-button
- 14 Machine base
- 15 Dough catch pan



3.5 Operating elements

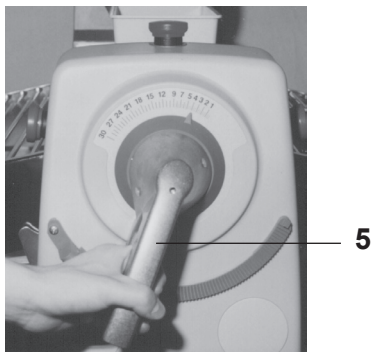
3.5.1 Safety guards



The safety guards (7) protect the operator against inadvertent contact with the rollers.

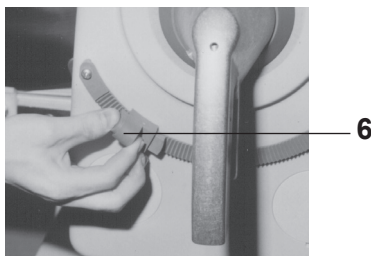
By raising the safety guards (7) the machine can also be stopped.

3.5.2 Roller gap adjusting mechanism



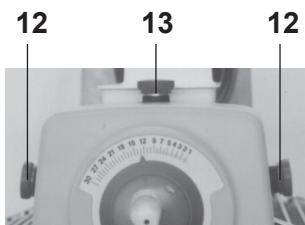
The desired roller gap is set using the roller gap adjusting mechanism (5) (see also 5.1.1 Sheeting).

3.5.3 Roller gap limit stop



The roller gap limit stop (6) serves for mechanical Adjusting of the roller gap (repeatedly sheeting) (see also 5.1.1 Sheeting).

3.5.4 Start push-button



Both start push-buttons (12) (two push-buttons on the side of front housing) serve to start the machine (see also 4.2 Starting/stopping the machine).

3.5.5 Stop push-button

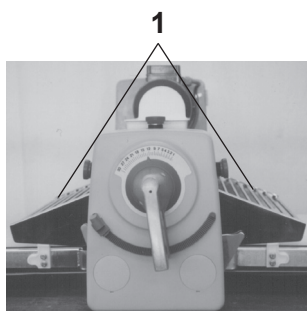
The stop push-button (13) (push-button at the top of front housing) serve to stop the machine (see also 4.2 Starting/stopping the machine).

4 Putting the machine into operation

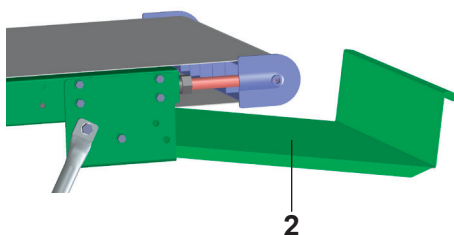


Prior to the first starting-up, the complete machine must be thoroughly cleaned.

4.1 Preparing for operational readiness



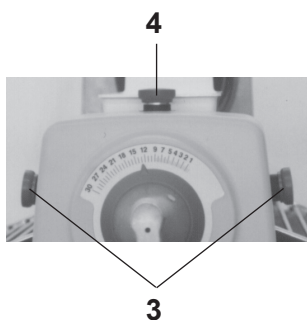
- Close both safety guards (1) (see 3.5.1 Safety guards)



On the SSO model.

- Pull out the dough catch pan (2) on both sides

4.2 Starting/stopping the machine



In order to start up the machine:

- Briefly press the left start push-button (3)
The conveyor belts begins to move from the left to the right

or

- Briefly press the right start push-button (3)
The conveyor belts begins to move from the right to the left

In order to stop the machine:

- Briefly press the stop push-button (4)

5 Operation

5.1 Operating instructions



Reaching under the closed safety guard is prohibited!

5.1.1 Sheeting

The machine is designed to accommodate dough pieces with a maximum weight of 4 kg!



Never leave loose objects such as knives, tools, articles of clothing, etc. lying in the area where the dough is located.

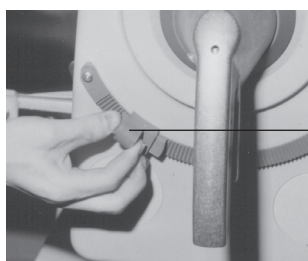


2

1

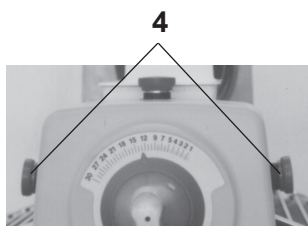
Set desired roller gap (maximum 30 mm/ minimum 0.5 mm) as follows:

- Push lever (1) towards the roller gap adjusting mechanism (2), do not release
- By way of the roller gap adjusting mechanism (2), set the roller gap desired (scale)
- Release lever (1)
Lever (1) must lock into place



3

- Compress Roller gap limit stop (3) and push it against the lever (1) and release it
- Place the dough piece (max. 4 kg) on the machine table (do not „throw“ it on the table!)



4

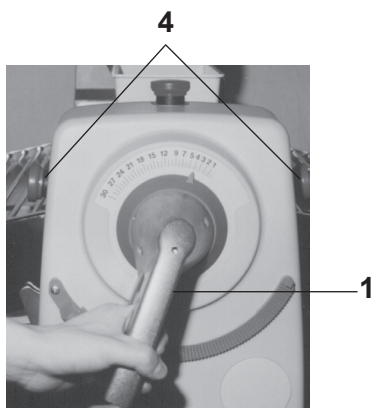
Start up the machine as follows:

- On the dough's infeed side, briefly press the start push-button (4) (see 4.2 Starting/stopping the machine)



Once the dough piece has fully cleared the rollers:

- Press the stop push-button (5)
The machine will stop
- Manually set the next roller gap (depending on type of dough being processed) (see 5.1.1 Sheeting)



- Release lever (1)
Lever (1) must lock into place
- On the dough's infeed side, briefly push the start push-button (4) (see 4.2 Starting/stopping the machine)

Once the dough piece has fully cleared the rollers:

- Press the stop push-button (5)
The machine will stop
- Repeat this procedure until the desired final thickness of the dough has been obtained

5.2 Sources of errors in the sheeting process

Fault finding	Cause / defect	Remedy / to remove
1. Dough piece sticks, tears underneath.	Dough too moist. Dough piece rubs against scraper bar.	Flour dough piece more. Mount scraper properly (see 6.1.1 General information).
2. Dough piece piles up (ripples).	Reduction steps too big.	Select smaller reduction steps: Let down the roller in smaller steps (see 5.1.1 Sheeting).
3. Dough sheet tapers.	Reduction steps too small.	Select bigger reduction steps: Let down the roller in bigger steps (see 5.1.1 Sheeting).

6 Cleaning

6.1 Cleaning



Before cleaning the machine, pull out the mains plug.



The machine must never be cleaned using spray water, high-pressure cleaners or a steam-cleaning machine.

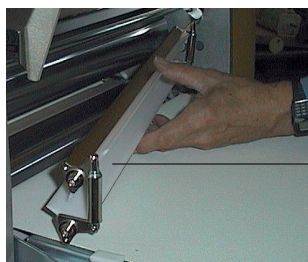
6.1.1 General information



Dismounting the scraper



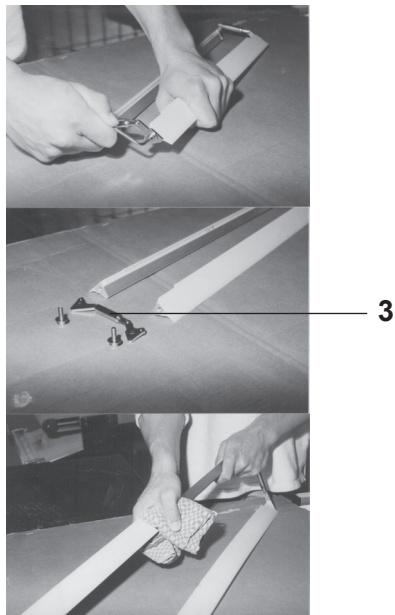
- Open rollers fully
- Lock the safety guard into the upper position
- Using the thumb, push the front and rear scraper blade (1) downwards



- Lift the scraper (2) out of the scraper mounting
- Pull out the scraper (2)
- Clean the scraper (see 6.1.2 Care)

Exchange of scraper blades

Required tool: Allen key No. 4



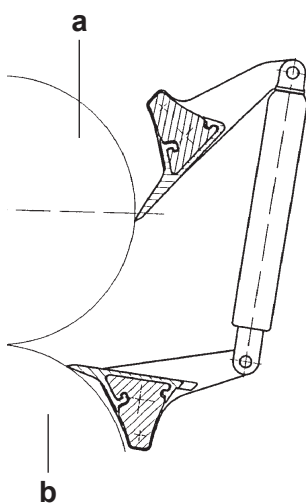
Exchange of scraper blades:

- disassemble the spring clamp (3) on the left or right hand side
- slide the scraper blade off

Attention

For protection of the fingers, please use a cloth. The edges of the blades are sharp and there is danger of cutting oneself.

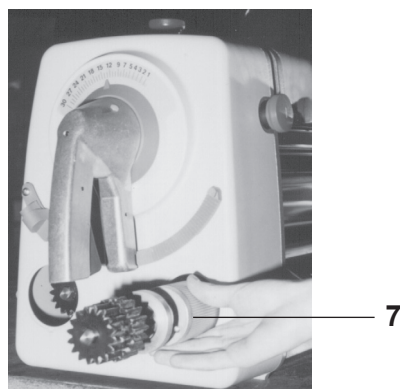
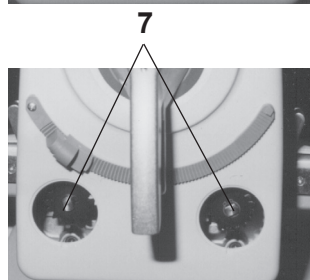
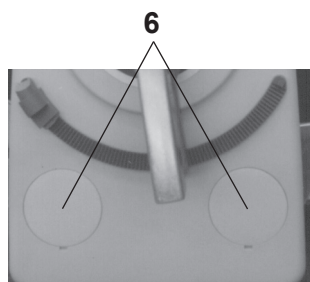
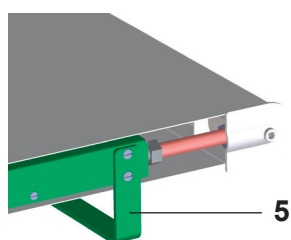
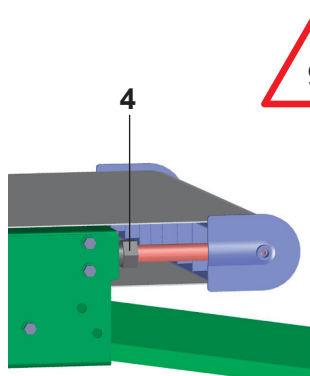
- Assemble the new scraper blades in reverse order
- Assemble the spring clamp in reverse order



Mounting the scraper

- To remount the scraper, carry out the dismounting instructions in reverse order

- a** upper roller
- b** lower roller



Dismounting machine tables/conveyor belts

In order to dismount the machine tables and conveyor belts, proceed as follows:

- Pull out the mains plug
- Lift up the safety guards
- Loosen the tension nuts (4) parallel, in order to retighten the conveyor belt
- Dismount the forked supports (only on SSO) (To remount forked supports, proceed in reverse order, see 2.4.2 Mounting the forked supports (SSO))
- Dismount the forked supports (5) (STM)
- Dismount tables (To dismount, follow machine table mounting instructions in reverse order, see 2.4.1 Installing the machine tables (SSO514 / STM514))

In order to dismount the conveyor belts, proceed as follows:

- Remove covers (6) with aid of a screw driver
- Remove the drive rollers (7) towards the front out of the roller head
- Remove the conveyor belt
- The conveyor belt can now be cleaned or replaced (see 6.1.2 Care / 7.3 Replacement parts list)



Mounting the machine tables and conveyor belts



Make absolutely sure that you do not confuse the left and right driving rollers or the left and right machine tables!

- Remount machine table and conveyor belts by proceeding in reverse order of the instructions for dismantling them

6.1.2 Care

Part	see	daily see legend	weekly see legend
Roller head and machine base	3.4 Complete view of the machine		A
Scraper	6.1.1 General information	A	
Cotton conveyor belt	6.1.1 General information	B	(E)
Synthetic conveyor belt	6.1.1 General information	B	C
Dough catch pan	2.4.5 Mounting the dough catch pans (SSO)	B	
Driving roller	2.4.1 Installing the machine tables (SSO514 / STM514) 6.1.1 General information		D
Idle roller	2.4.4 Tensioning the conveyor belts		D
Flour container	3.4 Complete view of the machine	B	



Only use cleaning agents with a ph-value of 6 to 8! Only cleaning materials approved for use in the food industry may be used.

Legend

- A Damp clean using cloth and soapy water
- B Dry clean using a brush
- C Wet clean using a brush
- D Remove excess dough using a brush and plastic scraper
- E Wash the cotton conveyor belt monthly as follows:
 - Maximum washing temperature 40° C
 - Hang the washed belt over a rod and weight it at the bottom with approx. 10 kg

7 Maintenance

7.1 General information on maintenance of the machine



Any defects on the machine must be repaired by an authorized customer service representative!

7.2 Maintenance list

What / part	Activity	daily working time less than 4 h	daily working time 4 - 8 h	daily working time more than 8 h
Conveyor belts	check, replace if necessary	M	W	W
Scraper blade (Dough sheeter)	check, replace if necessary	M	W	W
Table drive and roller adjustment mechanism in the front housing	grease according to the service manual	3 Y	2 Y	Y
Roller drive and adjustment in the rear housing	grease according to the service manual	3 Y	2 Y	Y

Legend

W weekly

M monthly

Y annually

2Y every 2 years

3Y every 3 years

7.3 Replacement parts list



The use of conveyor belts not supplied by RONDO can lead to premature wear or destruction on machine parts (coupling, drive rollers).

Item-no.	Description	Dimensions	Application
122773T02	Scraper complete	-	STM513, STM514, SSO514
122775T02	Scraper blade	-	STM513, STM514, SSO514
79302	Cotton conveyor belt	1490 x 475 mm	STM513
120750T04	Cotton conveyor belt	1940 x 475 mm	SSO514, STM514
121344T30	Synthetic conveyor belt	1470 x 475 mm	STM513
121344T31	Synthetic conveyor belt	2020 x 475 mm	SSO514, STM514
8934	Fuse 1,0 AT	1,0 AT slow Ø 5 x 20 mm	all types

8 Trouble shooting

Fault finding	Cause / defect	Remedy / to remove
1. Machine stands still after assembly.	Main switch not/not correctly plugged in.	Plug in the main switch.
	Safety guard not closed.	Close safety guard.
	Right or left start push-button not pressed.	Press the desired start push-button.
	Machine tables not level.	Put the machine tables in a even level position.
2. When pressing the right start push-button the conveyor belts move to the right.	Sense of rotation reverse (mains).	Moving direction test (see 2.6 Moving direction test).
3. Machine runs intermittently, stops, rattles.	Safety guard limit switch incorrect.	Readjusting by an expert.
	Support for safety guard incorrect.	Adjust supporting eccentric.
	Loose cables, wires.	Adjust loose wires, cables.
4. Main drive motor runs, rollers and conveyor belts stand still.	Belt drive defective.	Call after-sales service! Remove rear cover of machine base and roller head, replace belts or toothed belts if necessary.
5. Conveyor belts loops up, motor and rollers run.	Belt tension too weak.	Tension conveyor belt equally (see 2.4.4 Tensioning the conveyor belts),
	Driving roller dirty.	clean driving roller (see 6.1.2 Care).
6. Machine only runs to one side.	Defective motor contactor.	Call specialist (electrician).
	Safety guard limit switch defective.	Replace motor contactor/limit switch.
7. Discharge conveyor belt stands still or jerks.	Table drive defective.	Call after-sales service.
	Belt tension too weak.	Tension the belt equally (see 2.4.4 Tensioning the conveyor belts).

Fault finding	Cause / defect	Remedy / to remove
8. Dough piles up before the roller of passes under the roller between scraper and infeed conveyor belt.	Scrapers inserted incorrectly.	Close the scraper levers properly (see 6.1.1 General information). Check and if necessary adjust scraper levers by means of eccentric (center of motion).
	Scraper blades worn out.	If necessary replace scraper blades or the complete scraper.
9. Conveyor belts run to one side, tear at the edges.	Incorrect belt tension.	Tension conveyor belt (see 2.4.4 Tensioning the conveyor belts).
	Drive roller dirty.	Clean drive roller (see 6.1.2 Care).
10. Cotton conveyor belts too short after washing.	Washing temperature too high.	Washing temperature max. 40 °C. Hang washed conveyor belt over a rod and weigh it down below with approx. 10 kg.
11. All other faults/falling outs.		Inform nearest «RONDO» after-sales service giving as much information as possible.

9 Technical data

9.1 Technical data Econom

Technical data	STM 513 Econom	STM514 Econom	SSO 514 Econom
Machine base	No (table model)	No (table model)	Socle
Belt width	475 mm	475 mm	475 mm
Table width	487 mm	487 mm	487 mm
Total table length	1590 mm	2055 mm	2055 mm
Req floor-space: in working position	940 x 1590 mm	940 x 2055 mm	940 x 2500 mm (dough catch pans extended)
in resting position	940 x 700 mm	940 x 850 mm	940 x 850 mm
Roller length	500 mm	500 mm	500 mm
Roller gap	0,5 - 30 mm	0,5 - 30 mm	0,5 - 30 mm
Sheeting speed of discharge conveyor	55 cm/sec	55 cm/sec	55 cm/sec
Rated power	0,75 kVA / 0,5 kW	0,75 kVA / 0,5 kW	0,75 kVA / 0,5 kW
Supply voltage	3 x 200 - 420 V, 50 / 60 Hz 1 x 200 - 230 V, 50 Hz 1 x 200 - 230 V, 60 Hz 1 x 110 V, 60 Hz	3 x 200 - 420 V, 50 / 60 Hz 1 x 200 - 230 V, 50 Hz 1 x 200 - 230 V, 60 Hz 1 x 110 V, 60 Hz	3 x 200 - 420 V, 50 /60 Hz
Machine weight:	approx. 80 kg	approx. 85 kg	approx. 140 kg

Subject to technical changes without notice.

9.2 Additional information

All sheeters from RONDO have the following quality features:

- The conveyor belts made of plastic material:
All plastic coated conveyor belts used on our machines are approved for coming into contact with food stuff and correspond with the requirements of the directives EU 10/2011 as well as the FDA (Food and Drug Administration, USA).
- The conveyor belts made of cotton:
The fabric consists of 100 % cotton and has a non-toxic finish.
- The rollers are hard-chrome plated. This coating is approved for coming into contact with food stuff.
- The scraper blades are made of POM-C plastic material. This material is approved for coming into contact with food stuff and corresponds with the requirements of the directives EU 10/2011 as well as the FDA (Food and Drug Administration, USA).
- The dough catch pans are made of stainless steel (chromium nickel steel, DIN Mat. no. 1.4301, 1.4016). This material is approved for coming into contact with food stuff.
- The rollers of the manual and the automatic dough reeler that are touching the dough are made of aluminium, anodised colourless and are approved for coming into contact with food stuff.
- Flour container:
The flour container is made of plastic material (ABS). This material is approved for coming into contact with food stuff.

