



Operating manual

## Rondostar 5000

### Expert

SSH673\*.A

SSH673\*.C

SSH673\*.H.A

SSH673\*.H.A

### Cutomat

SSH672\*.C.A

SSH672\*.C.C

SSH672\*.HC.A

SSH672\*.HC.C

SSH673\*.C.A

SSH673\*.C.C

SSH673\*.HC.A

SSH673\*.HC.C

### Pro

SSH672\*.A

SSH672\*.C

SSH672\*.H.A

SSH672\*.H.C

### Basic

SSH670\*.A

SSH670\*.C

SSH670\*.H.A

SSH670\*.H.C

\* = See EC declaration for exact machine type

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**RONDO Burgdorf AG**

Heimiswilstrasse 42  
3400 Burgdorf / Switzerland  
Tel. +41 34 420 81 11  
info@rondo-online.com  
www.rondo-online.com

**RONDO Schio s.r.l.**

Via Lago di Albano, 86  
36015 Schio (VI) / Italy  
Tel. +39 0445 575 429  
info.it@rondo-online.com

**RONDO GmbH & Co. KG**

Hoorwaldstrasse 44  
57299 Burbach / Germany  
Tel. +49 2736 203-0  
info.de@rondo-online.com

**RONDO S.à.r.l.**

PAE „Les Pins “  
67319 Wasselonne Cédex / France  
Tel. +33 3 88 59 11 88  
info.fr@rondo-online.com

**RONDO Ltd.**

Unit 7, Chessington Park  
Lion Park Avenue  
Chessington, Surrey KT9 1ST / UK  
Tel. +44 20 8391 1377  
info.uk@rondo-online.com

**RONDO Inc.**

100 State Street  
Moonachie, N.J. 07074 / USA  
USA  
Tel. +1 201 229 9700  
info.us@rondo-online.com  
Canada  
Tel. +1 416 650 0220  
info.ca@rondo-online.com

**OOO RONDO Rus**

Dmitrovskoye Chaussee, 163A, b. 2  
Office 18.5 / Business Center SK Plaza  
127495 Moscow / Russia  
Tel. +7 (495) 419 51 23  
info.ru@rondo-online.com

**RONDO Asia Sdn. Bhd.**

A-2-21, Jalan Kuchai Maju 2  
Kuchai Entrepreneurs Park  
58200 Kuala Lumpur / Malaysia  
Tel. +60 3 7984 55 20  
Tel. +60 3 7984 55 30  
info.my@rondo-online.com

**RONDO China**

Room 2830, Guangzhou International  
Gang Hang Center  
No. 983 Huangpu Avenue East.  
Huangpu District  
Guangzhou City P.C 510700  
Guangdong Province / China  
Tel. +86 20 8388 2211  
info.cn@rondo-online.com

**RONDO México**

Ote. 180 No. 378  
Col. Moctezuma  
2da sección  
C.P. 15530 México D.F. / Mexico  
Tel. +52 55 2580 7075  
info.mx@rondo-online.com



## EC Declaration of conformity for machinery

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

Manufacturer RONDO Burgdorf AG  
Address Heimiswilstrasse 42, 3400 Burgdorf, Switzerland

Name (see signature) 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	Rondostar 5000 Basic	SSH670*.A / SSH670*.H.A SSH670*.C / SSH670*.H.C
	Rondostar 5000 Pro	SSH672*.A / SSH672*.H.A SSH672*.C / SSH672*.H.C
	Rondostar 5000 Expert	SSH673*.A / SSH673*.H.A SSH673*.C / SSH673*.H.C
	Rondostar-Cutomat 5000	SSH672*.C.A / SSH672*.HC.A / SSH673*.C.A / SSH673*.HC.A SSH672*.C.C / SSH672*.HC.C / SSH673*.C.C / SSH673*.HC.C

- is in conformity with the relevant provisions of the Machinery Directive (2006/42/EC)
- is in conformity with the provisions of the following other European Directive:
  - 2014/30/EU Directive EMC
  - EC 1935/2004 Materials, intended to come into contact with food
  - EC 2023/2006 Good manufacturing practice for materials and articles intended to come into contact with food
  - EU 10/2011 Plastic materials and articles intended to come into contact with food

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
  - EN 60204-1 Safety of machinery – Electrical equipment – Part 1
  - EN ISO 12100 Safety of machinery – General principles

Burgdorf, 11.07.2022



Christoph Albrecht  
Manager Machine Safety

### Rondostar 5000 Basic

SSH6703.A	SSH6703H.A
SSH6704.A	SSH6704H.A
SSH6705.A	SSH6705H.A
SSH6706.A	SSH6706H.A
SSH6707.A	SSH6707H.A
SSH6708.A	SSH6708H.A
SSH6709.A	SSH6709H.A
SSH6703.C	SSH6703H.C
SSH6704.C	SSH6704H.C
SSH6705.C	SSH6705H.C
SSH6706.C	SSH6706H.C
SSH6707.C	SSH6707H.C
SSH6708.C	SSH6708H.C
SSH6709.C	SSH6709H.C

### Rondostar 5000 Pro

SSH6723.A	SSH6723H.A
SSH6724.A	SSH6724H.A
SSH6725.A	SSH6725H.A
SSH6726.A	SSH6726H.A
SSH6727.A	SSH6727H.A
SSH6728.A	SSH6728H.A
SSH6729.A	SSH6729H.A
SSH6723.C	SSH6723H.C
SSH6724.C	SSH6724H.C
SSH6725.C	SSH6725H.C
SSH6726.C	SSH6726H.C
SSH6727.C	SSH6727H.C
SSH6728.C	SSH6728H.C
SSH6729.C	SSH6729H.C
SSH6723.A	SSH6723H.A

### Rondostar 5000 Expert

SSH6733.A	SSH6733H.A
SSH6734.A	SSH6734H.A
SSH6735.A	SSH6735H.A
SSH6736.A	SSH6736H.A
SSH6737.A	SSH6737H.A
SSH6738.A	SSH6738H.A
SSH6739.A	SSH6739H.A
SSH6733.C	SSH6733H.C
SSH6734.C	SSH6734H.C
SSH6735.C	SSH6735H.C
SSH6736.C	SSH6736H.C
SSH6737.C	SSH6737H.C
SSH6738.C	SSH6738H.C
SSH6739.C	SSH6739H.C

### Rondostar-Cutomat 5000

SSH6723C.A	SSH6723HC.A	SSH6733C.A	SSH6733HC.A
SSH6724C.A	SSH6724HC.A	SSH6734C.A	SSH6734HC.A
SSH6725C.A	SSH6725HC.A	SSH6735C.A	SSH6735HC.A
SSH6726C.A	SSH6726HC.A	SSH6736C.A	SSH6736HC.A
SSH6727C.A	SSH6727HC.A	SSH6737C.A	SSH6737HC.A
SSH6728C.A	SSH6728HC.A	SSH6738C.A	SSH6738HC.A
SSH6729C.A	SSH6729HC.A	SSH6739C.A	SSH6739HC.A
SSH6723C.C	SSH6723HC.C	SSH6733C.C	SSH6733HC.C
SSH6724C.C	SSH6724HC.C	SSH6734C.C	SSH6734HC.C
SSH6725C.C	SSH6725HC.C	SSH6735C.C	SSH6735HC.C
SSH6726C.C	SSH6726HC.C	SSH6736C.C	SSH6736HC.C
SSH6727C.C	SSH6727HC.C	SSH6737C.C	SSH6737HC.C
SSH6728C.C	SSH6728HC.C	SSH6738C.C	SSH6738HC.C
SSH6729C.C	SSH6729HC.C	SSH6739C.C	SSH6739HC.C





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**Note for operating manual:**

The image position numbers (e.g. — 1) are sequentially numbered, chapter by chapter.

## 1 Safety information

In the following sections, the term “installation” refers to RONDO installations.

### 1.1 Explanation of symbols

---














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



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

## 1.2 Explanation of symbols

---

- |   |  |
|---|--|
|    | Earthing point   |
|    | Reaching under the closed safety guard is prohibited!      |
|    | Ensure that the mains plug is disconnected before opening! |
|    | Pay attention to the centre of gravity!                    |
|    |  |
|  | Secure the machine with a padlock to prevent restarting!   |
|  | Turn the main switch off!                                  |
|  | Danger due to general causes.                              |
|  | Danger due to hazardous electrical supply voltage.         |
|  | Danger due to pinch points on bands, belts and chains.     |
|  | Danger due to pinch points on gearwheels.                  |





Danger due to contact points and pinch points.



Danger due to automatic starting.



Danger due to pinch points on rotating parts.



Danger due to sharp parts.



Danger due to heat.



Wear safety shoes.

## 1.3 Personnel

---

### 1.3.1 Personnel requirements

---

Only those persons who can reliably work on the installation and whose reactions are not impaired (e.g. due to medicines, alcohol or drugs) are approved as personnel.

Unqualified personnel cannot identify risks and are therefore exposed to increased dangers.

- Only instruct technically qualified personnel who have been trained by RONDO, to perform the tasks described in this operating manual.
- Ensure that the personnel adhere to locally valid rules and regulations for safe and hazard-aware working.
- Specify responsibilities for activities and make sure these are known. Only give assigned personnel the keys and passwords.
- Work on/with the machine requires personnel to have been instructed and be a minimum of 16 years of age.

### 1.3.2 Unauthorised persons

---

Unauthorised persons who do not fulfil the requirements described here and are not aware of the dangers in the work area. Unauthorised persons must be kept away from the work area. Work must be interrupted for as long as unauthorised persons are in the work area.

### 1.3.3 Personal protective equipment

---

Protective equipment	Use
Safety gloves	Wear safety gloves when working with sharp parts, e.g. scrapers.
Mask	Wear a mask to prevent breathing difficulties and flour dust allergies.
Safety shoes	To prevent severe slipping or falling accidents, wear safety shoes.
Protective clothing	Suitable protective clothing is close-fitting work clothing with low resistance to tearing, narrow sleeves and without protruding parts. It serves primarily as protection from entanglement in moving machine parts. Do not wear rings, necklaces or other jewellery. Wear a hair net if you have long hair.

## 1.3.4 Conversion

---

The machine may only be converted by trained and instructed RONDO personnel.

## 1.4 Area of application

---

The machine is designed solely for industrial and commercial use.

The machine may only be used in a dry environment protected from sunshine. This means that the machine can only be operated in a closed room.

## 1.5 Safety elements

---



**Safety elements (e.g. safety guards and similar) are designed to protect the operator and to shut down the installation safely and as quickly as possible in an emergency situation.**

**It is not permitted to use safety elements instead of the “STOP” mushroom button to stop the installation. Stopping the installation incorrectly may cause production defects.**

### 1.5.1 Safety guards

---



- Safety guards protect the operator from accidentally touching dangerous areas.
- If a safety guard is lifted, the installation stops.
- After the installation has been stopped by lifting a safety guard, the installation must then be restarted.
- The gas spring protects the operator against the safety guard dropping.

## 1.6 Safety instructions and information that must be observed

---

**Read the operating manual before putting the machine into operation.**



This RONDO machine is exclusively designed for sheeting, laminating and finish-rolling doughs (dough and marzipan sheets) for the food industry.

The RONDO automatic flour duster is exclusively designed for continuously dusting dough and marzipan bands with flour.

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 this machine is not in accordance with the purpose for which it was built. Therefore, the manufacturer will not be liable for any accidents or damage resulting from unauthorised use; the risk will be borne solely by the user.



Authorised use also means that users must follow all instructions prescribed by the manufacturer in regard to operation, maintenance and service.



Work on the electrical equipment of the machine, particularly professional installation of the mains plug, may only be carried out by qualified personnel who are familiar with the 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 electric power supply with the mains plug! No permanent installation, e.g. by means of screw clamps, is permitted. The mains plug is used as a disconnecting device, and must always be clearly visible and easily accessible.



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



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



The machine may only be connected to the power supply using the plug once it has been fully assembled. In particular, operation with the machine tables disassembled is prohibited.



Before beginning any repair and service work on the machine, the power supply to the machine must be interrupted (pull out the mains plug).



Safety elements may not be adjusted, electrically overridden or dismantled.



Operation when any of the safety elements is out of order is prohibited.



Defective safety elements must be replaced with new original parts immediately.



Machine parts located in the dough processing area, and whose surface coating becomes worn (e.g. chrome plating, colour, plastic), must be replaced.



The machine must not be lifted at the substructure for transportation. Fix and transport the machine on the pallet without tables. Fix the safety guard in the upper position.



Reaching under the closed safety guard is prohibited!



Do not touch the delivery roller of the automatic flour duster with hands or any other objects when it is in operation!



Do not deposit any loose objects such as knives, tools, clothing items, etc. in the dough processing area.



To prevent breathing difficulties and flour dust allergies, the machine must be equipped with an automatic flour duster. Never use more flour than strictly necessary. Do not use compressed air for cleaning. Using a dust extraction system in the bakehouse is recommended.



Check periodically to ensure that there are no loose screws in the dough processing area.



The machine must not be operated without the scrapers.



The automatic reeling device is started automatically by the electrical control. Handle with care! Do not reach into the stationary or running device!



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



The machine must never be cleaned using spray water, a high-pressure cleaner, steam-cleaning machine or any similar cleaning methods!



The machine is not designed for use in explosive atmospheres.



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



The entire machine must be thoroughly cleaned prior to initial operation.



Remove all remaining protective films from the machine.



Clean the machine thoroughly after every use. A machine that is not thoroughly cleaned may present a health hazard for consumers.



All assembly and disassembly work must be carried out by three people.



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



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



Before beginning any cleaning work, stop the machine and interrupt the power supply to the machine (pull out the mains plug). Exceptions:

- Cleaning the rollers in intermittent operation.
- Cleaning the top of the conveyor belt in continuous operation



If an installation is connected to a network, the operating company is responsible for the network security and network infrastructure.

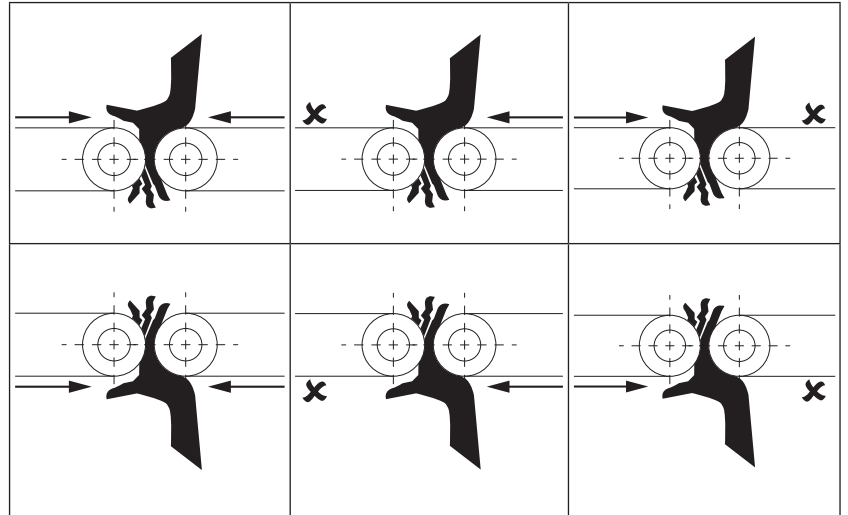




Pinch points can occur on adjacent bands, belts or chains as follows (view from above or below):

- One side stationary, the other running
- Both sides running

Keep limbs and objects away from pinch points.



Areas that are difficult to access must be regularly freed of flour residues, dough scraps and dirt to maintain hygiene.



During operation, it is not permitted to reach below closed safety guards using hands or objects.



Cutting rollers may only be lowered when the safety guard is closed.



Due to the risk of injury at the sharp edges, cutting rollers must be replaced carefully and correctly. Wear suitable protective gloves to prevent injuries. Cutting rollers that are outside the cutting point must be placed in the holding brackets beneath the machine table.

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

## 2 Transporting, setting up, connecting, dismantling and storing the device

### 2.1 Delivering the machine

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The machine is delivered in original packaging.

- Report any claims for damage caused during transport directly to the freight handlers (see packaging: the delivery documents are attached to the outside packaging).

### 2.2 Transporting the machine

---



The machine must not be lifted at the substructure for transportation. Fix and transport the machine on the pallet without tables. Fix the safety guard in the upper position.

For transport purposes and in particular to ensure stability during transport, the machine must be packed in the original packaging or in accordance with the manufacturer's instructions.

For shipping purposes, the entire machine is fastened to a pallet.

The machine tables must be disassembled.

The safety guards must be fixed in the upper position.

Accessories are packed separately and integrated in these units.

## 2.3 Unpacking the machine



Take care not to bend any parts when positioning the lifting devices. Only use tested lifting gear. Minimum load capacity 1000 kg. Pay attention to the centre of gravity! Secure loose parts to prevent falling.



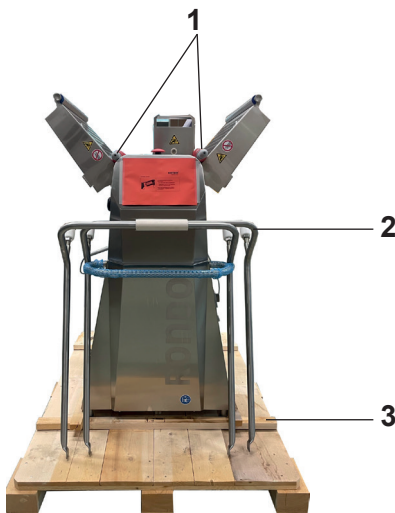
Wear safety shoes!



All assembly and disassembly work must be carried out by **three** people.

- Unpack machine tables and accessories.
- Unpack machine body and substructure (referred to as the machine further on in this chapter).
- Check everything for completeness in accordance with the delivery note.

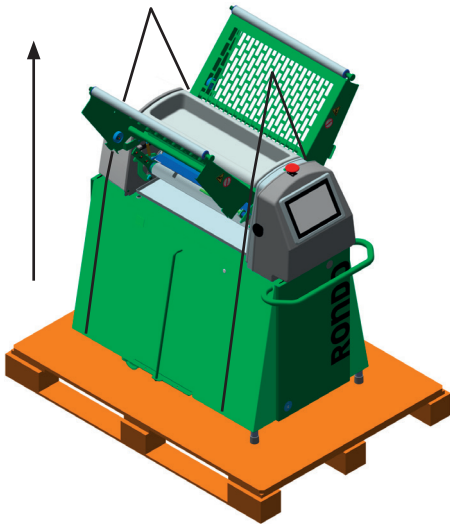
For other ambient conditions of the machine, see 3.1 General information.



1. Deposit pallet on a flat, stable surface.
2. Remove the dough reeler (1).
3. Remove the table support (2).
4. Remove wooden struts (3).
5. Unload pallet. See:
  - 2.3.1 Unloading the pallet with a crane,
  - 2.3.2 Unloading the pallet with a forklift truck,
  - 2.3.3 Unloading the pallet with a manual pallet jack.

## 2.3.1 Unloading the pallet with a crane

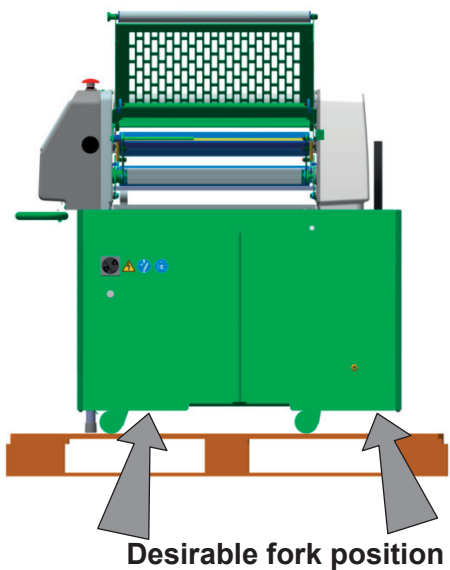
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1. Attach lifting straps as shown in the illustration.
2. Lift the machine.  
(Pay attention to the centre of gravity, can tip!)
3. Deposit machine on a flat, stable surface.

## 2.3.2 Unloading the pallet with a forklift truck

---



**Precondition:**

Fork height is < 7.5 cm.

Set the forks as wide apart as possible.



1. Lift the machine as shown in the illustration.  
(Pay attention to the centre of gravity, can tip!)
2. Deposit machine on a flat, stable surface.

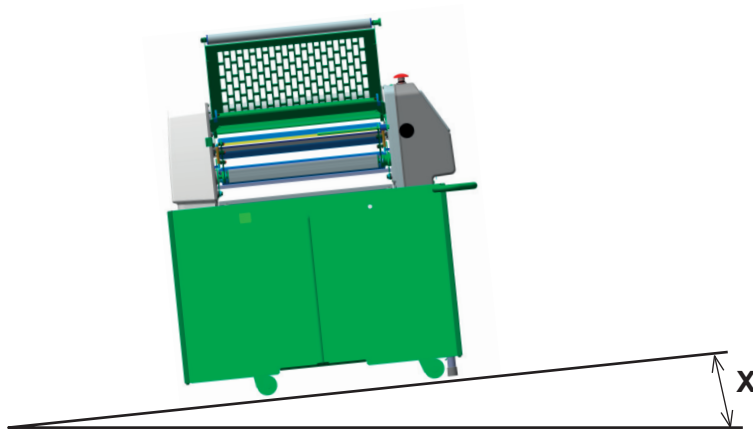
## 2.3.3 Unloading the pallet with a manual pallet jack

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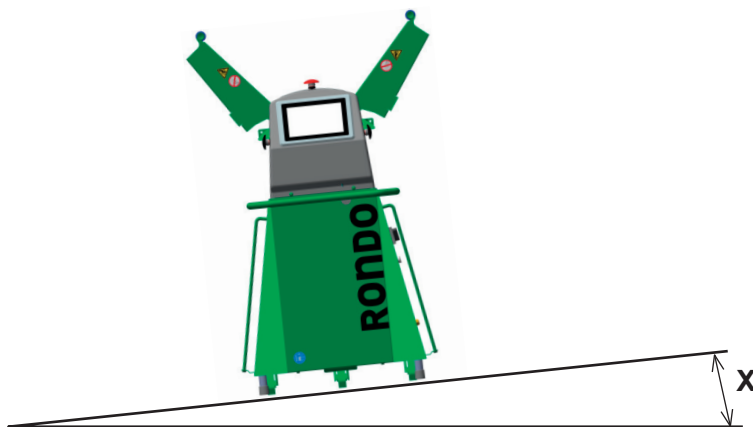
Permissible tilt angle:

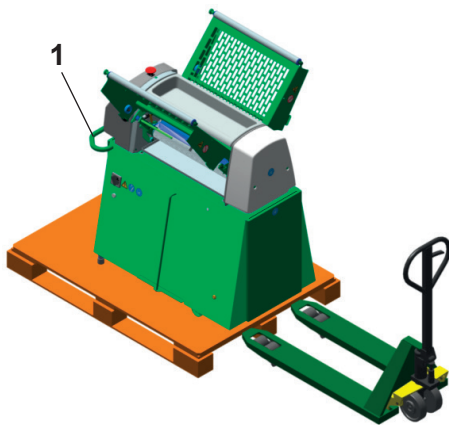
Maximum permissible  $X = 10^\circ$  in longitudinal / transverse direction.

- In longitudinal direction

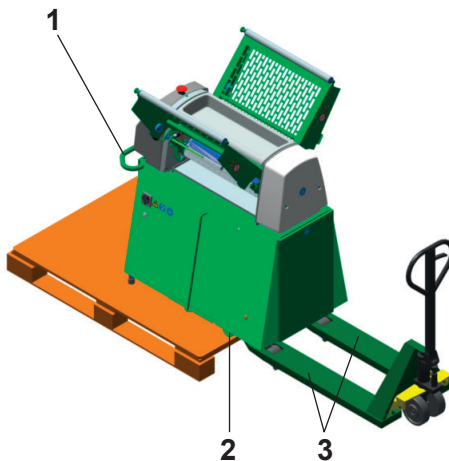


- In transverse direction





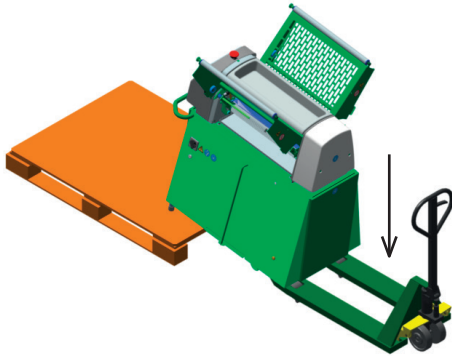
1. Lift the machine using the guard tube (1) until the front wheel engages.
2. Roll the machine so the rear side is at the edge of the pallet.
3. From the rear side of the machine, move the manual pallet jack towards the pallet.
4. Raise the fork of the manual pallet jack to the height of the pallet.
5. Secure the manual pallet jack to prevent it from rolling away.



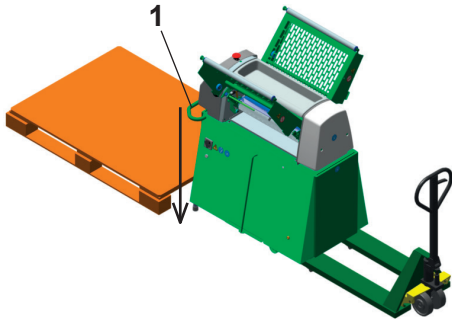
6. Two of you should hold the machine by the guard tube (1).
7. The third person ensures that the manual pallet jack is secure.
8. Push the machine onto the manual pallet jack until the rear wheels (2) have reached the edge of the pallet but are still on the pallet, as shown in the illustration.  
(Pay attention to the centre of gravity, can tip! Take care not to trip!)
9. Raise the fork (3) of the manual pallet jack.



10. Pull the manual pallet jack and the deposited machine backwards.
11. At the same time, two of you should hold the machine by the guard tube (1) and push it off the pallet.  
(Pay attention to the centre of gravity, can tip! Take care not to trip!)



12. Lower the fork of the manual pallet jack.



13. Two of you should hold the machine by the guard tube (1).  
Deposit the operating side of the machine on the surface.



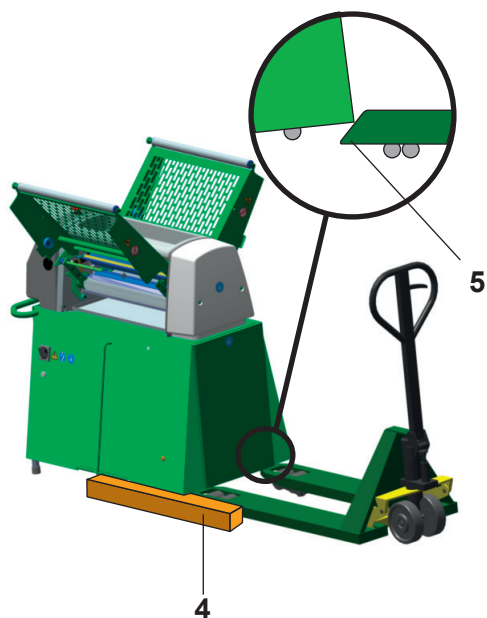
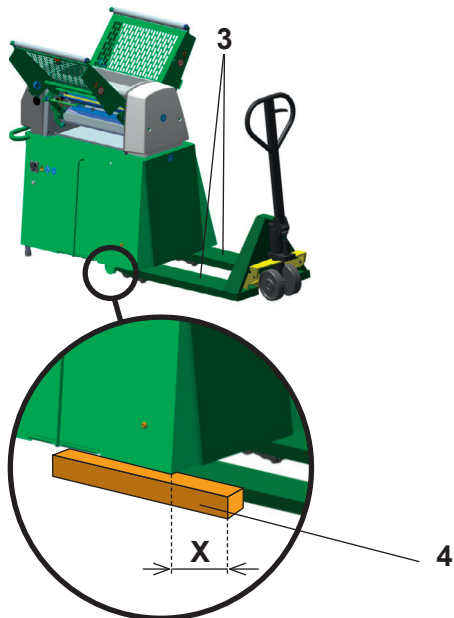
**if fork height < 7.5 cm:**

14. Put the manual pallet jack to one side.

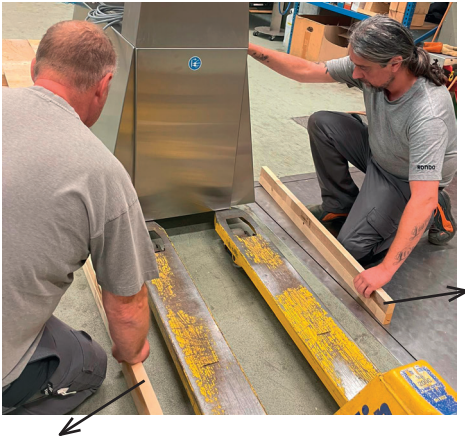


**if fork height > 7.5 cm:**

16. Raise the fork (3) of the manual pallet jack.
17. Place wooden braces (4) under the substructure.  
**X = 30 cm**, for secure handling
18. Lower the fork (3) of the manual pallet jack.



19. Pull the manual pallet jack out somewhat.
20. Lift the machine with the fork tips (5) of the manual pallet jack.



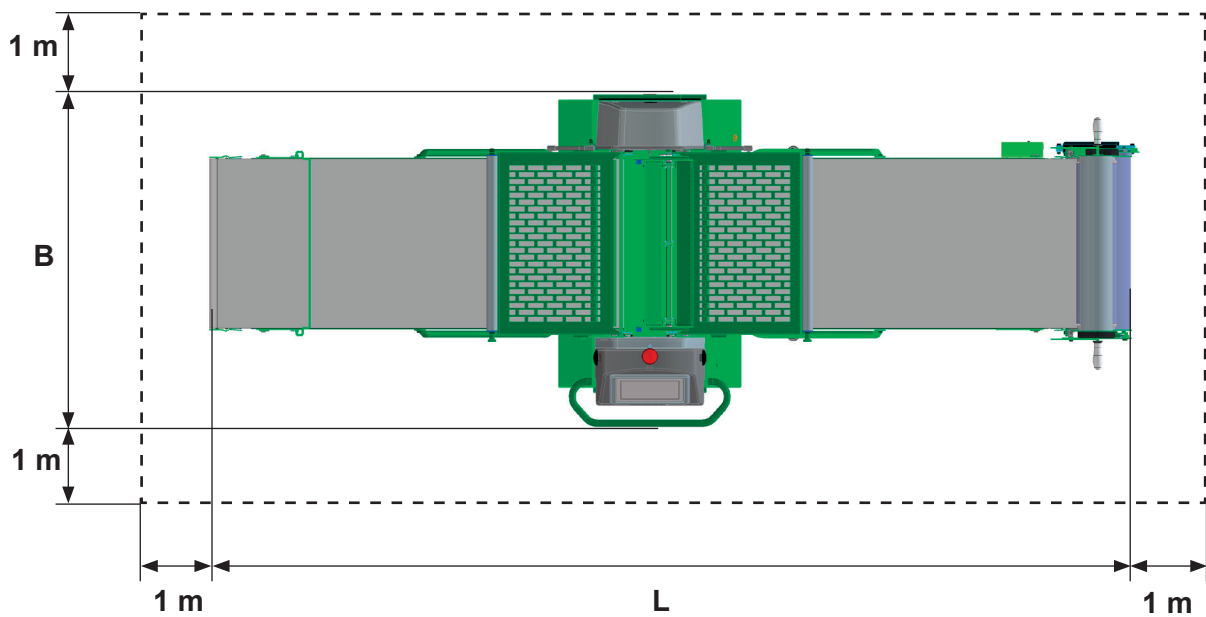
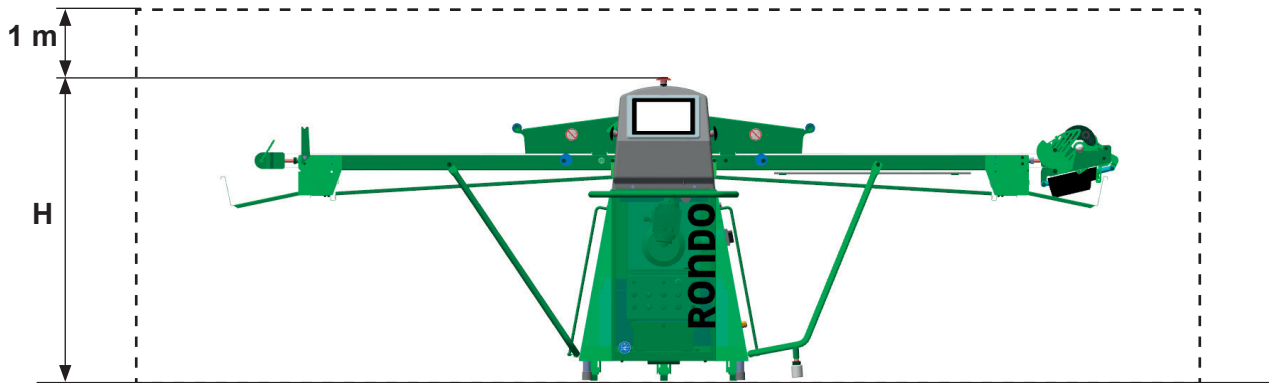
21. Remove wooden struts (4).  
(Pay attention to the centre of gravity, can tip! Take care not to trip! Make sure that you do not put any body parts beneath the machine!)



22. Lower the fork (3) of the manual pallet jack.
23. Put the manual pallet jack to one side.

## 2.4 Space requirement

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B = Total width

H = Total height

L = Total length

## 2.5 Setting up the machine

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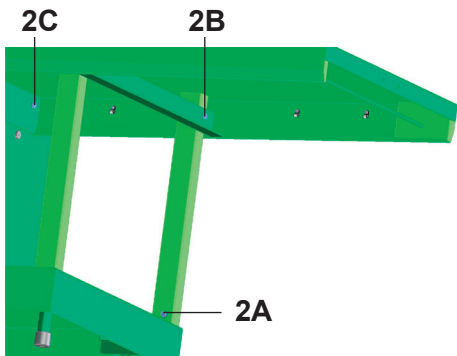
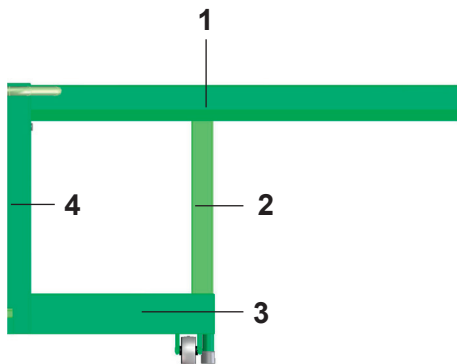
All assembly and disassembly work must be carried out by three people.



The machine must be set up on a level, even floor surface. Inclinations > 10° are not permitted. The machine must be locked during operation.

### 2.5.1 Mounting the undertables [SSH673\*\*\*.\*]

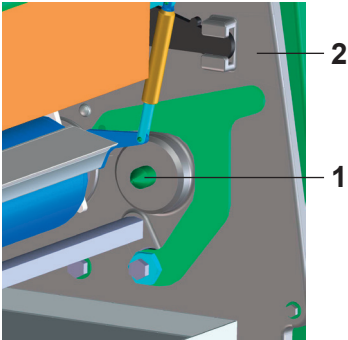
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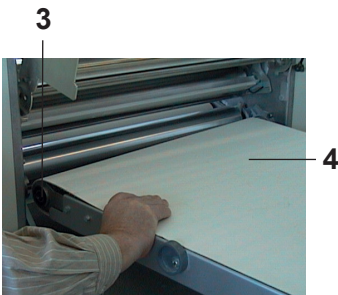
- Place the undertables (1) on the substructure (4) and on table supports (2).
- Mount the undertables on the substructure using two hexagon screws (2B) each.
- Mount the undertables on the table supports using three screws (2C) each.
- Do not tighten screws (2A/B/C) yet!
- Align the undertable.
- Tighten all screws for the following connections:
  - Substructure - Undertables
  - Undertables - Table supports
  - Table supports - Beams (3)

## 2.5.2 Mounting the machine tables

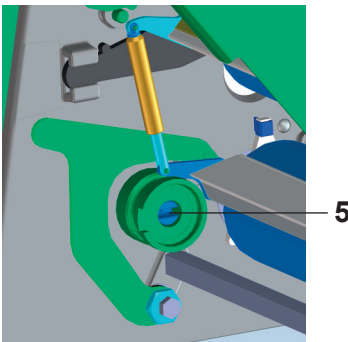
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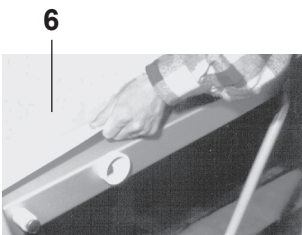
1. Remove all protective films on stainless machine parts.
2. Lift the machine table (4) with a second person.
3. Guide the centre of the drive roller of the machine table onto the spring bolt (1) in the rear housing (2).



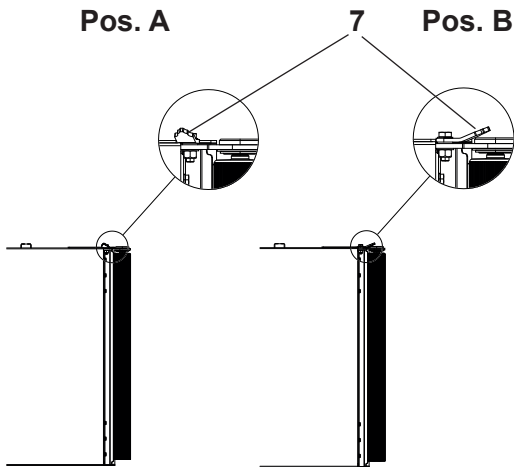
4. Move the machine table back, applying strong pressure.



5. Centre the driver (3) of the drive roller of the machine table in the holding device (5) of the front housing.



- To engage the machine table, proceed as follows:
6. Lightly pull the conveyor belt (6) until the driver engages.

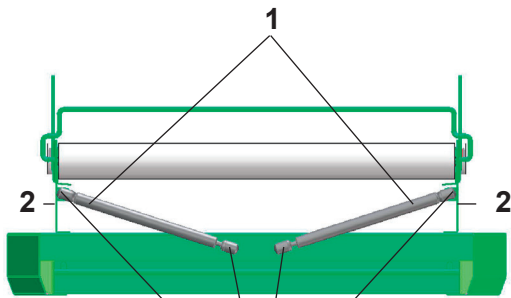


7. Fold down the table bolt (7) (this is designed to prevent unintentional disengagement of the table).

A: Position for fitting/removal

B Position for operation

### 2.5.3 Mounting gas springs: rigid substructure [SSH673\*\*\*.\*]

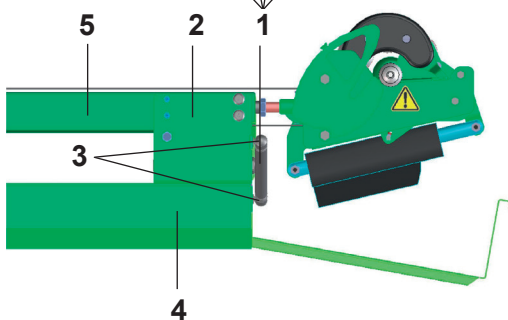


Machine table with automatic reeling device:

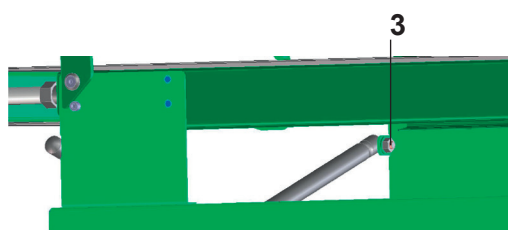
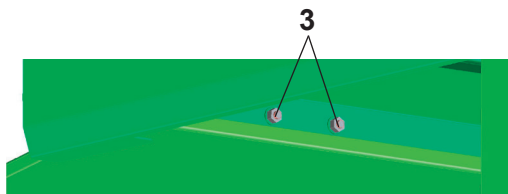
- Fit 200 N gas springs.

Machine table without automatic reeling device:

- Fit 100 N gas springs.

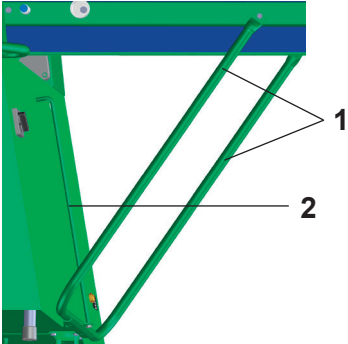


1. Mount gas springs with locking washers and hexagon nuts (3) on the undertable (4) and on guide plates (2).

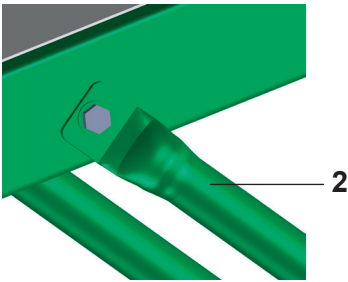


## 2.5.4 Mounting the table supports [SSH670\*\*.\*, SSH672\*\*\*.\*]

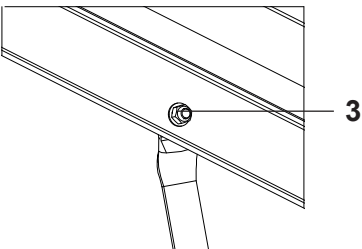
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1. Insert the table support (1) into the guideway rail (2).



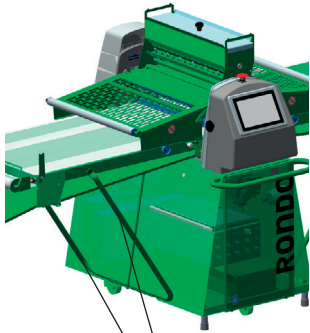
2. Fix the table support (2) with the hexagon screws.



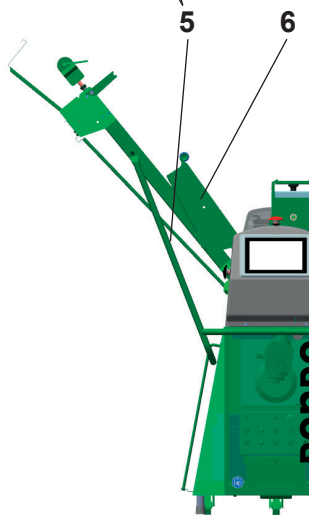
3. Attach the second washer on both inner sides, then screw on the locking nut (3).



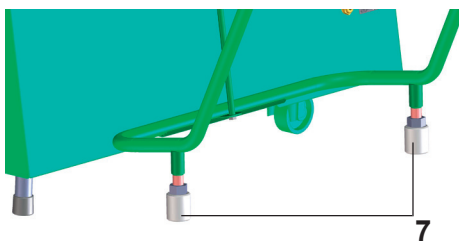
**Please note, the conveyor belt must be positioned under the locking nut again.**



Position of the table support (5) with folded down machine table (6) and folded up machine table.



**Please note the following: [SSH6707H.\* / SSH6727H.\* / SSH672\*C.\*]**



4. The feet (7) of the table support must be adjusted so that the machine table is horizontal. The machine must be locked.

Only in this way is optimal functioning of the safety guards ensured.



## 2.5.5 Tensioning the conveyor belts: Belt release [variant]



### Caution

A pinch point can develop between the conveyor belt and the idle roller if the conveyor belt is worn at the side or is damaged. If this happens, the conveyor belt must be replaced.

**Reason: Risk of injury to fingers in the area of the idle roller.**

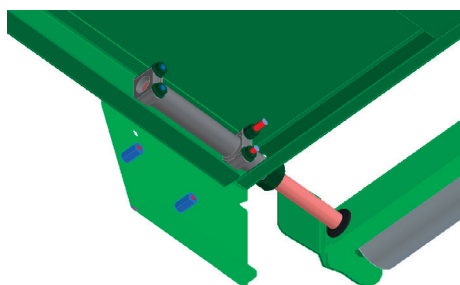
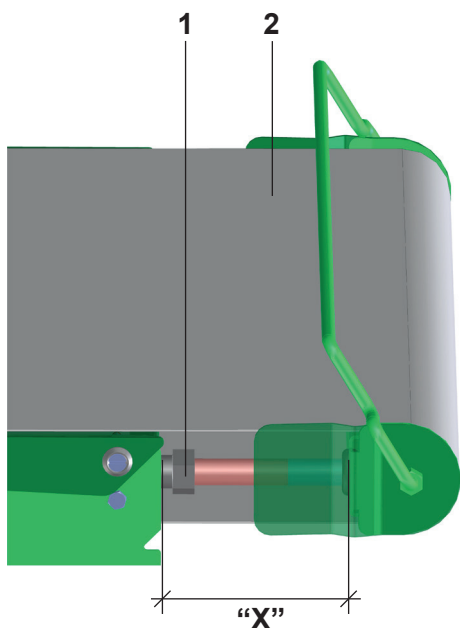
Tension the conveyor belts only so much that the heaviest dough pieces (maximum 12 kg) can still be moved along without the conveyor belt slipping.

Proceed as follows:

1. Re-tension the left and right tensioning nut (1) evenly and in parallel.
2. Remeasure the distance "X" on both sides using a millimetre measuring tape. The distance "X" must be identical on both sides.
3. Switch the machine on (see 5.3 Switching the machine on, basic screen).
4. Watch the conveyor belt (2) running to the left and right.

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

5. Loosen on the opposite side with the tightening nut
- or
6. Re-tension with the tensioning nut on the run-off side.
7. Watch the conveyor belt and, if necessary, adjust it until it runs exactly down the middle of the infeed table.



Repeat the procedure several times, if necessary. Routinely monitor the belt during the first few hours of operation and, if necessary, adjust again.

### Be patient when tightening and adjusting the conveyor belts!

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

Before starting to operate the machine, the conveyor belts must be lightly dusted with flour to prevent the dough from sticking to the conveyor belt.

## 2.5.6 Tensioning the conveyor belts: Quick-release belt [variant]



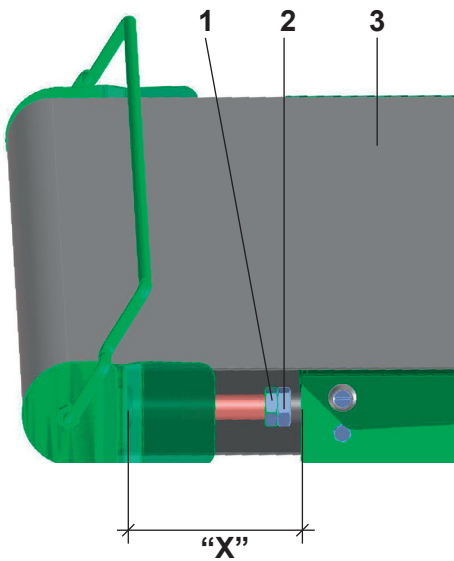
### Caution

A pinch point can develop between the conveyor belt and the idle roller, if the conveyor belt is worn at the side or is damaged. If this happens, the conveyor belt must be replaced.

**Reason: Risk of injury to fingers in the area of the idle roller.**

Tension the conveyor belts only so much that the heaviest dough pieces (max. 12 kg) can still be moved along without the conveyor belt slipping.

Proceed as follows:



1. The quick-release belt must be in the tightened position.
2. Loosen the locknut (1).
3. Tighten the left and right tensioning nut (2) evenly and in parallel.
4. Remeasure the distance "X" on both sides using a millimetre measuring device. The distance "X" must be identical on both sides.
5. Tighten the locknut (1).
6. Switch the machine on (see 5.3 Switching the machine on, basic screen).
7. Watch the conveyor belt (3) running to the left and right.

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

8. Tighten on the run-off side with the tensioning nut (2).

or

9. Loosen on the opposite side with the tensioning nut (2).

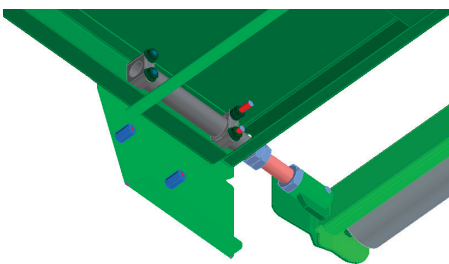
10. Watch the conveyor belt and, if necessary, adjust it until it runs exactly down the middle of the infeed table.

Repeat the procedure several times, if necessary. Routinely monitor the belt during the first few hours of operation and, if necessary, adjust again.

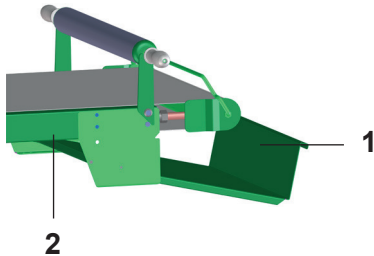
### Be patient when tightening and adjusting the conveyor belts!

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

Before starting to operate the machine, the conveyor belts must be lightly rubbed with flour, to prevent the dough from sticking to the conveyor belt.

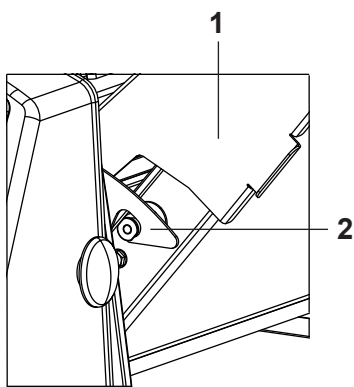


## 2.5.7 Mounting the dough catch pans



1. Remove protective film from the dough catch pan (1).
2. Insert the dough catch pan on both sides.
3. Raise the machine table (3).

## 2.5.8 Folding up the machine table [SSH670\*.\* / SSH672\*.\* / SSH672\*C.\*]



When raising the machine table, push in or remove the dough catch pan.

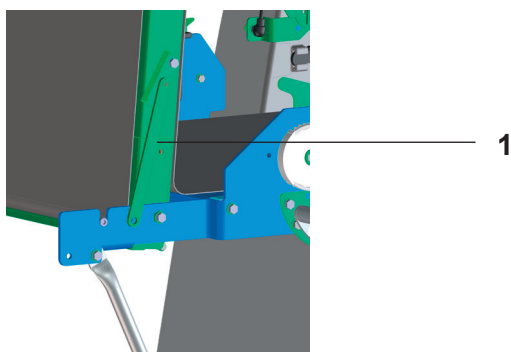
1. Attach the table hook (2).

The machine table (1) is now secured.

## 2.5.9 Folding up the machine table: Cutomat [SSH672\*\*C.\* / SSH673\*\*C.\*]



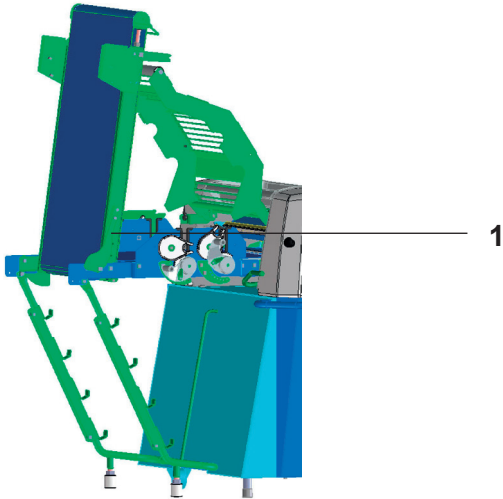
**A defective locking lever (1) must be replaced immediately!**  
Reason: Risk of injury from falling machine table!



1. Remove the cutting rollers.
2. Fold up the machine table until the locking lever (1) locks.

## 2.5.10 Folding down the machine table: Cutomat [SSH672\*\*C.\* / SSH673\*\*C.\* ]

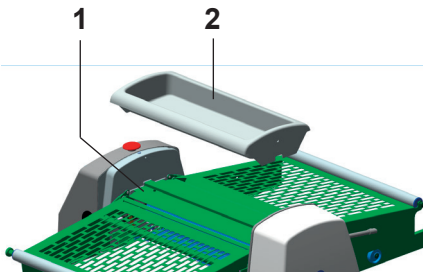
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1. Hold the machine table.
2. Push the locking lever (1) down slightly and lower the machine table at the same time.

## 2.5.11 Mounting the flour container [variant SSH670\*\*.\*]

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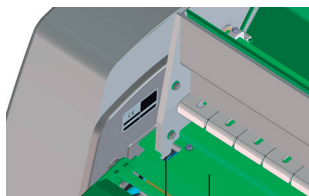


1. Mount the flour container (2) onto the cover plate (1) from above.

## 2.5.12 Mounting the automatic flour duster [variant SSH670\*\*.\*][standard SSH672\*\*\*.\*, SSH673\*\*\*.\*]



Remove all remaining protective films from the machine.



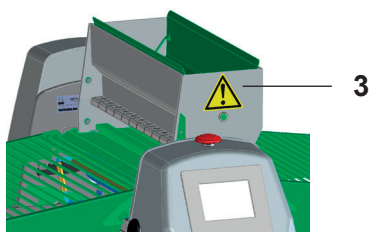
2 1

1. Remove protective film from the cover plate (1).

2. Place the automatic flour duster (3) on the cover plate.

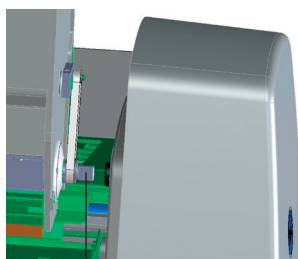
3. Insert the automatic flour duster into the two recesses (2) in the cover plate.

4. Push the automatic flour duster towards the rear.

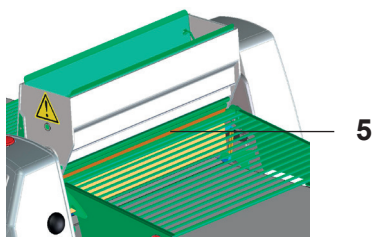


3

5. Turn the delivery roller (5) until the driver (4) can be inserted into the holding device and the automatic flour duster engages with the protruding catch of the cover plate.

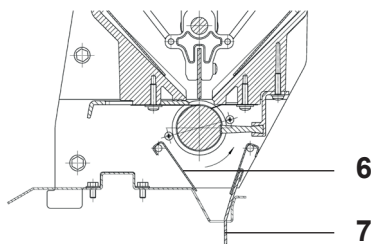


4



5

6. Hook the flour apron (7) and protective cover (6) in the correct position.



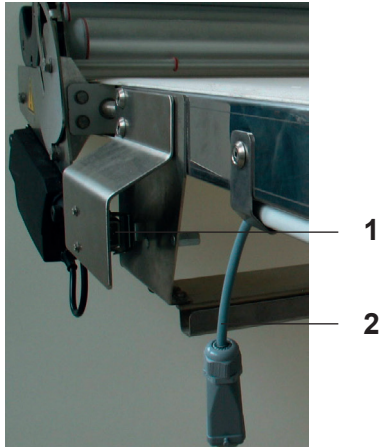
6

7

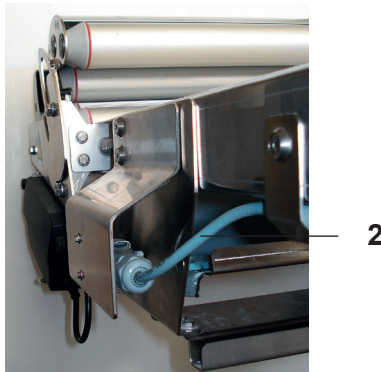
## 2.5.13 Mounting the automatic reeling device [SSH67\* 7H\*.\*)



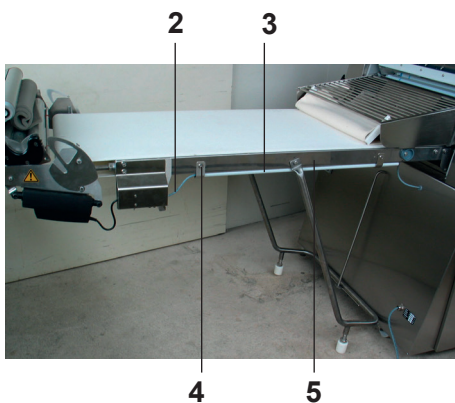
The automatic reeling device is started automatically by the electrical control. Handle with care! Do not reach into the stationary or running device!



1. Connect the connecting cable (2) for the automatic reeling device to the plug (1) of the Linak motor.

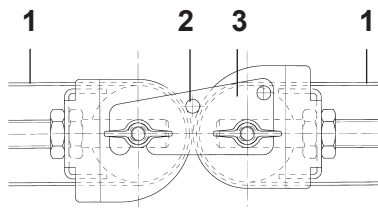


2. Check: Is the connecting cable (2) correctly connected to the Linak motor?



3. Fix the connecting cable (2) with the plastic tube (3) and screws (4) to the machine table (5).

## 2.5.14 Interconnected operation with PTT150/PTT250 transfer table



**Transfer-table**

**Rondostar**



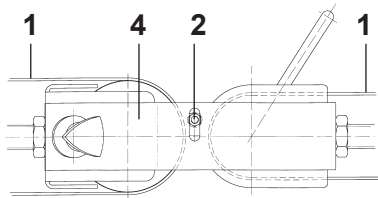
The Rondostar and transfer table must be firmly connected with the joining plate (3).

The distance between the protection bar (2) and the belts (1) must not exceed 3 mm.



Interconnected operation without a correctly installed protection bar is prohibited.

## 2.5.15 Interconnected operation with make-up line/donut line



**Make-up line/  
donut line**

**Rondostar**



The Rondostar and make-up line must be firmly connected with the joining plate (4).

The distance between the protection bar (2) and the belts (1) must not exceed 3 mm.



Interconnected operation without a correctly installed protection bar is prohibited.

## 2.5.16 Moving the machine

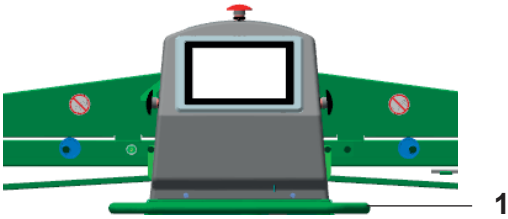


The machine must be set up on a level, even floor surface. Travelling over gradients  $> 10^\circ$  is not permitted. The machine must be locked during operation.

1. Lift on the operating side using the guard tube (1):

The front transport roller drops down.

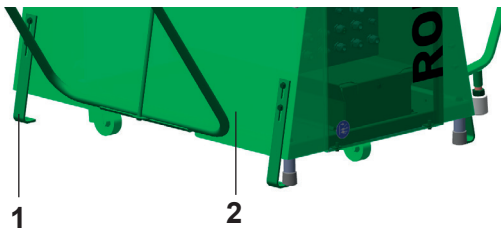
The machine can now be easily moved on the rollers.



At the desired location:

- Lift the machine slightly using the guard tube (1).
- Press the pedal (2) for the front transport roller with your foot.
- Lower the machine gently to the ground, do not let it "fall".

## 2.5.17 Mounting the ship feet [option SSH670\*\*.\*, SSH672\*\*\*.\*]



1. Mount the ship feet (1) on the substructure (2)
2. Fasten the ship feet to the floor
3. Tighten the screws



## 2.6 Storing the machine

---

**The machine is stored in assembled condition.**



When storing the machine, the temperature and humidity conditions must be monitored, see 3.2 Technical information.



The machine must be set up on a level, even floor surface. Travelling over gradients  $> 10^\circ$  is not permitted. The machine must be locked during storage.

### **Ambient conditions for storage:**

- Dry
- No sunshine
- Monitor the temperature and humidity conditions

1. Switch the machine off.
2. Clean the machine, see chapter 6 Cleaning.
3. Cover the machine with a plastic sheet.
4. Store the machine in a suitable place.

## 2.7 Requirements for commissioning the machine

---



Work on the electrical equipment of the machine, particularly professional installation of the mains plug, may only be carried out by qualified personnel who are familiar with the 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 electric power supply with the mains plug! No permanent installation, e.g. by means of screw clamps, is permitted. The mains plug is used as a disconnecting device, and must always be clearly visible and easily accessible.

Measure the alternating field direction. Swap two phases on the mains plug if necessary.

The line filter generates static and dynamic leakage currents. These can lead to unwanted tripping of the residual current device when inserting the mains plug or switching on and operating the machine.

Please note that on machines with a line filter, smooth DC residual currents or leakage currents can arise, which are not reliably detected by type A residual current devices. Type A residual current devices are therefore not permitted.

Please contact an electrical specialist to ensure correct selection of the residual current device and adhere to the local regulations.

### Note

- Three-phase electronic equipment with plug connections  $\leq 32$  A may only be operated via AC/DC-sensitive residual current devices with  $I_{\Delta n} \leq 30$  mA or protective isolating transformers.
- Three-phase electronic equipment with plug connections  $> 32$  A to 63 A may only be operated via AC/DC-sensitive residual current devices with  $I_{\Delta n} \leq 500$  mA or protective isolating transformers.
- Three-phase electronic equipment with plug connections  $> 63$  A may only be operated via AC/DC-sensitive residual current devices or protective isolating transformers.



The machine may only be connected to the power supply using the plug once it has been fully assembled. In particular, operation with the machine tables disassembled is prohibited.



To prevent breathing difficulties and flour dust allergies, the machine should be equipped with an automatic flour duster.

Never use more flour than strictly necessary.

Do not use compressed air for cleaning. Using a dust extraction system in the bakehouse is recommended.



Remove all remaining protective films from the machine.

In order to sheet doughs with the machine, the following requirements must be fulfilled:

- Dough piece weight max. 12 kg
- Flour the dough pieces: This prevents dough from sticking to the rollers and scrapers.

## 3 General information on the machine

### 3.1 General information

---

#### 3.1.1 Authorised use of the basic version

---



This RONDO machine is exclusively designed for sheeting, laminating and finish-rolling doughs (dough and 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).

Improper use includes the processing or filling of hazardous substances (harmful substances, particularly toxic, corrosive, easily or highly flammable and explosive substances).

Any other use of this machine is not in accordance with the purpose for which it was built. Therefore, the manufacturer will not be liable for any accidents or damage resulting from unauthorised use; the risk will be borne solely by the user.

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

#### **Laminating**

Incorporation of fat. Layers of fat and dough are created by sheeting to a thickness of around 6–11 mm, and then folding the dough. By repeating this process many thin layers are formed.

#### **Finish-rolling**

Sheeting the dough piece to the end thickness required for further processing.

### 3.1.2 **Authorised use of the automatic reeling device** [SSH67\* 7H\*. \*]

---

The RONDO automatic reeling device is exclusively designed for automatic reeling of the end product processed on the machine.

Any other use of this machine is not in accordance with the purpose for which it was built. Therefore, the manufacturer will not be liable for any accidents or damage resulting from unauthorised use; the risk will be borne solely by the user.

### 3.1.3 **Authorised use of the flour container [variant SSH670\*\*.\*]**

---

The RONDO flour container is exclusively designed for the manual application of process flour on the conveyor belts and product processed on the machine.

Any other use of this machine is not in accordance with the purpose for which it was built. Therefore, the manufacturer will not be liable for any accidents or damage resulting from unauthorised use; the risk will be borne solely by the user.

Recommended flour type:  
no. 550; only use dry, clean flour.

### 3.1.4 **Authorised use of the Cutomat [SSH67\*\*\*C.\*]**

---

The Cutomat (cutting station) is exclusively designed for cutting doughs (dough and marzipan sheets) for the food industry.

Any other use of this machine is not in accordance with the purpose for which it was built. Therefore, the manufacturer will not be liable for any accidents or damage resulting from unauthorised use; the risk will be borne solely by the user.

### 3.1.5 **Authorised use of the automatic flour duster** [variant SSH670\*\*.\*][standard SSH672\*\*.\*, SSH673\*\*.\*]

---

The RONDO automatic flour duster is exclusively designed for the automatic application of process flour on the conveyor belts and product processed on the machine.

Any other use of this machine is not in accordance with the purpose for which it was built. Therefore, the manufacturer will not be liable for any accidents or damage resulting from unauthorised use; the risk will be borne solely by the user.

Recommended flour type:  
no. 550; only use dry, clean flour.

### 3.1.6 **Authorised use of the ship feet [option SSH670\*\*.\*, SSH672\*\*.\*]**

---

The RONDO ship feet are exclusively designed for fixing (bolting) the machine to the ship floor.

Any other use of this machine is not in accordance with the purpose for which it was built. Therefore, the manufacturer will not be liable for any accidents or damage resulting from unauthorised use; the risk will be borne solely by the user.

## 3.2 Technical information

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### 3.2.1 Noise values

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

The accuracy class of the acoustic emission measurement corresponds to class 2 ( $\pm 2.5$  dB) in compliance with:

DIN EN ISO 11201 / DIN EN ISO 11202 /  
DIN EN ISO 11203 / DIN EN ISO 11204

### 3.2.2 Temperatures

---

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

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

### 3.2.3 Ambient humidity

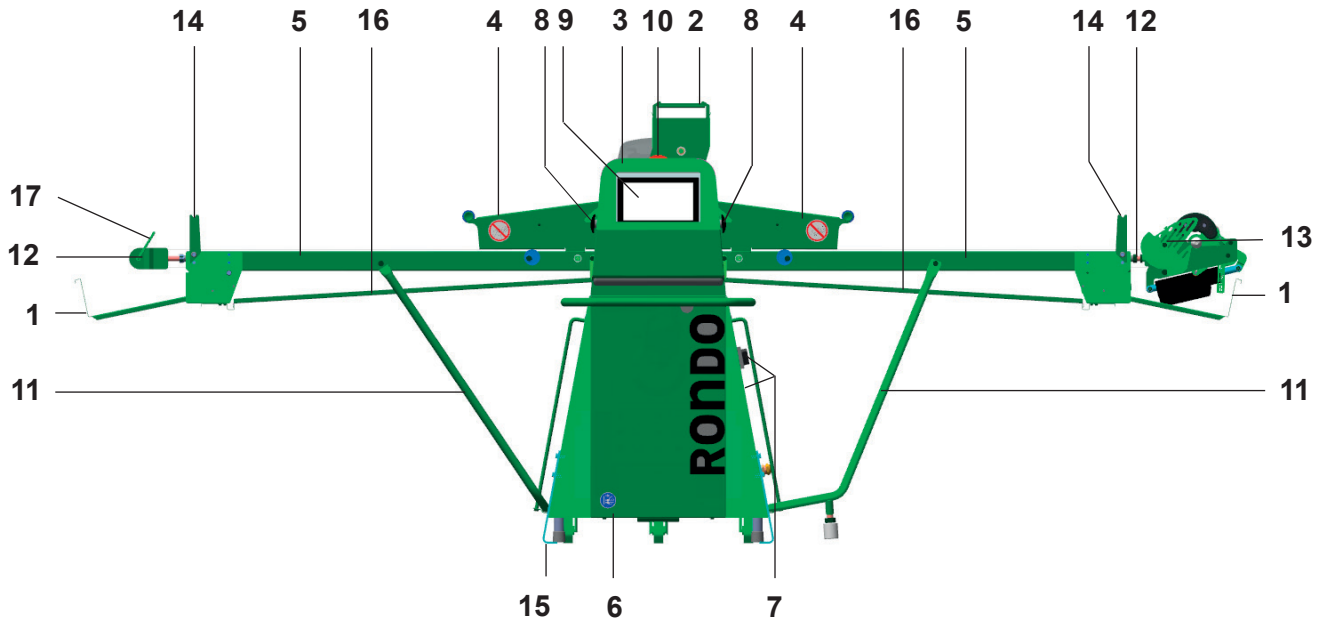
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The permissible humidity for the machine lies in the range of 30–95% relative humidity, non-condensing.

The permissible humidity for the flour used is max. 60% relative humidity, non-condensing.

## 3.3 Full view of the machine

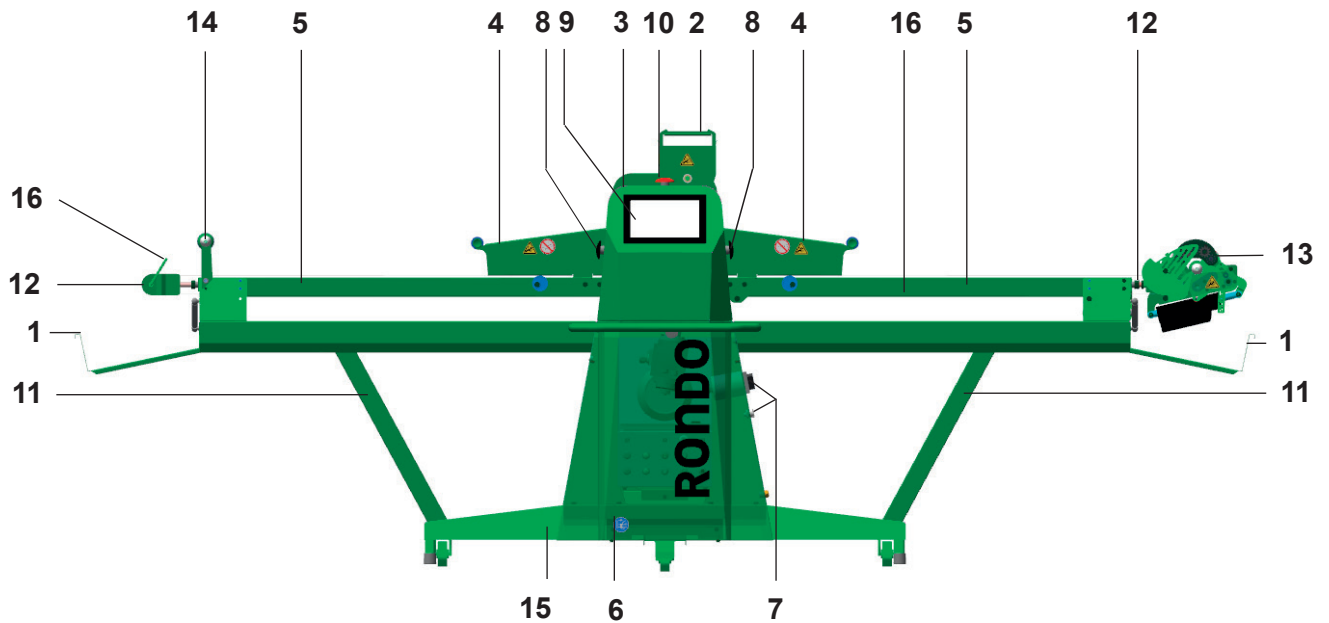
### 3.3.1 Rondostar 5000 Basic / Rondostar 5000 Pro



- 1 Dough catch pan
- 2 Flour container / Automatic flour duster
- 3 Machine body
- 4 Safety guards
- 5 Machine table
- 6 Substructure
- 7 Main switch and USB interface
- 8 "Start" mushroom button
- 9 Touch screen
- 10 "Stop" mushroom button
- 11 Table support
- 12 Belt release / Quick-release belt [variant]
- 13 Automatic reeling device [option]
- 14 Reeler holder
- 15 Ship feet [option]
- 16 Flour catch pan [option]
- 17 Dough retention arm

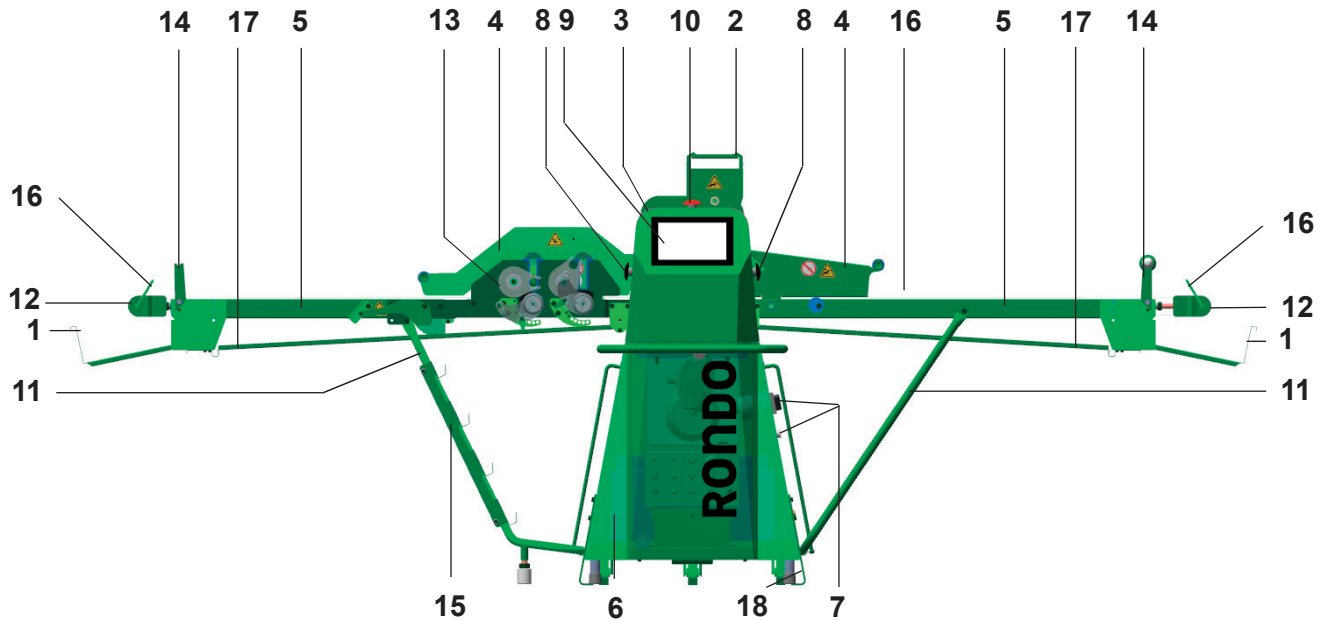


## 3.3.2 Rondostar 5000 Expert



- 1 Dough catch pan
- 2 Automatic flour duster
- 3 Machine body
- 4 Safety guards
- 5 Machine table
- 6 Rigid substructure
- 7 Main switch and USB interface
- 8 "Start" mushroom button
- 9 Touch screen
- 10 "Stop" mushroom button
- 11 Table support
- 12 Belt release / Quick-release belt [variant]
- 13 Automatic reeling device [option]
- 14 Reeler holder
- 15 Beam
- 16 Dough retention arm

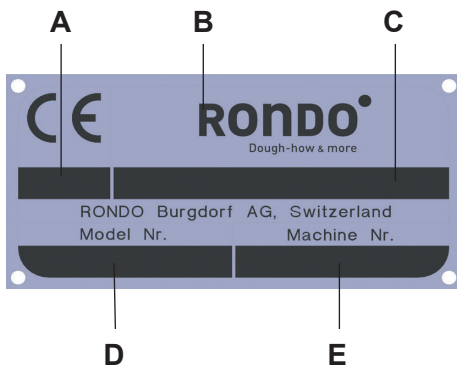
### 3.3.3 Rondostar-Cutomat 5000



- 1 Dough catch pan
- 2 Automatic flour duster
- 3 Machine body
- 4 Safety guards
- 5 Machine table
- 6 Substructure
- 7 Main switch and USB interface
- 8 "Start" mushroom button
- 9 Touch screen
- 10 "Stop" mushroom button
- 11 Table support
- 12 Belt release / Quick-release belt [variant]
- 13 Cutomat (cutting station)
- 14 Reeler holder
- 15 Holder for cutting rollers
- 16 Dough retention arm
- 17 Flour catch pan [option]
- 18 Ship feet [option]

## 3.3.4 Type plate

---



A Year of manufacture

B Manufacturer

C Product name

D Model number

E Machine number

## 3.4 Machine configurations

### 3.4.1 Overview

Component	Basic	Pro	Expert	Cutomat
Visualisation (operating software)	x	x	x	x
Complete housing	x	x	x	x
Safety guards	x	x	x	x
Blue scraper	x	x	x	x
White scraper	V	V	V	V
Machine tables	x	x	x	x
Table supports	x	x	x	x
Dough catch pans	x	x	x	x
Flour catch pans under machine tables	O	O	-	O
Conveyor belts, white	x	x	x	x
Conveyor belts, blue	V	V	V	V
Belt release	x	x	x	x
Quick-release belt	V	V	V	V
Flour container	V	-	-	-
Automatic flour duster	V	x	x	x
Dough reeler	x	x	x	x
Automatic reeling device	O	O	O	O
Ship feet	O	O	-	O
Cutomat (cutting station)	-	-	-	x
Interconnected operation (transferring)	O	O	O	-

- = Not available

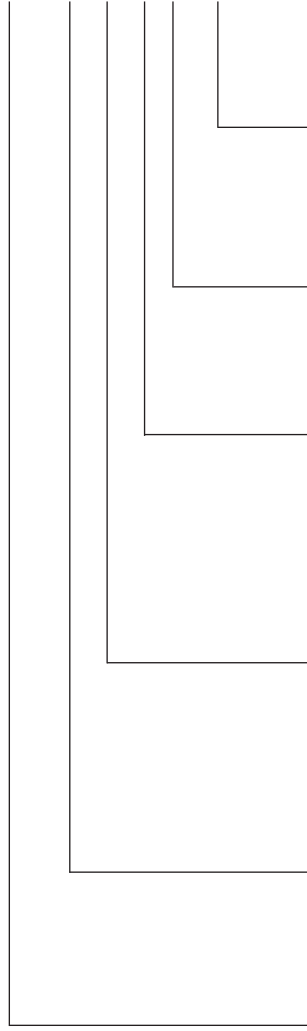
x = Standard

V = Variant

O = Option

## 3.4.2 Machine type nomenclature

**SSH6707H.A**



### Electrical design

- A EU and rest of the world
- C UL

### Option

- H Automatic reeling device
- C Cutomat

### Machine table length

- 5 Table length 5
- 7 Table length 7

### Machine name

- 70 Rondostar 5000 Basic
- 72 Rondostar 5000 Pro
- 73 Rondostar 5000 Expert

### Machine table width

- 6 approx. 600 mm

### Machine family

- SSH Sheeter 4.0

Notes:

- Not all options are included in the nomenclature.
- Not all variants are included in the nomenclature.

## 3.5 Individual components

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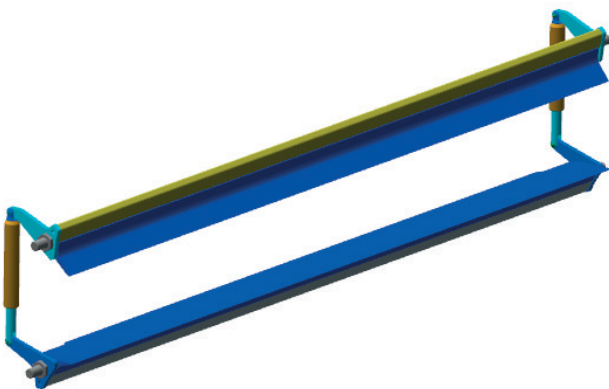
### 3.5.1 Complete housing (housing covers include basic structure)

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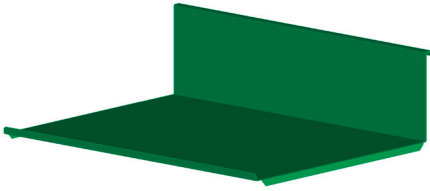
### 3.5.2 Scraper

---



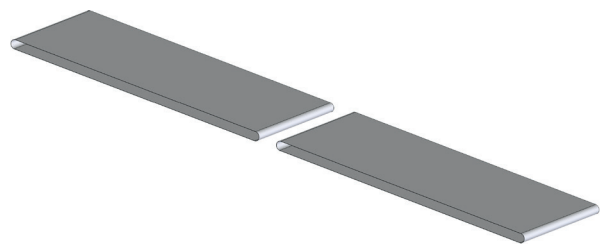
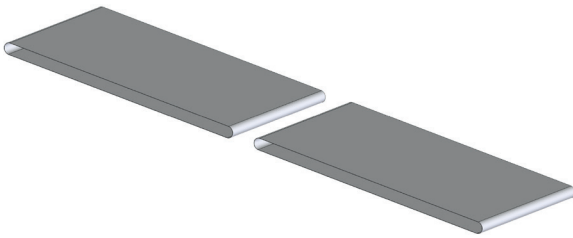
## 3.5.3 Dough catch pans

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## 3.5.4 Conveyor belts

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## 3.5.5 Machine tables

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Table length 5 [SSH67\*5.\* / SSH67\*5C.\*]

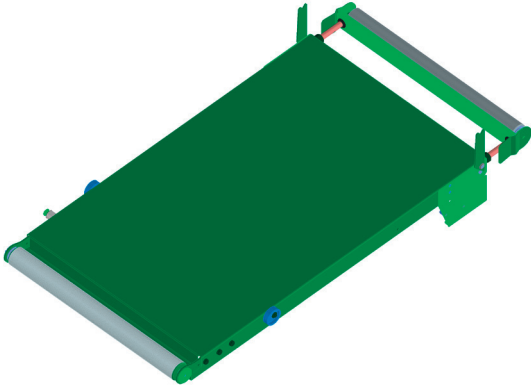


Table length 7 [SSH67\*7\*\*.\*]

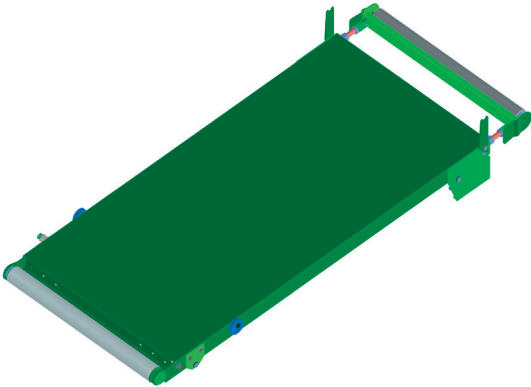
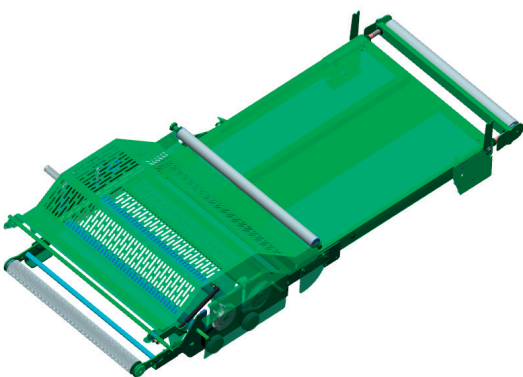


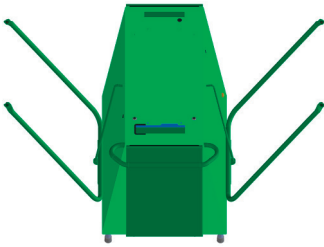
Table length 7 with Cutomat [SSH67\*\*\*C.\*]





## 3.5.6 Substructure

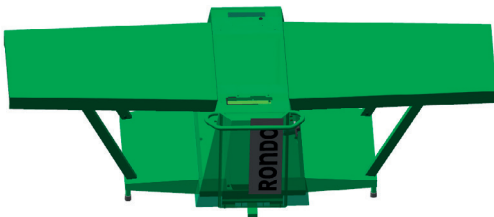
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[SSH6705.A / SSH6705.C / SSH6707.A / SSH6707.C / SSH6725.A / SSH6725.C / SSH6727.A / SSH6727.C]



[SSH6707H.A / SSH6707H.C / SSH6727H.A / SSH6727H.C]



[SSH673\*\*\*.\*]



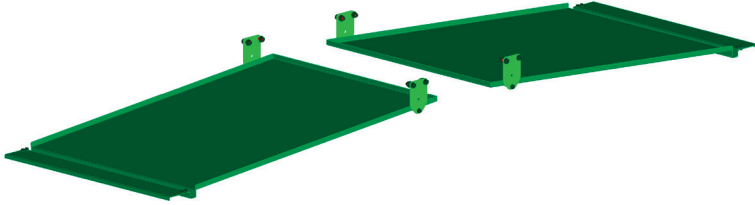
[SSH672\*C.\*]



[SSH6727HC.\*]

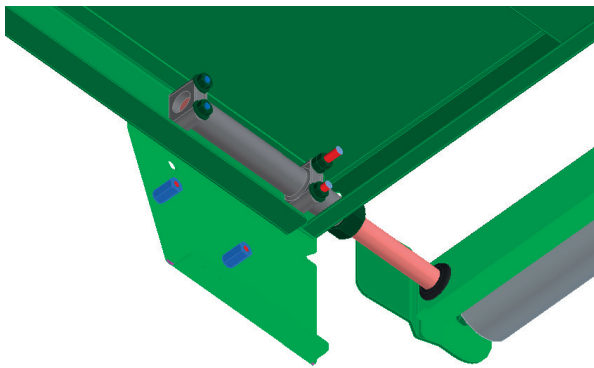
## 3.5.7 Flour catch sheets [option SSH670\*\*.\*, SSH672\*\*\*.\*]

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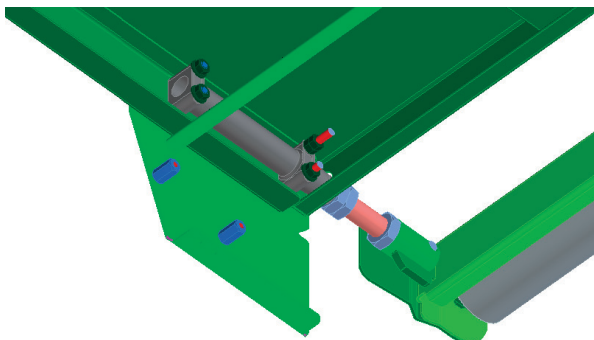
## 3.5.8 Belt release [variant]

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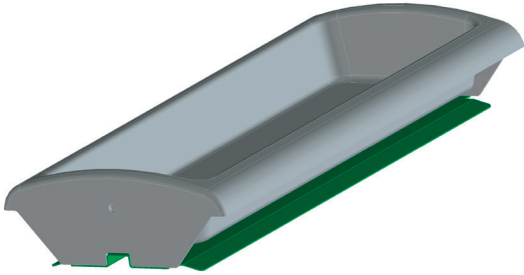
## 3.5.9 Quick-release belt [variant]

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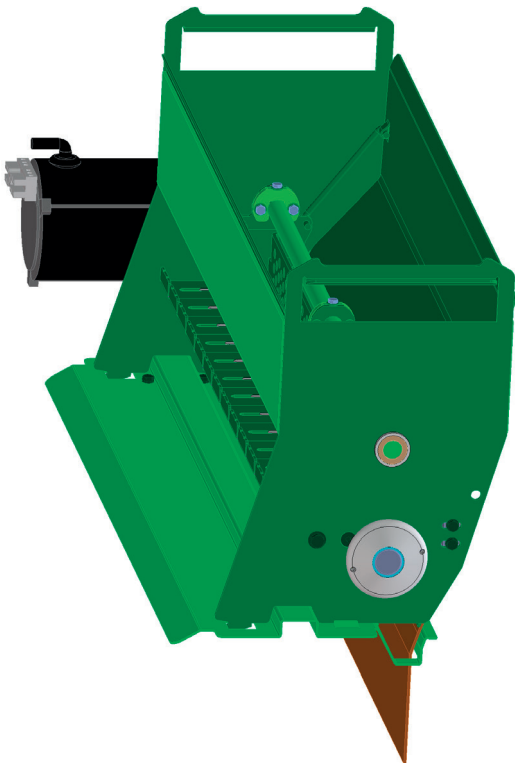
## 3.5.10 Flour container [variant SSH670\*\*.\*]

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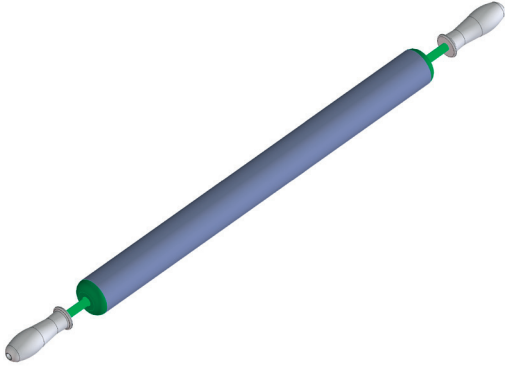
## 3.5.11 Automatic flour duster [variant SSH670\*\*.\*][standard SSH672\*\*\*.\*, SSH673\*\*\*.\*]

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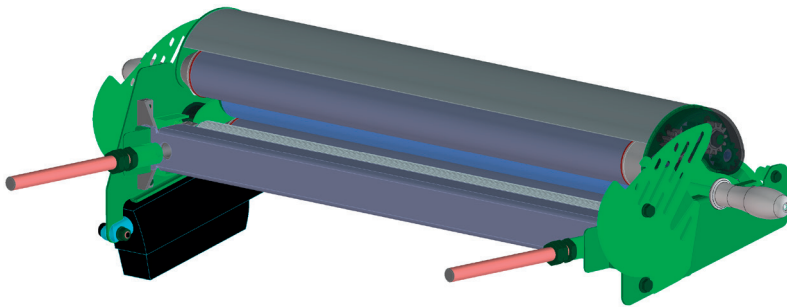
## 3.5.12 Dough reeler

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## 3.5.13 Automatic reeling device [SSH67\*7H\*.\*]

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## 3.5.14 Ship feet [option SSH670\*\*.\*, SSH672\*\*\*.\*]

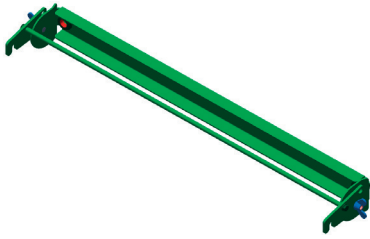
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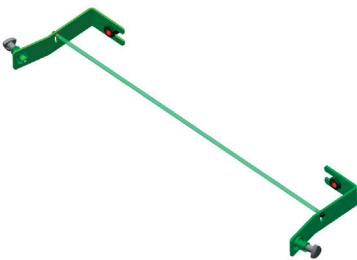
The ship feet (1) hold the machine in position in rough seas.

## 3.5.15 Transferring [option]

---



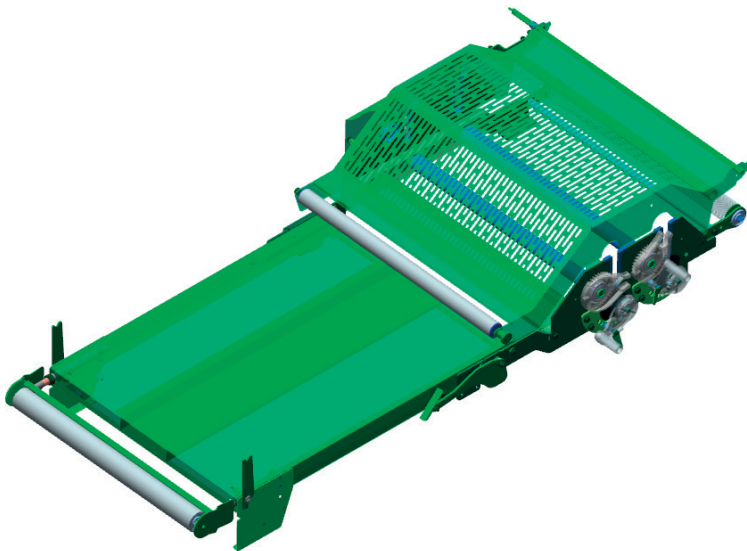
Transferring to PTT 150 / PTT 250



Transferring to PMML\* / SFT\*

## 3.5.16 Cutomat [SSH672\*\*C.\*]

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## 3.6 Operating and display elements

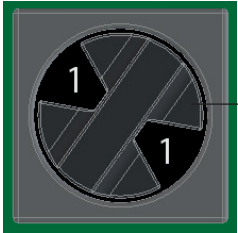
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### 3.6.1 Switches – buttons – displays

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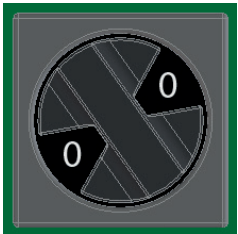
#### 3.6.1.1 main switch

---



##### Switching the machine on

Turn the main switch (1) on the substructure to position (I).

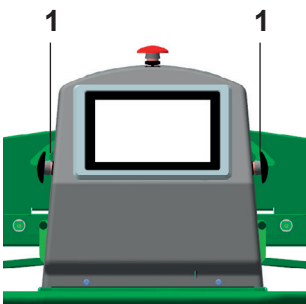


##### Switch machine off

Turn the main switch (1) on the substructure to position (0).

#### 3.6.1.2 Black mushroom button

---

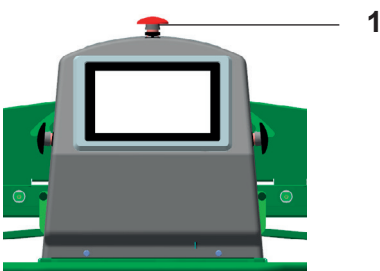


##### Start machine

Press black mushroom button (1).

#### 3.6.1.3 Red mushroom button

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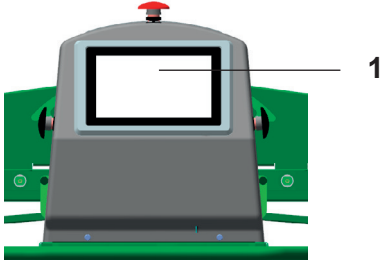


##### Stop machine

Press the red mushroom button (1).

### 3.6.1.4 Touch screen

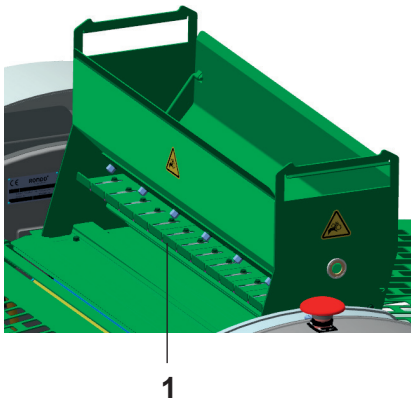
---



The touch screen (1) lets you select functions and display data on the user interface of the software (visualisation).

### 3.6.1.5 Automatic flour duster: Dosing slides [variant SSH670\*\*.\*][standard SSH672\*\*.\*, SSH673\*\*.\*]

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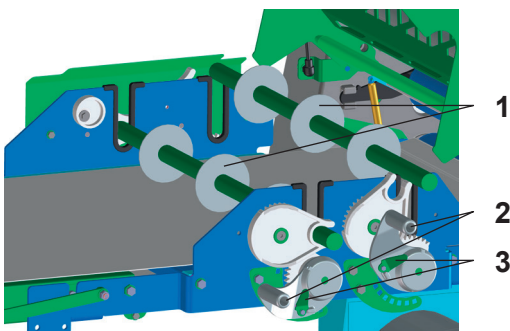


The desired dosing width can be set with the dosing slides (1). The maximum dosing width is 630 mm.

The dusting flour consumption can be considerably reduced by setting the dosing slides (1) to the actually required dusting width.

### 3.6.1.6 Cutomat: Tension lever / stop lever [SSH67\*\*\*C.\*]

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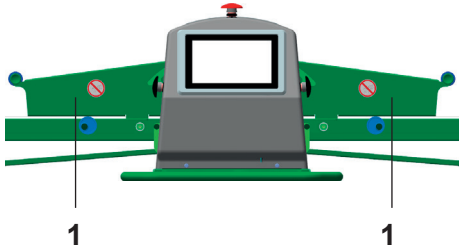
The height of the cutting roller (1) is set with the tension lever (2). The stop lever (3) locks the tension lever (2).

## 3.6.2 Safety elements

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### 3.6.2.1 Safety guards

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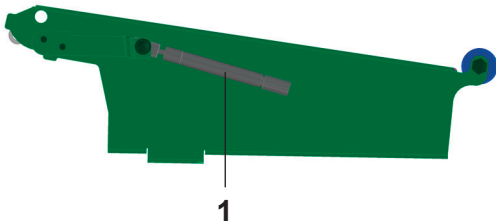
Safety guards (1) protect the operator from accidental contact with dangerous parts of the installation and moving elements.

The machine stops immediately when a safety guard (1) is opened. Raising the safety guards (1) even slightly must stop the machine. When the safety guards (1) are closed, the machine must not restart automatically.

After the machine has been stopped by opening a safety guard (1), the machine must be restarted.

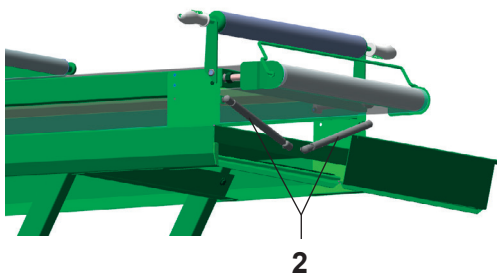
### 3.6.2.2 Gas spring

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The gas spring (1) protects the operator against the safety guard dropping.

[SSH673\*\*\*.\*]



The gas spring (2) protects the operator against the machine table dropping.



### 3.6.2.3 Warning label

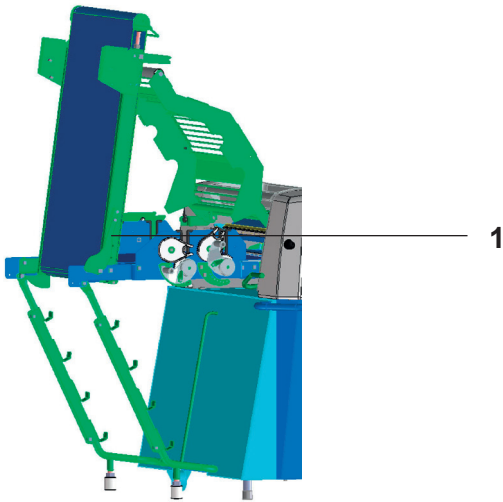
---

Warning labels on the machine warn the operator of imminent danger.

### 3.6.2.4 Cutomat: Locking lever [SSH67\*\*\*C.\*]

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The locking lever (1) protects the operator against the machine table dropping.

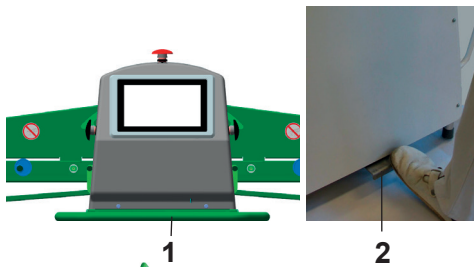


## 4 Putting into operation

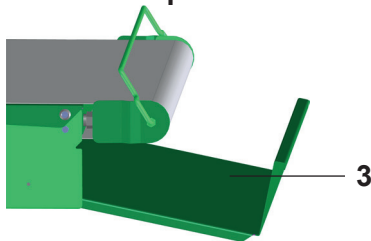
### 4.1 Preparing for standby



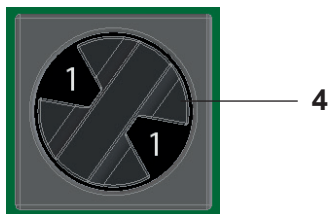
The entire machine must be thoroughly cleaned prior to initial operation.



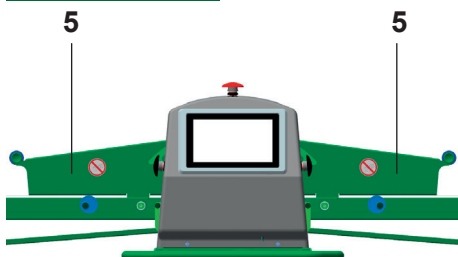
1. Lift the machine slightly using the guard tube (1).
2. Press the pedal (2) for the front transport roller with your foot.
3. Lower the machine gently to the ground, do not let it "fall".



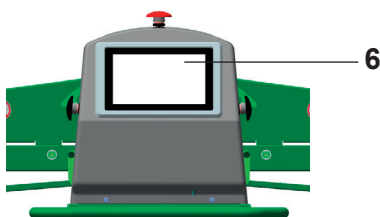
4. Pull out the dough catch pan (3) on both sides.
5. If necessary insert the flour catch pan on the infeed and outfeed belt.



6. Turn the main switch (4) of the machine to position "I".



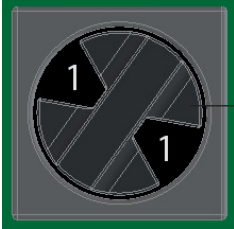
7. Fold both safety guards (5) down.



8. On the touch screen (6):
  - Select and load the desired program.

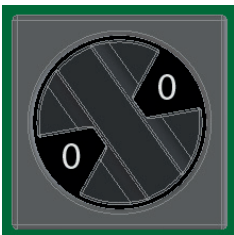
## 4.2 Switching the machine on / off

---



### Switching the machine on

Turn the main switch (1) on the substructure to position (I).



### Switch machine off

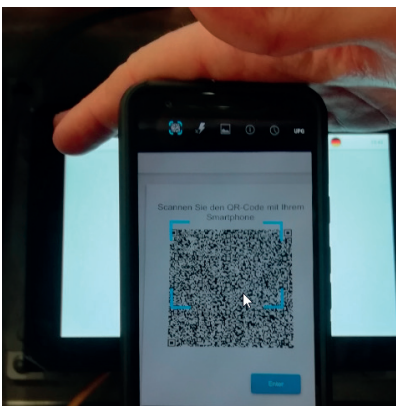
Turn the main switch (1) on the substructure to position (0).

## 4.3 Registering the machine

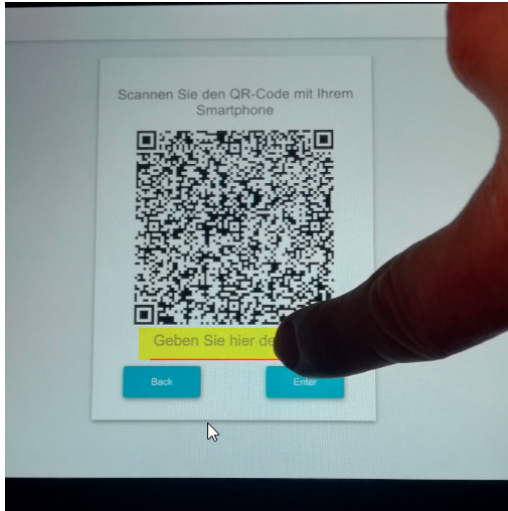
---

Requirements:

- Mobile device (smartphone, pad, etc.) with QR code scanning function is available.
- Mobile device with Internet connection is available.



1. Scan the QR code.
2. Tap Enter.
  - ▶ A new QR code is displayed on the touch screen.
3. Scan the new QR code.
  - ▶ Depending on the mobile device, you must tap on "Visit website".
  - ▶ A 64-digit code appears on the mobile device.



4. Tap the input field.



5. Either tap in the 64-digit code manually without spaces, or use the scanner to scan in the small QR code on the mobile device. To do this, plug the scanner into the USB interface. Scan in the QR code.

▶ The 64-digit code is entered in the input field.

6. Tap Enter.

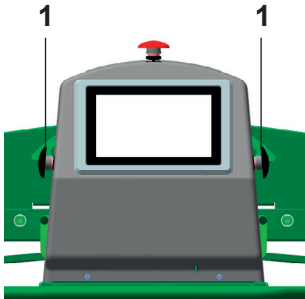
▶ The start process is displayed on the touch screen.

▶ The main screen is displayed.

▶ The registration process is complete.

## 4.4 Starting / stopping the machine

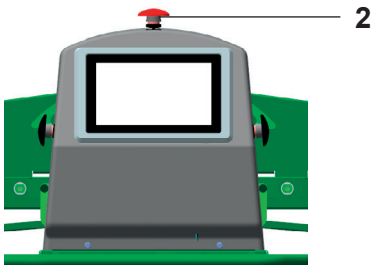
---



### Start machine

Press black mushroom button (1).

Press the black mushroom button on the side on which the dough is located on the conveyor belt.



### Stop machine

Press the red mushroom button (2).

## 5 Operation

### 5.1 General functional description

---

The dough sheeter is computer-controlled, equipped with a colour touch screen and suitable for sheeting and laminating pieces of dough.

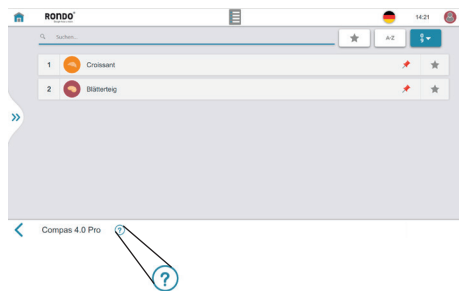
The important data for the operator is continuously shown on the touch screen during the sheeting process.

Thanks to the process visualisation the entire operation and programming is image-guided and therefore language-independent, making it easily understandable for everyone.

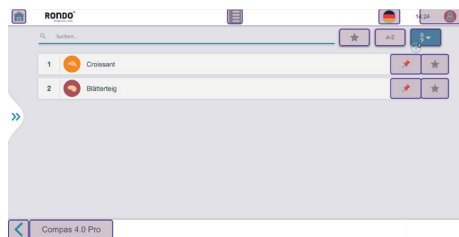
A total of 999 programs can be stored.

### 5.2 Explanatory texts

---



Drag the question mark symbol onto the highlighted areas to display the explanatory texts. Subsequently in this operating manual only information is described, which is supplementary to the explanatory texts or is not considered intuitive.



## 5.3 User

---

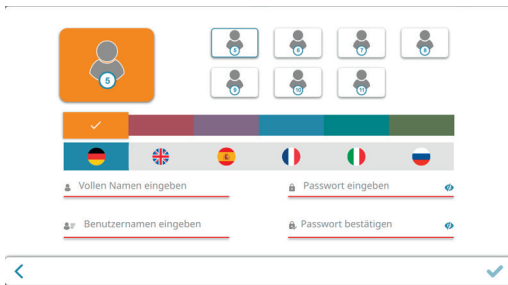
### 5.3.1 User levels

---

The following user levels are pre-programmed at the factory. Each higher user level inherits the access authorisations of the lower ones. The access authorisations are not exhaustively listed below.

No.	User level	Explanations
1	Operator	<ul style="list-style-type: none"> <li>• Not password-protected</li> <li>• Run programs</li> <li>• Perform daily corrections</li> </ul>
2	Foreman	<ul style="list-style-type: none"> <li>• Password-protected (initially: 222; change at first logon)</li> <li>• Create new programs and manage existing programs</li> <li>• Create new users and manage existing users</li> <li>• Display diagnostic information</li> <li>• Set parameters for dough processing</li> <li>• Set basic parameters for end function</li> </ul>
3	Service	<ul style="list-style-type: none"> <li>• Password-protected</li> <li>• Set parameters for advanced dough processing</li> <li>• Set parameters for end function</li> </ul>
4	Rondo Service	<ul style="list-style-type: none"> <li>• Password-protected</li> <li>• All options</li> </ul>

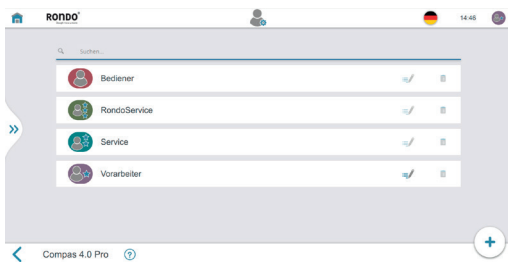
## 5.3.2 Create new user [foreman or higher]



You can create an unlimited number of users. These will have the access authorisations of the operator user level.

1. Open side tab.
2. Open user management menu.
3. Tap plus icon.
4. Enter the user's full name, user name, user colour, user language, user photo and password.
5. Tap the quality mark icon.
  - ▶ The new user is displayed in the user management.

## 5.3.3 Manage users [foreman or higher]



You can manage existing users at the operator user level.

1. Open side tab.
2. Open user management menu.
3. Tap the icon for editing the relevant program.
4. Change the user's full name, user name, user colour, user language, user photo and password.
5. Tap the quality mark icon.
  - ▶ The user has been changed.

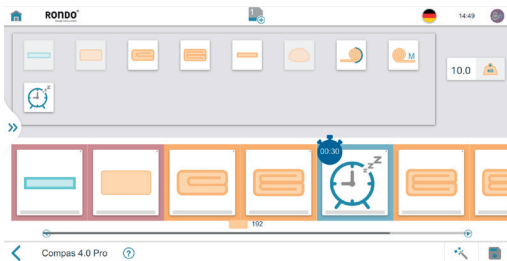


## 5.4 Programs

---

### 5.4.1 Create new program: Swipe-programming [foreman or higher]

---



For swipe-programming...

- you need advanced process know-how.
  - you compile the program steps freely in the desired order and in sequences.
1. Open side tab.
  2. Open program list.
  3. Tap plus icon.
  4. Enter dough weight.
  5. Compile program by dragging & dropping the program steps.
  6. Tap the program step and make the settings.  
(initial roller gap, final roller gap, width monitoring, roller reduction curve, speed, speed ratios, automatic flour duster, etc.) (also see 5.7 Process know-how)
  7. Tap the save icon.
  8. Select the program name, program number, program colour and the program image, if desired.
  9. Tap the save icon.
    - ▶ The program is saved.
    - ▶ The program appears in the program list.

Alternatively you can use the program wizard.

## 5.4.2 Create new program: Program wizard [foreman or higher]



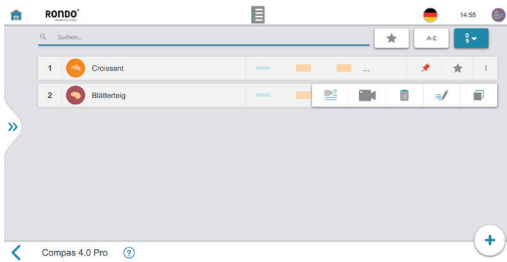
The program wizard...

- makes it easier to create the program. You select a product group. The program wizard guides you through the necessary settings.
- compiles the necessary program steps and sequences based on your settings.

1. Open side tab.
2. Open program list.
3. Tap plus icon.
4. Enter dough weight.
5. Tap the magic wand icon.
6. Select product group.
7. Detail dough weight.
8. Select number of fat layers where applicable.
9. Tap the quality mark icon.
10. Perform settings for final sheeting and the end functions.
11. Tap the quality mark icon.
12. Tap the save icon.
13. Select the program name, program number, program colour and the program image, if desired.
14. Tap the save icon.
  - ▶ The program is saved.
  - ▶ The program appears in the program list.

## 5.4.3 Copy program [foreman or higher]

---



1. Open side tab.
2. Open program list.
3. Tap the three point icon.
4. Tap the copy icon.
  - ▶ The save dialogue opens.
5. Enter the program name, program number, program colour and the program image, if desired.
6. Tap the save icon.
  - ▶ The program is saved.
  - ▶ The program appears in the program list.

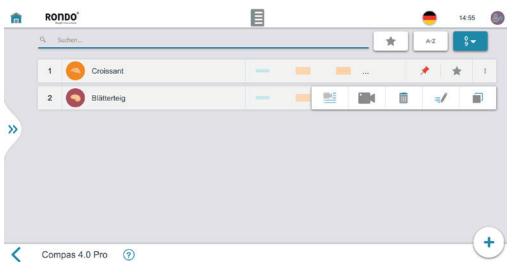
## 5.4.4 Permanently change program [foreman or higher]

---

1. Open side tab.
2. Open program list.
3. Open program.
4. Make changes.
5. Tap the save icon.
6. Follow further instructions where applicable.
  - ▶ The program is permanently changed.

## 5.4.5 Delete program [foreman or higher]

---

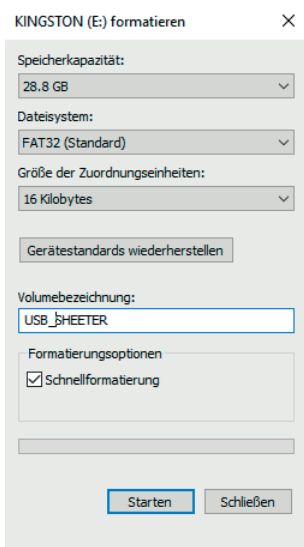


1. Open side tab.
2. Open program list.
3. Tap the three point icon.
4. Tap the recycle bin icon.
  - ▶ The delete dialogue opens.
5. Follow further instructions where applicable.
  - ▶ The program is deleted.

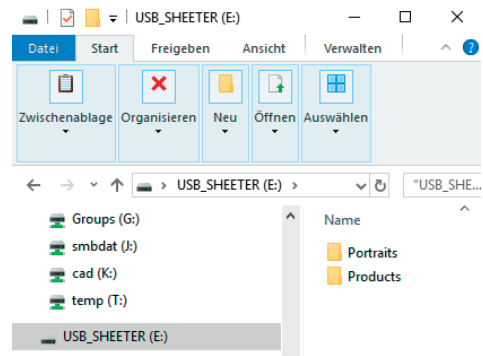
## 5.4.6 Preparing the USB stick [foreman or higher]

### Requirements for the USB stick

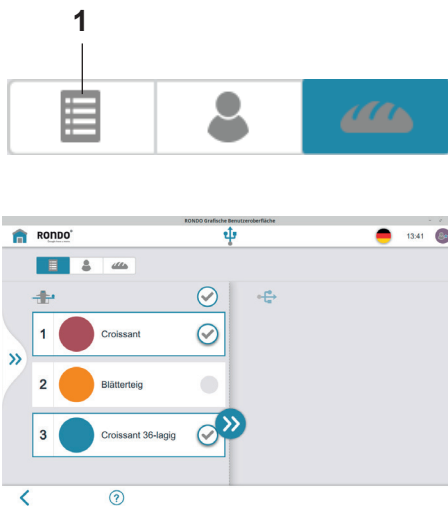
Storage capacity	8 GB
USB type	1.0 / 2.0 / 3.0



1. Format the USB stick: FAT 32
2. Create folder: "Portraits"
3. Create folder: "Products"



## 5.4.7 Saving a program on the USB stick [foreman or higher]



1. Prepare the USB stick.  
See chapter 5.4.6 Preparing the USB stick [foreman or higher]
2. Insert the USB stick into the interface.
3. Log on as foreman. Otherwise you will have no read authorisation.
4. Tap import/export programs.  
▶ The import/export pop-up opens automatically. Otherwise tap the USB icon in the program list.
5. Tap the program list icon (1).
6. Select the program to be saved from the left-hand column.  
(Multiple selection is possible)
7. Tap the double arrow icon.
8. Follow further instructions where applicable.  
▶ The program is saved on the USB stick.
9. Remove USB stick from the interface.

## 5.4.8 Load program from USB stick [foreman or higher]

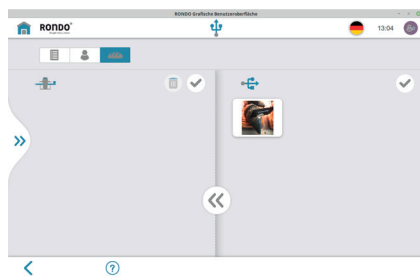


1. Prepare the USB stick.  
See chapter 5.4.6 Preparing the USB stick [foreman or higher]
2. Insert the USB stick into the interface.
3. Log on as foreman. Otherwise you will have no read authorisation.
4. Tap import/export programs.  
▶ The import/export pop-up opens. Otherwise tap the USB icon in the program list.
5. Tap the list icon (1).
6. Select relevant programs from the right-hand column.  
(Multiple selection is possible)
7. Tap the double arrow icon.
8. Follow further instructions where applicable.  
▶ The program is saved on the machine.
9. Remove USB stick from the interface.

## 5.4.9 Load product image / portrait from USB stick [foreman or higher]

### Requirements for product image / portrait

File format	PNG, SVG, JPG
File size (maximum)	500KB
Image size (recommended)	200 x 200 pixel
Image size (maximum)	2000 x 2000 pixel



1. Prepare the USB stick.  
See chapter 5.4.6 Preparing the USB stick [foreman or higher]
2. Copy product image to the “Products” folder on the USB stick.
3. Copy portrait to the “Portraits” folder on the USB stick.
4. Insert the USB stick into the interface.
5. Log on as foreman. Otherwise you will have no read authorisation.
6. Tap import product image / portrait.  
▶ Import pop-up opens. Otherwise tap the USB icon in the program list.
7. Tap bread icon / person icon.
8. Select relevant image from the right-hand column.
9. Tap the double arrow icon.
10. Follow further instructions where applicable.  
▶ The program image is saved on the machine.
11. Remove USB stick from the interface.

## 5.5 Sheeting

---

- The machine must be started on the side on which the dough is located.
- The initial roller gap should be 5 mm less than the dough.

### 5.5.1 Working in production mode

---



1. Open side tab.
2. Open program list.
3. Select the desired program.
4. Tap the desired sequence.
  - ▶ The sequence is highlighted.
5. Position the dough.
6. Press the black mushroom button on the dough side.
  - ▶ Machine starts.

#### 5.5.1.1 Re-entering the sequence from a defined program step

---

1. Open side tab.
2. Open program list.
3. Select the desired program.
4. Tap and hold the desired program step.
  - ▶ The sequence is highlighted from the re-entry point.
5. Position the dough.
6. Press the black mushroom button on the dough side.
  - ▶ Machine starts.
  - ▶ The sequence is processed from the re-entry point.
  - ▶ The sequence is highlighted and is ready for complete processing.

## 5.5.1.2 Performing daily corrections



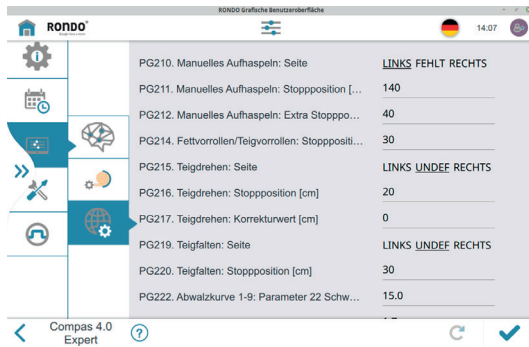
The program can be temporarily changed with daily corrections by any user. When you exit the program, the daily corrections are deleted. Daily corrections can be saved by the foreman or users with higher authorization. The following daily corrections are possible:

- Initial roller gap
  - Automatic width monitoring system
  - Activate/deactivate automatic flour duster
  - Final roller gap
  - Roller reduction curve
  - etc.
1. Open side tab.
  2. Open program list.
  3. Select the desired program.
  4. Tap the desired sequence.
    - ▶ The sequence is highlighted
  5. Tap the program step to be changed.
    - ▶ The program step settings open.
  6. Carry out settings.
    - ▶ Changed settings are highlighted with a yellow triangle.
  7. Tap the quality mark icon.
    - ▶ The daily correction is performed.



## 5.6 Settings

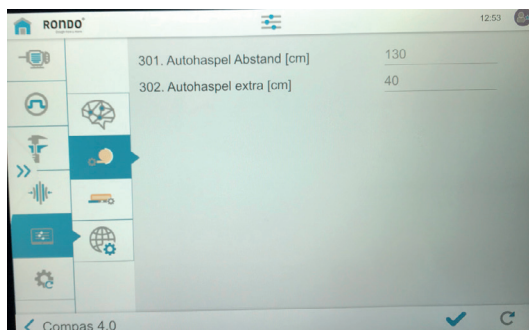
### 5.6.1 Set parameters: Dough processing [foreman or higher]



The parameters are preset at the factory. Only change them if absolutely essential. Only change them if you know their function. If the explanatory texts are inadequate, contact customer service.

1. Open side tab.
2. Open the settings menu.
3. Open the parameter list.
4. Tap global parameters.
5. Set parameters.

### 5.6.2 Set parameters: End function [foreman or higher]



The parameters are preset at the factory. Only change them if absolutely essential. Only change them if you know their function. If the explanatory texts are inadequate, contact customer service.

1. Open side tab.
2. Open the settings menu.
3. Open the parameter list.
4. Tap automatic reeling device or transfer.
5. Set parameters.

## 5.7 Process know-how

---

Dough is a living thing. Different tensions develop, depending on the recipe and temperature of the dough. Different masses and weights may therefore differ from reality.

### 5.7.1 Automatic width monitoring system: At roller gap

---



This function enables pre-rolling of the dough to a desired width. The width is obtained here by means of a selected roller gap. The machine sheets the dough to the selected roller gap. The machine stops so that the dough block can be turned by 90°. After restarting the machine with the black mushroom button, the machine sheets the dough block to the set final roller gap.

This function requires regular dough blocks, in order to obtain a reliable and reproducible result.

### 5.7.2 End function

---

#### 5.7.2.1 Manual reeling

---

After sheeting, the dough stops at a position which is predefined in the parameters. The reeler holders must be folded up. The dough reeler must be positioned and the dough rolled around the dough reeler. After restarting, the dough is reeled onto the dough reeler.

#### 5.7.2.2 Automatic reeling

---

To enable stress-free reeling, the reeling speed must be reduced. For very delicate doughs, the time for the slow process can be adapted so that the entire dough band is reeled at this speed.

#### 5.7.2.3 Transferring to downstream machine

---

After sheeting, the dough stops at a position predefined in the parameters, if the start signal for the downstream line is not available. After the start signal has been given to the downstream line, the dough is transferred to the downstream machine.

### 5.7.3 Dough retention arm

---

During final sheeting the dough band is placed in the dough catch pan. During removal, the dough band may turn over at the end. When fitted and folded upwards, the dough retention arm prevents this.

## 5.8 Automatic flour duster [variant SSH670\*\*.\*][standard SSH672\*\*\*.\*, SSH673\*\*\*.\*]



Do not touch the delivery roller of the automatic flour duster with hands or any other objects when it is in operation!



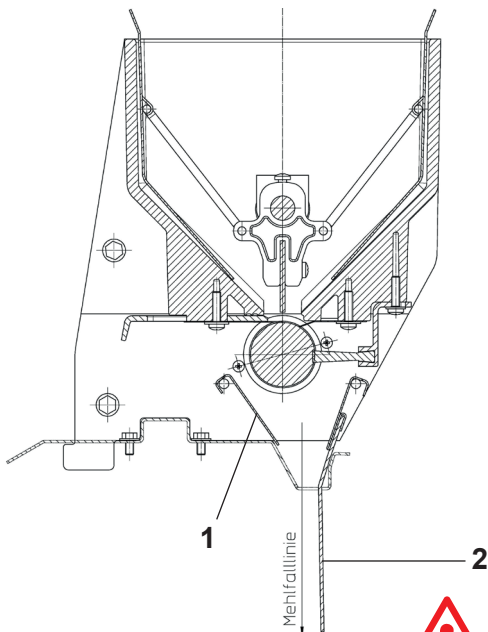
To prevent breathing difficulties and flour dust allergies, the machine should be equipped with an automatic flour duster. Never use more flour than strictly necessary. Do not use compressed air for cleaning. Using a dust extraction system in the bakehouse is recommended.

### General information

(Switching the automatic flour duster on/off; see 5.5.6 Switching the automatic flour duster on/off).

The programmable automatic flour duster enables uniform dusting of dough bands with flour, with minimal flour dust generation.

Observe proper use of the machine and the provided flour dust guards.



### Functional description

A rotating delivery roller picks up the flour from the container. The flour is then knocked off the roller by a brush and distributed over the dough band.

Various loosening aids are fitted inside the container, to prevent undesired compacting of the flour.

A flour dust guard (2) and a protective plate (1) are loosely mounted beneath the dusting container.



**The automatic flour duster must not be operated without the flour dust guard!**

To ensure perfect functioning, flour type no. 550 is recommended.

### Setting the dusting width

The dusting width is set by opening and closing the slides to the desired dusting width.

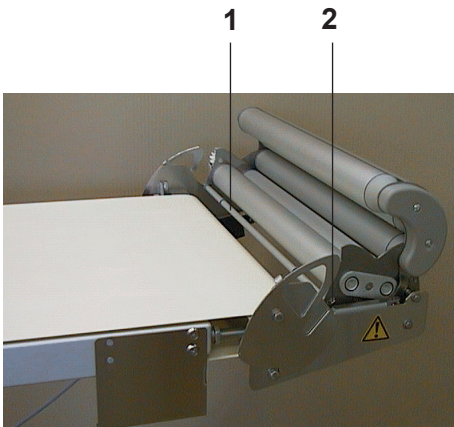
## 5.9 Automatic reeling device [SSH67\*7H\*.\*]

### Function of the automatic reeling device



The automatic reeling device is started automatically by the electrical control. Handle with care! Do not reach into the stationary or running device!

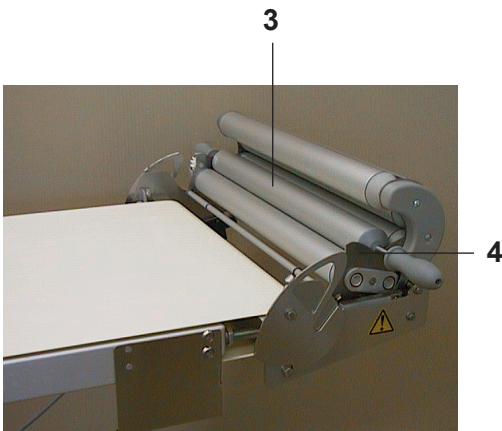
Basic position of the automatic reeling device (open).



### Dough retention bail (1)

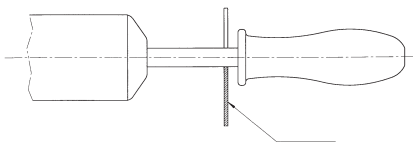
If, when sheeting large dough blocks, the dough band does not run through the opening between the machine table and the reeling device, but pushes against the dough retention arm (1), this can be removed.

- Loosen and remove the plastic screw (2).



### Side plate (4)

- Insert the dough reeler (3) correctly into the side plates (4).



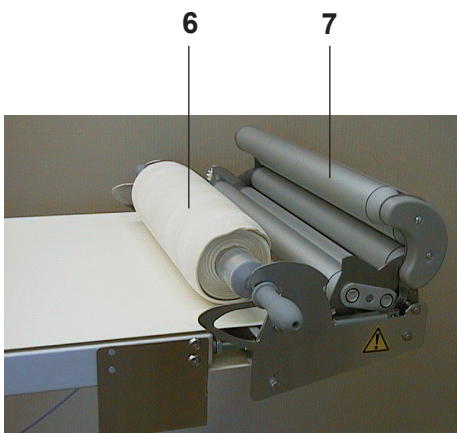
Side plates



Working position of the automatic reeling device (closed)

5

Before the last pass of the dough through the roller in a program with activated reeler, the reeling device (5) closes automatically. The device folds down, and the dough reeler is held with the lower and upper rollers (7).



The dough band is reeled up, and the upper rollers (7) swing up.

At the end of the sheeting process, the device swivels back into its basic position.

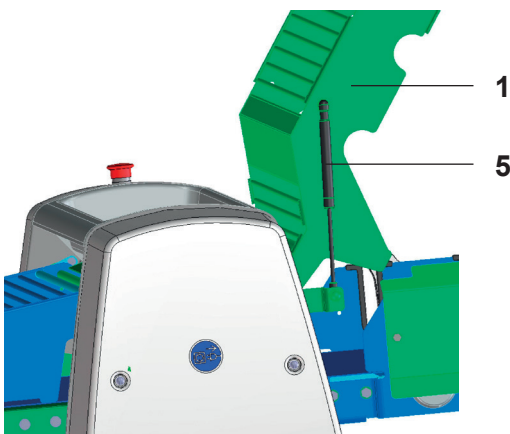
The reeled dough band (6) remains on the machine table.

## 5.10 Cutomat with cutting station [SSH67\*\*\*C.\*]

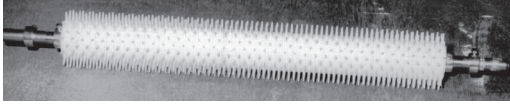
### Safety guards

The cutting equipment is covered by a safety guard (1).

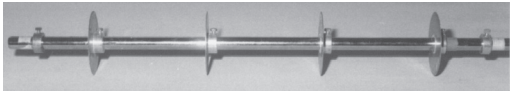
**A defective gas spring (5) on the safety guard (1) must be replaced immediately! Reason: Risk of injury from falling safety guard!**



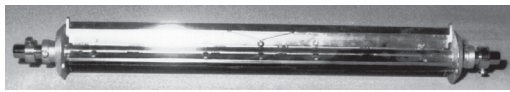
## 5.10.1 Cutting roller types



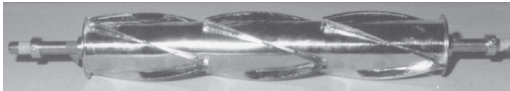
**Push roller**



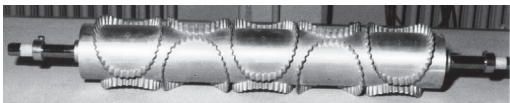
**Length cutting roller**



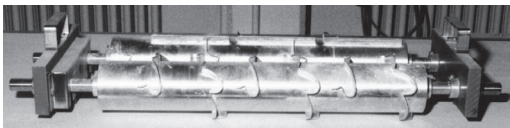
**Cross cutting roller**



**Zig-zag cutting roller**

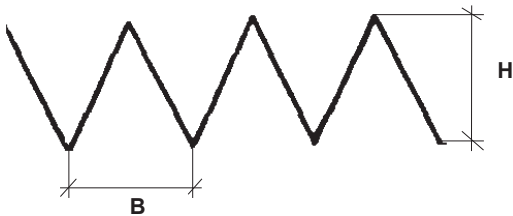


**Form cutting roller**



**Tandem cutting roller**

Standard dimensions for stainless-steel zig-zag cutting rollers for triangles.

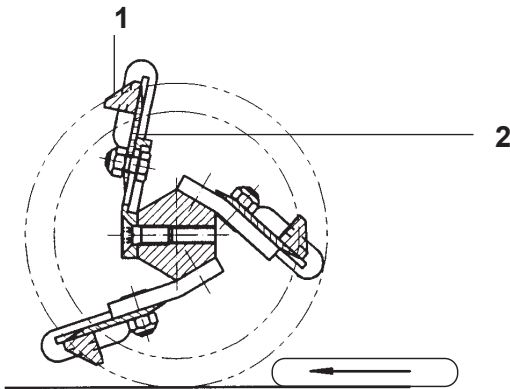


<b>B</b>	<b>H</b>	<b>Number of Rows</b>
120	105	5
140	180	3
180	140	4
180	100	5

## 5.10.2 Inserting the cutting rollers



**Danger of injury on the sharp cutting edges of the cutting rollers!**



The cutting rollers must be inserted in the running direction of the dough in the following sequence:

### a) For rectangles / squares

First cut lengthwise, then crosswise.

In order to ensure trouble-free working with the cross cutting roller, it must be inserted into the cutting station in such a way that the dough band is first cut with the cutting knife (2) and then ejected by the ejector (1).

### b) For triangles

First use zig-zag cutting, then length cutting.



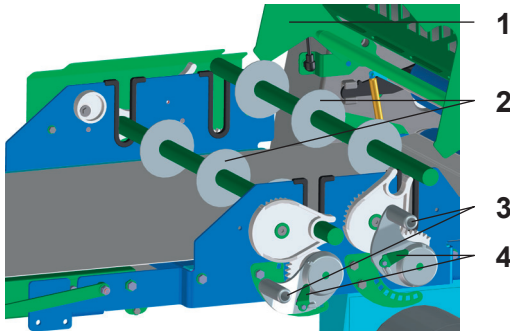
**Cutting rollers not being used must be stored in the repository provided for this purpose.**

**Reason: This will prevent damage to the cutting knives. Injury to the operator will also be prevented.**

## 5.10.3 Lowering the cutting rollers



Close the safety guard (1)



1. Lift the tension lever (3) slightly and turn the stop lever (4) anti-clockwise to the limit stop.
2. Lower the tension lever (3) gradually until the cutting roller (2) rests on the conveyor belt.

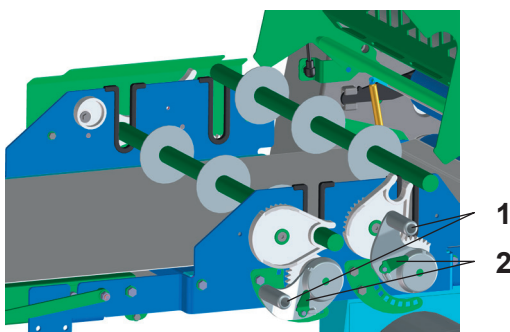
The further down the tension lever (3) is lowered, the greater the cutting pressure.



**When using a length cutting roller, make sure to watch out for the following:**

**As soon as the length cutting rollers touch down on the conveyor belt, lower the tension lever by no more than 2 steps, otherwise the belt may be cut.**

## 5.10.4 Lifting the cutting rollers



1. Gently push down the tension lever (1).
2. Turn the stop lever (2) clockwise to the limit stop.
3. Release the tension lever (1) and lift it to the limit stop.



## 5.10.5 Cutting

---

- The “Dough cutting” program step must be added to the program as an end function.
  - Immediately before cutting, the width of the dough band must correspond to the length of the cutting roller to be used plus approx. 1–2 cm on both sides.
  - The roller gap must be sufficiently open while cutting. This prevents the dough from jamming. The roller gap can be influenced by the foreman or higher during the cutting and transferring processes using parameter PC211.
1. Insert the cutters.  
(See chapter 5.10.2 Inserting the cutting rollers).
  2. Create and/or manage program.
  3. Position the dough.
  4. Press the black mushroom button on the dough side.
    - ▶ Machine starts.
    - ▶ Program is processed.
    - ▶ “Lower cutting roller” pop-up opens.
  5. Press the black mushroom button on the dough side.
    - ▶ Machine starts.
  6. Lower cutting roller at the right moment.  
(See chapter 5.10.3 Lowering the cutting rollers)
    - ▶ Dough is cut.

## 5.11 RONDOconnect [Technician or higher]

---



If a machine is connected to a network, the operating company is responsible for the network security and network infrastructure.

RONDOconnect comprises the following components:

- The RONDOconnect gateway is the hardware required for connecting to the WIFI.
- The RONDOconnect Customer Dashboard is used to display the current machine data.
- RONDOconnect Customer Care Services enables remote access to the machine so that the RONDO Service Centre can provide you with optimum support.
- RONDOconnect Doug-how Services enables RONDO technicians to access the display (touch screen) remotely. They can provide you with optimum support when it comes to process issues.
- With RONDOconnect MES/ERP connectivity, you can connect your machine to an MES/ERP system and exchange data via the standardised OPC UA interface.

## 5.11.1 Establishing the basic requirements

---



**The customer is responsible for the IT and network infrastructure.**

Make sure that the following requirements are met:

- WIFI with internet connection.
- Mobile Android or iOS device.
- cMT Viewer app installed on the terminal. Available to download from the Google Playstore or Apple app store.
- Basic IT knowledge for gateway settings.



## 5.11.2 Connecting a machine to the WIFI

You can use a static or dynamic IP (DHCP).



1. Open side tab.
2. Open the settings menu.
3. Tap Gateway.
4. Enter the SSID of the WIFI.

### Attention!

Enter the SSID password spaces.

**Danger:** No connection can be established.

5. Enter the SSID password.
  - ▶ The machine is connected to the WIFI.
  - ▶ The signal strength, SSID and MAC address of the connected WIFI are displayed.
6. In the event of connection issues:
  - a) Enter the country code that is provided in the table and repeat the procedure from step 4 onwards.
  - b) Contact the service centre.

Country	Code	Country2	Code2	Country3	Code3	Country4	Code4	Country5	Code5
Afghanistan	AF	Colombia	CO	Hungary	HU	Mozambique	MZ	Singapore	SG
Aland Islands	AX	Comoros	KM	Iceland	IS	Myanmar	MM	Slovakia	SK
Albania	AL	Congo (Brazzaville)	CG	India	IN	Namibia	NA	Slovenia	SI
Algeria	DZ	Congo, (Kinshasa)	CD	Indonesia	ID	Nauru	NR	Solomon Islands	SB
American Samoa	AS	Cook Islands	CK	Iran, Islamic Republic of	IR	Nepal	NP	Somalia	SO
Andorra	AD	Costa Rica	CR	Iraq	IQ	Netherlands	NL	South Africa	ZA
Angola	AO	Côte d'Ivoire	CI	Ireland	IE	Netherlands Antilles	AN	South Georgia and the South Sandwich Islands	GS
Anguilla	AI	Croatia	HR	Isle of Man	IM	New Caledonia	NC	South Sudan	SS
Antarctica	AQ	Cuba	CU	Israel	IL	New Zealand	NZ	Spain	ES
Antigua and Barbuda	AG	Cyprus	CY	Italy	IT	Nicaragua	NI	Sri Lanka	LK
Argentina	AR	Czech Republic	CZ	Jamaica	JM	Niger	NE	Sudan	SD
Armenia	AM	Denmark	DK	Japan	JP	Nigeria	NG	Suriname	SR
Aruba	AW	Djibouti	DJ	Jersey	JE	Niue	NU	Svalbard and Jan Mayen Islands	SJ
Australia	AU	Dominica	DM	Jordan	JO	Norfolk Island	NF	Swaziland	SZ
Austria	AT	Dominican Republic	DO	Kazakhstan	KZ	Northern Mariana Islands	MP	Sweden	SE
Azerbaijan	AZ	Ecuador	EC	Kenya	KE	Norway	NO	Switzerland	CH
Bahamas	BS	Egypt	EG	Kiribati	KI			Syrian Arab Republic (Syria)	SY
Bahrain	BH	El Salvador	SV	Korea (North)	KP	Oman	OM	Taiwan, Republic of China	TW
Bangladesh	BD	Equatorial Guinea	GQ	Korea (South)	KR	Pakistan	PK	Tajikistan	TJ
Barbados	BB	Eritrea	ER	Kuwait	KW	Palau	PW	Tanzania, United Republic of	TZ
Belarus	BY	Estonia	EE	Kyrgyzstan	KG	Palestinian Territory	PS	Thailand	TH
Belgium	BE	Ethiopia	ET	Lao PDR	LA	Panama	PA	Timor-Leste	TL
Belize	BZ	Falkland Islands (Malvinas)	FK	Latvia	LV	Papua New Guinea	PG	Togo	TG
Benin	BJ	Faroe Islands	FO	Lebanon	LB	Paraguay	PY	Tokelau	TK
Bermuda	BM	Fiji	FJ	Lesotho	LS	Peru	PE	Tonga	TO
Bhutan	BT	Finland	FI	Liberia	LR	Philippines	PH	Trinidad and Tobago	TT
Bolivia	BO	France	FR	Libya	LY	Pitcairn	PN	Tunisia	TN
Bosnia and Herzegovina	BA	French Guiana	GF	Liechtenstein	LI	Poland	PL	Turkey	TR
Botswana	BW	French Polynesia	PF	Lithuania	LT	Portugal	PT	Turkmenistan	TM
Bouvet Island	BV	French Southern Territories	TF	Luxembourg	LU	Puerto Rico	PR	Turks and Caicos Islands	TC
Brazil	BR	Gabon	GA	Macedonia, Republic of	MK	Qatar	QA	Tuvalu	TV
British Virgin Islands	VG	Gambia	GM	Madagascar	MG	Réunion	RE	Uganda	UG
British Indian Ocean Territory	IO	Georgia	GE	Malawi	MW	Romania	RO	Ukraine	UA
Brunei Darussalam	BN	Germany	DE	Malaysia	MY	Russian Federation	RU	United Arab Emirates	AE
Bulgaria	BG	Ghana	GH	Maldives	MV	Rwanda	RW	United Kingdom	GB
Burkina Faso	BF	Gibraltar	GI	Mali	ML	Saint-Barthélemy	BL	United States of America	US
Burundi	BI	Greece	GR	Malta	MT	Saint Helena	SH	US Minor Outlying Islands	UM
Cambodia	KH	Greenland	GL	Marshall Islands	MH	Saint Kitts and Nevis	KN	Uruguay	UY
Cameroun	CM	Grenada	GD	Martinique	MQ	Saint Lucia	LC	Uzbekistan	UZ
Canada	CA	Guadeloupe	GP	Mauritania	MR	Saint-Martin (French part)	MF	Vanuatu	VU
Cape Verde	CV	Guam	GU	Mauritius	MU	Saint Pierre and Miquelon	PM	Venezuela (Bolivarian Republic)	VE
Cayman Islands	KY	Guatemala	GT	Mayotte	YT	Saint Vincent and Grenadines	VC	Viet Nam	VN
Central African Republic	CF	Guernsey	GG	Mexico	MX	Samoa	WS	Virgin Islands, US	VI
Chad	TD	Guinea	GN	Micronesia, Federated States of	FM	San Marino	SM	Wallis and Futuna Islands	WF
Chile	CL	Guinea-Bissau	GW	Moldova	MD	Sao Tome and Principe	ST	Western Sahara	EH
China	CN	Guyana	GY	Monaco	MC	Saudi Arabia	SA	Yemen	YE
Hong Kong, SAR China	HK	Haiti	HT	Mongolia	MN	Senegal	SN	Zambia	ZM
Macao, SAR China	MO	Heard and McDonald Islands	HM	Montenegro	ME	Serbia	RS	Zimbabwe	ZW
Christmas Island	CX	Holy See (Vatican City State)	VA	Montserrat	MS	Seychelles	SC		
Cocos (Keeling) Islands	CC	Honduras	HN	Morocco	MA	Sierra Leone	SL		

### 5.11.3 Registering the machine for RONDOconnect

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In order to use RONDOconnect and receive optimum after-sales service, registration is required.

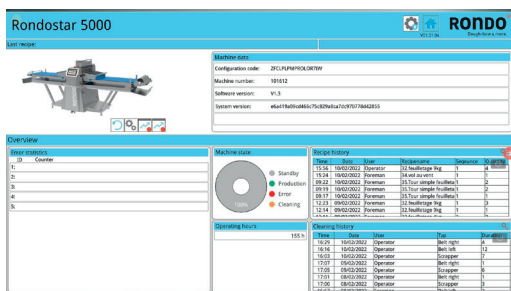
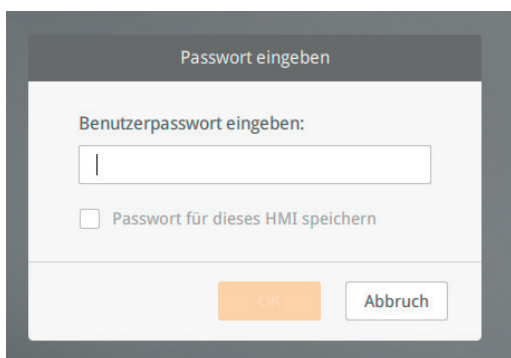
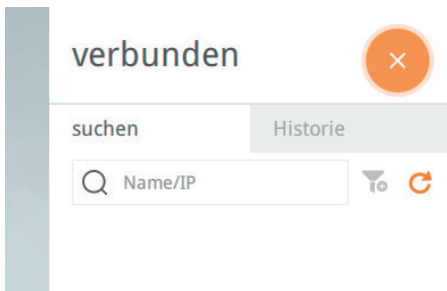
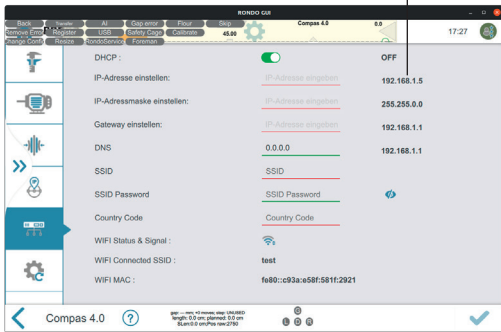
Precondition:

- 5.11.2 Connecting a machine to the WIFI

1. Open side tab.
2. Open the settings menu.
3. Tap Gateway.
4. Tap Register.
5. Enter the company name.
6. Enter the company email address.
7. Enter the contact person.
8. Enter the contact person's email address.
9. Confirm terms and conditions.

## 5.11.4 Displaying the customer dashboard: via WIFI

1



Precondition:

- 5.11.1 Establishing the basic requirements
- 5.11.2 Connecting a machine to the WIFI

1. Open side tab.
2. Open the settings menu.
3. Tap Gateway.
4. Note the IP address (1).
5. Connect a mobile device to the WIFI.
6. Open the cMT-Viewer app on the mobile device.
7. Tap the plus icon in the top-right corner of the screen.
8. When accessing the dashboard from the mobile device for the first time:  
Enter the IP address you have noted and confirm with Enter.
9. When accessing the dashboard from the mobile device at a later time:  
Tap on the current IP address in the history and confirm with Enter.

10. Enter the password 111111 and confirm with “OK”.

11. Wait until the customer’s dashboard is displayed.

## 5.11.5 Using the customer dashboard

The customer dashboard shows the current machine data for the last 30 days. It offers the following benefits, but this list of benefits is not exhaustive:

- The recipe history shows which products were produced when and by whom.
- The cleaning history provides proof of compliance with hygiene regulations.
- The operating hours counter and machine state show how high the productivity of the machine is. Furthermore, they provide the basis for preventive maintenance and optimal operation of the machine.
- Error statistics and chronological diagrams of various machine components can assist with error analysis and lead to quicker troubleshooting.

Rondostar 5000

Dough-how & more.

Last recipe:

V01.01.04

Machine data

Configuration code:	ZFCLPLPMPROLOR7IW
Machine number:	101612
Software version:	V1.3
System version:	e6a419a09cd466c75c829a8ca7dc970778d42855

Overview

Error statistics

ID	Counter
1:	
2:	
3:	
4:	
5:	

Machine state

100%

- Standby
- Production
- Error
- Cleaning

Recipe history

Time	Date	User	Recipename	Sequence	Quantity
15:56	10/02/2022	Operator	32.feuilletage 9kg	1	4
15:24	10/02/2022	Foreman	34.vol au vent	1	1
09:22	10/02/2022	Foreman	35.Tour simple feuilleta	1	2
09:19	10/02/2022	Foreman	35.Tour simple feuilleta	1	2
09:17	10/02/2022	Foreman	35.Tour simple feuilleta	1	1
12:23	09/02/2022	Foreman	32.feuilletage 9kg	1	3
12:14	09/02/2022	Foreman	32.feuilletage 9kg	1	1

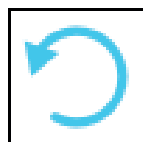
Operating hours

155 h

Cleaning history

Time	Date	User	Typ	Duration
16:29	10/02/2022	Operator	Belt right	4
16:16	10/02/2022	Operator	Belt left	12
16:03	10/02/2022	Operator	Scrapper	7
17:07	09/02/2022	Operator	Belt right	1
17:05	09/02/2022	Operator	Scrapper	6
17:01	08/02/2022	Operator	Belt right	1
17:00	08/02/2022	Operator	Scrapper	3

### 5.11.5.1 Operating elements



It is possible to zoom in on certain elements of the customer dashboard. To return to the initial overview, tap the three-quarter circle icon.

## 5.11.5.2 Recipe history

**Completed quantity in the sequence**

**Sequence**

**Recipe name**

**Operator**

Recipe history					
Time	Date	User	Recipename	Sequeunce	Quantity
17:17	17/03/2021	RONDO Tech	1.Croissant	1	12
16:27	17/03/2021	Operator	1.Croissant 60g	1	1
12:29	16/03/2021	Operator	32.טאָרנען	1	1
12:27	16/03/2021	Operator	יארנאָג 31	1	1
08:34	16/03/2021	Foreman	33.Fat	1	3
18:16	15/03/2021	RONDO Tech	1.Croissant	2	2
18:12	15/03/2021	RONDO Tech	1.Croissant	1	4
18:02	15/03/2021	RONDO Tech	1.Croissant	1	1
15:07	15/03/2021	Operator	1.Croissant	1	2

## 5.11.5.3 Cleaning history

If the cleaning duration is zero minutes, the cleaning page was opened only briefly.

**Cleaning duration [min]**

**Part cleaned**

**Operator**

Cleaning history				
Time	Date	User	Typ	Duration
11:26	15/03/2021	Operator	Scrapper	1
11:24	15/03/2021	Operator	Belt right	3



## 5.11.5.4 Machine data

The configuration code, machine number, software version and system version facilitate communication with the service centre.

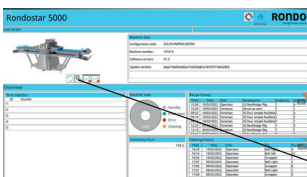
Machine data	
Configuration code:	ZFCLPLMPROLOR7IW
Machine number:	101612
Software version:	V1.3
System version:	e6a419a09cd466c75c829a8ca7dc970778d42855



## 5.11.5.5 Customer data

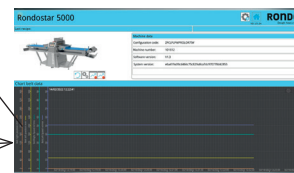
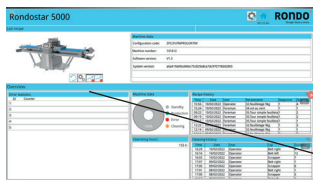
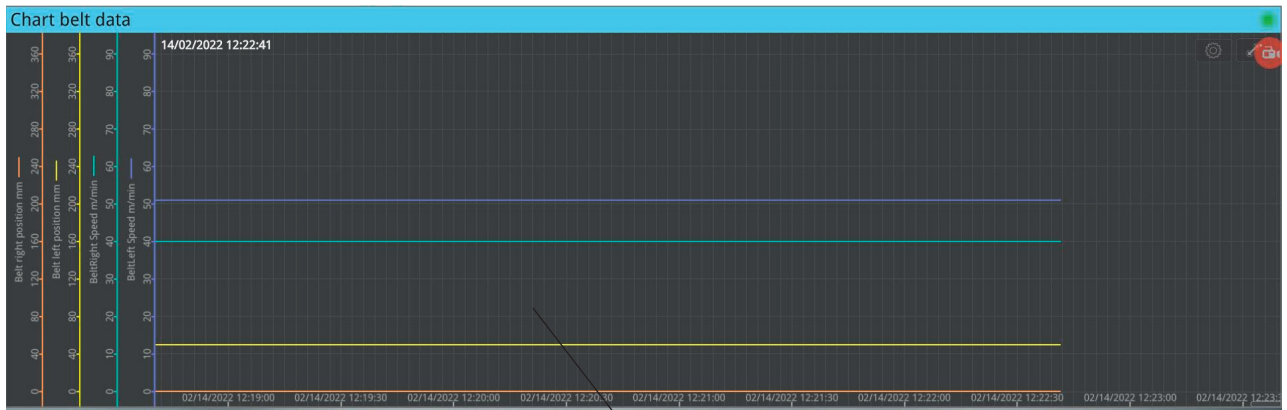
Overview of the stored customer data from machine registration.

Customer data	
Surname:	Registration not completed
First name:	
Email:	
Country:	
Location:	
Postcode:	
Address:	
Company:	
Position:	
Tel. no.:	
GMT time zone (minute)	120 min



## 5.11.5.6 Chart production

Chronology of the data recorded for a machine component.



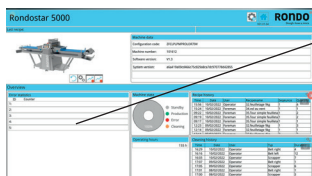
## 5.11.5.7 Error statistics

Errors are listed according to the frequency of their occurrence. Thus, errors that occur frequently appear at the top.

**Count**

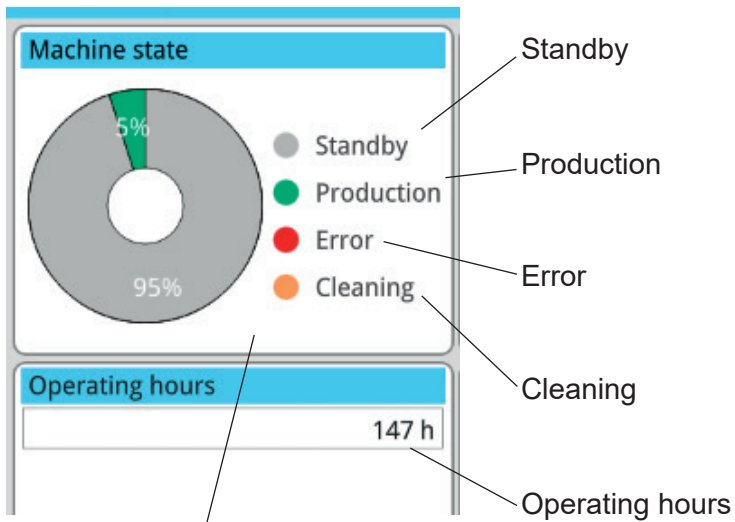
**Error number**

Error statistics	
ID	Counter
1: 0000	4
2: 0	0
3: 0	0
4: 0	0
5: 0	0



## 5.11.5.8 Operating hours counter and machine state

The donut chart displays the machine state over the last four hours.



## 6 Cleaning

### 6.1 Cleaning

---



Authorised use also means that users must follow all instructions prescribed by the manufacturer in regard to operation, maintenance and service.



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



To prevent breathing difficulties and flour dust allergies, the machine must be equipped with an automatic flour duster. Never use more flour than strictly necessary. Do not use compressed air for cleaning. Using a dust extraction system in the bakehouse is recommended.



The machine must never be cleaned using spray water, a high-pressure cleaner, steam-cleaning machine or any similar cleaning methods!



Before beginning any cleaning work, stop the machine and interrupt the power supply to the machine (pull out the mains plug). Exceptions:

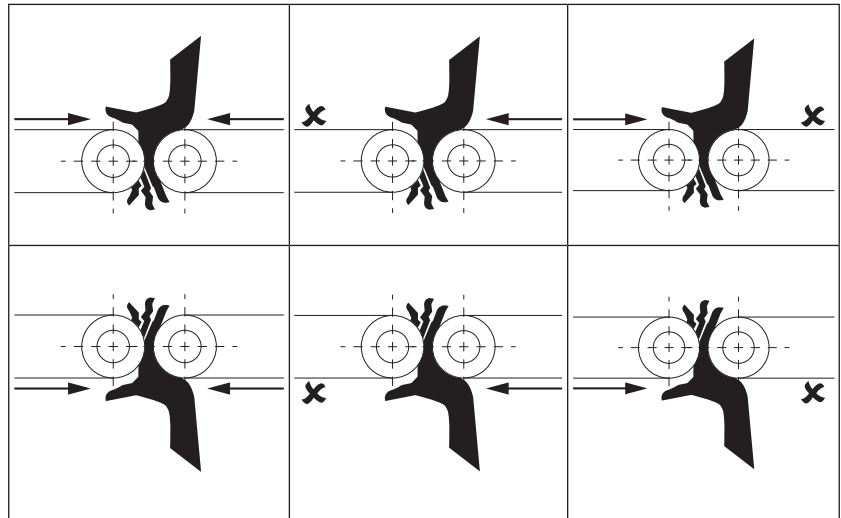
- Cleaning the rollers in intermittent operation.
- Cleaning the top of the conveyor belt in continuous operation



Pinch points can occur on adjacent bands, belts or chains as follows (view from above or below):

- One side stationary, the other running
- Both sides running

Keep limbs and objects away from pinch points.



Areas that are difficult to access must be regularly freed of flour residues, dough scraps and dirt to maintain hygiene.



Cutting rollers may only be lowered when the safety guard is closed.



Due to the risk of injury at the sharp edges, cutting rollers must be replaced carefully and correctly. Wear suitable protective gloves to prevent injuries. Cutting rollers that are outside the cutting point must be placed in the holding brackets beneath the machine table.

## 6.1.1 Care

Part	Chapter	daily *	weekly *
Machine body + substructure	6.1.1.1 Machine body and substructure	B	A
Safety guards	6.1.1.2 Safety guards		A
Light barrier / sensor wiper	6.1.1.3 Light barrier / sensor wiper		B
Scrapers / rollers	6.1.1.4 Scrapers / Rollers	A	
Conveyor belts: Top	6.1.1.5 Conveyor belts: Top	C	
Conveyor belt: Underside / machine tables / drive roller / idle roller	6.1.1.6 Conveyor belts: underside / machine table / drive roller / idle roller		C
Table supports	6.1.1.7 Table supports		A
Flour catch sheets	3.3 Full view of the machine	B	
Dough catch pans	2.5.7 Mounting the dough catch pans	B	
Automatic flour duster	6.1.1.11 Automatic flour duster [variant SSH670**.*][standard SSH672***.*, SSH673***.*]	B	
Automatic reeling device	2.5.13 Mounting the automatic reeling device [SSH67* 7H*.*]	A	
Touch screen	6.1.1.10 Touch screen	D	
Cutting rollers	5.10.2 Inserting the cutting rollers	B	



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

### \*Legend

- A Damp clean with a cloth and soapy water.
- B Dry clean with a brush.
- C Remove dough scraps with a horn scraper (plastic).
- D Clean with window cleaner.

## 6.1.1.1 Machine body and substructure

---

- Damp clean the machine body and substructure weekly with a brush / cloth and soapy water.

Also see 3.3 Full view of the machine

## 6.1.1.2 Safety guards

---

- Damp clean the safety guards weekly with a brush / cloth and soapy water.

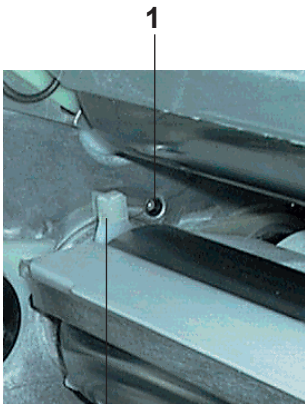
## 6.1.1.3 Light barrier / sensor wiper

---



**Never clean the light barrier / sensor wiper when the machine is running!**

- Dry clean the light barrier / sensor weekly with a brush.



The light barrier (1) installed in the machine is cleaned automatically with the light barrier cleaning mechanism (2).

If the conveyor belts on the machine only run in one direction, i.e. non-reversing, while the automatic flour duster is in operation at the same time, an undesired flour accumulation will result (scraper/belt), which can lead to problems with the light barrier function.

1. Remove occasional flour accumulations manually.



## 6.1.1.4 Scrapers / Rollers

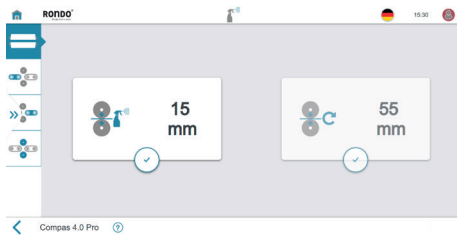


**Use a cloth to protect your hands, as the edges of the scraper blades are sharp and there is a danger of cuts.**



- Damp clean the scrapers / rollers daily with a brush / cloth and soapy water.
- RONDO recommends cleaning the conveyor belts while the scrapers are removed.
- RONDO recommends cleaning the light barrier while the scrapers are removed.

Also see 7.3.2 Replacing the scrapers



1. Open side tab.
2. Tap cleaning menu.
3. Tap scraper cleaning.
4. Tap scraper change position.
5. Open the safety guard.
6. Remove scrapers.  
(see 7.4.6.1 Removing the scrapers)
7. Clean scrapers.
8. Close the safety guard.
9. Tap maximum roller gap.
10. Open the safety guard.
11. Clean rollers.
12. Close the safety guard.
13. Tap scraper change position.
14. Open the safety guard.
15. Insert scrapers.  
(see 7.4.6.3 Mounting the scraper)
16. Close the safety guard.

## 6.1.1.5 Conveyor belts: Top



- Dry clean the conveyor belts daily with a plastic horn scraper.

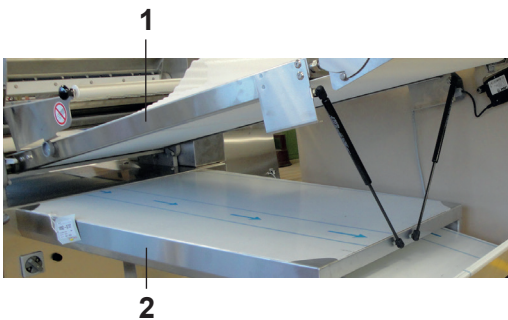
1. Open side tab.
2. Tap cleaning menu.
3. Tap cleaning of left conveyor belt.
4. Press and hold down the black mushroom button.
  - ▶ Conveyor belts run from right to left
5. Clean the left conveyor belt.
6. Release the black mushroom button.
7. Tap clean right conveyor belt.
8. Press and hold down the black mushroom button.
  - ▶ Conveyor belts run from left to right
9. Clean the right conveyor belt.
10. Release the black mushroom button.

## 6.1.1.6 Conveyor belts: underside / machine table / drive roller / idle roller

- Free the conveyor belt underside / machine table / drive rollers / idle rollers of dough scraps weekly with a brush and plastic horn scraper.

Also see 3.3 Full view of the machine

Also see 2.5.5 Tensioning the conveyor belts: Belt release [variant] / 2.5.6 Tensioning the conveyor belts: Quick-release belt [variant]



1. Release tension of the conveyor belts.
2. Lift the machine table (1). [SSH673\*\*\*.\*]
3. Free the conveyor belt underside / machine table / drive rollers / idle rollers of dough scraps with a brush and horn scraper.
4. Clean the undertable (2). [SSH673\*\*\*.\*]
5. Lower the machine table. [SSH673\*\*\*.\*]
6. Tensioning the conveyor belts.

## 6.1.1.7 Table supports

---

- Damp clean the table supports monthly with a brush / cloth and soapy water.

Also see 3.3 Full view of the machine

## 6.1.1.8 Flour catch sheets

---

- Dry clean the flour catch sheets daily with a brush.

Also see 3.3 Full view of the machine

## 6.1.1.9 Dough catch pans

---

- Dry clean the dough catch pans daily with a brush.

Also see 3.3 Full view of the machine

## 6.1.1.10 Touch screen

---

- Clean the touch screen daily with window cleaner

Also see 3.3 Full view of the machine

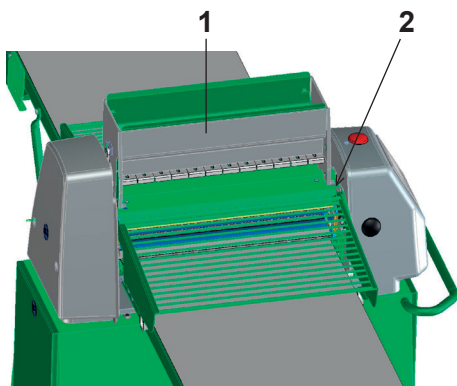
## 6.1.1.11 Automatic flour duster

[variant SSH670\*\*.\*][standard SSH672\*\*\*.\*, SSH673\*\*\*.\*]

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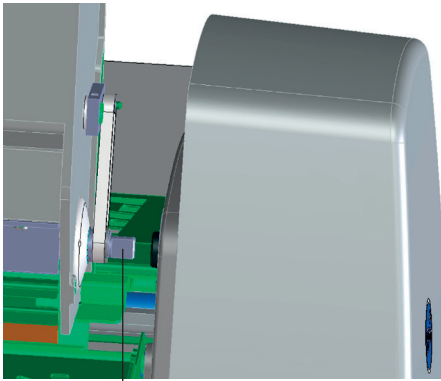


All assembly and disassembly work must be carried out by three people.

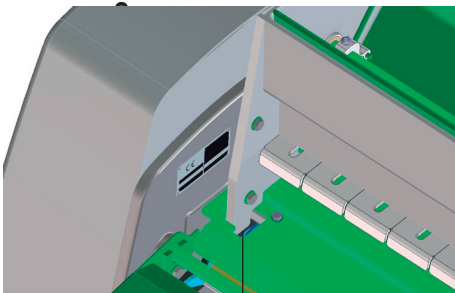


Disassemble the automatic flour duster as follows:

1. Slightly lift the automatic flour duster (1) at the front on the right-hand side.



2. Pull the automatic flour duster forward via the protruding plate (2) until the driver (3) has come out of the holding device.



4

3. Pull the automatic flour duster out of the recesses (4) and remove.

Now clean the automatic flour duster as follows:

4. Empty the automatic flour duster completely by tipping it out.
5. Tap out the automatic flour duster.
6. Brush the delivery roller clean with a dry brush.



**There should be no flour between the flour container and the movable side plates.**



**Do not use any solvents!**

7. Mount the automatic flour duster again (see 2.5.12 Mounting the automatic flour duster [variant SSH670\*\*.\*][standard SSH672\*\*\*.\*, SSH673\*\*\*.\*]).

## 6.1.1.12 Automatic reeling device [SSH67\*7H\*.\*]

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- Clean the automatic reeling device with a cloth and soapy water.

Also see 2.5.13 Mounting the automatic reeling device [SSH67\* 7H\*.\*].

## 6.1.1.13 Cutting rollers [SSH67\*\*\*C.\*]

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- Dry clean the cutting rollers daily with a brush.

Also see 5.10.2 Inserting the cutting rollers.

## 7 Maintenance

### 7.1 General information for machine maintenance

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Authorised use also means that users must follow all instructions prescribed by the manufacturer in regard to operation, maintenance and service.



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



Operation when any of the safety elements is out of order is prohibited.



Defective safety elements must be replaced with new original parts immediately.



Machine parts located in the dough processing area, and whose surface coating becomes worn (e.g. chrome plating, colour, plastic), must be replaced.

For professional servicing and maintenance of the machine, we recommend taking out an appropriate maintenance contract. Your authorised dealer will be pleased to provide you with details of the different options.



Cutting rollers may only be lowered when the safety guard is closed.

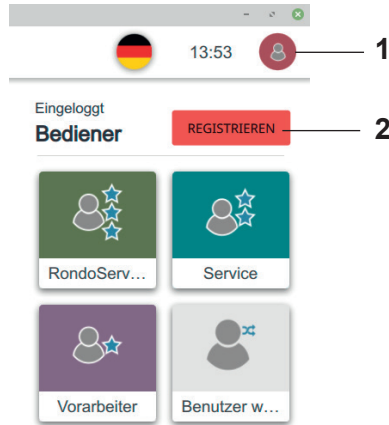


Due to the risk of injury at the sharp edges, cutting rollers must be replaced carefully and correctly. Wear suitable protective gloves to prevent injuries. Cutting rollers that are outside the cutting point must be placed in the holding brackets beneath the machine table.



**All defects on the machine must be rectified by an authorised customer service representative.**

## 7.2 Software updates



RONDO provides software updates once a year. If you register, RONDO can actively inform you about new software updates.

1. Tap the person icon (1).
2. Tap the register button (2).
3. Provide your personal details.
4. Follow further instructions where applicable.
  - ▶ The register button disappears.
  - ▶ Your registration will be confirmed by email.

Registration successful!  
The confirmation e-mail has been send to:

OK

Alternatively you can check whether the software is up to date.



5. Open side tab.
6. Open the settings menu.
7. Tap system information.
8. Scan the QR code with a mobile device.
9. Follow further instructions where applicable.
  - ▶ Any applicable software updates are indicated.



## 7.3 Maintenance list

What / Part	Activity	Daily run time 4 – 8 h	Daily run time more than 8 h
Conveyor belt	Check belt running, tension if necessary, replacement by customer service if necessary	W	W
Scraper blade	Check, replace if necessary	2 Y	Y
Spindle in front housing of roller gap drive	Lubrication by customer service	Y	1/2 Y
Gas spring	Check, replace if necessary	M	M
Sensor wiper	Check, replace if necessary	M	M
Automatic reeling device	Check seal rings, replace if necessary	Y	1/2 Y
Brush (automatic flour duster)	Check, adjust or replace if necessary	M	M
Safety elements	Check safety function	W	W
Warning signs	Check legibility, replace if necessary	M	M
Guide	Check, replace if necessary	2 Y	2 Y

### Legend

W	Weekly
M	Monthly
1/2 Y	Biannually
A	Annually
2 Y	Every 2 years

## 7.4 Replacement kit



Defective safety elements must be replaced with new original parts immediately.



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

Article No.	Designation	Dimensions	Use
122954T01	Scraper, complete		All models
122954T02	Scraper, complete (blue)		All models
122775T03	Scraper blade		All models
122955	Scraper blade		All models
133577T03	Scraper blade (blue)		All models
135597T01	Scraper blade		All models
121344	Conveyor belt	3570 x 640 mm	SSH67***C.*
105467	Conveyor belt	3280 x 640 mm	SSH67*7.* / SSH67*7H.* / SSH67*7C.*
121344T02	Conveyor belt	2680 x 640 mm	SSH6705.* / SSH6725.* / SSH67*5C.*
B1014572	Conveyor belt (blue)	3570 x 640 mm	SSH67***C.*
B1011376	Conveyor belt (blue)	3280 x 640 mm	SSH67*7.* / SSH67*7H.* / SSH67*7C.*
B1011382	Conveyor belt (blue)	2680 x 640 mm	SSH6705.* / SSH6725.* / SSH67*5C.*
52881	Fuse 5.0 AT	5.0 AT slow Ø 5 x 20 mm	All models
50466	Seal rings	47.3 x 2.62 mm	SSH67*7H*.*
50162	Gas spring	350N	SSH67***C.*
50485	Gas spring	200N	SSH673*H*.*
52011	Gas spring	200N	All models
50048	Gas spring	100N	SSH673**.*
126084	Sensor wiper		All models
126088	Wiper		All models
91992T18	Flour catch sheet	950 x 642 x 28.5 mm	SSH6705.* / SSH6725.* / SSH67*5C.*
91992T15	Flour catch sheet	1250 x 642 x 28.5 mm	SSH67*7.* / SSH67*7H.* / SSH67*7C.*
121036T01	Flour catch sheet	704 x 304 x 18 mm	All models
101507	Guide	108.5 x 70 x 9 mm	SSH67***C.*
B1021928	QR code reader		All models

## 7.4.1 Checking and replacing the sensor wiper

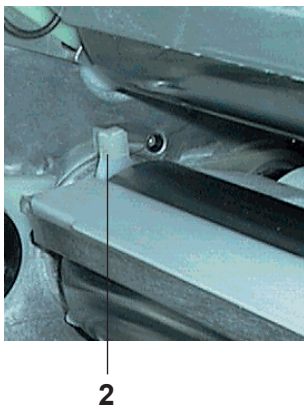
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Remove used sensor wiper (2), fit new sensor wiper with the wiper lip against the light barrier (1).

## 7.4.2 Lubricating the sensor wiper

---



In the event of unusual noises, lubricate the sensor wiper (2) with a grease approved for use in the food industry.

Recommended grease:

- Cassida HDS 2 grease B1000505
- Cassida 320 spray B1000506

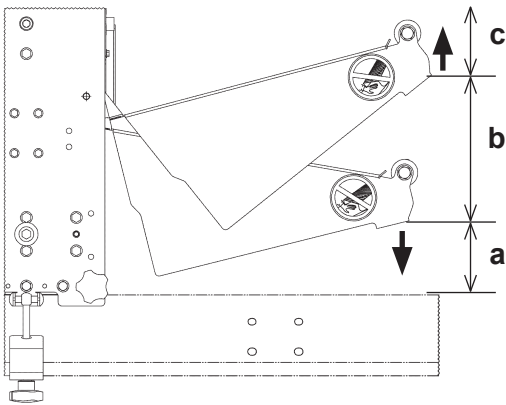
## 7.4.3 Check and replace gas spring: Safety guards

This process must be performed for the **infeed and outfeed safety guards individually**.

Interval	Servicing work
Monthly	Visual inspection to determine if oil spots are present.
Monthly	Check the functioning of the gas springs. The function is correct if the safety guard <b>closes (a)</b> or <b>opens (c)</b> at a certain distance from the table with the pressure from the gas spring (see table below).

**Distance from the table at which the safety guard closes (a), or opens (c) by the gas spring pressure. At the distance (b) the safety guard moves easily in both directions.**

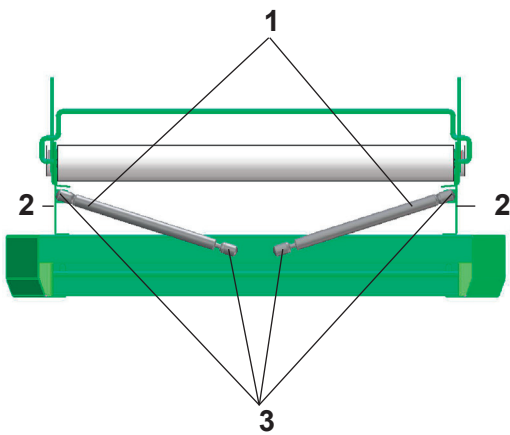
Safety guards	(a)	(b)	(c)
Infeed Outfeed	150 mm	150 – 200 mm	> 200 mm
Cutomat [SSH67***C.*]	210 mm	210 – 300 mm	> 300 mm



1. Position the scale.
2. Lift the safety guard.  
The safety guard must **close at distance (a)**, and **open at distance (c)**.
3. Close the safety guard.
4. Replace the gas springs if necessary.

## 7.4.4 Checking and replacing the gas springs: rigid substructure [SSH673\*\*\*.\*]

Interval	Servicing work
Monthly	Visual inspection to determine if oil spots are present.
Monthly	<p>Check the functioning of the gas springs. The function is correct when...</p> <ul style="list-style-type: none"> <li>- the machine table (5) is held in position with the gas springs (1) fully extended.</li> <li>- after deliberately overcoming the self-locking mechanism manually, it is placed on the undertable (4) at a gentle speed. Injuries caused by crushing hands between the undertable and the guide plates (2) must be avoided.</li> </ul>



Machine table with automatic reeling device:

- Fit 200 N gas springs.

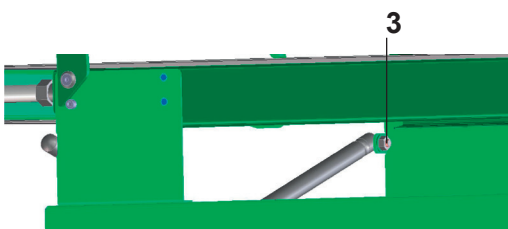
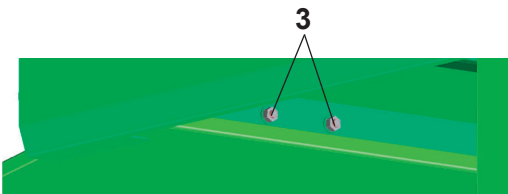
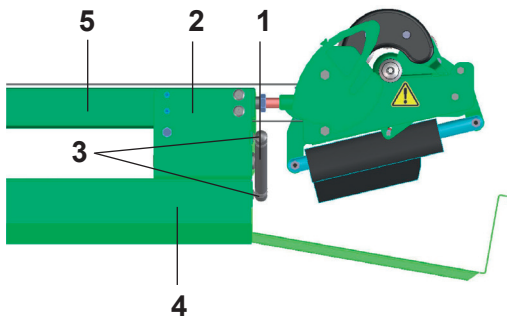
Machine table without automatic reeling device:

- Fit 100 N gas springs.

1. Check gas springs.

2. Replace gas springs if necessary:

Mount gas springs with locking washers and hexagon nuts (3) on the undertable (4) and on guide plates (2).



## 7.4.5 Checking the safety guards trigger point

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Check the trigger point (see 9.1 Technical data) of the safety guards. In case of deviation:

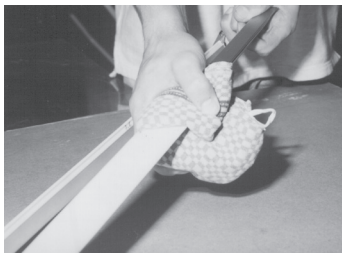
- Shut the machine down immediately.
- Contact customer service immediately.

## 7.4.6 Replacing the scrapers

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Use a cloth to protect your hands, as the edges of the scraper blades are sharp and there is a danger of cuts.



### 7.4.6.1 Removing the scrapers

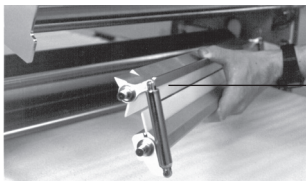
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1. Close rollers to around 2 mm in “manual” operating mode.
2. Engage safety guard in the upper position.
3. Push down the front and rear scraper bracket (3) with your thumb.
4. Lift the scraper (4) out of the scraper mount.
5. Remove the scraper (4).
6. Clean the scraper (see 6.1.1 Care).



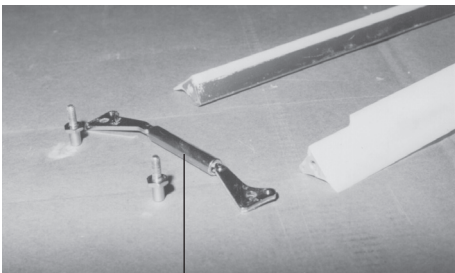
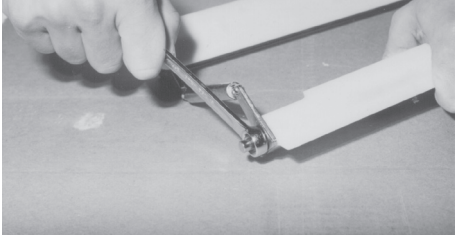
3



4

## 7.4.6.2 Replacing the scraper blade

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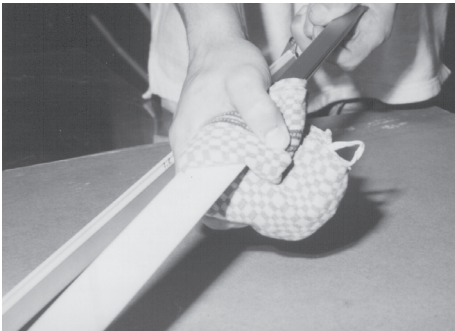


5

1. Using an A/F 13 spanner, dismount the spring compressor (5) on the left or right side and carefully push out the scraper blade.



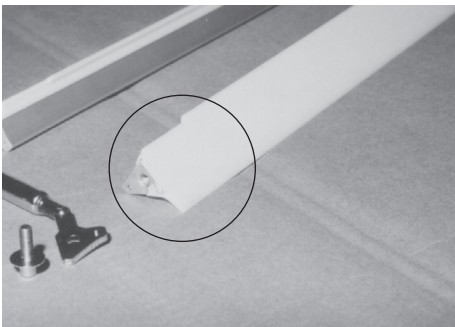
**Caution**  
Use a cloth to protect your hands, as the edges of the scraper blades are sharp and there is a danger of cuts.



2. Mount the new scraper blade in the reverse order.



**Caution**  
Make sure that the scraper blade is mounted with the side bevels on the lower, i.e. clear anodised, scraper holder!



3. Remount the spring compressor in the reverse order.

## 7.4.6.3 Mounting the scraper

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1. To remount the scraper, follow the removal instructions in reverse order.

## 7.4.7 Conveyor belt

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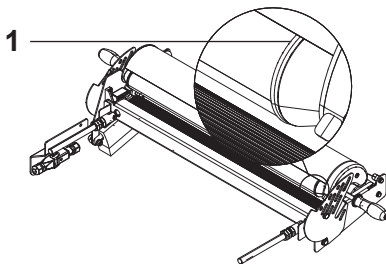
### 7.4.7.1 Checking for wear

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- If the conveyor belts are worn, contact customer service.
- If slight signs of wear are visible at the edges, the conveyor belt is skewed. Adjust the belt release.

## 7.4.8 Automatic reeling device: Check seal rings [SSH67\*7H\*.\*)

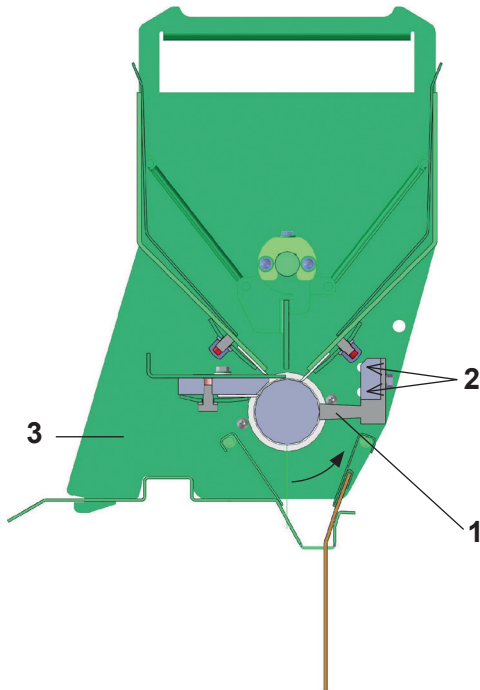
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Check seal rings (1). Arrange replacement by customer service if necessary.



## 7.4.9 Automatic flour duster: Adjusting the brush [variant SSH670\*\*.\*][standard SSH672\*\*\*.\*, SSH673\*\*\*.\*]

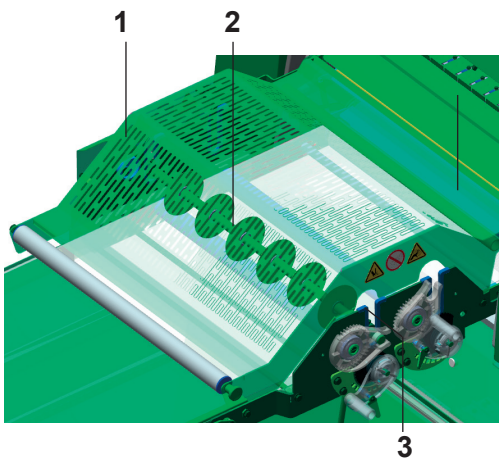


1. Loosen the brush (1) by means of the two screws (2) (front and rear) on the container (3).
2. Adjust the brush (1)
3. Tighten screws (2) again.

## 7.4.10 Cutomat: Replacing the guideway [SSH67\*\*\*C.\*]



Due to the risk of injury at the sharp edges, cutting rollers must be replaced carefully and correctly. Wear suitable protective gloves to prevent injuries. Cutting rollers that are outside the cutting point must be placed in the holding brackets beneath the machine table.

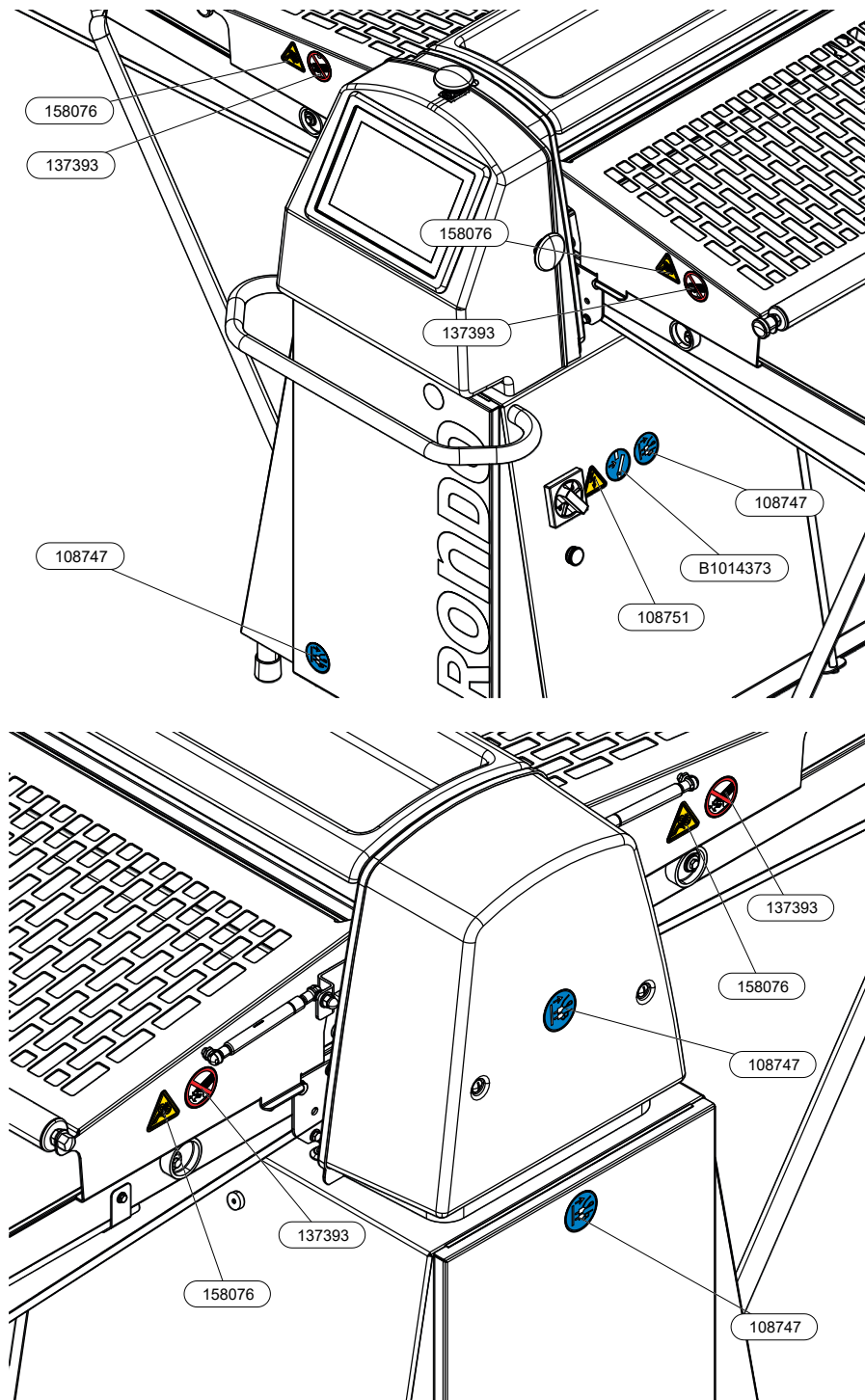


1. Open the safety guard (1).
2. Remove the cutting roller (2).
3. Replace the guideway (3).
4. Insert the cutting roller (2).
5. Close the safety guard (1).

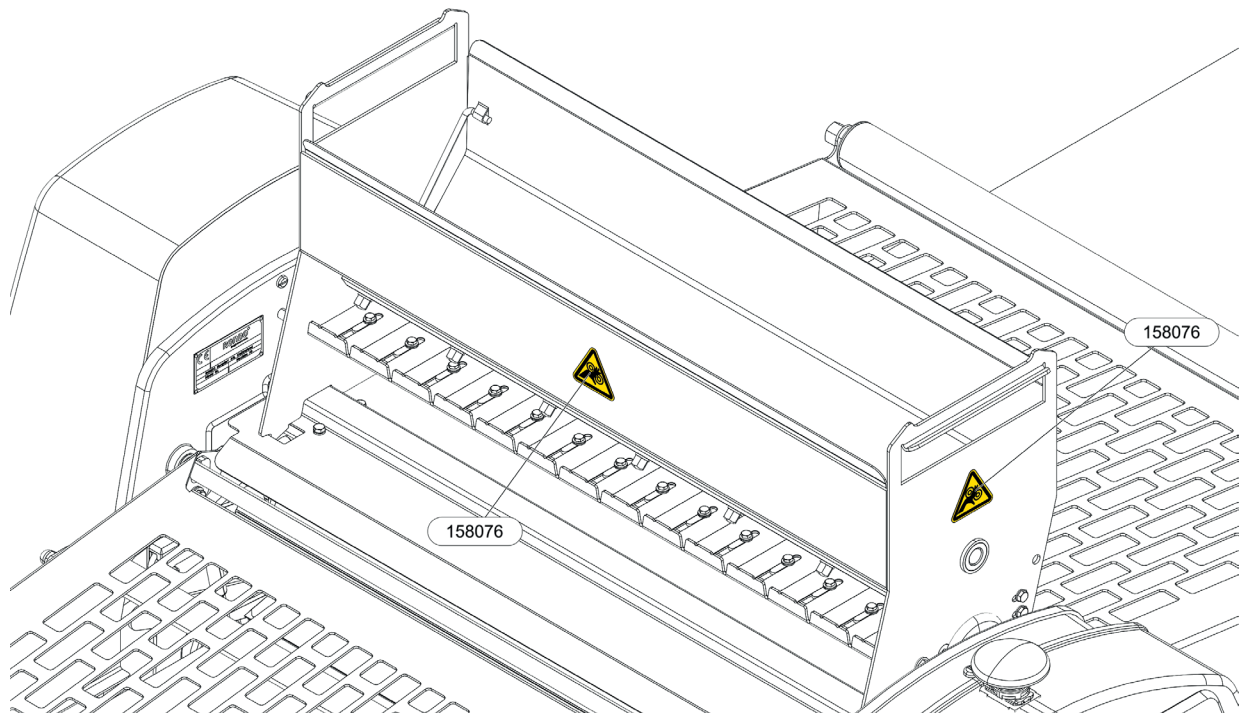
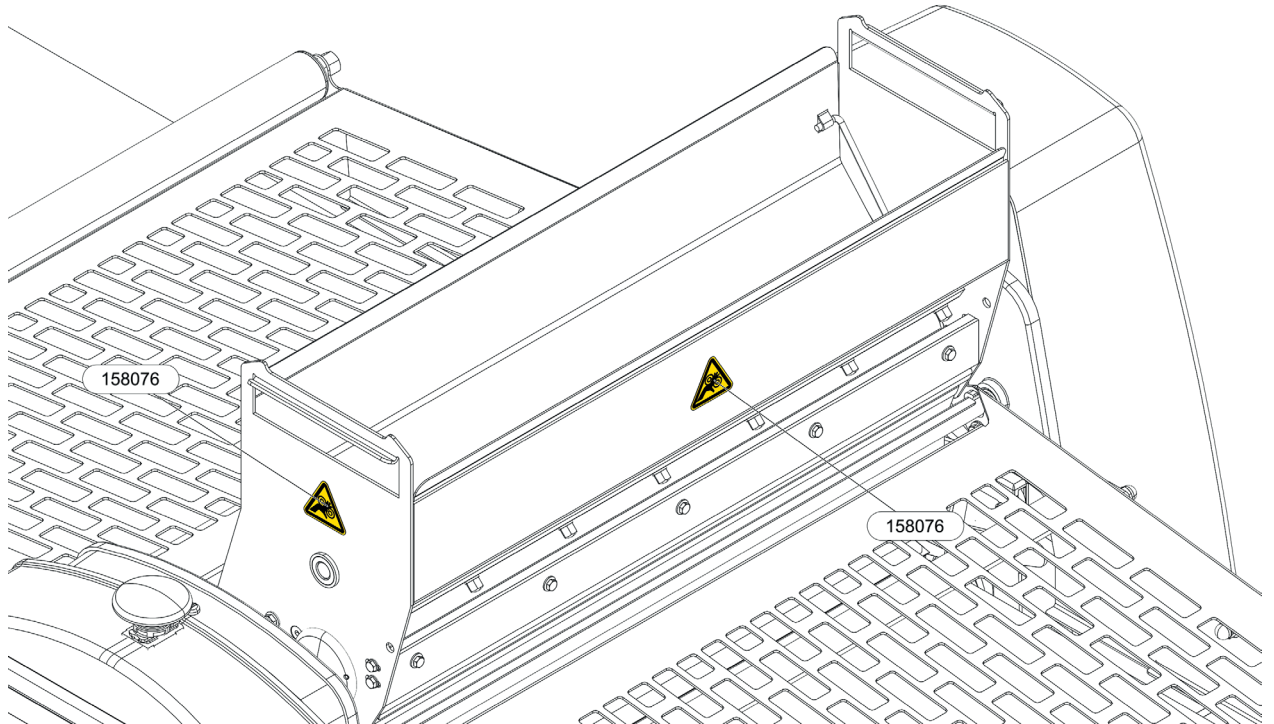
## 7.4.11 Check warning labels

Warning labels and safety elements. These are indispensable for the safety of persons working with the machine. Defective or missing warning labels must be replaced immediately.

### 7.4.11.1 Warning label: Complete housing: ISO [SSH67\*\*\*\*.A]

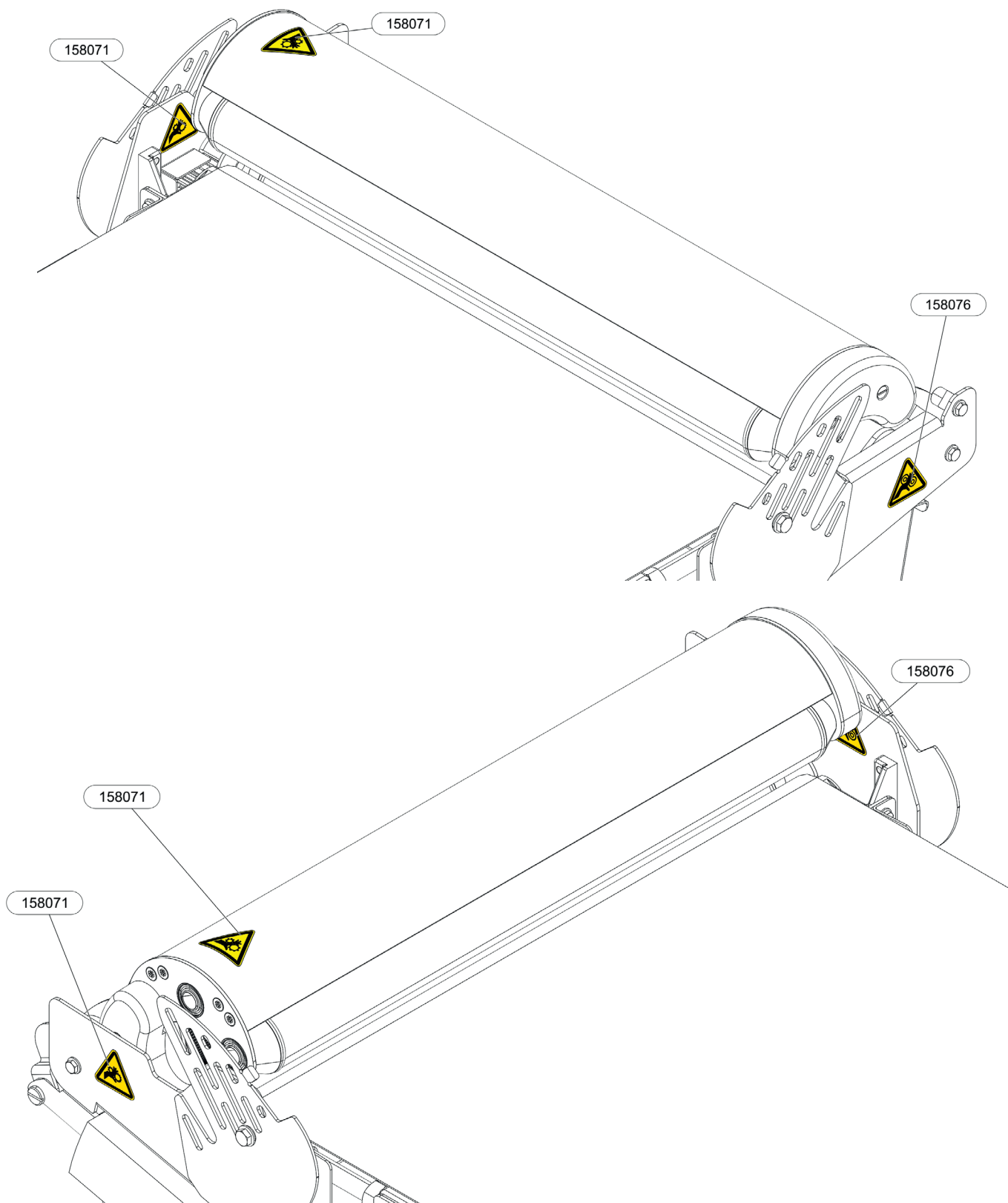


## 7.4.11.2 Warning label: Automatic flour duster: ISO [variant SSH670\*\*.A][standard SSH672\*\*\*.A, SSH673\*\*\*.A]

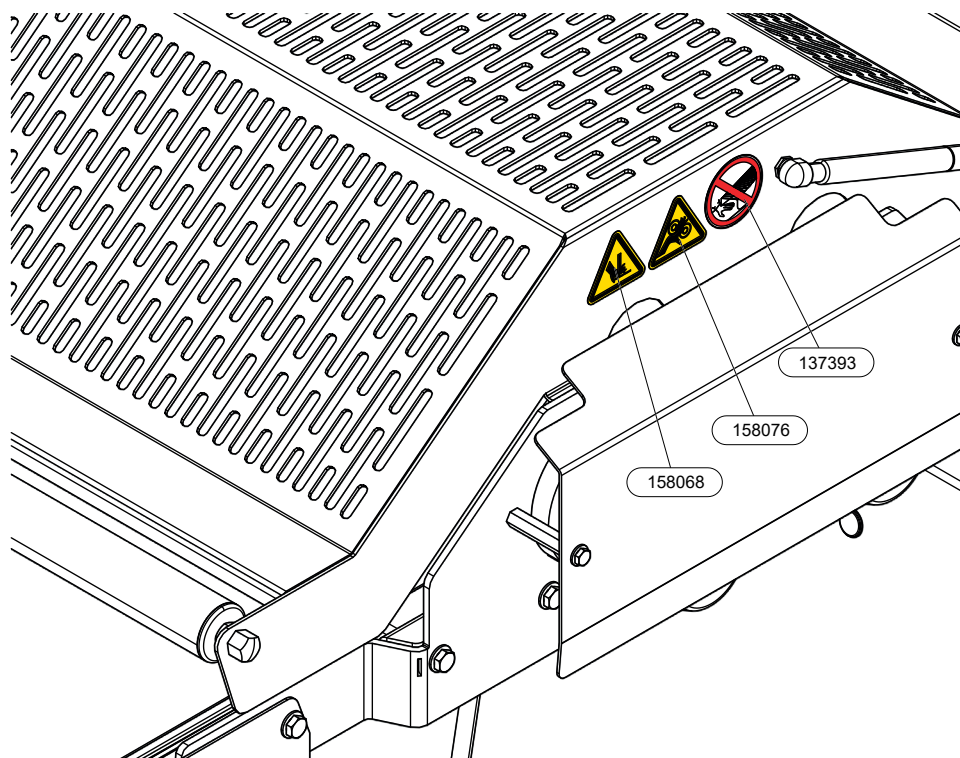
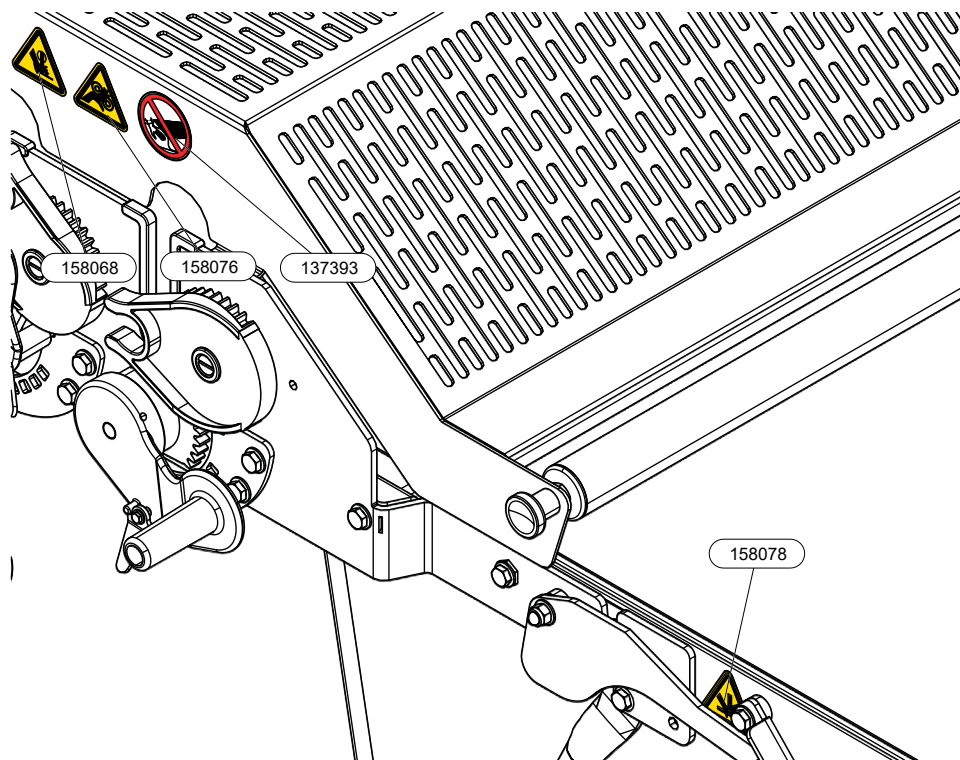


## 7.4.11.3 Warning label: Automatic reeling device: ISO [SSH67\*7H\*.A]

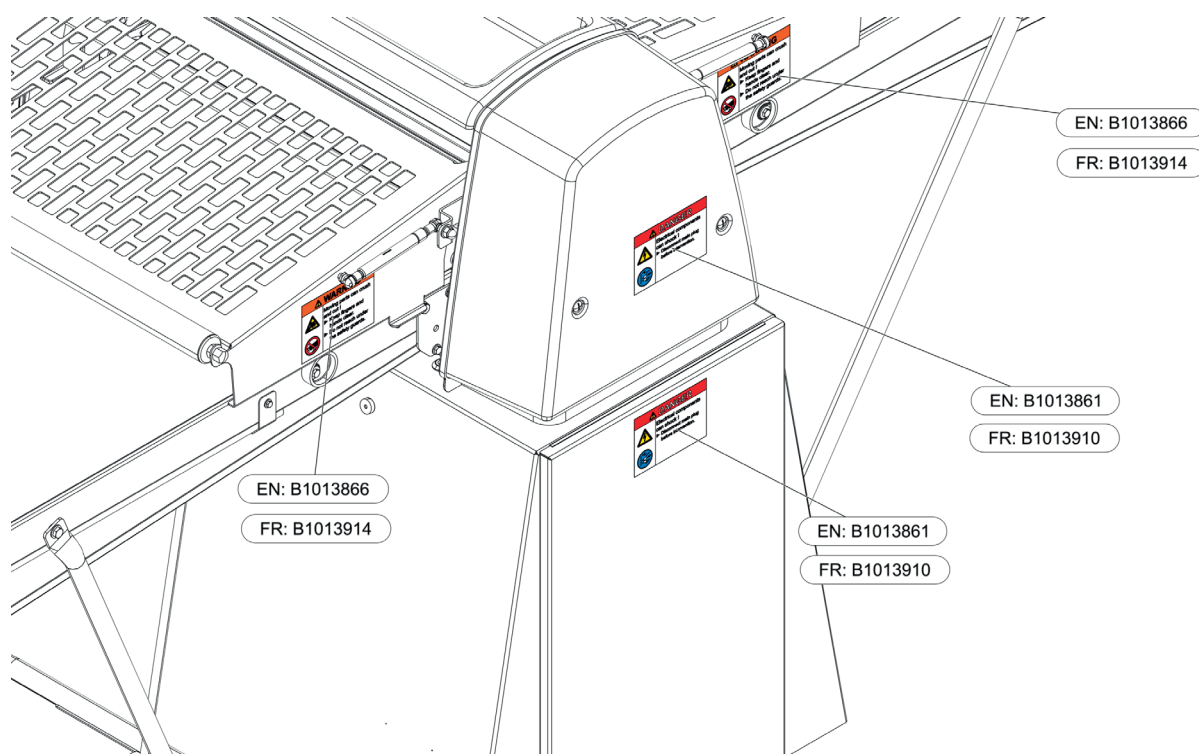
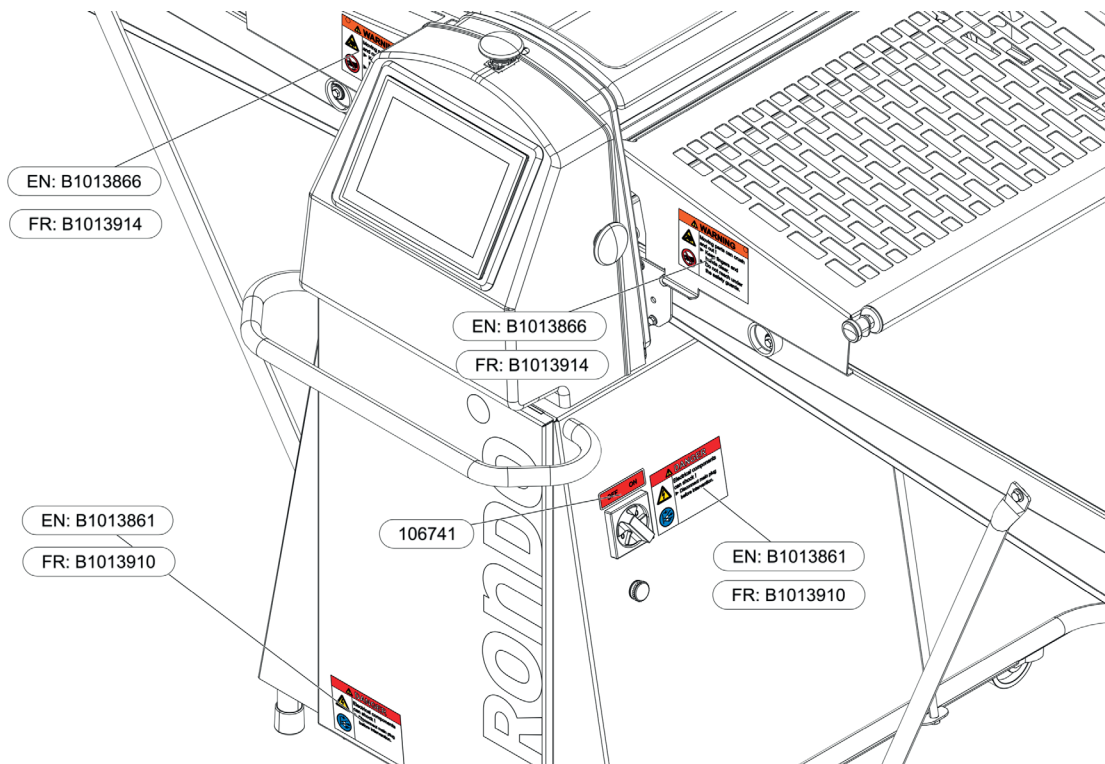
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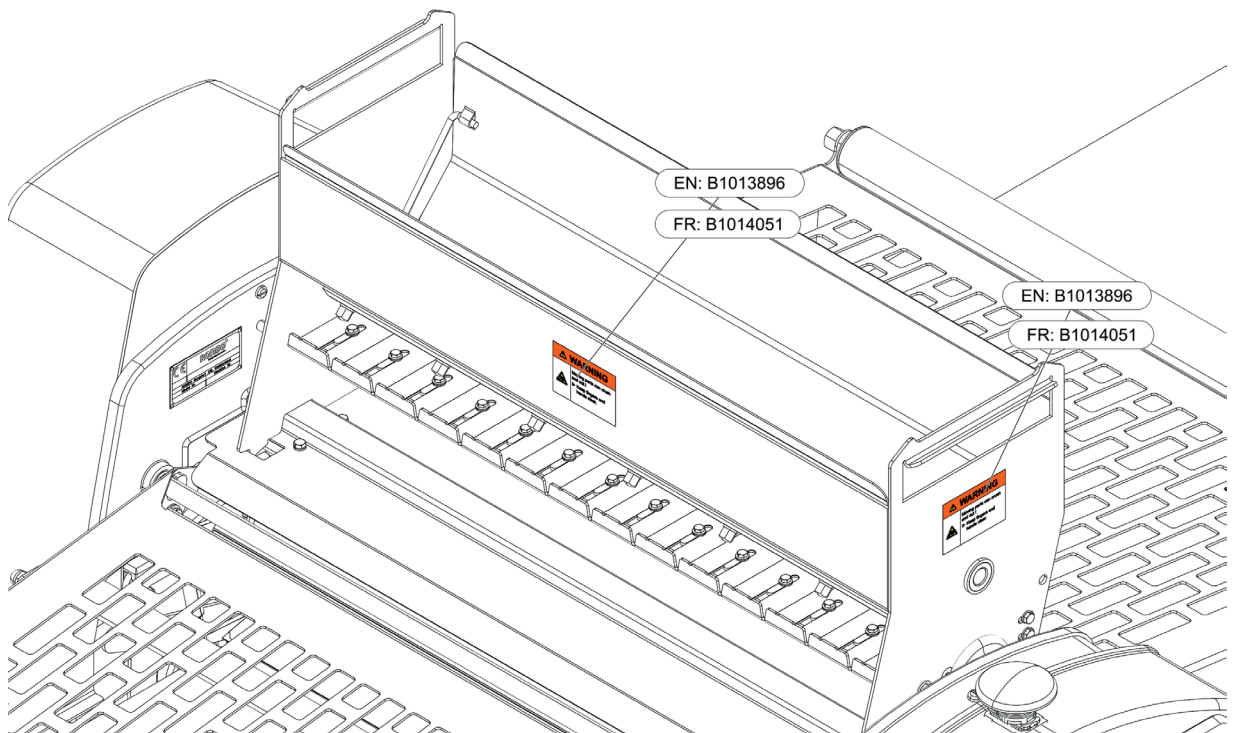
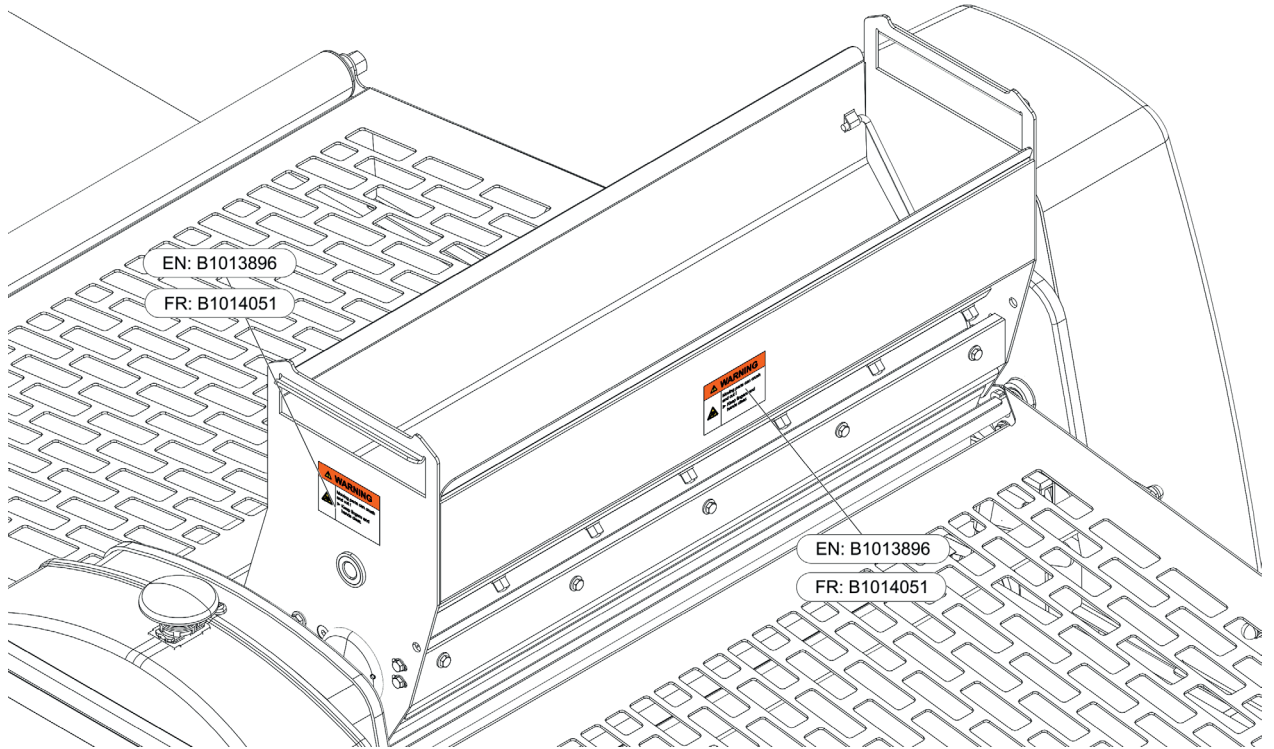
## 7.4.11.4 Warning label: Cutomat: ISO [SSH67\*\*\*C.A]



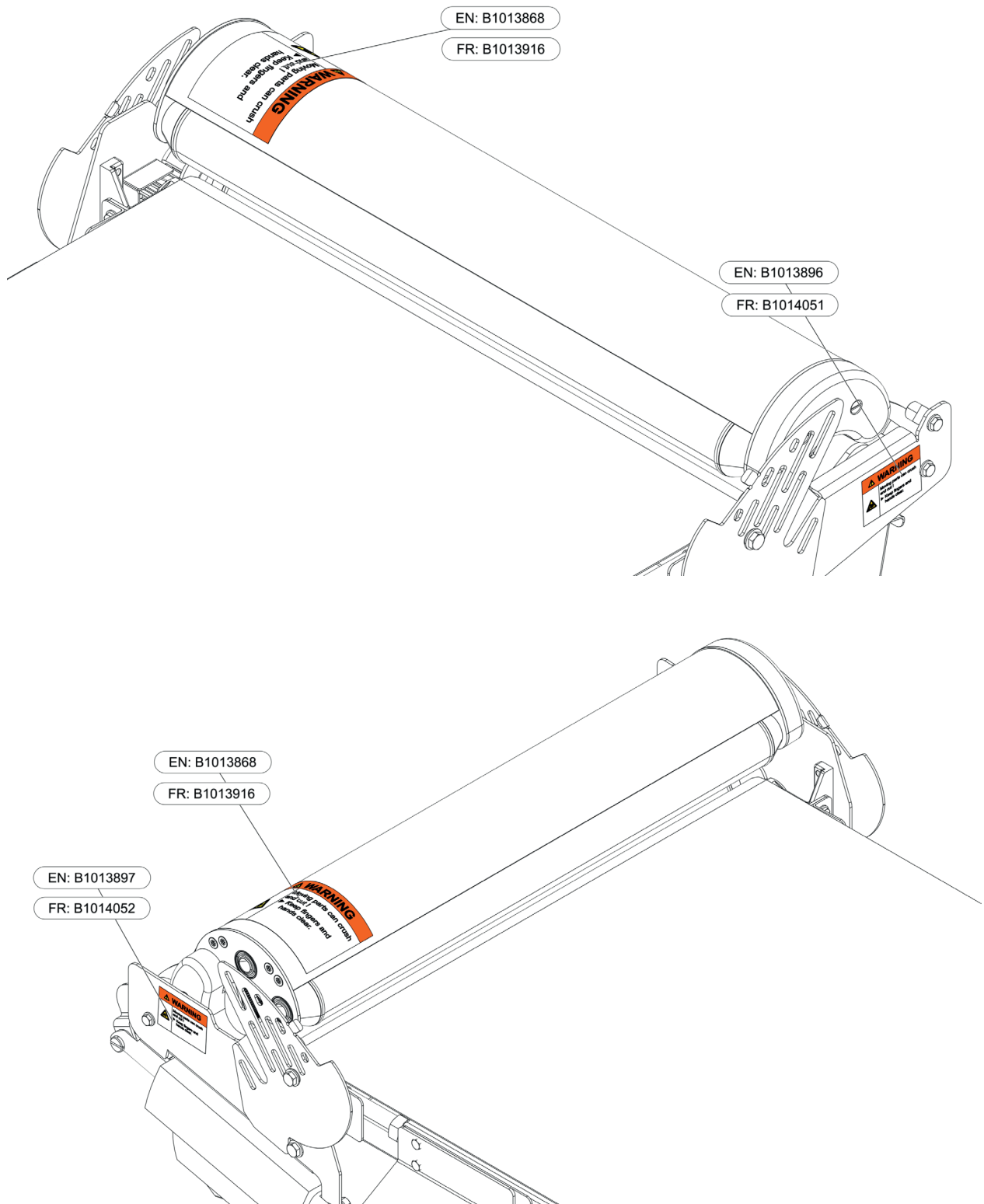
## 7.4.11.5 Warning label: Complete housing: ANSI [SSH67\*\*\*\*.C]



## 7.4.11.6 Warning label: Automatic flour duster: ANSI [variant SSH670\*\*.C][standard SSH672\*\*\*.C, SSH673\*\*\*.C]

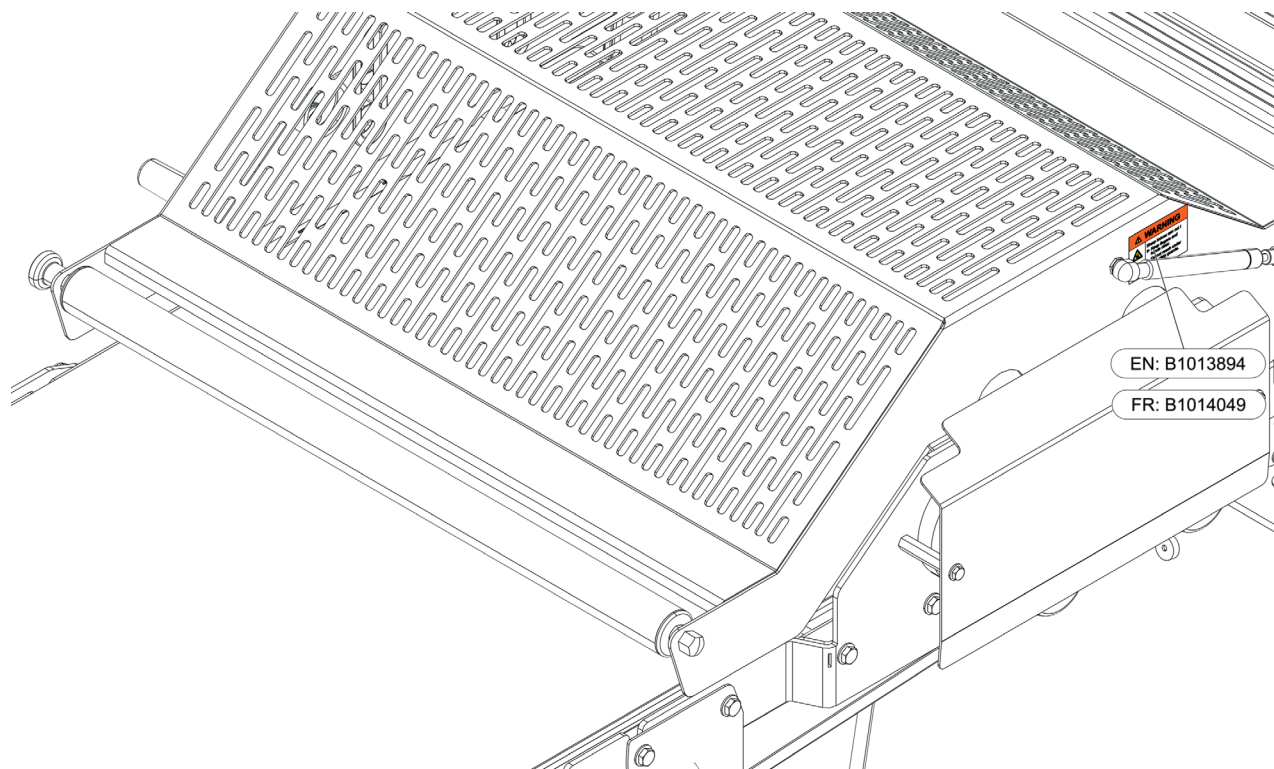
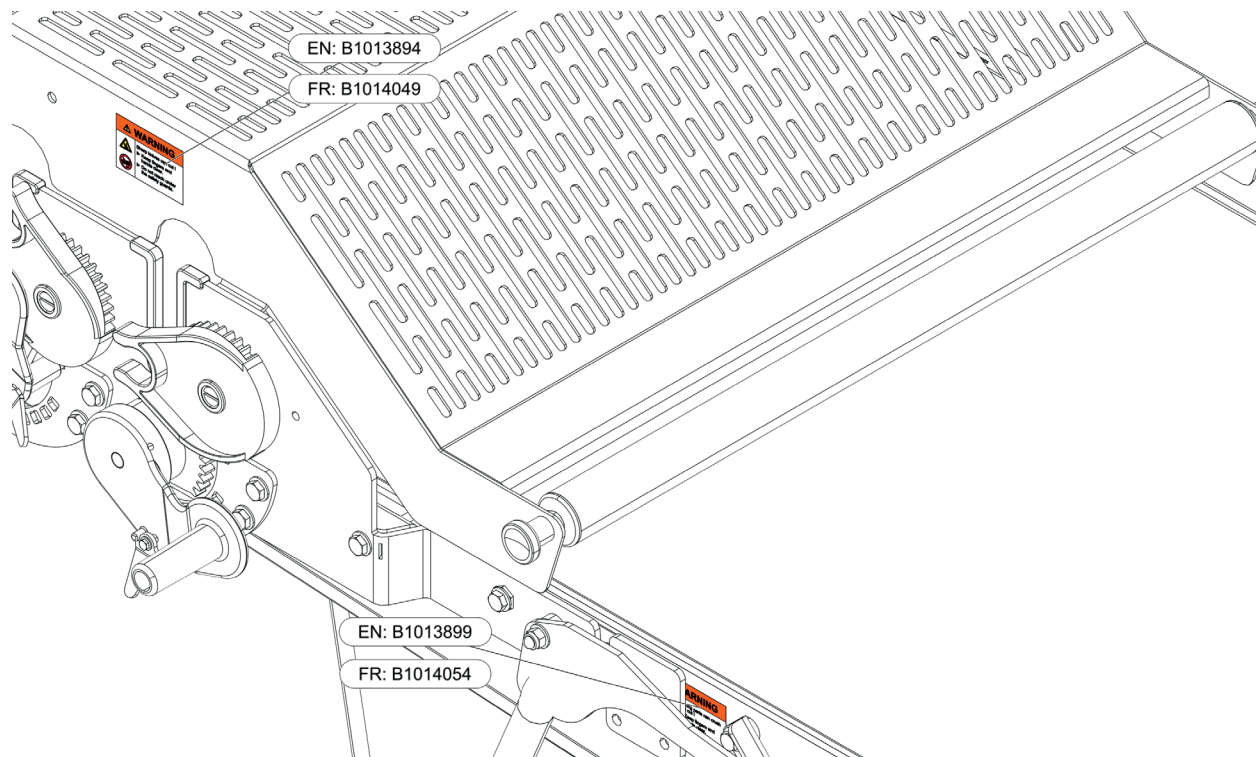


## 7.4.11.7 Warning label: Automatic reeling device: ANSI [SSH67\*7H\*.C]





## 7.4.11.8 Warning label: Cutomat: ANSI [SSH67\*\*\*C.C]



## 8 Troubleshooting

### 8.1 List of errors

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<b>Fault symptom</b>	<b>Cause / defect</b>	<b>Remedy / repair</b>
1. No display on the touch screen.	- Mains plug inserted?	- Insert mains plug.
	- Main switch turned on?	- Turn on main switch.
		Check by electrician:
	- Mains voltage available?	- Check mains voltage (all 3 phases).
	- Mains plug faulty?	- Check connections in plug
	- Mains must match the details on the "Electrical connected loads" plate of the machine.	
	- Disconnect the mains plug and check fuses (in the substructure, in the electrical box).	
	- F1 circuit-breaker for equipment tripped?	- Inform customer service.
2. Display working, machine cannot be started.	- Safety guards closed? (See display on the touch screen)	- Close the safety guard.
	- Machine in programming mode?	- Switch machine to production mode.
	- Safety guards support incorrectly adjusted?	- Readjust eccentric. Limit switches must not be adjusted.
3. Machine runs intermittently, stops.	- Support – eccentric (for safety guards) on machine table incorrectly adjusted.	- Readjust eccentric.
		By electrician:
	- Loose wires (loose contact).	- Connect cables, wires correctly.
4. Main drive motor runs, rollers and conveyor belts are stationary.	- Ribbed belt defective.	- Remove rear cover of substructure and of machine body, replace ribbed belt if necessary. This work may only be carried out by an authorised customer service representative.

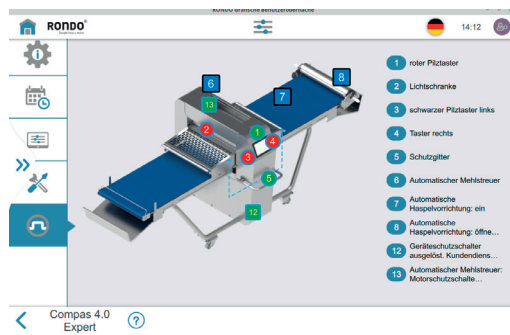
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Fault symptom	Cause / defect	Remedy / repair
5. Conveyor belts loop through, motor and rollers turn.	<ul style="list-style-type: none"> <li>- Belt release is too weak.</li> <li>- Drive roller soiled.</li> </ul>	<ul style="list-style-type: none"> <li>- Re-tension conveyor belt evenly (see 2.5.5 Tensioning the conveyor belts: Belt release [variant] / 2.5.6 Tensioning the conveyor belts: Quick-release belt [variant]).</li> <li>- Clean the drive roller (see 6.1.1 Care).</li> </ul>
6. Infeed conveyor belt is stationary or is moving poorly/not at all, rollers are turning correctly.	<ul style="list-style-type: none"> <li>- Electromagnetic clutch is not working.</li> <li>- Toothed belt of table drive defective.</li> <li>- Belt release is too weak.</li> </ul>	<ul style="list-style-type: none"> <li>- Replace clutch.</li> <li>- Replace the toothed belt.</li> <li>- Re-tension conveyor belt evenly (see 2.5.5 Tensioning the conveyor belts: Belt release [variant] / 2.5.6 Tensioning the conveyor belts: Quick-release belt [variant]).</li> </ul>
7. Outfeed conveyor belt stationary or jerks.	<ul style="list-style-type: none"> <li>- Belt release is too weak.</li> </ul>	<ul style="list-style-type: none"> <li>- Re-tension conveyor belt evenly (see 2.5.5 Tensioning the conveyor belts: Belt release [variant] / 2.5.6 Tensioning the conveyor belts: Quick-release belt [variant]).</li> </ul>
8. Conveyor belts run off, are worn at the side.	<ul style="list-style-type: none"> <li>- Tension of the conveyor belt is incorrectly adjusted.</li> <li>- Drive roller soiled.</li> </ul>	<ul style="list-style-type: none"> <li>- Re-tension conveyor belt (see 2.5.5 Tensioning the conveyor belts: Belt release [variant] / 2.5.6 Tensioning the conveyor belts: Quick-release belt [variant]).</li> <li>- Clean the drive roller (see 6.1.1 Care).</li> </ul>
9. Dough splits open before roller or passes through between scraper and infeed belt.	<ul style="list-style-type: none"> <li>- Scraper: Check correct mounting.</li> <li>- Check wear of scraper blades.</li> </ul>	<ul style="list-style-type: none"> <li>- Mount the scraper correctly (see 6.1.1 Care).</li> <li>- Replace scraper blades if necessary. Replace scraper completely if necessary.</li> </ul>

Fault symptom	Cause / defect	Remedy / repair
10. Automatic flour duster does not work.	<p>Automatic flour duster only runs if dough is located between the rollers.</p> <ul style="list-style-type: none"> <li>- Automatic flour duster not correctly engaged.</li> <li>- Connection between motor shaft and driver defective.</li> <li>- Automatic flour duster motor does not run. Motor protection relay tripped?</li> </ul>	<ul style="list-style-type: none"> <li>- Engage correctly (flattened automatic flour duster shaft must engage with the driver).</li> <li>- Check connection.</li> <li>- Inform customer service.</li> </ul> <p>Check by electrician:</p> <ul style="list-style-type: none"> <li>- Reset motor protection relay</li> </ul>
11. Light barrier does not work.	<ul style="list-style-type: none"> <li>- Light barrier eye soiled, the light barrier eyes are no longer cleaned, because:</li> <li>- Sensor wiper is defective or no longer present.</li> <li>- Light barrier is defective.</li> <li>- Wiper is worn.</li> </ul>	<ul style="list-style-type: none"> <li>- Check wiper mechanism, replace defective parts. Inform customer service. (The program sequence is not disturbed when the safety guard is opened and the photocell cleaned).</li> <li>- Replace sensor wiper.</li> <li>- Check light barrier (see 8.2 Checking the inputs and outputs).</li> <li>- Replace wiper.</li> </ul>
12. All other errors / failures.		<ul style="list-style-type: none"> <li>- Inform the nearest "RONDO" service centre providing as much information as possible.</li> </ul>

## 8.2 Checking the inputs and outputs

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The states of the inputs and outputs are displayed in the I/O menu.

1. Open side tab.
2. Open the settings menu
3. Tap I/O menu
4. Read states of the inputs and outputs

## 9 Technical data

### 9.1 Technical data

#### 9.1.1 Technical data for Rondostar 5000 Basic / Rondostar 5000 Pro

Technical data	SSH6705.* / SSH6725.*	SSH6707.* / SSH6727.*	SSH6707H.* / SSH6727H.*
Total length	3095 mm	3626 mm	3700 mm
Total width	1255 mm	1255 mm	1255 mm
Total height	1402 mm	1402 mm	1402 mm
Substructure	Table supports	Table supports	Table supports
Belt release	Standard	Standard	Standard
Quick-release belt	Variant	Variant	Variant
Dough reeler	Variant	Variant	Variant
Automatic reeling device	No	No	Yes
Flour container	Standard / No	Standard / No	Standard / No
Automatic flour duster	Variant / Standard	Variant / Standard	Variant / Standard
Ship feet	Option	Option	Option
Total conveyor belt width	640 mm	640 mm	640 mm
Usable conveyor belt width	600 mm	600 mm	600 mm
Total table length	2720 mm	3330 mm	3500 mm
Safety guard opening	90 mm	90 mm	90 mm
Safety guard: Trigger point	97 +3/-0 mm	97 +3/-0 mm	97 +3/-0 mm
Roller length	660 mm	660 mm	660 mm
Roller gap	0.2–45 mm	0.2–45 mm	0.2–45 mm
Motorised roller gap reduction (according to software)	Yes	Yes	Yes
Sheeting speed of outfeed belt	85 cm / sec.	85 cm / sec.	85 cm / sec.
Rated power	1.4 kW	1.4 kW	1.4 kW
Supply voltage	3 x 220–480 V; 50 / 60 Hz	3 x 220–480 V; 50 / 60 Hz	3 x 220–480 V; 50 / 60 Hz
Space requirement in working position; dough catch pan pulled out	3100 x 1254 x 1400 mm	3700 x 1254 x 1400 mm	3700 x 1254 x 1400 mm
Space requirement in idle position	1730 x 1254 x 1400 mm	2050 x 1254 x 1400 mm	2900 x 1254 x 1400 mm
Machine weight without accessories	approx. 300 kg	approx. 310 kg	approx. 310 kg
Weight of flour container	1 kg	1 kg	1 kg
Weight of automatic flour duster	18.2 kg	18.2 kg	18.2 kg
Weight of automatic reeling device	-	-	13 kg
Weight of flour catch pans	-	7.5 kg	7.5 kg

Technical specifications subject to change without notice.

## 9.1.2 Technical data for Rondostar 5000 Expert

Technical data	SSH6737.*	SSH6737H.*
Total length	3753 mm	3756 mm
Total width	1255 mm	1255 mm
Total height	1409 mm	1409 mm
Substructure	Rigid substructure	Rigid substructure
Belt release	Standard	Standard
Quick-release belt	Variant	Variant
Dough reeler	Variant	Variant
Automatic reeling device	No	Yes
Flour container	No	No
Automatic flour duster	Standard	Standard
Ship feet	No	No
Total conveyor belt width	640 mm	640 mm
Usable conveyor belt width	600 mm	600 mm
Total table length	3326 mm	3512 mm
Safety guard opening	90 mm	90 mm
Safety guard: Trigger point	97 +3/-0 mm	97 +3/-0 mm
Roller length	660 mm	660 mm
Roller gap	0.2–45 mm	0.2–45 mm
Motorised roller gap reduction (according to software)	Yes	Yes
Sheeting speed of outfeed belt	85 cm / sec.	85 cm / sec.
Rated power	1.4 kW	1.4 kW
Supply voltage	3 x 220–480 V; 50 / 60 Hz	3 x 220–480 V; 50 / 60 Hz
Space requirement in working position;dough catch pan pulled out	3753 x 1254 x 1409 mm	3756 x 1254 x 1409 mm
Space requirement in idle position	3326 x 1254 x 1409 mm	3512 x 1254 x 1409 mm
Machine weight without accessories	approx. 380 kg	approx. 390 kg
Weight of automatic flour duster	18.2 kg	18.2 kg
Weight of automatic reeling device	-	13 kg

**Technical specifications subject to change without notice.**

## 9.1.3 Technical data for Rondostar-Cutomat 5000

Technical data	SSH6725C.*	SSH6727C.*	SSH6727HC.*
Total length	3649 mm	3804 mm	3855 mm
Total width	1255 mm	1255 mm	1255 mm
Total height	1402 mm	1402 mm	1402 mm
Substructure	Table supports	Table supports	Table supports
Belt release	Standard	Standard	Standard
Quick-release belt	Variant	Variant	Variant
Dough reeler	Variant	Variant	Variant
Automatic reeling device	No	No	Yes
Flour container	No	No	No
Automatic flour duster	Standard	Standard	Standard
Ship feet	Option	Option	Option
Total conveyor belt width	640 mm	640 mm	640 mm
Usable conveyor belt width	600 mm	600 mm	600 mm
Total table length	3172.5 mm	3472 mm	3500 mm
Safety guard opening	90 mm 45 mm (Cutomat side)	90 mm 45 mm (Cutomat side)	90 mm 45 mm (Cutomat side)
Safety guard: Trigger point	97 +3/-0 mm 52 +3/-0 mm (Cutomat side)	97 +3/-0 mm 52 +3/-0 mm (Cutomat side)	97 +3/-0 mm 52 +3/-0 mm (Cutomat side)
Roller length	660 mm	660 mm	660 mm
Roller gap	0.2–45 mm	0.2–45 mm	0.2–45 mm
Motorised roller gap reduction (according to software)	Yes	Yes	Yes
Sheeting speed of outfeed belt	85 cm / sec.	85 cm / sec.	85 cm / sec.
Rated power	1.4 kW	1.4 kW	1.4 kW
Supply voltage	3 x 220–480 V; 50 / 60 Hz	3 x 220–480 V; 50 / 60 Hz	3 x 220–480 V; 50 / 60 Hz
Space requirement in working position; dough catch pan pulled out	3649 x 1254 x 1400 mm	3804 x 1254 x 1400 mm	3855 x 1254 x 1400 mm
Space requirement in idle position	2359 x 1254 x 1909 mm	2086 x 1254 x 2154 mm	2838 x 1254 x 1909 mm
Machine weight without accessories	approx. 320 kg	approx. 330 kg	approx. 348 kg
Weight of automatic flour duster	18.2 kg	18.2 kg	18.2 kg
Weight of automatic reeling device	-	-	13 kg
Weight of flour catch pans	7.5 kg	7.5 kg	7.5 kg

**Technical specifications subject to change without notice.**



## 9.2 Supplementary information

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RONDO sheeters are distinguished by the following quality features:

- 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).
- Conveyor belts made of cotton material:  
The fabric consists of 100% cotton and is non-toxic.
- The rollers are hard chrome plated, and this coating is approved for contact with food.
- The scraper blades are made of plastic (POM-C), which is approved for contact with food and complies with the requirements of EU directive 10/2011 as well as the FDA specifications (Food and Drug Administration, USA).
- The dough catch pans are made of stainless steel (chromium nickel steel, DIN Mat. No. 1.4301, 1.4016), which is approved for contact with food.
- The rollers of the manual reeler and the automatic dough reeler that are in contact with dough are made of aluminium, are clear anodised and are approved for contact with food.
- The blades of the cutter shafts (Cutomat models) that are in contact with dough are made of stainless steel (chromium nickel steel, DIN Mat. No. 1.4301) which is approved for contact with food.
- Automatic flour duster with inox container:  
The container is made of stainless steel (DIN Mat. No. 1.4301, 1.4016), the delivery roller is aluminium, clear anodised, and the bristles of the brush are made of plastic (PA). These materials are approved for contact with food.
- Automatic flour duster with plastic container:  
The container is made of plastic (PS-TSG), the delivery roller is aluminium, clear anodised, and the bristles of the brush are made of plastic (PA). These materials are approved for contact with food.
- Flour container:  
The flour container is made of plastic (ABS), which is approved for contact with food.

## 9.3 Dismantling, dismounting and disposal

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### Notice

- Information about disposal and collection points can be obtained from your local authorities.
- The equipment manufacturer's instructions must be followed when disposing of equipment.
- The machine contains no materials that require special authorisation for their disposal.

### Dismantling

- End running production process.
- Disconnect electricity connection.

### Disposal

- Disassemble machine components as required.
- Recycle individual parts according to material type.
- Dispose of non-recyclable materials correctly.