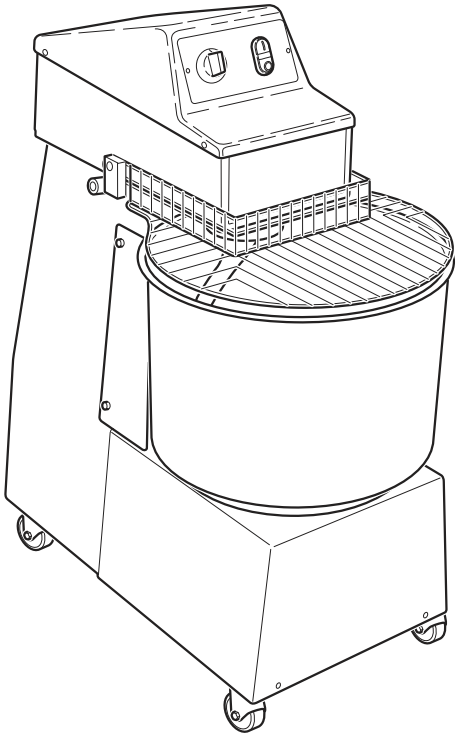
IMPASTATRICE - SPIRAL PASTRY MIXER
PÉTRISSEUSE A SPIRALE - TEIGKNETMASCHINE
AMASADORA - AMASSADEIRA



CE

Mod. FX - RB - RVE

I MANUALE D'USO E LA MANUTENZIONE - PARTI DI RICAMBIO

GB OPERATING AND SERVICE MANUAL - SPARE PARTS

F MODE D'EMPLOI ET D'ENTRETIEN - PIECES DE RECHANGE

D GEBRAUCHS- UND INSTANDHALTUNGSHANDBUCH - ERSATZTEILE

E MANUAL DE USO Y MANTENIMIENTO - PIEZAS DE RECAMBIO

COSTRUTTORE - MANUFACTURER - PRODUCTEUR - HERSTELLER - FABRICANTE - FABRICANTE

OEM - ALI SpA
Viale Lombardia, 33
46012 BOZZOLO (MN) Italia
Tel. 0376- 910511 - Fax 0376 - 920754

SEDI o AGENTI - OFFICES OR AGENTS - SIÈGES OU AGENTS
NIEDERLASSUNGEN oder VERTRETER - SEDES y AGEN-

....

Tel. : ..... - .....

Fax. : ..... - .....

....

Tel. : ..... - .....

Fax. : ..... - .....

Modello. .....
Model - Modèle - Modell - Modelo - Modelo

Numero di matricola. .....
Serial number - Numéro d' immatriculation - Kenn-Nummer - Número de matrícula - Número de matrícula

Data di consegna. ..... .
Delivery date - Date di livraison - Lieferdatum - Fecha de entrega - Data de entrega .....

DICHIARAZIONE CE DI CONFORMITA'

DECLARATION OF CONFORMITY* - DECLARATION CE DE CONFORMITE *CE-KONFORMITÄTSERKLÄRUNG* - DECLARACIÓN CE DE CONFORMIDAD' *DECLARAÇÃO CE DE CONFORMIDADE

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Tel. 0376- 910511 - Fax 0376 - 920754

Dichiara che il modello - *It is hereby declared that model*
Déclare que le modèle - *erklärt, daß die Maschine Modell*
Declara que el modelo - *Declara que o modelo*

FX = FX101-M / FX201-M / FX201-T / FX202-T / FX301-T FX302-T /

FX401-T / FX402-T / FX601-T / FX602-T
RVE = RVE201-M / RVE201-T / RVE202-T
RB = RB 301-T / RB 302-T / RB 401-T / RB 402-T

anno di costruzione - *Year of manufacture* - An de production - *Baujahr*
año de fabricación - *ano de fabricação*

I è conforme alle disposizioni legislative che traspongono le direttive e successivi emendamenti:
GB complies with the law provisions that transpose the directives and relevant amendments:
F est conforme aux dispositions législatives qui transposent les directives et amendements successifs:
D den gesetzlichen Richtlinienbestimmungen und nachfolgenden Änderungen:
E es conforme a las disposiciones legislativas que transponen las directivas y sucesivas enmiendas:
P encontra-se em conformidade com as disposições legislativas relativas as diretivas:

89/392 - 2004/108 - 2006/42 - 2006/95/CE

I e inoltre dichiara che sono state applicate le seguenti norme armonizzate
GB it is also hereby declared that the following harmonized provisions have been applied
F et en plus elle déclare que les normes suivantes ont été appliquées
D sowie folgenden harmonisierten Normen:
E y declara además que han sido aplicadas las siguientes normas armonizadas
P e declara além disso que foram aplicadas as seguintes normas harmonizadas

EN 60204-1; EN 60335-2-64; EN 292-1/2; EN 294
EN 55014; EN 55104; EN 60555-2/3

Firma del legale rappresentante - Signature of the legal representative
Signature du représentant légal - Unterschrift des Rechtsvertreters
Firma del representante legal - Assinatura do representante legal

(Finatti Paolo)

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Chapter 1

1.1 - GENERAL WARNINGS

- Before setting the machine at work the operator should have carefully red these instructions and have acquired a deep knowledge of the technical specifications and control devices.

- **To the operator is suggested to attend a training course on the use of the machine.**

- Before installing the machine make sure that the used area is compatible with the dimensions and the weight of the machine.

- For the installation or removal of any machine part, the used lifting and handling devices should be suitable to the weight and geometrical characteristics of the part to be lifted or handled.

- Only skilled and authorized personnel is allowed to start adjust or repair the machine. This handbook should be always consulted before to do any work on the machine.

- Mechanical parts and electrical components inside the machine are protected by totally enclosed panels fastened with screws.

- Before cleaning and/or maintaining the machine and before removing any type of protection, **make sure that the general switch is on "OFF" position (O),** in order to turn off the power while the operator is working.

- The power supply system of the purchaser should be provided with an automatic release device above the machine main switch and with a suitable earthling system complying with the accident prevention regulations.

- In case of repairs to be done on the main switch or in the main switch area, turn off the power of the electrical line.

- Any inspection and maintenance works requiring the removal of the safety protections are made under the responsibility of the user.
  Therefore it is recommended that the above mentioned works are done by authorized and skilled personnel only.

- Make sure that all safety devices (barriers, protections, carter, micro-switches, etc.) have not been tampered and are perfectly working. On the contrary, they should be repaired.

- **Do not remove the safety devices.**

- In order to avoid personal risks, only suitable tools should be used, in accordance with the local safety regulations.

- Do not tamper the electric and pneumatic plant or any other mechanism for any reason.

- Do not leave the machine unattended while it is working.

- Wear safety clothing only, approved by the law in force.

- In case of works to be done in a position that cannot be reached from the ground, use safe ladders or lifting devices only, in conformity with the local safety regulations.

- In case of repairs to be done near or under the machine, make sure that:
  • there are no machine members that can start working and/or instable parts placed on the machine or near the machine.

- Do not use your hands instead of suitable tools to work on the machine.

- Do not use your hands or other tools to stop any moving parts.

- Do not use matches, lighters or flames near the machine.

- **YOUR BEST ATTENTION SHOULD BE PAID TO THE WARNING PLATES LOCATED ON THE MACHINE BEFORE DOING ANY WORK ON THE MACHINE OR NEAR THE MACHINE.**

- The user is obliged to keep all the warning plates in legible conditions and, if required, to change their position in order to make them fully visible to the operator.

- Moreover the user is obliged to replace any warning plate that, for any reason, has been damaged or is not clearly legible. New warning plates can be obtained through our Technical Service Centre.

- **Stop the machine before doing any repair work.**

- In case of malfunction of the machine or damages to its components, get in touch with the maintenance engineer and do not try to repair the machine.

- **It is absolutely prohibited to use the machine for other purposes different from those expressly indicated and documented.**
  The machine should be used always when and how provided by the good technique, in compliance with the EEC machine directive 89/392 and in compliance with the regulations concerning health and safety of the workers, as indicated by the local regulations or according to the EEC directive 89/391.

- **The manufacturer declines all responsibility for any accident or damage to persons or properties arising from the non compliance with the safety regulations and the directions of this booklet.**

- **THESE SAFETY REGULATIONS INTEGRATE OR COMPLEMENT THE LOCAL SAFETY REGULATIONS.**
- **DO NOT make hurried or inaccurate repairs that may compromise the good running of the machine and the safety of the operator.**
- **IN CASE OF DOUBT ALWAYS ASK FOR THE PRESENCE OF SKILLED PERSONNEL.**
- **FOR ANY ELECTRIC/ELECTRONIC OR MECHANIC TAMPERING OF THE MACHINE BY THE USER OR IN CASE OF A NEGLIGENT USE OF THE MACHINE, THE MANUFACTURER IS RELIEVED FROM ANY RESPONSIBILITY AND THE USER WILL BE THE ONLY ONE RESPONSIBLE AGAINST THE COMPETENT AUTHORITIES FOR THE ACCIDENT PREVENTION.**

1.2 - REFERENCE NORMATIVE

- The machine and its safety components have been manufactured in compliance with the directives indicated in the declaration of conformity.

1.3 - DESCRIPTION OF THE SYMBOLS

Many accidents are caused by a poor knowledge of and by a non compliance with the safety regulations to put into practice during the functioning and maintenance works to be done on the machine.
In order to avoid any accidents, read understand and follow all the warnings and cautions contained in this booklet and those written on the plates located on the machine.
To identify the safety messages included in this booklet, following symbols have been used:



DANGER
This symbol is used in the safety messages contained in the booklet in case of potential danger situations or possibility to cause serious injuries or dead.



ATTENTION
This symbol is used in the safety messages of the booklet for any danger situation that, if disregarded, may cause small or moderate injuries or damages. The message can be used also in case of danger situations that may cause damages to the machine.



IMPORTANT
This symbol is used in case of precautionary measures to be taken in order to avoid any operation that may reduce the life of the machine or for important communication to the operator.



For clarity reasons, some illustrations of this booklet show the machine without safety guards. DO NOT USE THE MACHINE WITHOUT SAFETY GUARDS.

1.4 - COMPOSITION OF THE MACHINE

FX,RB,RVE kneading machines are the result of a multiyear experience.

- The machine consists of a bearing structure the motor is housed in, of a head, which controls the kneading spiral element, of a container to contain the dough mix.
- Depending on the concerned model, it is possible to get a tip-up head or an extractable container.

1.5 - PREARRANGEMENTS AT PURCHASER'S CHARGE

a) Prearrangement of the installation place.

- The purchaser shall prearrange a supporting surface for the machine as indicated in the chapter "Installation".

b) Electric prearrangement.

- The power system should comply with the local regulations and provided with an efficient earthing.
- Place an omnipolar sectioning device on the power feed line, above the machine.
- **The size of the electric power cables should comply with the maximum current required by the machine, so that the total voltage drop at full charge will be less than 2%.**

1.6 - EMERGENCY OPERATIONS IN CASE OF FIRE

a) In case of fire turn off the power by disconnecting the main power switch.

b) Put out the fire by means of suitable fire extinguishers.

DANGER

Do not attempt to put out the fire by using water.

1.7 - EXPLOSION RISK

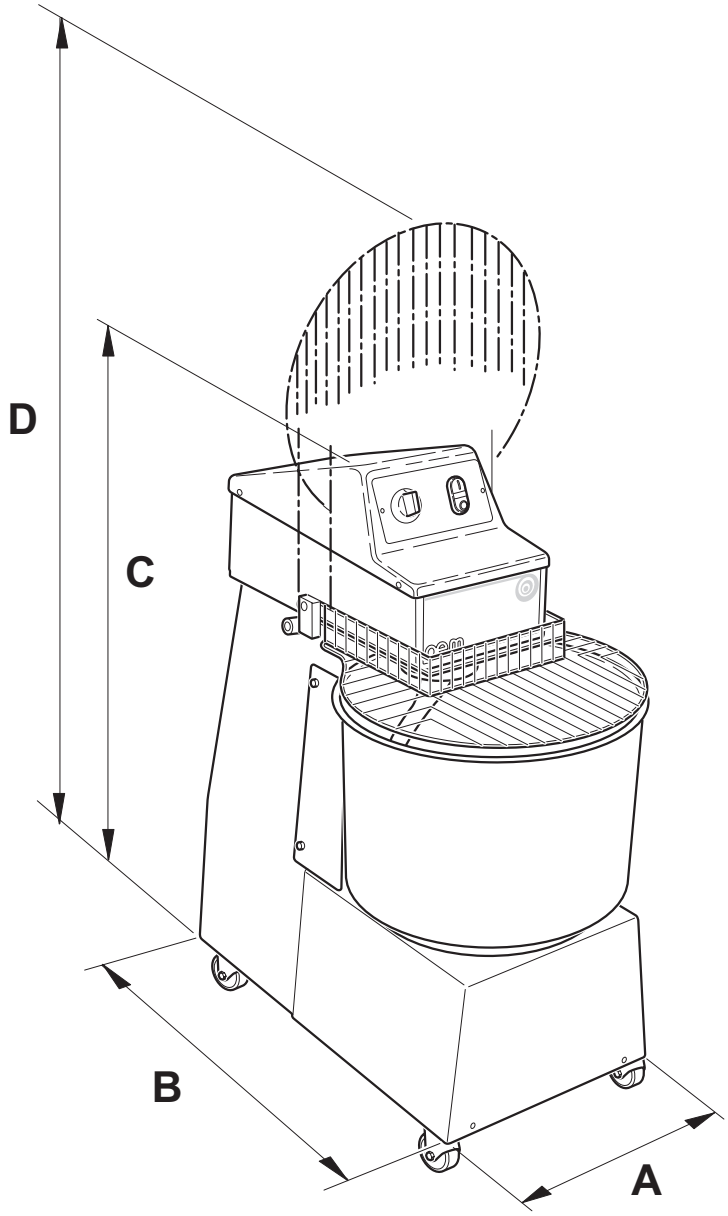
- The machine is not suitable to be used in a place with explosion risk.

1.8 - SOUND PRESSURE LEVEL

FX,RB,RVE models have been developed to keep a continuous weighed acoustic pressure level A (dB) lower than 70dB during the machine idling.

Chapter 2

OVERALL DIMENSIONS



Model FX/RVE/RB	A	B	C	D
101	**28,5**	54	67	83,5
201 - 202	**38,6**	66,3	81	101,6
301 - 302	**43**	78	88	125,8
401 - 402	**48**	80,5	88	115,8
601 - 602	**58,5**	98,6	109	140,6

sizes in mm

Indicated height (C-D) is without wheels, with wheels, the height has a 9cm increase.
Indicated height (C-D) is without feet, with feet, the height has a 2.5cm increase.

2.1 - TECHNICAL FEATURES

Max working temperature	60°C
Relative humidity	10 ÷ 80 %

MODEL FX	Container capacity	Speed	Power	Electric connection	Net weight
FX101/M	10 l - 8 kg	1	0,37 kW	230 V ~ 1	40 kg
FX101/T	10 l - 8 kg	1	0,37 kW	400 V ~ 3N	40 kg
FX201/M	26 l - 20 kg	1	0,6 kW	230 V ~ 1	80 kg
FX201/T	26 l - 20 kg	1	0,75 kW	400 V ~ 3N	80 kg
FX202/T	26 l - 20 kg	2	0,45 - 0,56 kW	400 V ~ 3N	80 kg
FX301/T	37 l - 30 kg	1	1,1 kW	400 V ~ 3N	115 kg
FX302/T	37 l - 30 kg	2	0,75 - 1,1 kW	400 V ~ 3N	115 kg
FX401/T	47 l - 40 kg	1	1,1 kW	400 V ~ 3N	125 kg
FX402/T	47 l - 40 kg	2	0,75 - 1,1 kW	400 V ~ 3N	125 kg
FX601/T	83 l - 60 kg	1	2,2 kW	400 V ~ 3N	210 kg
FX602/T	83 l - 60 kg	2	1,87 - 2,6 kW	400 V ~ 3N	210 kg

MODEL RVE	Container capacity	Speed	Power	Electric connection	Net weight
RVE201/M	26 l - 20 kg	1	0,6 kW	230 V ~ 1	85 kg
RVE201/T	26 l - 20 kg	1	0,75 kW	400 V ~ 3N	85 kg
RVE202/T	26 l - 20 kg	2	0,45 - 0,56 kW	400 V ~ 3N	85 kg
RB301/T	37 l - 30 kg	1	1,1 kW	400 V ~ 3N	120 kg
RB302/T	37 l - 30 kg	2	0,75 - 1,1 kW	400 V ~ 3N	120 kg
RB401/T	47 l - 40 kg	1	1,1 kW	400 V ~ 3N	130 kg
RB402/T	47 l - 40 kg	2	0,75 - 1,1 kW	400 V ~ 3N	130 kg

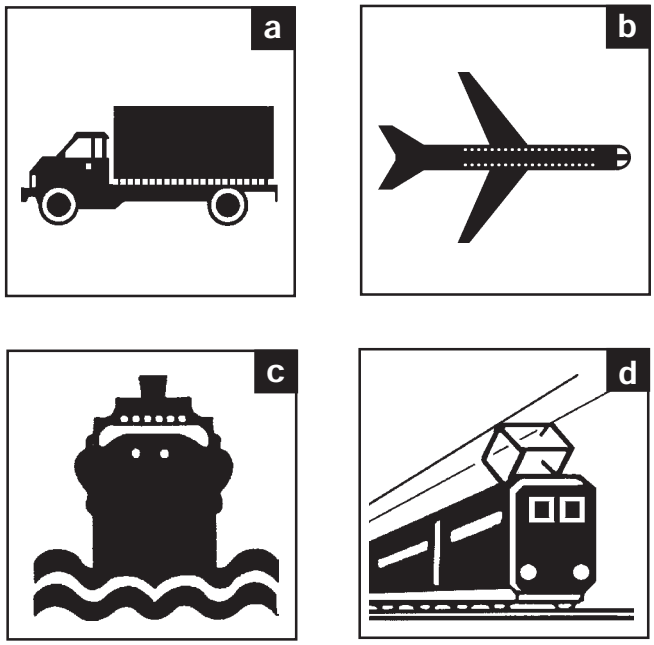
FX = Versions with fixed head -- RB = Tip-up head
RVE = Versions with tip-up head and extractable container

2.1.a - Container rotation speed Spiral for new kneading machines

MOD. FX/RVE/RB	Container capacity	Speed	Ø Container	Ø Max spiral	r.p.m.	Container number of revolutions r.p.m.	Spiral number of revolutions r.p.m.
FX101/M	10 l - 8 kg	1	260mm	110mm	1400	18	83
FX201/M	26 l - 20 kg	1	360mm	140mm	1400	13	75
FX201/T	26 l - 20 kg	1	360mm	140mm	1400	13	75
RVE201/M	26 l - 20 kg	1	360mm	140mm	1400	13	75
RVE201/T	26 l - 20 kg	1	360mm	140mm	1400	13	75
FX202/T	26 l - 20 kg	2	360mm	140mm			
		1 Speed			950	12,5	71,5
		2 Speed			1400	18	105
RVE202/T	26 l - 20 kg	2	360mm	140mm			
		1 Speed			950	12,5	71,5
		2 Speed			1400	18	105
FX301/T	37 l - 30 kg	1	400mm	220mm	1400	11	85
RB301/T	37 l - 30 kg	1	400mm	220mm	1400	11	85
FX302/T	37 l - 30 kg	2	400mm	220mm			
		1 Speed			950	10,5	83
		2 Speed			1400	15	120
RB302/T	37 l - 30 kg	2	400mm	220mm			
		1 Speed			950	10,5	83
		2 Speed			1400	15	120
FX401/T	47 l - 40 kg	1	450mm	220mm	1400	13	85
RB401/T	47 l - 40 kg	1	450mm	220mm	1400	13	85
FX402/T	47 l - 40 kg	2	450mm	220mm			
		1 Speed			950	12,5	83
		2 Speed			1400	18	120
RB402/T	47 l - 40 kg	2	450mm	220mm			
		1 Speed			950	12,5	83
		2 Speed			1400	18	120
FX601/T	83 l - 60 kg	1	550mm	240mm	1400	10,5	56
FX602/T	83 l - 60 kg	2	550mm	240mm			
		1 Speed			950	9,5	51
		2 Speed			1400	14	75

2.2 - TRANSPORT

FIG. 1



2.2a - Shipment (Fig. 1)

The machine is positioned on a wooden pallet, in a strapped cardboard box.

The machine can be delivered with one of the following means of transport:

a) Land transport (lorry)
b) Air transport
c) Sea transport
d) Railway transport

The way of transport will be agreed in course of contract between supplier and purchaser.

IMPORTANT

The packing containing the machine should be kept away from the weather. Do not put other boxes or materials on it.

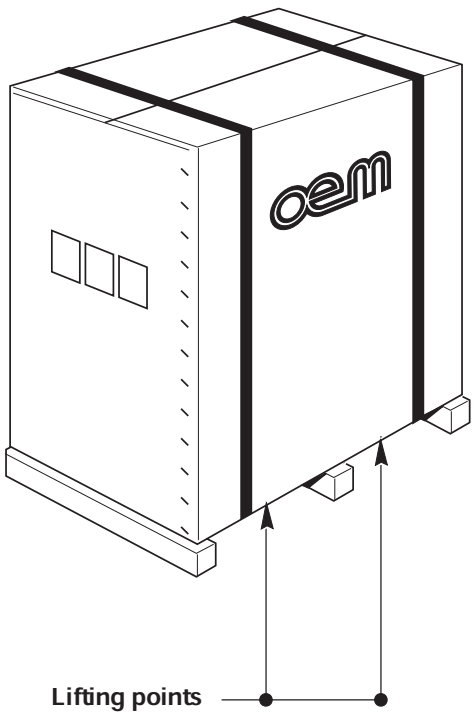
2.2b - Lifting of the packing (Fig. 2)

The box should be handled with the most care. To lift and to position the box use suitable lifting systems, according to the weight of the machine.
The box should be lifted by using a crane or a hoist with appropriate belts or by means of a lift track, by inserting the forks in the appropriate joints.

DANGER

Any handling and lifting operation should be done by skilled personnel, authorized to use appropriate equipments.
The manufacturer declines all responsibility for any damage to persons or things caused by inobservance of the current safety regulations regarding lifting and moving of materials inside or outside the factory.

FIG. 2



2.2c - Storage

IMPORTANT

The box containing the machine should be stored away from weather. Do not put other boxes or materials on it.

2.3 - RECEPTION OF THE MACHINE

Upon reception of the machine make sure that the packing is complete and not damaged. Should the packing be complete, remove it as specify at point 2.4 (unless otherwise instructed by the manufacturer).
Check if the instruction booklet is inside the packing as well as the components specified in the transport documentation.
In case any damage or defect is found:

a- Inform immediately the transport company and your agent, both by phone and by registered letter with return receipt;

b- Inform the manufacturer as mentioned above, addressing the correspondence to:

OEM - ALI S.p.A.
46012 BOZZOLO (MN) Italia
Viale Lombardia, 33
Tel. 0376- 910511
Fax 0376 - 920754

FIG. 3



2.4 - UNPACKING (Fig. 3)

To remove the packing from the machine proceed as follows:

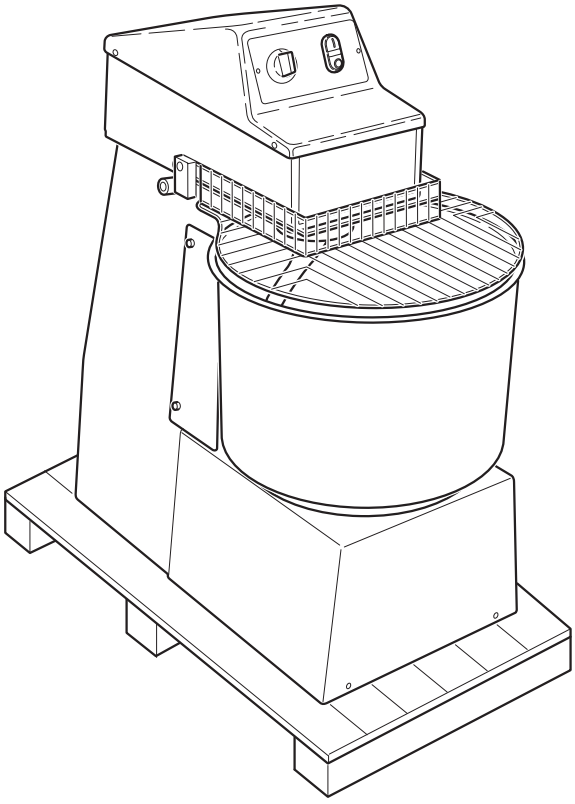
- Cut the straps (1) that tie up the carton.
- Open the carton (2), by removing the metallic clips.
- Remove the cardboard packaging (2).
- Check if everything is complete.
- Check if the delivery is complying with the PACKING LIST.

ATTENTION

All packing materials should be collected and sent to the special recovery centres for a correct recycling.

IMPORTANT

Any damage or defect or non conformity with the packing list should be immediately reported and, in any case, it should be notified within 8 days from the date of reception of the machine. On the contrary the goods are to be considered as accepted.



25 - IDENTIFICATION OF THE COMPONENTS (Fig. 4)

1. Head
2. Control instrument panel
3. Protection grid
4. Container
5. Base
6. Electric cable
7. Spiral element
8. Wheels or adjustable feet
9. Data plate

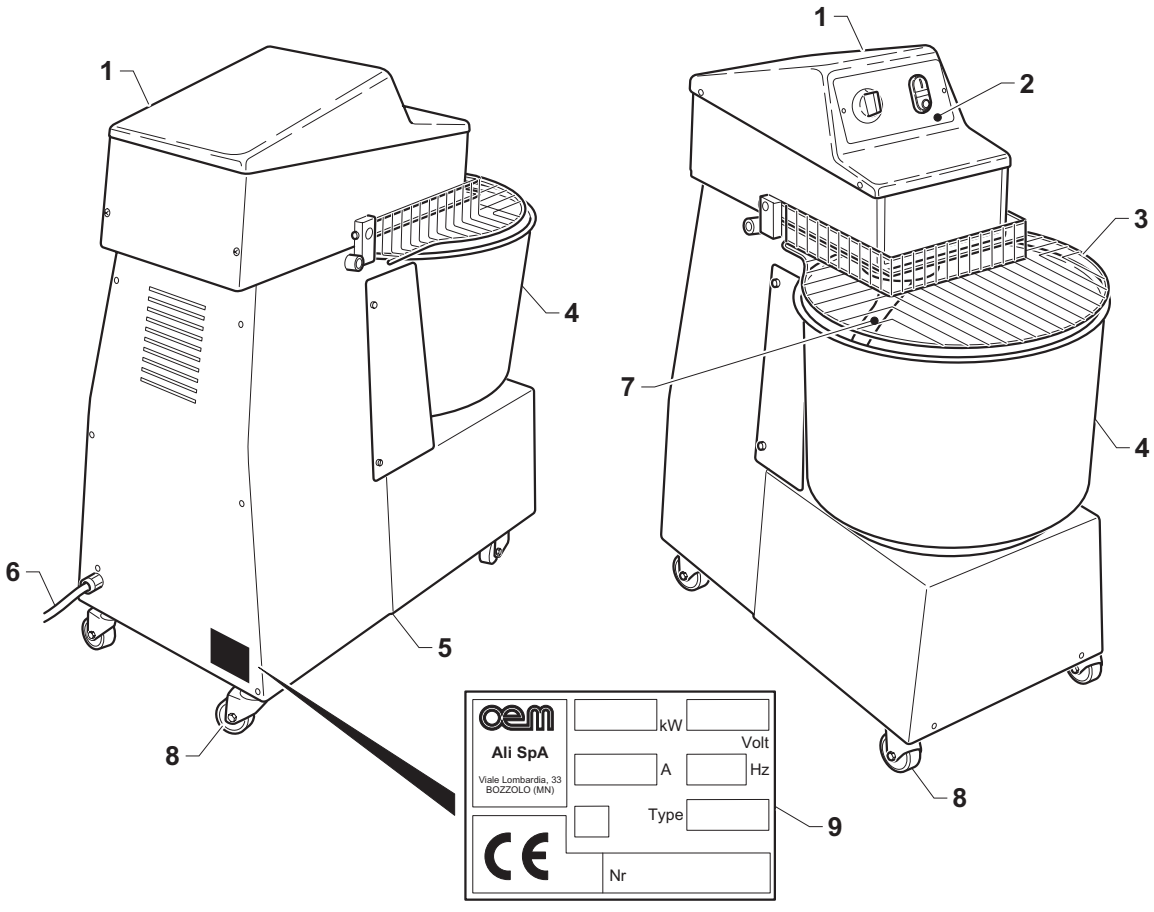
26 - IDENTIFICATION OF THE MACHINE (Fig. 4)

The serial number and identification data of the machine are punched on a plate (9) fastened to the machine base.

IMPORTANT

The machine serial number should be always mentioned in your request of technical assistance or in your spare part orders.

FIG. 4



Chapter 3

DANGER

All operations described in this chapter shall be carried out by skilled technicians.

3.1 - LIFTING OF THE MACHINE (Fig. 1)

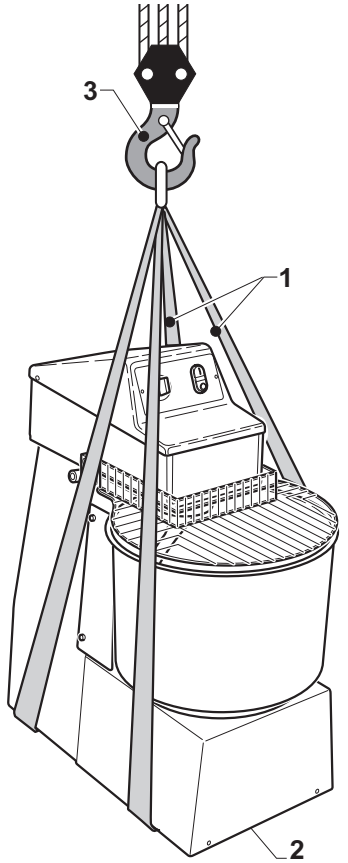
The machine shall be lifted by two persons in case of FX 101 and RVE 101 versions, since they shall be lifted from their bottom, while the other models shall be lifted by utilizing a crane or a hoist as follows:

- Insert two belts, (1) suitably dimensioned to the weight of the machine, under the base (2) of the machine and connect them to the hook (3) of a crane or hoist.

IMPORTANT

To hoist the machine do not use steel belts as they may damage the outside body.

FIG. 1



3.2 - WHEELS/FEET ASSEMBLING (Fig 2)

Depending on the concerned models, the machines are shipped with demounted adjustable feet or wheels in order to simplify their transport, for assembling proceed as follows:

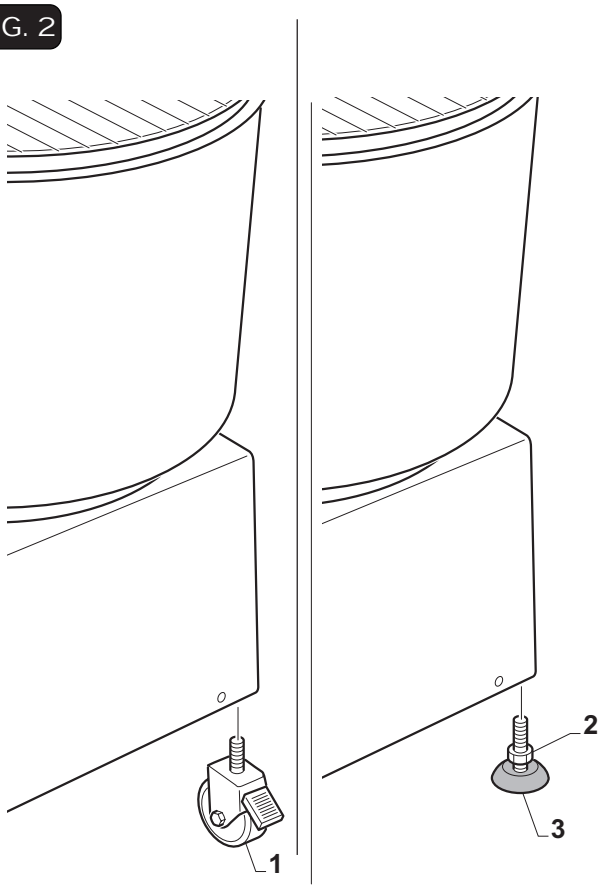
Wheels assembling

Lift the machine as described in the preceding paragraph.
Tightly fix the wheels (1) under the machine base, the braking wheels shall be fixed at the front of the machine

Feet assembling

Lift the machine as described in the preceding paragraph.
Screw the feet (2) on the machine base, after positioning the machine level it and tighten the feet by the lock nut (3).

FIG. 2



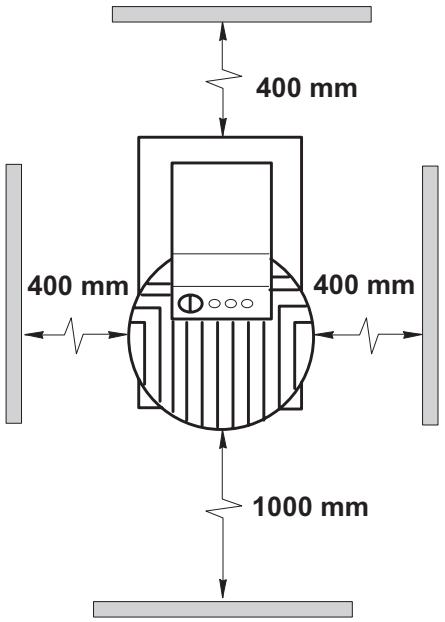
3.3 - POSITIONING OF THE MACHINE (Fig. 3)

DANGER

Make sure that the carrying plane is suitable to support the charges as mentioned in the chapter "TECHNICAL SPECIFICATIONS".

The machine shall be positioned by carefully following the instructions as reported in Fig 3, since they indicate the minimum distances needed by the user or technician in order to properly carry out every work and/or maintenance operation.

FIG. 3



3.4 - ELECTRICAL CONNECTION (Fig. 4)

DANGER

- **The power feed line should be provided with a suitable omnipolar DISCONNECTING SWITCH** (automatic thermomagnetic switch or differential) **placed before the control unit main switch, with a minimum contact opening of 3 mm.**
- **The earthing system should comply with the local electric regulations in force.**
- **The electric power cables should comply with the maximum current required by the machine, so that the total voltage drop at full charge will be less than 2%.**
- **The specifications of the electric power line should correspond to the specifications of the identification plate and to those mentioned in the technical specifications table that can be consulted in the first part of this booklet.**

DANGER

Before connecting the machine with the electric line, make sure that the DISCONNECTING SWITCH is disconnected (line not energized), therefore:

- Connect the power cable (1) of the machine with the disconnecting switch placed above.

FIG. 4

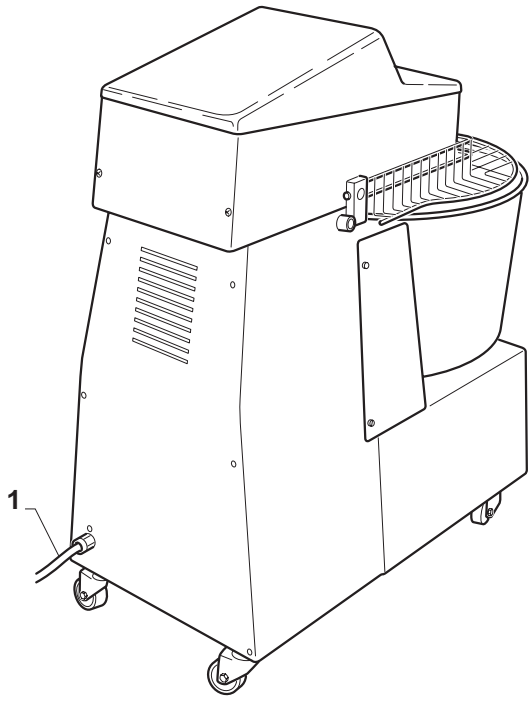
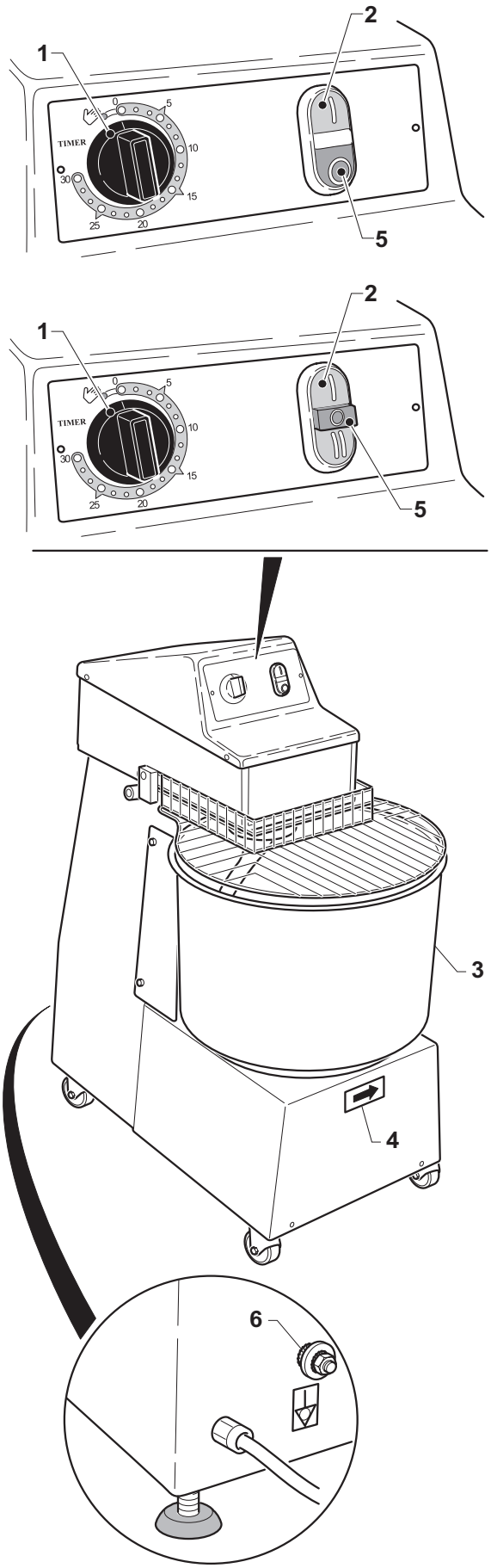


FIG. 5



3.4.a - Control of a correct electrical connection (Fig. 5)

For the connection 230/400V three phase, it is necessary to check if the engine rotation is right, to do this proceed as follows:

- The cutout switch placed at the machine upper side shall be positioned on "ON".
- Turn the timer knob (1) onto "✋".
- Press the key (2) "⏽".
- Visually make sure the container (3) rotates according to the direction indicated by the arrow (4).

  Disconnect the machine by pressing "◎" (5)

  If the rotation direction is contrary to the arrow direction, proceed as follows:

⚠ DANGER ⚠

Before making any change in the electrical connection, make sure that the <u>DISCONNECTING SWITCH</u> is disconnected (line not energized), then: reverse two of the three phase wires on the main switch and check again the correct rotation.

3.4.b - Unipotential connection (Fig. 5)

The machine is provided with a screw (6) for unipotential connection.

To make the connection, unscrew the screw nut (6), connect the cable of the unipotential net to the screw and tighten the nut again.

3.5 - FIRST START (Fig. 5)

- The cutout switch placed at the machine upper side shall be positioned on "ON".
- Turn the timer knob (1) onto "✋".
- Press (2) "⏽".
- Let the machine idle for a few minutes and check if the rotation is regular and free.
- Disconnect the machine by pressing "◎" (5).

Chapter 4

4.1 -TYPE OF USE AND CONTRAINDICATIONS

IMPORTANT

FX,RB and RVE kneading machines are professional machines being suitable for pizza restaurants and handicraft/industrial pizza dough productions.
The ingredients to prepare the pizza dough shall be inserted in the machine;
The machine should be used for this purpose only; any other use will release the manufacturer from all responsibilities for accidents to persons or properties and will cancel all guarantee rights.

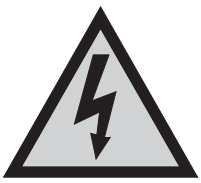
4.2 - SAFETY PLATES (Fig. 1)

The warning plates with explanatory symbols are to be found in all those areas that may be dangerous for operators or engineers.

DANGER

Anyone preparing to work on the machine should protect the warning plates with the safety instructions. The non compliance with the instructions mentioned on the safety plates will release the manufacturer from all responsibilities for damages or injuries to persons or properties that may arise.

Danger: machine under voltage



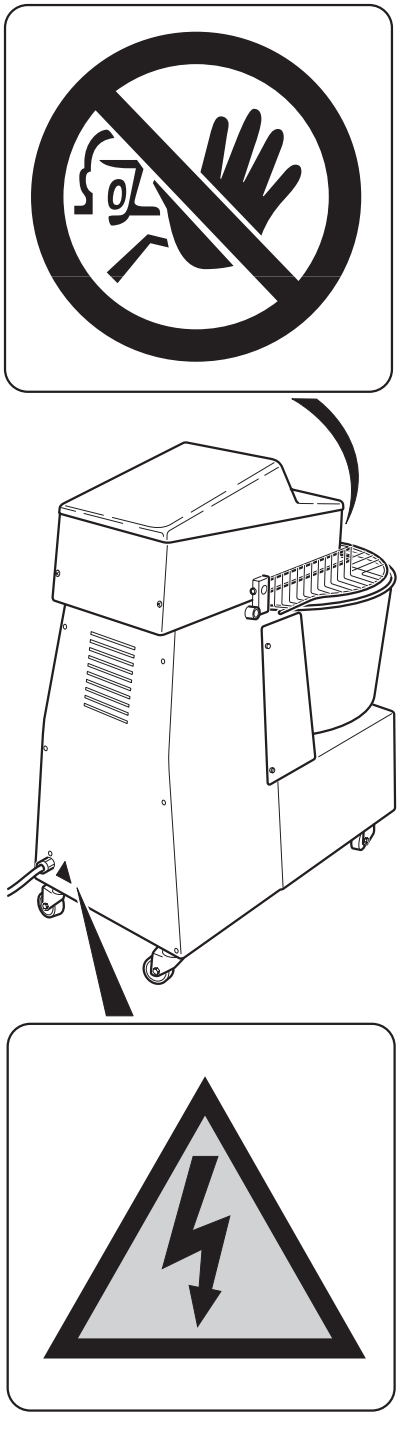
• Do not work with the machine under voltage.

Dangerous for hands



• Do not insert your hands in the machine, when it is functioning.

FIG. 1



4.3 - SAFETY DEVICE (Fig. 2)

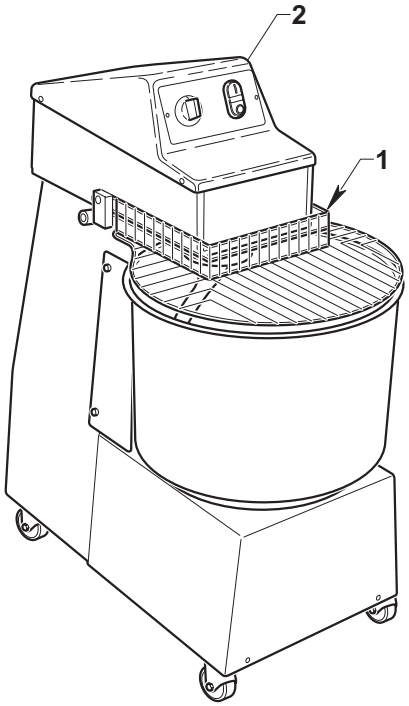
The machine is provided with following safety systems:

1) All danger areas are protected by safety guards with screws.

2) In models with fixed head, the machine is equipped with a microswitch, which stops the spiral element functioning, when the protection grid (1) shall be lifted; in case of models with tip-up head, there is a grid microswitch and also another microswitch, which stops the spiral element functioning, when the head (2) is lifted.

3) If by enabling one of the two safety microswitches the machine stops, you shall press "Ⓘ" or "Ⓘ" again, depending on the concerned model, to restart the machine.

FIG. 2



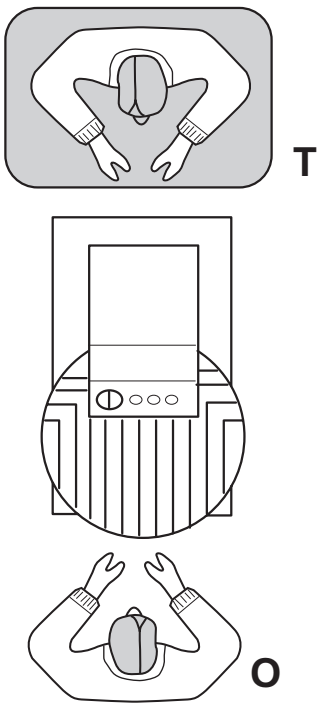
4.4 - OPERATOR AREAS (Fig. 3)

During the machine functioning, the user is in front of it, so that he is able to easily insert/remove the dough in/from the container;
allowed positions: see Fig 3 positions (O).
To maintain the machine, the technician can place himself on the rear part of the machine - position (T).

4.5 - RESIDUAL DANGER AREAS (Fig. 3)

There are no remaining danger areas.

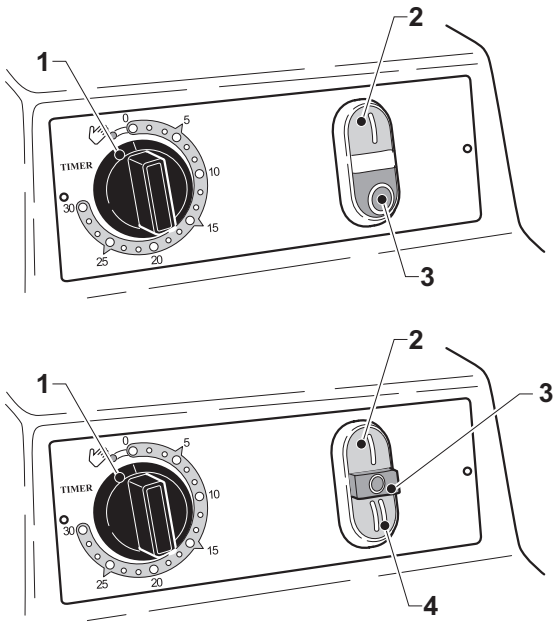
FIG. 3



Chapter 5

5.1 - CONTROL BOARD AND SIGNALLING LAMPS (Fig 1)

FIG. 1



On the machine you can find following control elements:

1. **Timer**
   The timer has three positions:
   "✋"
   allows the machine manually to function, to start the cycle press "Ⅰ" or "Ⅱ", depending on the concerned model, to stop the cycle press "◎".
   "O"
   the machine functioning is disabled.
   "Minute counter (1a)"
   It is possible to set the machine functioning minutes (from 0 to 30 minutes) by turning the timer knob (1) clockwise, then press "Ⅰ" or "Ⅱ", depending on the concerned model, to start the cycle; the latter ends when the timer knob (1) reaches "**O**".

2. **Green starting push-button "Ⅰ" 1st speed.**
   enabled by turning the timer knob (1) on "✋" or onto the minute counter.
   If you press it, the machine starts.

3. **Red stop push-button "◎"**
   If you press it, the machine stops.

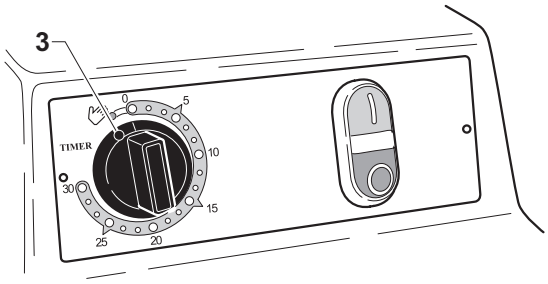
4. **Green starting push-button "Ⅱ" 2 speed. (If any)**
   Enabled by positioning the timer knob (1) on "✋"or on the minute counter.
   If you press it, the machine starts.

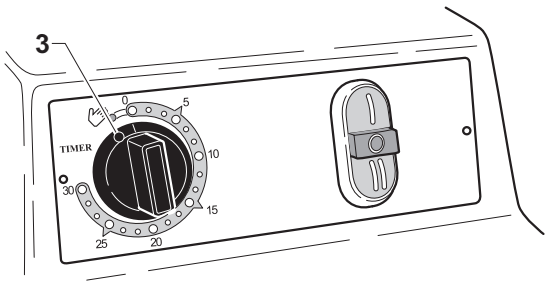
5.2 - FUNCTIONING

FIG. 2

5.2a - Machine preparation and functioning (Fig 2)

- Lift the protection grid (1) and insert the right quantity of ingredients in the container to prepare the dough (2). The machine capacity is suited to prepare normal doughs; approximately 65% of flour and 35% of water. In the event you need the dough to be thicker, capacity shall be reduced.
- Lower the protection grid (1) and energize by operating the cutout switch placed at the machine upper side.
- Turn the time knob (3) towards "✋" to allow the machine manually to function or towards the right to get a timed functioning by positioning the knob on the wished time.
- In case of machines being equipped with two speeds, the kneading process shall be started with the second speed by pressing "Ⅱ", before a dough hardening occurs "◎" then press "Ⅰ".
  In case of machines equipped with one speed, press "Ⅰ".

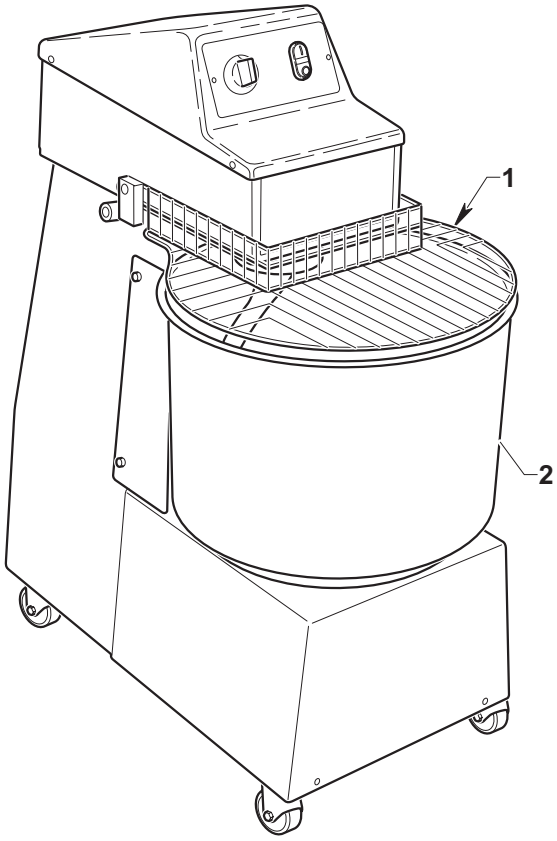




IMPORTANT

In case of machines with two speeds, DO NOT use the second speed when the dough is well-mixed.

It is also possible to add in ingredients through the grid (1).



5.2b - Machine stop under emergency conditions (Fig. 2)

- In case of EMERGENCY conditions, press "◎" or lift the grid (1).

5.2c - Machine disconnection (Fig. 2)

- The machine automatically stops when the timer knob (3) reaches "0" or, in case of manual functioning, press "◎".

WARNING

The machine shall never be disconnected by lifting the protection grid, since electric parts of the machine could be damaged.
In case the machine has been disconnected by lifting the grid (1), to restart the cycle press "Ⅰ" or "Ⅱ" (if any).

5.2d - Head lifting (For models being equipped with) (Fig.3)

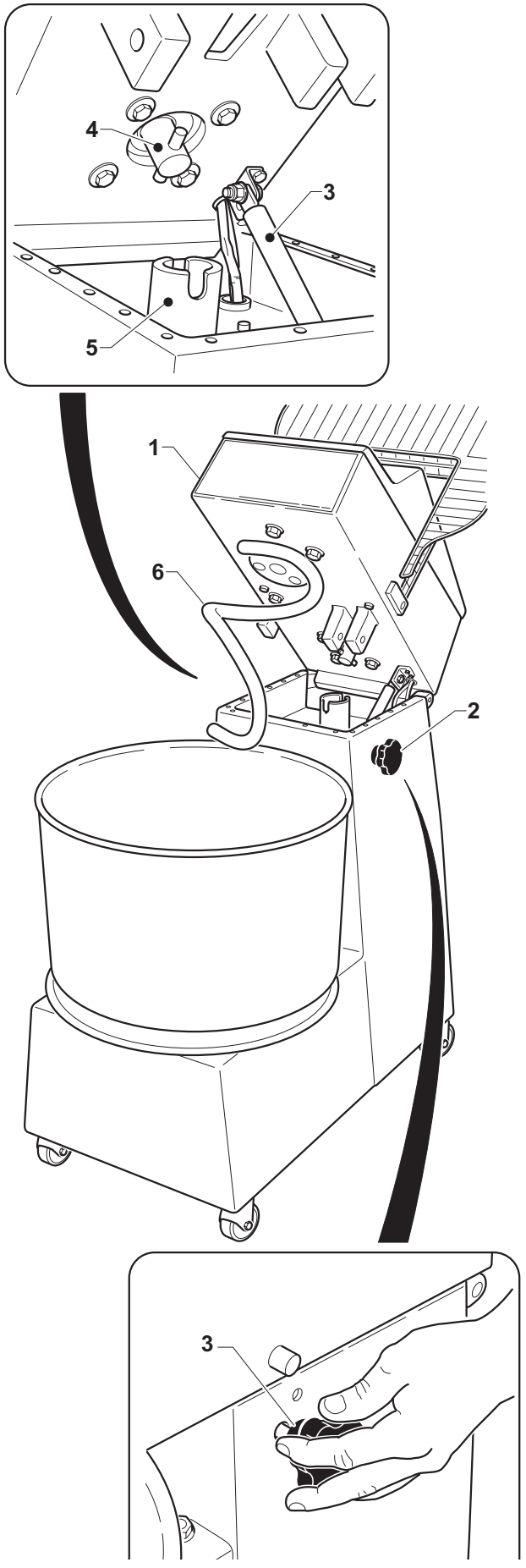
DANGER

The head (1) shall be lifted when the machine does not function and the cutout switch placed at the upper part of the machine is off.

The machine is equipped with a safety microswitch, which stops the machine functioning in case of a lifting of the head.

- Loosen both knobs (2) placed on both structure sides, until the head (1) is released.
- Lift the head (1), completely; the head position is kept by the hydraulic absorber (3).
- To lower the head, make sure the coupling between the head joint (4) and the motor joint (5) is correct, if it is not the case, manually rotate the spiral element (6) to allow the two joints to fit together.
- Tighten the knobs (2) to fix the head.

FIG. 3



5.2e - Container removal (For models equipped with)

- Stop the machine and lift the head as indicated in the relevant paragraph.
- Release the container (1) by turning the coupling disk (2) counterclockwise.
- One or two persons (depending on the weight) shall lift the container and remove it.
- To mount the container (1) again, the three pins (3) placed on the container bottom shall be inserted in their relevant seats (4) being on the coupling disk (2).
- Fix the container by turning the coupling disk (2) counterclockwise.
- Lower the head as indicated in the relevant paragraph.

DANGER

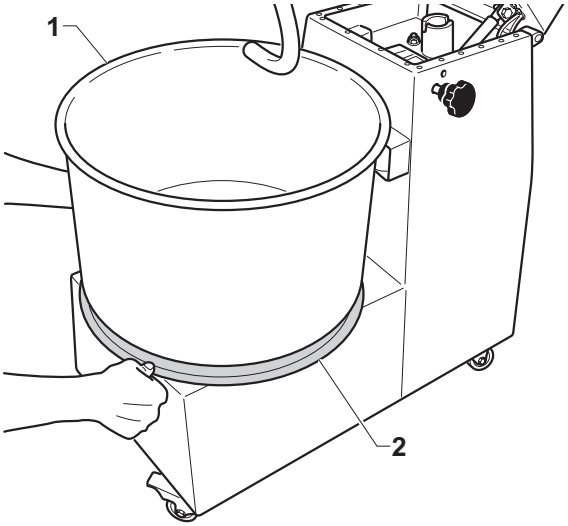
Always properly position the container before running the machine.

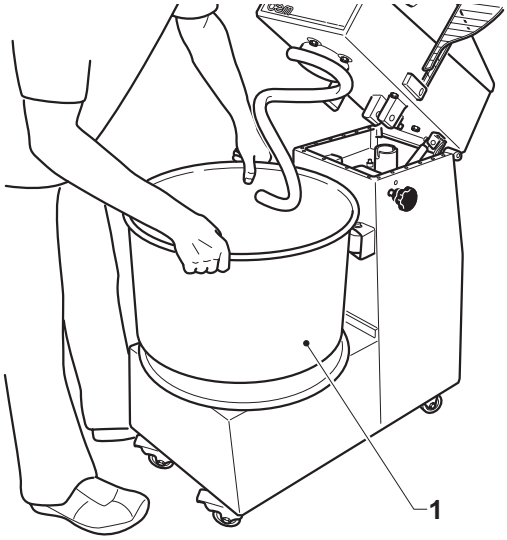
5.3 - MALFUNCTIONING, CAUSES AND REMEDIES

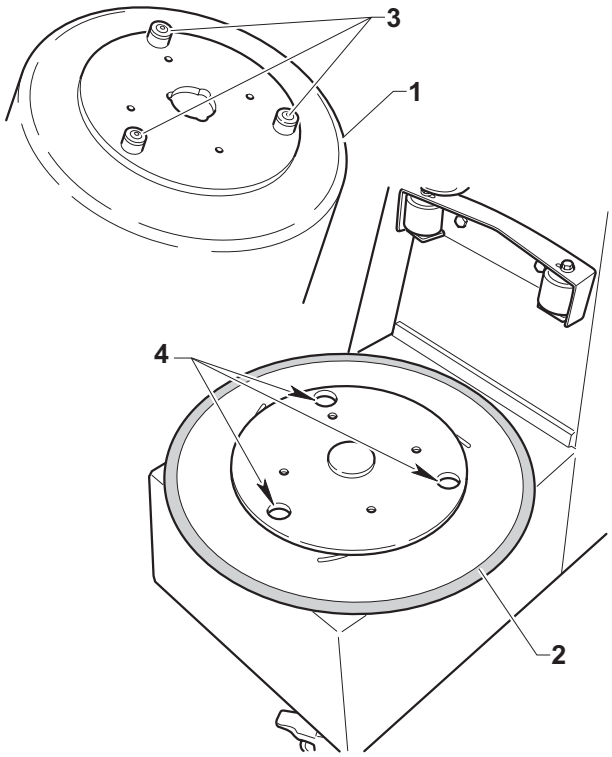
-The machine doesn't start:

- check the electric connection.
- make sure that no foreign bodies are inside the machine and stop the rotation.
- make sure the timer knob is on "✋" or on the minute counter position.
- make sure both grid and head are properly lowered and the head fixing knobs are tightened.

FIG. 4







Chapter 6

6.1 - ROUTINE AND PLANNED MAINTENANCE

6.1.a- In general

DANGER

The routine and planned maintenance works should be performed when the machine is stopped and the main switch is in position "(0)" OFF.

The routine maintenance works have been divided in two types:

- **ROUTINE MAINTENANCE:**
  It includes all the maintenance works to be made on the machine everyday.

- **PLANNED MAINTENANCE:**
  It includes all the maintenance works to be made according to a maintenance plan in order to ensure a correct working of the machine.

6.1.b - Routine maintenance

6.1.b.a - Machine cleaning

- The outer part of the machine shall be cleaned by utilizing a water-soaked cloth.

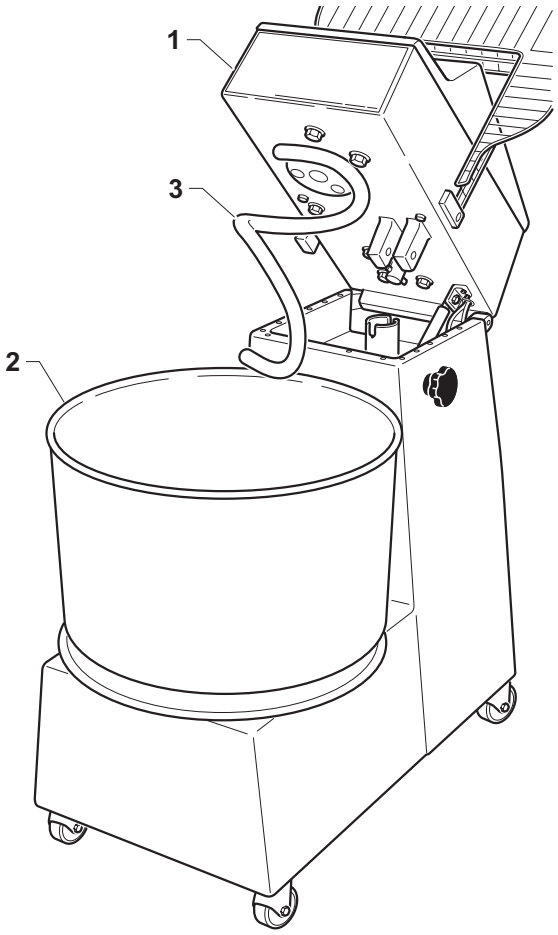
- In case of machines equipped with head (1), lift the latter and remove the container (2), as indicated in the relevant chapters.

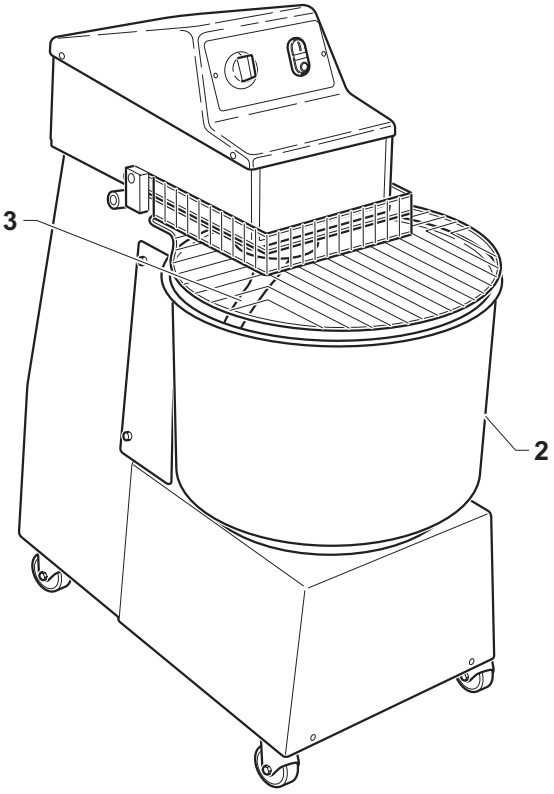
- Clean the container (2) by washing it with water and utilizing detergents or other degreasing, non-chemical products being suitable for food equipment.

- Clean the spiral element (3) by utilizing a water-soaked sponge.

- Mop the machine components and in case of machines equipped with container, mount the latter again and lower the head.

FIG. 1





6.1.c - Planned maintenance works

6.1.c.a - Chains tensioning check (Fig 2) (EVERY 2000 hours or yearly)

DANGER

This operation must be carried out by a qualified technician.

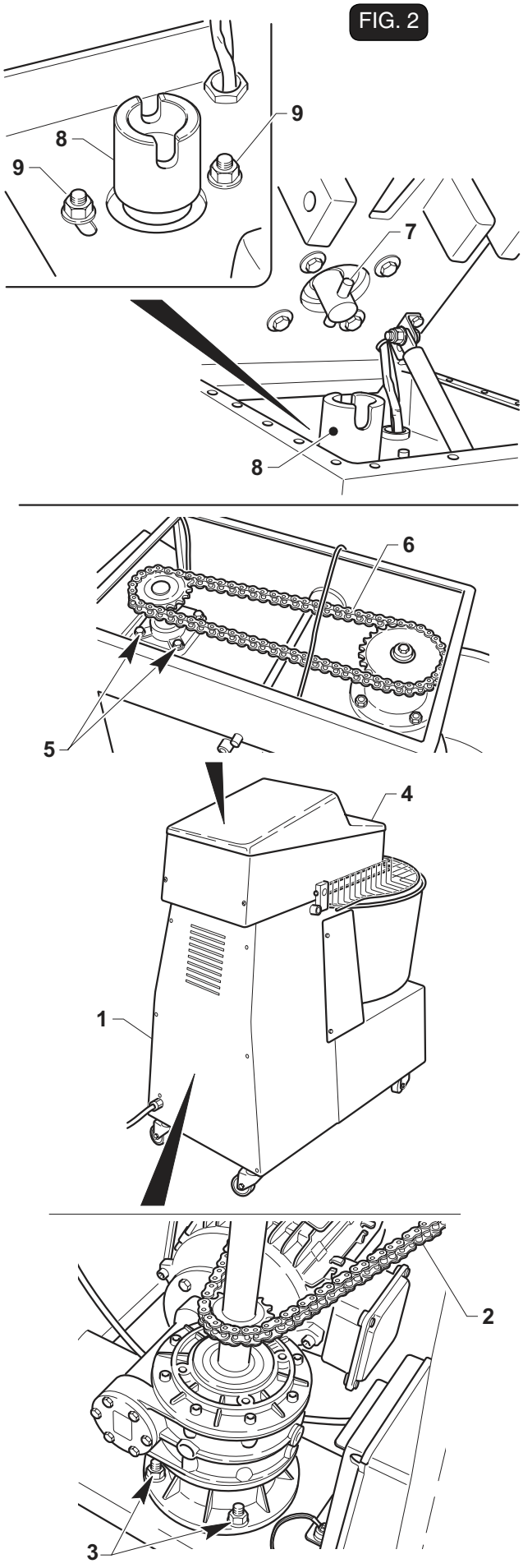
Container rotation chain tensioning.

- Remove the rear case (1) by unscrewing the relevant screws.
- Tension the chain (2) by loosening the gearmotor nuts (3), then tension the chain and tighten the nuts (3).
- Lubricate the chain by using lubricating grease.

Spiral element rotation chain tensioning.

- Remove the rear case (1) by unscrewing the relevant screws.
- Remove the head case (4) by unscrewing the relevant screws, in case of models being equipped with head, lift the latter.
- Loosen the bearing nuts (5) and tension the chain (6), then tighten the nuts (5). In versions equipped with tip-up head, after tensioning the chain, you shall center the drive joint (7) with the relevant joint (8) placed on the machine structure. For adjusting, loosen the nuts (9), then make sure the joints are properly coupled and tighten the nuts (9).
- Lubricate both the chain and the bearings by utilizing lubricating grease.

FIG. 2



Chapter 7

7.1 - DISMANTLING THE MACHINE

Proceed by complying with the instructions given in the "Installation" chapter, working in reverse order, if the machine must be dismantled and then moved to another site.

DANGER

Before disassembling the machine or demounting some machine components, disconnect the power supply.

The machine assembling shall only be carried out by skilled and authorized personnel.

ATTENTION

In case it is necessary to disassemble the machine or demount some machine components in a different way in comparison with the written instructions, Company manufacturer or its Agent shall be contacted - see addresses on the third page of this publication.

7.2 - DEMOLISHING THE MACHINE



To protect the environment, please proceed in compliance with the local laws in force.
When the machine can no longer be used or repaired, please proceed with recycle and disposal.

Electrical equipment cannot be disposed of as ordinary urban waste: it must be disposed of according to the special EU directive for the recycling of electric and electronic equipment.
OEM electrical equipment is marked with a pictogram of a garbage can inside a barred circle. This symbol means that the equipment was sold on the market after August 13, 2005, and must be disposed of accordingly.
Due to the substances and materials it contains, inappropriate or illegal disposal of this equipment, or improper use of the same, can be harmful to humans and the environment. Improper disposal of electric equipment that fails to respect the laws in force will be subject to administrative fines and penal sanctions.

ATTENTION

Consult the next paragraph when disposing of harmful materials (lubricants, solvents, coating products, etc.).

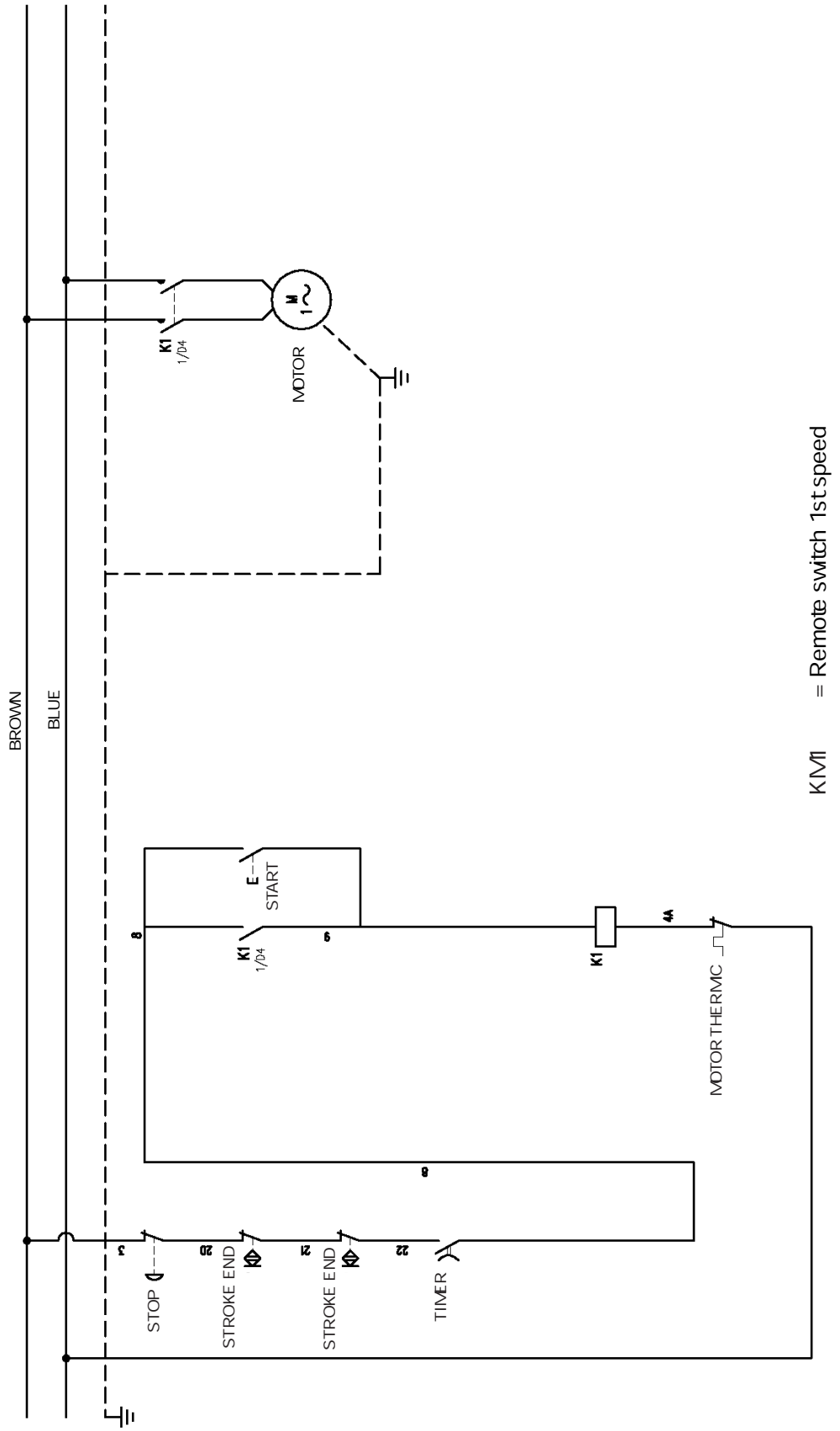
7.3 - DISPOSING OF HARMFUL SUBSTANCES

Consult the provisions established by the Standards in force in each individual country before disposing of such substances.

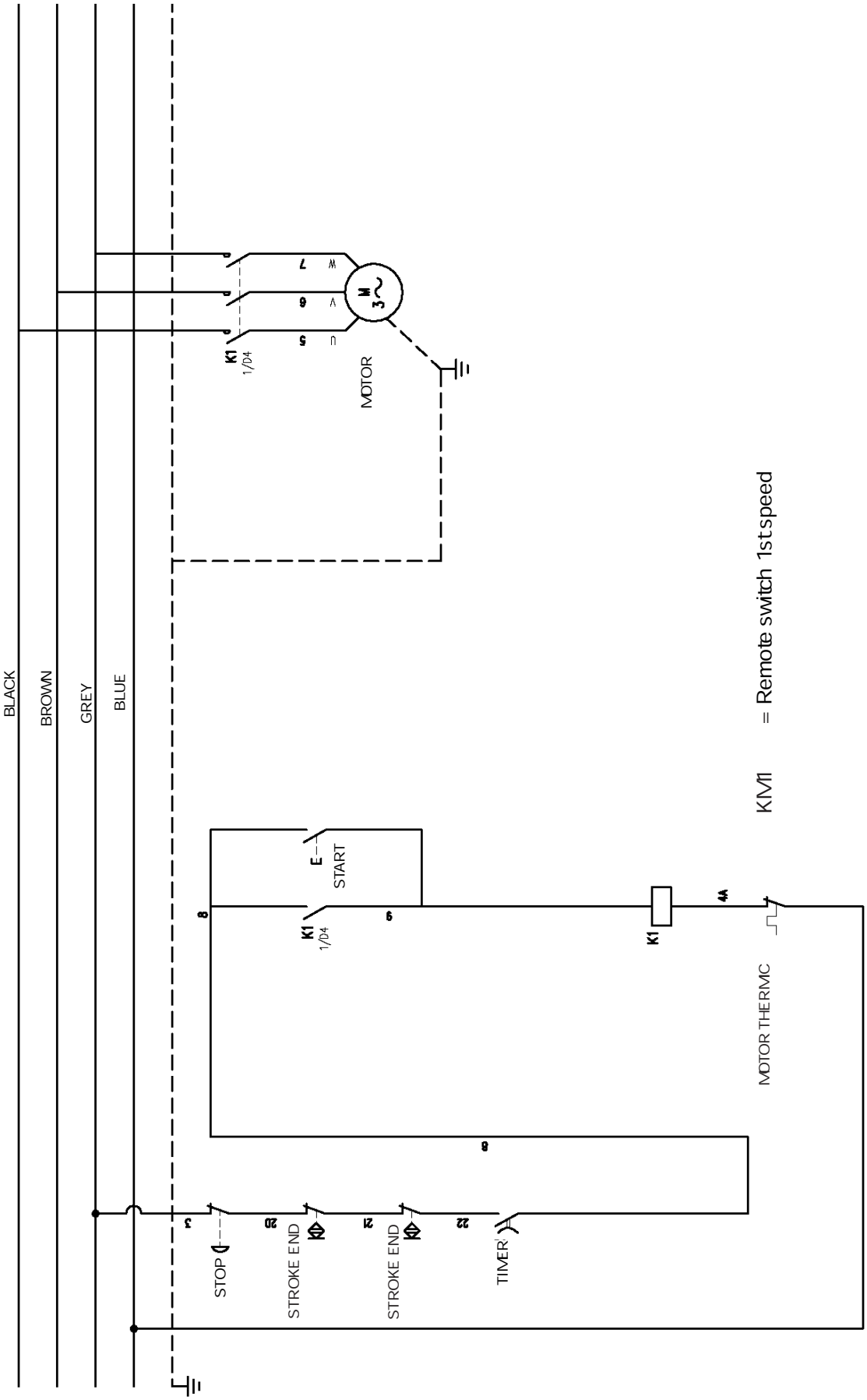
ATTENTION

Any improper use by the Customer before, during or after scrapping and disposing of the parts of the machine, in respect of the construction and application of the applicable regulations, shall be the customer's responsibility.

WIRING DIAGRAM - SINGLE-PHASE KNEADING MACHINE



WIRING DIAGRAM - ONE SPEED KNEADING MACHINE



WIRING DIAGRAM - TWO-SPEED KNEADING MACHINE

