







1- GENERAL INFORMATION	
1.1- Importance of the manual	page 18
1.2- Consultation notes	page 18
1.2.1- Addressees (authorised operators)	page 19
1.2.2- "Machine off" status	page 19
1.3- Warranty	page 19
2- TECHNICAL DESCRIPTION	
2.1- Names of models	page 19
2.2- Intended use for the machine	page 20
2.3- Technical data	page 20
2.4- Intended use for the machine	page 20
2.5- Names of components	page 20
2.6- Conveyor belt speeds	page 21
2.7- Dimensions	page 22
2.8- Electrical data	page 22
2.9- Foreseeable incorrect use	page 23
2.10- Accessories available on request	page 23
3- TRANSPORT AND MOVEMENT	
3.1- Transporting the machine	page 23
3.2- Packaging	page 23
3.3- Transporting the package with a lift truck	page 23
3.4- Unpacking	page 24
3.5- Positioning	page 24
4- INSTALLATION	
4.1- General instructions	page 24
4.2- Electrical connection	page 25
4.3- Connecting the inversion pedal board	page 25
4.4- Opening the work surfaces	page 25

5- SAFETY	
5.1- Safety devices adopted	page 26
5.2- Safety signs	page 26
5.3- Personal protective equipment (ppe)	page 26
5.4- Residual risks	page 26
6- USE AND OPERATION	
6.1- Places occupied by the authorised operators	page 27
6.2- Inversion pedal board	page 28
6.2.1- Control panel	page 29
6.3- Checks prior to start-up	page 30
6.4- Starting up the machine	page 30
6.5- Commissioning	page 30
6.6- Switching off the machine	page 31
6.7- Emergency stop	page 31
6.8- Starting up after an emergency stop	page 31
7- MAINTENANCE	
7.1- Ordinary maintenance	page 31
7.1.1- Cleaning the lower and upper scrapers	page 31
7.1.2- Replacing the conveyor belts	page 32
7.2- Special maintenance	page 32
8- DECOMMISSION	
8.1- Storage	page 32
8.2- Demolition	page 32
9- SPARE PARTS	
9.1- General instructions	page 32
9.2- Spare parts	page 32
10- ELECTRICAL PART	
10.1- Wiring diagrams	page 35
EEC DECLARATION AND MARKING	
Ecc declaration of conformity	page 02

 **THE MANUFACTURER DECLINES ALL RESPONSIBILITY FOR ANY DAMAGE TO PEOPLE, ANIMALS AND OBJECTS CAUSED BY FAILURE TO OBSERVE THE STANDARDS AND INSTRUCTIONS DESCRIBED IN THIS MANUAL.**
THIS MANUAL REFLECTS THE STATE OF THE ART AT THE TIME OF SALE OF THE MACHINE AND MAY NOT BE CONSIDERED INADEQUATE SIMPLY BECAUSE, BASED ON NEW EXPERIENCE, IT MAY LATER BE UPDATED.

 **BEFORE USING THE MACHINE IN QUESTION, IT IS COMPULSORY FOR THE AUTHORISED OPERATORS TO READ AND UNDERSTAND ALL PARTS OF THIS MANUAL. THIS MANUAL MUST ALWAYS BE AVAILABLE FOR THE AUTHORISED OPERATORS TO USE AND BE KEPT NEAR THE MACHINE AND LOOKED AFTER PROPERLY. THIS MANUAL MUST BE DELIVERED ALONG WITH**

1.2- CONSULTATION NOTES

	Sign of general hazard: HIGHLIGHTS RISKS FOR THE HEALTH AND SAFETY OF OPERATORS AND/OR RISK OF DAMAGE OR MALFUNCTIONING OF THE MACHINE.
	Sign of general obligation: HIGHLIGHTS INSTRUCTION (OBLIGATION TO PERFORM AN ACTION).
	Sign of general prohibition: HIGHLIGHTS THAT IT IS FORBIDDEN TO PERFORM AN ACTION.
	Bin crossed out: HIGHLIGHTS THAT IT IS FORBIDDEN TO THROW ELECTRICAL AND ELECTRONIC EQUIPMENT (WEEE) IN THE BINS.

TAB. 1 (Description of symbols)

1.2.1- ADDRESSEES (AUTHORISED OPERATORS)

This technical manual is exclusively intended for authorised operators, for the use and maintenance of the machine based on the specific technical/professional skills required for the type of intervention.

The symbols indicated below are set out at the start of a chapter and/or a paragraph, to indicate which operator is affected by the subject discussed.



AUTHORISED OPERATORS MUST ONLY PERFORM INTERVENTIONS ON THE MACHINE FOR WHICH THEY ARE SPECIFICALLY QUALIFIED. BEFORE PERFORMING ANY INTERVENTION ON THE MACHINE, THE AUTHORISED OPERATORS MUST ENSURE THEY POSSESS THE FULL PSYCHOLOGICAL/PHYSICAL FACULTIES IN ORDER TO GUARANTEE CONSTANT RESPECT FOR

TRAINED OPERATOR

This is a professionally trained operator, who is over the age of 18, with respect for the legislation in force in the country of use, qualified exclusively to switch on, use, commission (with the guards enabled and the machine off) and switch off the machine, with absolute respect for the instructions described in this manual, equipped with the personal protective equipment (PPE) envisaged in **par. 5.3** occupying the places described in **par. 6.1**.

ELECTRICAL MAINTENANCE OPERATOR

This is a qualified technician (electrician with all the professional/technical requirements stated by legislation in force), qualified exclusively to perform interventions on electric devices to carry out adjustments, maintenance and/or repairs, also in the presence of electric voltage and with the guards disabled (with permission from the safety manager) with absolute respect for the instructions described in this manual or another specific document provided exclusively by the manufacturer, equipped with the personal protective equipment (PPE) envisaged in **par. 5.3** occupying the places described in **par. 6.1**.

MECHANICAL MAINTENANCE OPERATOR

This is a qualified technician, exclusively qualified to perform interventions on the mechanical parts in order to carry out adjustments, maintenance and/or repairs, also with the guards disabled (with permission from the safety manager) with absolute respect for the instructions described in this manual or another specific document provided exclusively by the manufacturer, equipped with the personal protective equipment (PPE) envisaged in **par. 5.3** occupying the places described in **par. 6.1**.

1.2.2- "MACHINE OFF" STATUS

Before carrying out any kind of maintenance and/or repair intervention on the machine, it is compulsory to isolate all the (electrical) power supply sources, ensuring that the machine is actually off and does not start unexpectedly (general electric switch in "0" pos., electric power supply cable unplugged and positioned by the machine).

1.3- WARRANTY

1) Within the limits of the provisions established herein, the manufacturer undertakes to repair any manufacturing faults that may arise during the period of the warranty, that is 12 (twelve) months from the date of sale for a daily use of 8 (eight) working hours.

The obligations deriving from the warranty are forfeited in the event of suspension or variations to the payment terms agreed.

The warranty is forfeited should the purchaser fail to adhere correctly to the envisaged standards described in the "Use and maintenance instructions" for the machine.

The following are excluded from the warranty: defects and faults due to normal consumption of the parts that are inherently subject to rapid and continuous wear and defects deriving from the use of tools and accessories not directly supplied by the manufacturer.

In order to be able to make use of the right to the warranty, the purchaser, upon encountering the fault, must notify the manufacturer thereof promptly, that is no later than 8 (eight) days after the discovery and allow, if considered necessary, the relative inspections and repairs to be carried out.

The purchaser is responsible for sending the manufacturer the faulty part, under warranty, for it to be repaired or replaced. The warranty obligation, as envisaged in this clause, is considered fulfilled with the delivery to the purchaser of the part suitably repaired or replaced.

The warranty excludes breakages caused by incorrect manoeuvres, inexperience, accidents or anything attributable to the user, either due to the fault of third parties or when the purchaser has made any changes or repairs without written consent from the manufacturer, regardless of the connection between such changes or repairs and the faults that have occurred.

It is expressly agreed hereby that the manufacturer is to be held harmless from all responsibility due to any damage caused to the purchaser by lack of or reduced production, due to manufacturing faults or defects covered by this warranty.

2-TECHNICAL DESCRIPTION

2.1- NAMES OF MODELS

The machine is produced in various models. **TAB. 2** shows the names of the models and the specifications associated with them.

MODEL	DESCRIPTION
1 V	ONE-SPEED DOUGH SHEETER
2 V	TWO-SPEEDS DOUGH SHEETER
VAR 1 PH	MONOPHASE DOUGH SHEETER WITH INVERTER
1 PH	ONE MONOPHASE-SPEED DOUGH SHEETER

TAB. 2 (Names of models)

2.2- INTENDED USE FOR THE MACHINE

The machine was designed and manufactured for the following use:

FIELD OF USE	FOOD INDUSTRY
PLACE OF USE	SEE PAR. 3.5.
INTENDED USE	ROLLING DOUGH FOR THE FOOD INDUSTRY IN BAKERIES, PASTRY SHOPS AND PIZZERIAS.
OPERATORS TRAINED FOR USE	Only one authorised operator with the technical/professional requirements described in par. 1.2.1.

TAB. 3 (Intended use for the machine)

2.3 TECHNICAL DATA

TAB. 4 shows some technical data regarding the machine.

ROLLING THICKNESSES	MM	0,1 ÷ 27	WORKING TEMPERATURE	°C	+10 ÷ +40
GUARANTEED SOUND LEVEL	DBA	<80	MAX. WORKING HUMIDITY	%	90

TAB. 4 (Technical data)

2.4- INTENDED USE FOR THE MACHINE

POWER SUPPLY SOURCE	POWER SUPPLY
ELECTRIC	ELECTRIC POWER SUPPLY NETWORK (PROVIDED BY THE CUSTOMER)

TAB. 5 (Power supply source)

2.5- NAMES OF COMPONENTS

FIG. 1 and 2 show and name the main components that make up the machine.

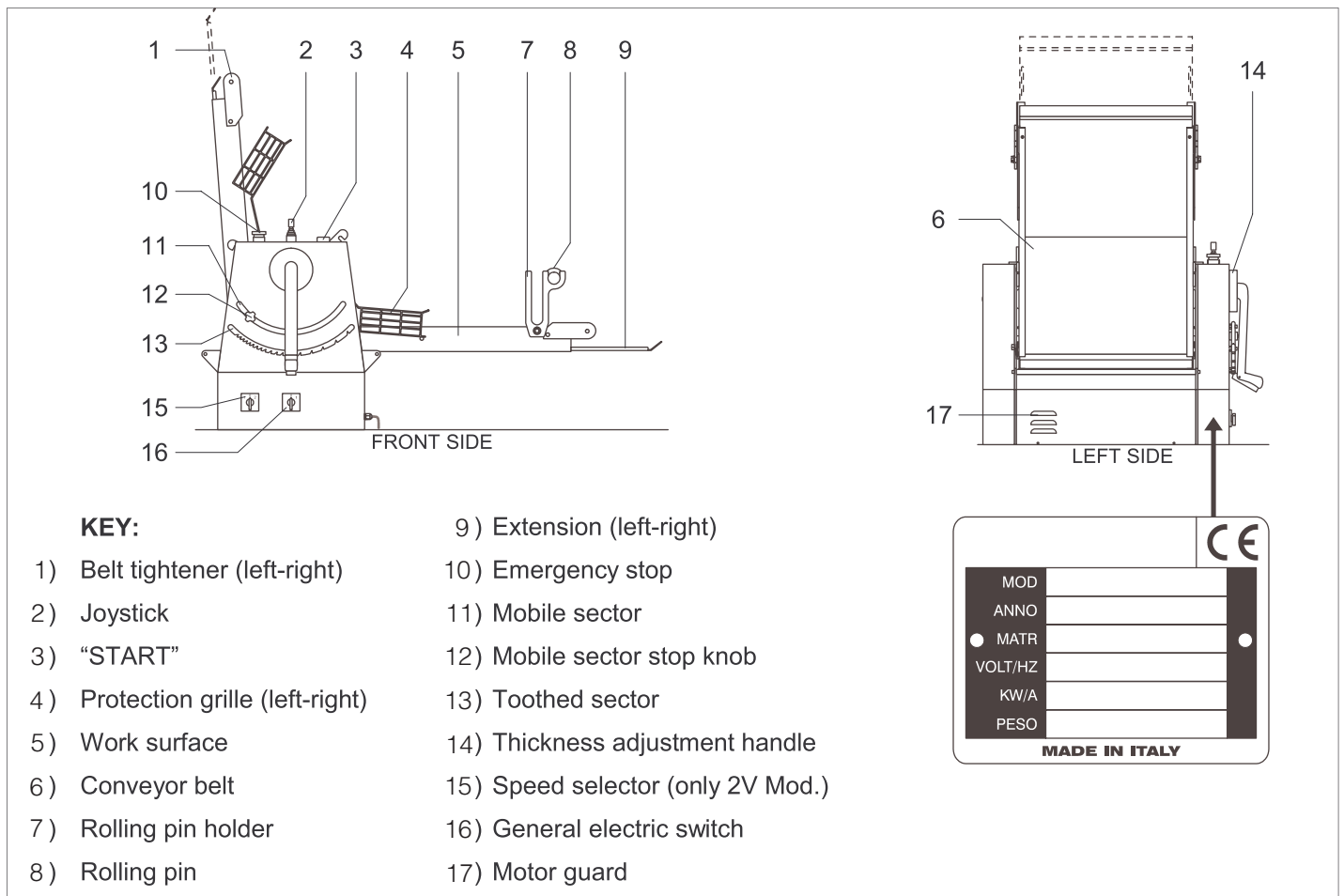


FIG. 1 (Names of main components)

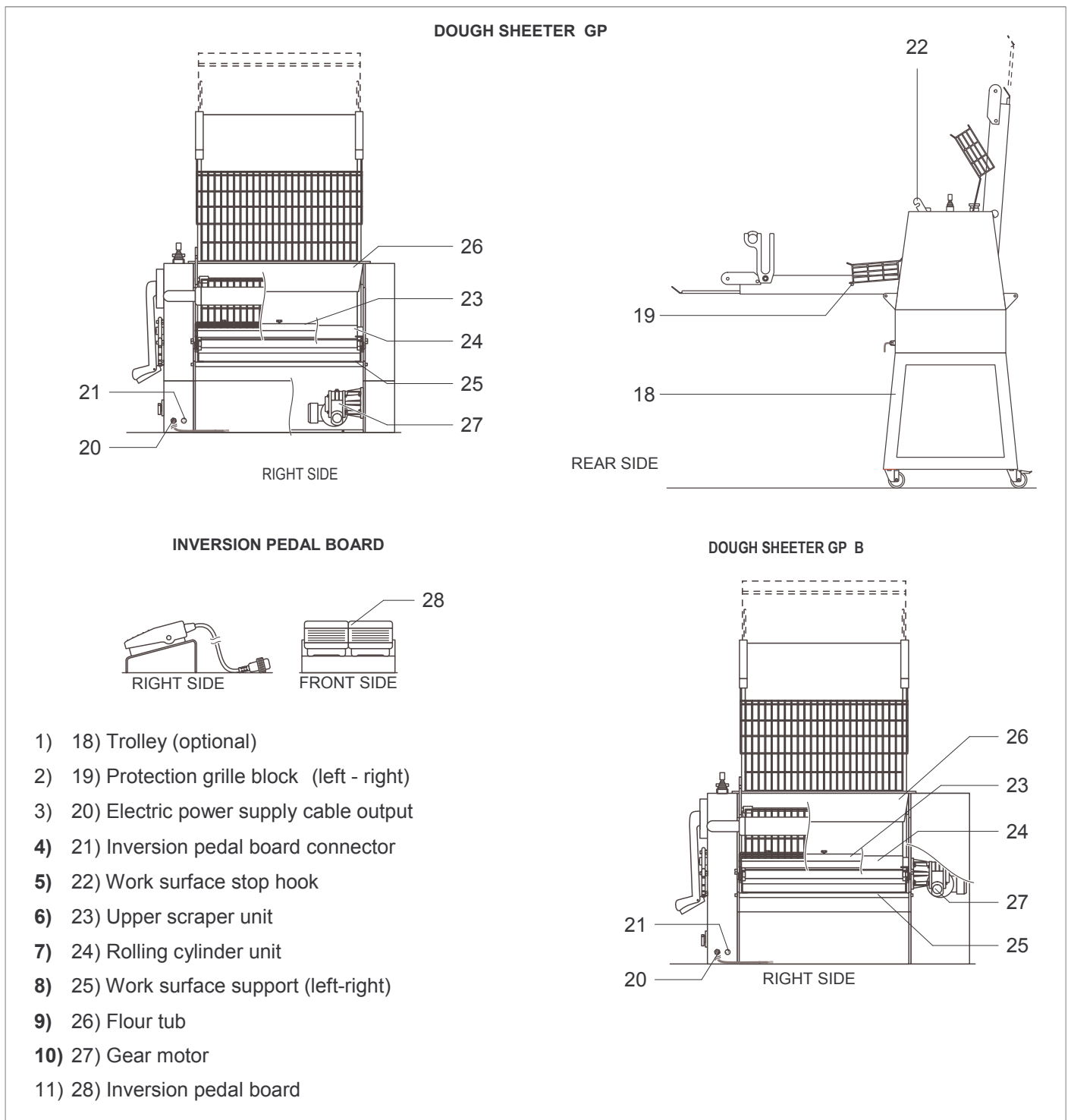


FIG. 2 (Names of main components)

2.6 CONVEYOR BELT SPEEDS

TAB.6 shows the various speeds of the models

			GP 500 B / 500		GP 600 B / 600	
			ENTRATA	USCITA	ENTRATA	USCITA
ONE-SPEED (1 V)		M/MIN	11	20	11	20
TWO-SPEED (2 V)	1 ^A SPEED	M/MIN	10.8	19.2	10.8	19.2
	2 ^A SPEED	M/MIN	21.6	38.4	21.6	38.4
VAR	1 ^A SPEED	M/MIN
	2 ^A SPEED	M/MIN
	3 ^A SPEED	M/MIN
	4 ^A SPEED	M/MIN
	VAR	M/MIN

TAB. 6 (Conveyor belt speeds)

2.7- DIMENSIONS

TAB. 3 shows the dimensions of the machine relative to FIG. 3.

		GP 500 B		GP 500		GP 600 B		GP 600	
		800	1000	800	1000	1000	1200	1000	1200
A	MM	955		955		1055		1055	
B	MM	1650	2050	1650	2050	2050	2450	2050	2450
B1	MM	2050	2450	2050	2450	2450	2850	2450	2850
C	MM	555		1280		555		1280	
D	MM	530	545	545		545	560	545	560
E	MM	900	1100	1630	1830	1100	1300	1830	2030
WEIGHT	KG	120	130	155	165	135	145	170	180
MOTOR		1V= 0,55 kW - 2V= 0,37/0,55 kW - 1 PH= 0,55 kW - VAR 1 PH= 0,55 kW							

TAB. 7 (Dimensions)

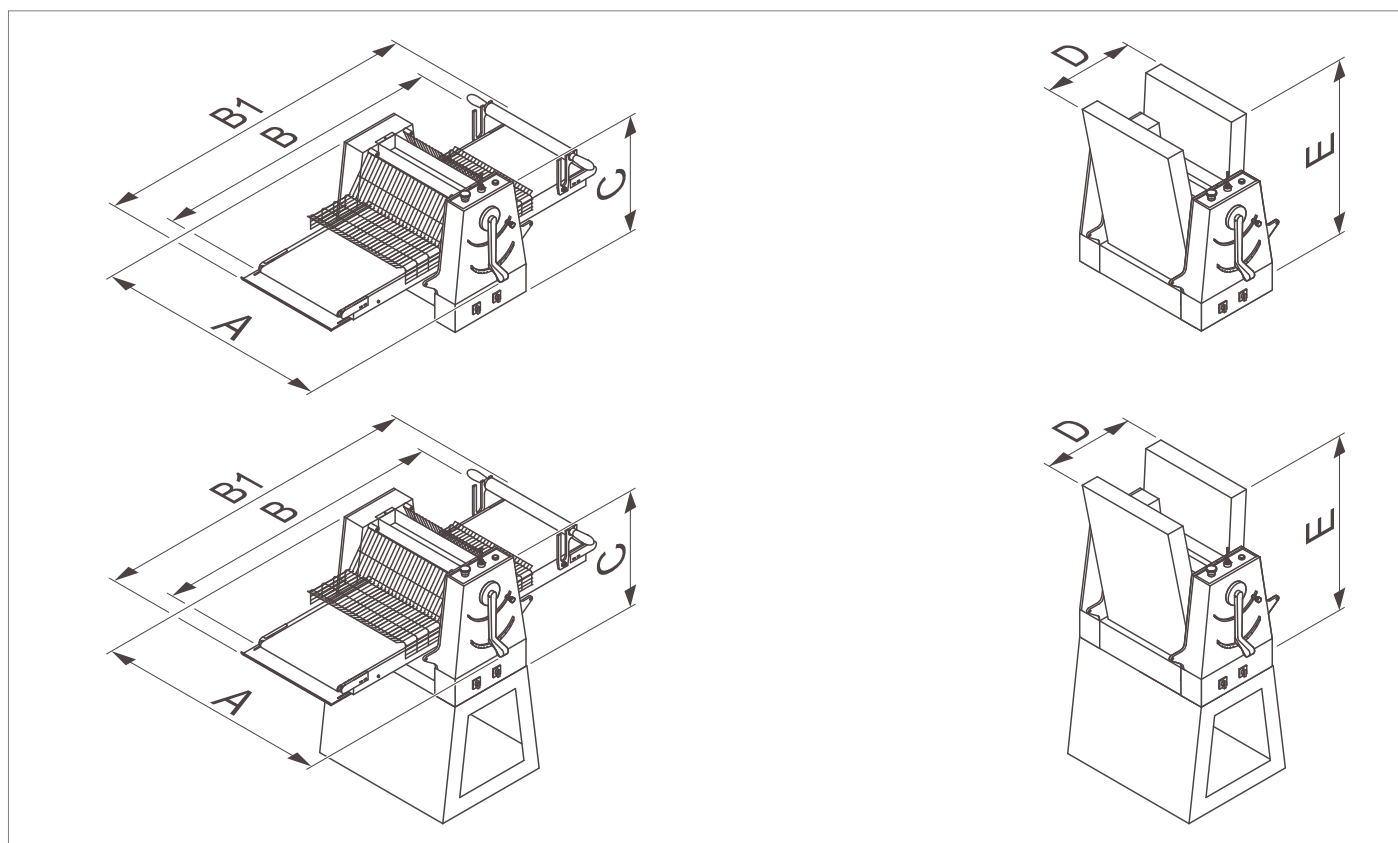


FIG. 3 (Dimensions of the machine)

2.8- ELECTRICAL DATA

TAB. 5 shows some data relative to the electrical part of the machine.

		GP 500 B / 500 - GP 600 B / 600			
		1 V	2 V	VAR1 PH	1 PH
ELECTRIC POWER SUPPLY VOLTAGE	V	230/400		230	
FREQUENCY	HZ	50-60			
ELECTRIC POWER ABSORBED	KW	0,55			
PHASES	N.	1/3	3	1	1
CONSUMPTION AT RUNNING SPEED 400 V THREE-PHASE	A	1.8	1.4/1.6	/	/
CONSUMPTION AT RUNNING SPEED 230 V THREE-PHASE	A	3	2.4/2.7	/	/
CONSUMPTION AT RUNNING SPEED 230 V MONO-PHASE	A	/	/	3.4	3.8
MOTOR	HP	0,75	0,5/0,75	0.75	0.75

TAB. 8 (Electrical data)

2.9- FORESEEABLE INCORRECT USE

The machine was designed and manufactured exclusively for the intended use described in **par. 2.7**; therefore it is absolutely forbidden to make another other kind of use of it, in order to guarantee, at all times, the safety of the authorised operators and the efficiency of the machine.



IT IS COMPULSORY, DURING USE, TO SUPERVISE CONSTANTLY TO ENSURE THAT NO UNAUTHORISED PEOPLE APPROACH THE MACHINE. THE AUTHORISED OPERATORS MUST NOT WEAR CLOTHING OR ACCESSORIES THAT COULD GET CAUGHT IN THE MACHINE: LOOSE CLOTHING, TIES, BELTS, NECKLACES, BRACELETS, WATCHES, EARRINGS, RINGS, ETC. IT IS COMPULSORY FOR LONG HAIR TO BE TIED BACK. (THERE IS A RESIDUAL RISK. SEE PAR.



**IT IS ABSOLUTELY FORBIDDEN TO MAKE USE OF THE MACHINE FOR ANY OTHER USE THAN THOSE SPECIFIED BY THE MANUFACTURER (PAR. 2.7).
IT IS ABSOLUTELY FORBIDDEN TO CLIMB ONTO THE MACHINE.**



IT IS ABSOLUTELY FORBIDDEN TO OPERATE THE MACHINE IN POTENTIALLY EXPLOSIVE ENVIRONMENTS AND/OR IN THE PRESENCE OF COMBUSTIBLE POWDERS.

2.10- ACCESSORIES AVAILABLE ON REQUEST

The machine has accessories that are available on request, which increase its versatility, such as:
Double pedal control device (to change movement direction);



THE ACCESSORIES MUST BE REQUESTED EXCLUSIVELY SPECIFYING THE IDENTIFICATION DATA OF THE DOCUMENT SUCH AS THE CODE AND REVISION (SEE COVER).

3- TRANSPORT AND MOVEMENT

3.1- TRANSPORTING THE MACHINE



THE MANUAL MOVEMENT OF THE MACHINE AND ITS COMPONENTS MUST TAKE PLACE WITH RESPECT FOR LEGISLATION ON THE “MANUAL MOVEMENT OF LOADS” IN ORDER TO PREVENT ADVERSE ERGONOMIC CONDITIONS LEADING TO THE RISK OF BACK INJURIES.

3.2- PACKAGING

The machine is packed inside a carton and fixed to a pallet with straps. The packaging contains:

- 1 dough roller; 1 instruction manual.



ENSURE THAT THE ABOVE COMPONENTS ARE CONTAINED IN THE RESPECTIVE PACKAGING AND THAT THEY HAVE NOT BEEN DAMAGED DURING TRANSPORT. ENSURE THAT THE PACKAGING HAS NOT BEEN DAMAGED DURING TRANSPORT. MAKE A NOTE ON THE TRANSPORT DOCUMENT OF ANY DAMAGE AND SIGN THE DOCUMENT FOR “ACCEPTANCE SUBJECT TO VERIFICATION”.

3.3- TRANSPORTING THE PACKAGE WITH A LIFT TRUCK

The staff in charge of carrying out this task must adhere to the instructions applied on the outside of the machine packaging. (see **par. 11.1**).



THE MACHINE PACKING MUST BE LIFTED BY A LIFT TRUCK (SUITABLE FOR USE) WITH RESPECT FOR THE INSTRUCTIONS APPLIED ON THE OUTSIDE OF THE PACKAGING.

IT IS COMPULSORY THAT DURING THE OPERATIONS, WITHIN THE ACTION RADIUS THERE ARE NO PEOPLE, ANIMALS AND/OR OBJECTS WHOSE WELLBEING COULD BE ACCIDENTALLY ARMED.



IT IS ABSOLUTELY FORBIDDEN TO CLIMB ONTO THE PACKAGING.

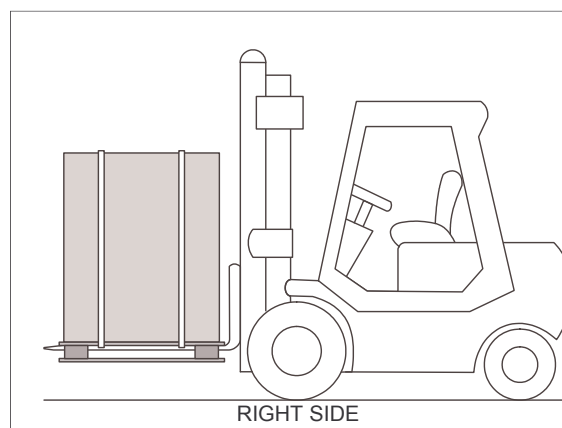


FIG. 4 (Lifting the package)

3.4- UNPACKING



THE OPERATIONS MUST BE CARRIED OUT BY TWO TRAINED OPERATORS.

After resting the package on a flat (level) horizontal surface that ensures its stability, proceed to unpack it as follows:

With a suitable tool cut the straps taking care to ensure that they do not hit you due to their elasticity;

Open the carton;

Remove the box;

Rest the machine on the pre-established work station.



IT IS RECOMMENDED TO DISPOSE OF THE PACKAGING MATERIALS WITH RESPECT FOR LEGISLATION IN FORCE.

3.5- POSITIONING

The machine must be positioned in a closed, covered, dry and sufficiently well-lit area, with the temperature and humidity values indicated in **TAB. 4** and in accordance with the legislative provisions in force on health and safety in the workplace in the country of use. The machine must be positioned on a flat (level) horizontal surface that ensures its stability with respect to the dimensions and weight (see **TAB. 3**) and respecting the minimum positioning measurements shown in **FIG. 5**.



IT IS COMPULSORY TO GUARANTEE THE MINIMUM POSITIONING MEASUREMENTS SHOWN IN FIG. 5. LEAVE THE FRONT SIDE FREE TO ALLOW THE AUTHORISED OPERATOR TO PROCESS THE DOUGH.

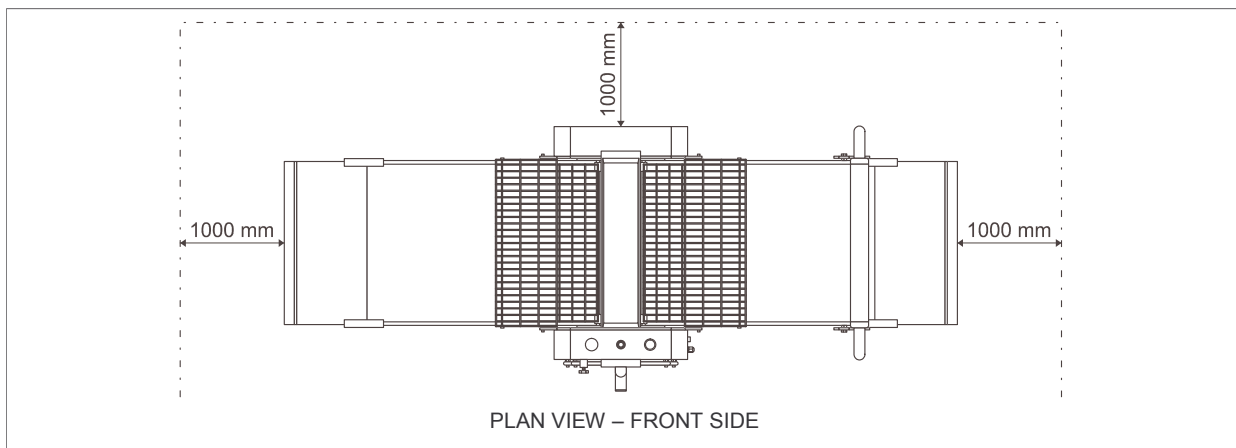


FIG. 5 (Positioning)

4-INSTALLATION

4.1- GENERAL INSTRUCTIONS



THE MANUFACTURER DECLINES ALL RESPONSIBILITY FOR OPERATING FAULTS OR ANOMALIES CAUSED BY SUDDEN CHANGES IN ELECTRIC VOLTAGE BEYOND THE TOLERANCES ENVISAGED BY THE DISTRIBUTING BODY (VOLTAGE $\pm 10\%$).



IT IS COMPULSORY TO USE THE ORIGINAL ACCESSORIES SUPPLIED BY THE MANUFACTURER OR THE AUTHORISED RETAILER.

4.2- ELECTRICAL CONNECTION



FAILURE TO OBSERVE THE INSTRUCTIONS DESCRIBED IN THIS MANUAL CAN CAUSE IRREPARABLE DAMAGE TO THE ELECTRICAL APPARATUS ON THE MACHINE AND HENCE INVALIDATE THE WARRANTY.



THE ELECTRIC POWER SUPPLY NETWORK TO WHICH THE MACHINE IS CONNECTED MUST FULFIL THE TECHNICAL CHARACTERISTICS SHOWN IN TAB. 5 (PAR. 2.5) AND RESPOND TO THE REQUIREMENTS ENVISAGED BY LEGISLATION IN FORCE IN THE COUNTRY WHERE THE MACHINE IS USED. ALL TYPES OF ELECTRICAL MATERIAL (CABLES, SOCKETS, PLUGS, ETC..) USED FOR CONNECTION MUST BE SUITABLE FOR USE, HAVE "EC" MARKING IF SUBJECT TO THE LOW VOLTAGE DIRECTIVE 2006/95/EC AND COMPLY WITH THE REQUIREMENTS STATED BY LEGISLATION IN FORCE IN THE COUNTRY WHERE THE MACHINE IS USED. IT IS COMPULSORY TO INSTALL A SUITABLE ISOLATION DEVICE WITH A CIRCUIT BREAKER OF 30 MA COORDINATED WITH THE EARTHING SYSTEM UPSTREAM FROM THE ELECTRIC POWER SUPPLY LINE. ANY ELECTRICAL MAINTENANCE INTERVENTIONS ON THE MACHINE MAY ONLY BE CARRIED OUT BY THE ELECTRICAL MAINTENANCE OPERATOR (SEE PAR. 1.2.1). FAILURE TO OBSERVE THE INSTRUCTIONS DESCRIBED ABOVE CAN CAUSE IRREPARABLE DAMAGE TO THE ELECTRICAL APPARATUS ON THE MACHINE AND THEREFORE INVALIDATE THE WAR-



IT IS ABSOLUTELY FORBIDDEN TO REPLACE ELECTRICAL PARTS OF THE MACHINE WITH NON-ORIGINAL COMPONENTS OR DIFFERENT FROM THOSE SUPPLIED BY THE MANUFACTURER.

4.3- CONNECTING THE INVERSION PEDAL BOARD

Should it be necessary to use the inversion pedal board, connect it, using the relevant cable, to the pedal board connector (FIG. 2 - Rif. 21).

4.4- OPENING THE WORK SURFACES



FOR THIS PROCEDURE THE PRESENCE OF TWO AUTHORISED OPERATORS IS REQUIRED. THERE IS A RESIDUAL POTENTIAL RISK DESCRIBED IN PAR. 5.4.

After positioning and connecting the machine correctly, proceed to open the work surfaces as follows:

Keeping one hand on the left work surface (FIG. 6 - Ref. 3) lift the work surface stop hook (FIG. 6 - Ref. 2);

Lower the left work surface slowly until it is fully resting on the work surface support (FIG. 6 - Ref. 1);

Repeat the operations in points 1) and 2) for the right work surface (FIG. 6 - Ref. 5);

Lower the protection grilles (FIG. 6 - Ref. 4) gently as far as possible.

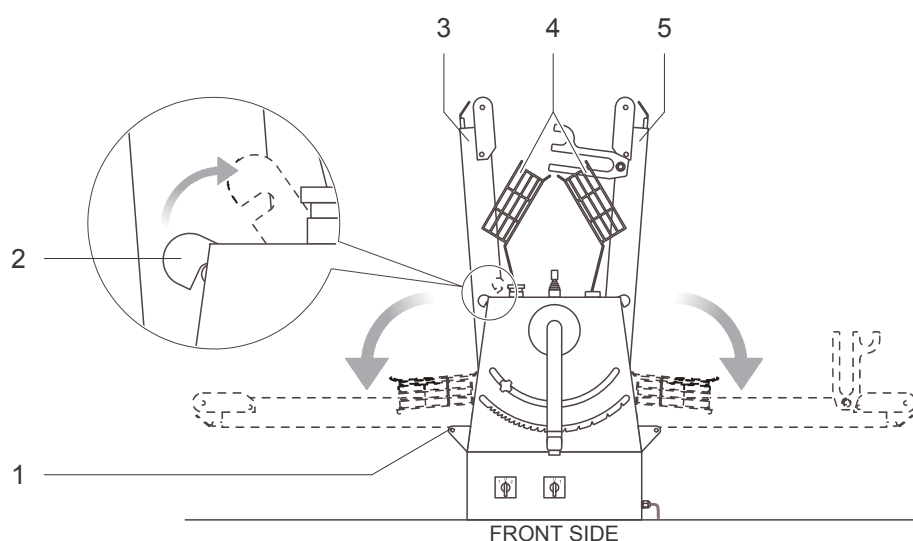


FIG. 6 (Opening the work surfaces)

5-SAFETY

5.1- SAFETY DEVICES ADOPTED

FIG. 7 indicates the safety systems adopted on the machine, de-

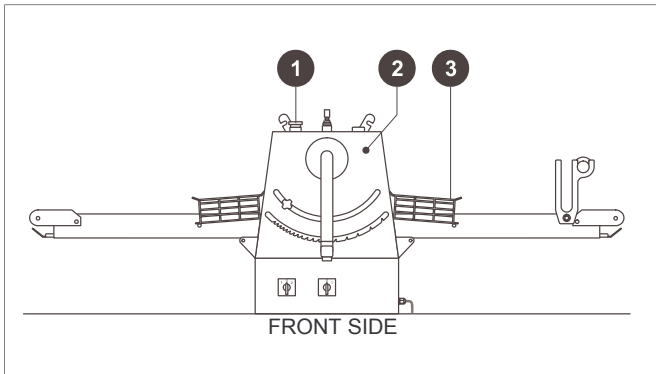




FIG. 7 (Safety devices adopted)

 IT IS ABSOLUTELY FORBIDDEN TO TAMPER WITH, EXCLUDE AND/OR REMOVE ANY OF THE SAFETY DEVICES PRESENT ON THE MACHINE.
IT IS ABSOLUTELY FORBIDDEN TO REPLACE ANY OF THE SAFETY DEVICES OR THEIR COM-

 IT IS ABSOLUTELY FORBIDDEN TO TAMPER WITH, EXCLUDE AND/OR REMOVE ANY OF THE SAFETY DEVICES PRESENT ON THE MACHINE.
IT IS ABSOLUTELY FORBIDDEN TO REPLACE ANY OF THE SAFETY DEVICES OR THEIR COMPONENTS WITH NON-ORIGINAL SPARE PARTS.

REF.	DEVICE	DESCRIPTION
1	EMERGENCY STOP BUTTON	THIS IS A RED MUSHROOM BUTTON WITH ANTI-CLOCKWISE ROTATION RELEASE, INSTALLED ON THE CONTROL PANEL ON THE FRONT PART OF THE MACHINE. IF OPERATED, IT STOPS THE WORK CYCLE BUT THE MACHINE IS STILL POWERED.
2	PROTECTION GRILLE MICRO SWITCHES	THESE ARE TWO MICRO SWITCHES INSTALLED INSIDE THE CASE ON THE FRONT PART OF THE MACHINE, WHICH ARE OPERATED BY LIFTING THE SAFETY CAGE. IF OPERATED, THEY STOP THE WORK CYCLE BUT THE MACHINE IS STILL POWERED.
3	PROTECTION GRILLES	THEY ARE MADE UP OF A PLASTIC-COATED METAL GRILLE, INSTALLED ON THE BACK OF THE MACHINE WITH HINGES TO MAKE THE ROLLING AREA (CYLINDER UNIT) INACCESSIBLE.

TAB. 9 (Safety devices adopted)

5.2- SAFETY SIGNS

 IT IS COMPULSORY TO KEEP THE SAFETY SIGNS VERY CLEAN IN ORDER TO ENSURE THEIR FULL VISIBILITY.

 IT IS ABSOLUTELY FORBIDDEN TO REMOVE AND/OR DAMAGE THE SAFETY SIGNS APPLIED BY THE MANUFACTURER.

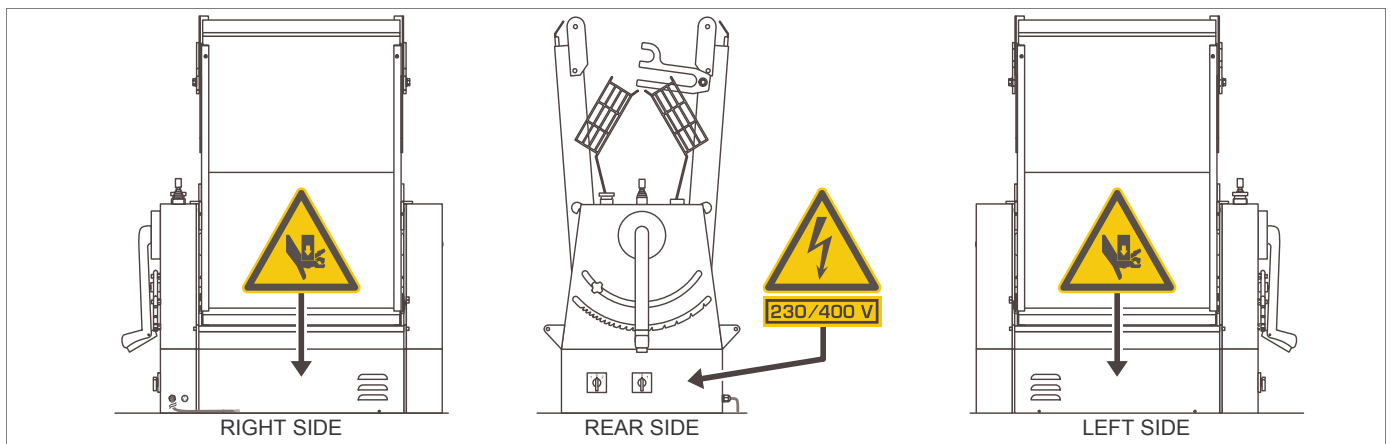


FIG. 8 (Safety signs)

5.3- PERSONAL PROTECTIVE EQUIPMENT (PPE)

The use of Personal Protective Equipment (PPE) is compulsory for the respect of legislation on health and safety in the workplace in force in the country where the machine is used. The **employer** and **authorised operators** must be aware of and apply the obligations and duties envisaged by the aforementioned legislation.

5.4- RESIDUAL RISKS

The authorised operators are informed that, although the manufacturer has adopted all the manufacturing technical devices to make the ma-

RESIDUAL RISK NO. 1	DRAGGING AND CRUSHING OF THE UPPER LIMBS ON THE CYLINDER UNIT.
SERIOUSNESS OF DAMAGE	SLIGHT INJURIES (NORMALLY REVERSIBLE) AND/OR SERIOUS INJURIES (NORMALLY IRREVERSIBLE).
EXPOSURE	IF THE OPERATOR DECIDES TO VOLUNTARILY PERFORM AN INCORRECT, FORBIDDEN AND UNREASONABLY FORESEEABLE ACTION.
PROBABILITY	LOW AND ACCIDENTAL.
WHEN THE RISK IS PRESENT	DURING THE WORK CYCLE.
MEASURES ADOPTED	<ul style="list-style-type: none"> PERSONAL PROTECTIVE EQUIPMENT (SEE PAR. 5.3); SAFETY SIGNS (SEE PAR. 5.2).

TAB. 10 (Residual risk no. 1)

RESIDUAL RISK NO. 2	RISK OF CRUSHING DUE TO THE WORK SURFACES FALLING.
SERIOUSNESS OF DAMAGE	SLIGHT INJURIES (NORMALLY REVERSIBLE).
EXPOSURE	IF THE OPERATOR DECIDES TO VOLUNTARILY PERFORM AN INCORRECT, FORBIDDEN AND UNREASONABLY FORESEEABLE ACTION WHILE THE WORK SURFACES ARE IN THEIR CLOSED POSITION.
PROBABILITY	LOW AND ACCIDENTAL.
WHEN THE RISK IS PRESENT	WHILE THE MACHINE IS BEING MOVED. DURING WORK SURFACE LOWERING AND RAISING OPERATIONS.
MEASURES ADOPTED	<ul style="list-style-type: none"> FIXING THE WORK SURFACES USING MECHANICAL LOCKING HOOKS. OBLIGATION TO OPERATE ACCORDING TO THE WORK PROCEDURES (SEE FROM PAR. 6.3 TO PAR. 6.8).

TAB. 11 (Residual risk no. 2)

RESIDUAL RISK NO. 3	MUSCULOSKELETAL DISORDERS.
SERIOUSNESS OF DAMAGE	SLIGHT INJURIES (NORMALLY REVERSIBLE).
EXPOSURE	IF THE OPERATOR DECIDES TO VOLUNTARILY PERFORM AN INCORRECT, FORBIDDEN AND UNREASONABLY FORESEEABLE ACTION WHILE MOVING THE WORK SURFACES.
PROBABILITY	LOW.
WHEN THE RISK IS PRESENT	DURING WORK SURFACE LOWERING AND RAISING OPERATIONS.
MEASURES ADOPTED	<ul style="list-style-type: none"> OBLIGATION TO MOVE THE WORK SURFACES BY TWO AUTHORISED OPERATORS (SEE PAR. 4.4). OBLIGATION TO OPERATE ACCORDING TO THE WORK PROCEDURES (SEE FROM PAR. 6.3 TO PAR. 6.8).

TAB. 12 (Residual risk no. 3)

6-USE AND OPERATION

6.1- PLACES OCCUPIED BY THE AUTHORISED OPERATORS

According to the type of manual intervention required, the authorised operators must exclusively occupy the places indicated in **FIG. 9** and de-



ACCORDING TO THE PLACES OCCUPIED, THE AUTHORISED OPERATORS MUST EXCLUSIVELY PERFORM THE MANUAL INTERVENTIONS DESCRIBED IN THE RELATIVE PARAGRAPHS.

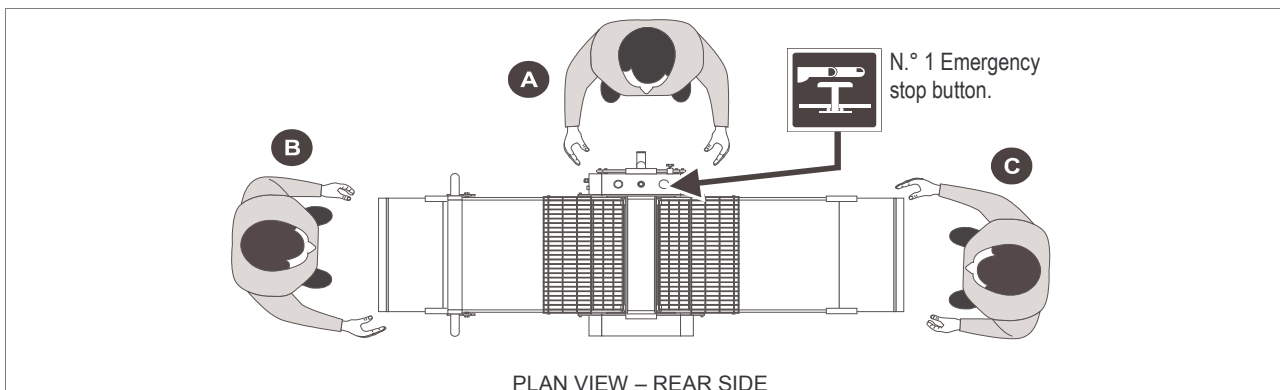


FIG. 9 (Places occupied)

PLACE	INTERVENTION DESCRIPTION
ALL	TO PERFORM ALL THE PACKAGING AND MACHINE TRANSPORT AND MOVEMENT OPERATIONS (SEE CHAP. 4).
ALL	TO PERFORM ANY TECHNICAL ASSISTANCE INTERVENTIONS REQUESTED BY THE CUSTOMER ON THE MACHINE, WITH PERMISSION FROM THE HEALTH AND SAFETY MANAGER.
A	STANDING ON THE FRONT SIDE OF THE MACHINE TO: 1) Switch the machine on and/or off; 2) Choose the working speed; 3) Operate the emergency stop button; 4) Choose the rotation direction; 5) Adjust the mobile sector knob; 6) Choose the thickness of the pastry; 7) Connect and use the pedal board; 8) Start and/or stop the work cycle.
B	STANDING ON THE RIGHT SIDE OF THE MACHINE TO: 1) Use the rolling pin; 2) Open or close the right work surface; 3) Open or close the extension of the right work surface; 4) Unload the processed dough.
C	STANDING ON THE LEFT SIDE OF THE MACHINE TO: 1) Open or close the left work surface; 2) Open or close the extension of the left work surface; 3) Load the dough to be processed.

TAB. 13 (Places occupied by the authorised operators)

6.2.- INVERSION PEDAL BOARD

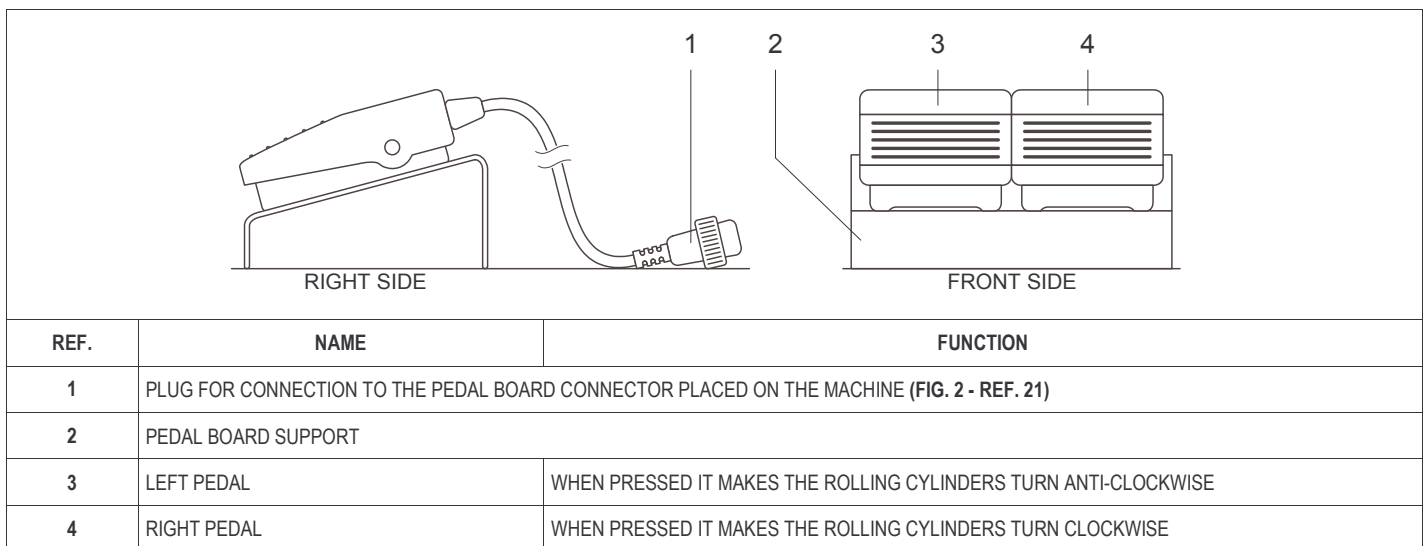


FIG. 10 (Inversion pedal board)

6.2.1- CONTROL PANEL

From place A (see par. 6.1).

REF.	NAME	FUNCTION
1	3 position "Speed" selector (only for mod. 2 V)	<ul style="list-style-type: none"> • Pos. "0": Machine stopped; • Pos. "1": Selects the speed "1"; • Pos. "2": Selects the speed "2";
2	2 position "General" selector	<ul style="list-style-type: none"> • Pos. "0": Removes power from the machine; • Pos. "1": Gives power to the machine.
3	"Thickness" adjustment lever	When moved to the left (+) it increases the thickness of the dough, to the right (-) it reduces the thickness.
4	Red mushroom "Emergency stop" button (clockwise rotation release)	When pressed during operation it stops the machine but the panel is still powered.
5	3-position joystick "Rotation direction"	<ul style="list-style-type: none"> • Pos. Left: The rolling cylinders turn anti-clockwise; • Pos. "0": The rolling cylinders are stopped; • Pos. Right: The rolling cylinders turn clockwise.
6	Black "START" button	When pressed it starts the processing cycle.
7	"+" button	When pressed it increases the cylinder rotation speed (visible on display - Ref. 6).
8	"-" button	When pressed it decreases the cylinder rotation speed (visible on display - Ref. 6).
9	Display	It displays the speed from 0 to 60 Hz.
10	5-selection button with green "MODE" led	<ul style="list-style-type: none"> • Sel. "0" (flashing led): It is possible to set the speed using the buttons "+" (Ref. 10) and "-" (Ref. 11); • Sel. "1" (fixed led): The speed is 15 Hz; • Sel. "2" (fixed led): The speed is 30 Hz; • Sel. "3" (fixed led): The speed is 45 Hz; • Sel. "4" (fixed led): The speed is 60 Hz.
11	Button with green "START" led	When pressed it starts the machine (fixed light).
12	Button with red "STOP" led	When pressed it stops the machine (fixed light).

FIG. 11 (Control panel)

6.3- CHECKS PRIOR TO START-UP



BEFORE STARTING UP THE MACHINE, THE AUTHORISED OPERATORS MUST PERFORM THE CHECKS SHOWN IN TABLE 14.



IT IS ABSOLUTELY FORBIDDEN TO SWITCH ON THE MACHINE SHOULD ANY DAMAGE AND/OR ANOMALY BE DISCOVERED. IF NECESSARY REQUEST THE MANUFACTURER'S INTERVENTION AND LET THE COMPANY SAFETY MANAGER KNOW.

NO.	MAKE SURE THAT:
1	THERE ARE NO UNAUTHORISED PEOPLE NEAR THE MACHINE.
2	AFTER A VISUAL CHECK THE MACHINE DOES NOT HAVE ANY EXTERNAL DAMAGE.
3	THE MACHINE AND ITS COMPONENTS ARE CORRECTLY POSITIONED AND INSTALLED.
4	THE EMERGENCY STOP BUTTON IS NOT PRESSED (SEE PAR. 6.1).
5	THE PROTECTION GRILLES ARE LOWERED.
6	THE GENERAL ELECTRIC SWITCH IS IN THE "0" (OFF) POS.
7	SINCE THE LAST TIME THE MACHINE WAS SWITCHED OFF, STANDARD ORDINARY MAINTENANCE HAS BEEN CARRIED OUT (SEE PAR. 9.1).
8	THE PERSONAL PROTECTIVE EQUIPMENT IS AVAILABLE FOR THE OPERATOR (SEE PAR. 6.3)
9	THIS MANUAL HAS BEEN FULLY READ AND UNDERSTOOD.

TAB. 14 (Checks prior to start-up)

6.4- STARTING UP THE MACHINE

From place A (see par. 6.1).

THE MANUFACTURER DECLINES ALL RESPONSIBILITY FOR ANY DAMAGE TO PEOPLE, ANIMALS AND/OR OBJECTS CAUSED BY FAILURE TO OBSERVE THE STANDARDS DESCRIBED IN THIS MANUAL.

After performing the checks described in par. 6.3, proceed as follows:

Remove the extensions from the work surfaces (FIG. 1 - Ref. 9);

If necessary, using the special connector, connect (FIG. 2 - Ref. 21) the inversion pedal board;

Connect the machine to the electric mains using the relevant plug.

6.5- COMMISSIONING

1) The commissioning procedure is as follows:

2) *(Only for mod. 2 V)* If necessary, select the processing speed by turning the speed selector to the "1" or "2" pos. (FIG. 10 - Ref. 1);

3) Put the general electric switch in the "1" (ON) pos. (FIG. 10 - Ref. 2);

4) *(Only for mod. VAR 1 PH)* If necessary select the processing speed by using the control panel (see FIG. 10);

5) Adjust the knob (FIG. 1 - Ref. 12) on the mobile sector (FIG. 1 - Ref. 11);

6) Adjust the desired dough thickness using the handle (FIG. 10 - Ref. 3);

7) *(Only for mod. 1 V - 2 V - 1 PH)* Start the machine by pressing the "START" button (FIG. 10 - Ref. 6);

8) *(Only for mod. VAR 1 PH)* Start the machine by pressing the "START" button (FIG. 10 - Ref. 11);

9) Choose the movement direction of the conveyor belts using the joystick (FIG. 10 - Ref. 5);

10) Rest the dough on the left work surface and start the rolling cycle (various rolling at different thicknesses);

11) Once the desired thickness has been reached (end of cycle), wait for the dough to come completely out of the rolling cylinders (FIG. 2 - Ref. 24) and put the joystick into "0" pos. (FIG. 10 - Ref. 5);

12) Remove the dough from the work surface.

ACCORDING TO THE TYPE OF PROCESSING AND THE LENGTH OF THE DOUGH IT IS POSSIBLE TO WRAP IT AROUND THE RELEVANT ROLLING PIN.

6.6- SWITCHING OFF THE MACHINE



BEFORE SWITCHING OFF THE MACHINE ENSURE THAT NO DOUGH IS LEFT BETWEEN THE TWO ROLLING CYLINDERS.

At the end of the work cycle, proceed as follows:

1) Switch the machine off, putting the general electric switch in the "0" (OFF) pos. (FIG. 10 - Ref. 2);

2) Disconnect the machine plug from the mains.

6.7- EMERGENCY STOP

The emergency stop can be carried out by pressing the “**Emergency stop**” button installed on the control panel (FIG. 10 - Ref. 4). In order to prevent dangerous situations happening immediately or being caused, the trained operator must perform the operations shown in TAB. 15.

1	PRESS THE “EMERGENCY STOP” BUTTON PROMPTLY.
2	REPORT THE EMERGENCY TO THE “SAFETY MANAGER” AND WAIT FOR INSTRUCTIONS.

TAB. 15 (Emergency stop)

6.8- STARTING UP AFTER AN EMERGENCY STOP

Only and exclusively after removing the cause of the emergency and after carefully checking that it has not caused any damage and/or anomalies on the machine, with the permission of the "Safety manager" proceed as follows:

- 1) Release the emergency button by turning it anti-clockwise (to the left);
- Start a new work cycle by repeating the operations described in par. 6.5 from point 2).

7- MAINTENANCE

7.1- ORDINARY MAINTENANCE

This is the set of activities that aim to maintain the use and operating conditions of the machine constant, through various types of interventions

 **BEFORE CARRYING OUT ANY KIND OF MAINTENANCE INTERVENTION, IT IS COMPULSORY TO PUT THE MACHINE INTO THE “MACHINE OFF” STATUS (SEE PAR. 1.2.2).**

ORDINARY MAINTENANCE TABLE		
FREQUENCY	POINT OF INTERVENTION	TYPE OF INTERVENTION
EVERY DAY	MACHINE BODY	CLEANING WITH SUITABLE PRODUCTS TO PREVENT ACCUMULATIONS OF FLOUR AND DIRT ON THE SURFACES.
	PROTECTION GRILLES EMERGENCY STOP BUTTON	CHECKING CORRECT OPERATING CONDITIONS.
	SCRAPERS	CLEANING LOWER AND UPPER SCRAPERS (SEE PAR. 8.1.1).
	Power supply cable and electric plug (MACHINE AND INVERSION PEDAL BOARD)	VISUAL CHECKING THE CONDITIONS.
EVERY 100 HOURS	TRANSMISSION CHAINS	CHECKING TENSION AND GREASING THE CHAINS.
EVERY YEAR	TRANSMISSION CHAINS	CHECKING TENSION AND GREASING THE CHAINS.
WHENEVER NECESSARY	CONVEYOR BELT	REPLACE (SEE PAR. 8.1.2).

TAB. 16 (Ordinary maintenance table)

7.1.1- CLEANING THE LOWER AND UPPER SCRAPERS

For correct machine operation, it is necessary to clean the outside of the scrapers every day and the parts that are more difficult to reach every week.

• LOWER SCRAPERS

- 1) Lift the work surfaces and lock them in position using the work surface stop hooks (FIG. 2 - Ref. 22);
- 2) Unhook the anchoring springs under the conveyor belts;
- 3) Put the work surfaces back into horizontal position;
- 4) Extract the scraper - support block upwards;
- 5) Clean using sponges and suitable detergents;
- 6) Carry out the procedure from point 4) to point 1) to reassemble the machine.

•• UPPER SCRAPERS

- 1) With the surfaces in working position, unscrew the fixing knobs;
- 2) Extract the scraper - block upwards and extract it from the chrome-plated cylinder;
- 3) Clean using sponges and suitable detergents;
- 4) Carry out the procedure from point 2) to point 1) to reassemble the machine.;



FOR THIS PROCEDURE THE PRESENCE OF TWO AUTHORISED OPERATORS IS REQUIRED. THERE IS A RESIDUAL POTENTIAL RISK DESCRIBED IN PAR. 5.4.

7.1.2- REPLACING THE CONVEYOR BELTS

For correct operation of the machine, the conveyor belts must be replaced whenever necessary. Proceed as follows:

- 1) With a pin punch, remove the elastic pin and take off the handle;
- 2) Remove the front and rear covers;
- 3) Remove the chains;
- 4) Remove the toothed cylinder along with the triangular flange, unscrewing the screws on the latter;
- 5) With the help of a second operator, hold the surface firmly and, after removing the elastic ring, take out the surface support shaft;



WARNING ! WHEN THE SUPPORT SHAFT IS REMOVED, THE SURFACE WILL FALL. THE SECOND OPERATOR MUST BE PRESENT IN ORDER TO PREVENT DANGEROUS SITUATIONS OCCURRING.

- 6) Then remove the surface and sub-surface and take off the conveyor belt;
- 7) Then tension the new conveyor belt, letting it run for about thirty minutes in one direction and if necessary adjusting the tensioning with the adjustment screws;
- 8) Repeat point 7) in the opposite direction

7.2- SPECIAL MAINTENANCE

this is the set of activities that aim to maintain the use and operating conditions of the machine constant, through various types of interventions carried out by the manufacturer's technician.



FOR ANY SPECIAL MAINTENANCE INTERVENTION IT IS COMPULSORY TO ASK FOR THE TECHNICAL ASSISTANCE AND/OR AUTHORISATION OF THE MANUFACTURER. BEFORE CARRYING OUT ANY KIND OF MAINTENANCE INTERVENTION, IT IS COMPULSORY TO PUT THE MACHINE INTO THE "MACHINE OFF" STATUS (SEE PAR. 1.2.2).

8-DECOMMISSIONING

8.1- STORAGE

If the machine needs to be stored for a longer period of time, it is necessary to put it in a safe environment, with a suitable temperature and level of humidity, protected from dust.

8.2- DEMOLITION



ALL THE MACHINE COMPONENTS MUST BE IDENTIFIED ACCORDING TO THE "EWC" (EUROPEAN WASTE CATALOGUE) CODE DEFINITIONS AND DISPOSED OF BY CONTACTING AUTHORISED AND SPECIALIST FIRMS, WITH ABSOLUTE RESPECT FOR THE LEGISLATION IN FORCE IN THE COUN-



WASTE ELECTRICAL AND ELECTRONIC EQUIPMENT (WEEE) MUST BE DISPOSED OF WITH FULL RESPECT FOR THE LEGISLATION IN FORCE IN THE COUNTRY OF DEMOLITION OF THE MACHINE.

9- SPARE PARTS

9.1- GENERAL INSTRUCTIONS



THE ACCESSORIES MUST BE REQUESTED EXCLUSIVELY SPECIFYING THE IDENTIFICATION DATA OF THE DOCUMENT SUCH AS THE CODE AND REVISION (SEE COVER).



IT IS ABSOLUTELY FORBIDDEN TO REPLACE ANY COMPONENT OF THE MACHINE WITH NON-ORIGINAL SPARE PARTS.

9.2- SPARE PARTS