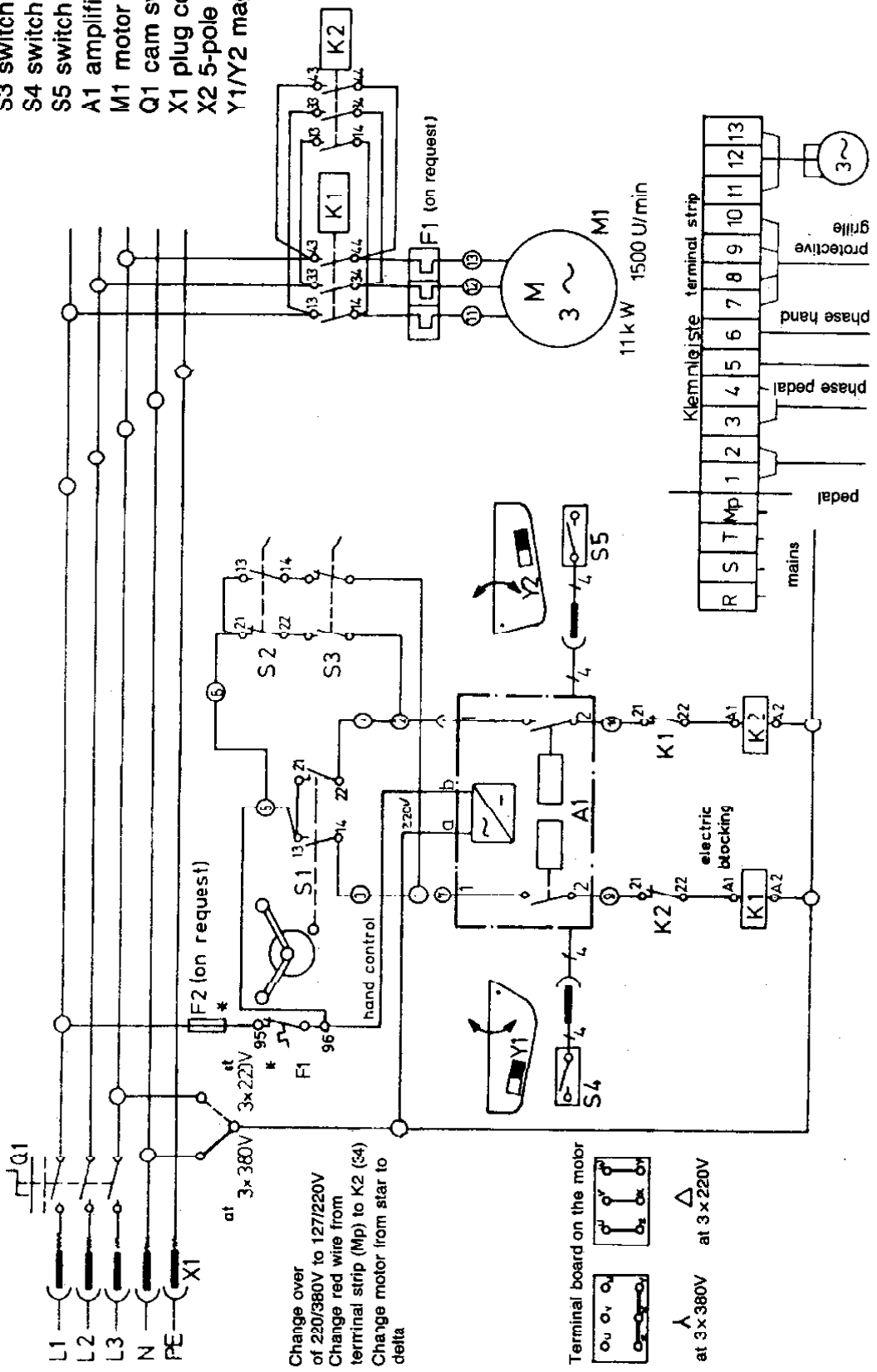


ELECTRIC CONTROL DIAGRAM

unit list:

- F1 motor protector relay
- F2 fine fuse 1A
- K1 contactor
- K2 contactor
- S1 switch
- S2 switch
- S3 switch
- S4 switch
- S5 switch
- A1 amplifier
- M1 motor
- Q1 cam switch
- X1 plug connector
- X2 5-pole plug
- Y1/Y2 magnet



Search for defects and repair of electric of dough sheeting machines

1. Machine does not run at all

Check plug socket R, S, T and Mp (neutral conductor) Switch on, check on terminal R, S, T and Mp (neutral conductor)

2. Check right-handed run

Click hand-lever into position "Right-handed run".

Meter from Mp (n.c.) to terminal 6, then meter from Mp (n.c.) to terminal 3.

Meter from Mp (neutral c.) to terminal 9. If there is no tension, check protective grille and table switch. In order to do so, unscrew cover of the head on the opposite side. If they are alright, meter from terminal 41 of contactor C2 to Mp (neutral c.). If there is no tension on terminal 42, exchange contactor C2.

If there is tension on terminal 42 of contactor C2, meter from contactor connection C1a to C1b.

3. Check left-handed run

Click hand lever in position "left handed run".

Meter from Mp (neutral c.) to terminal 6, then from Mp (n.c.) to terminal 4.

Meter from Mp (neutral c.) to terminal 10. If there is no tension, check protective grille and table switch. In order to do so, unscrew cover of the head on the opposite side.

If these are alright meter from terminal 41 of contactor C1 to Mp (neutral c), then meter from terminal 42 to Mp (n.c.).

If there is tension on terminal 42 of C1, then meter contactor connection C2a to C2b.

If there is 220V, exchange contactor C1.

4. Check pedal switch

If hand switch is alright, check pedal switch as follows:

Meter from Mp (n.c.) to terminal 5.

Then operate right pedal switch.

Now power must be on terminal 2, at the left foot-operated switch on terminal 1.

If this is not the case remove cover at the bottom of the machine and check final switch.

5. Motor is purring

Meter from terminal 11 to terminal 12 and 13. In both cases there must be right voltage.

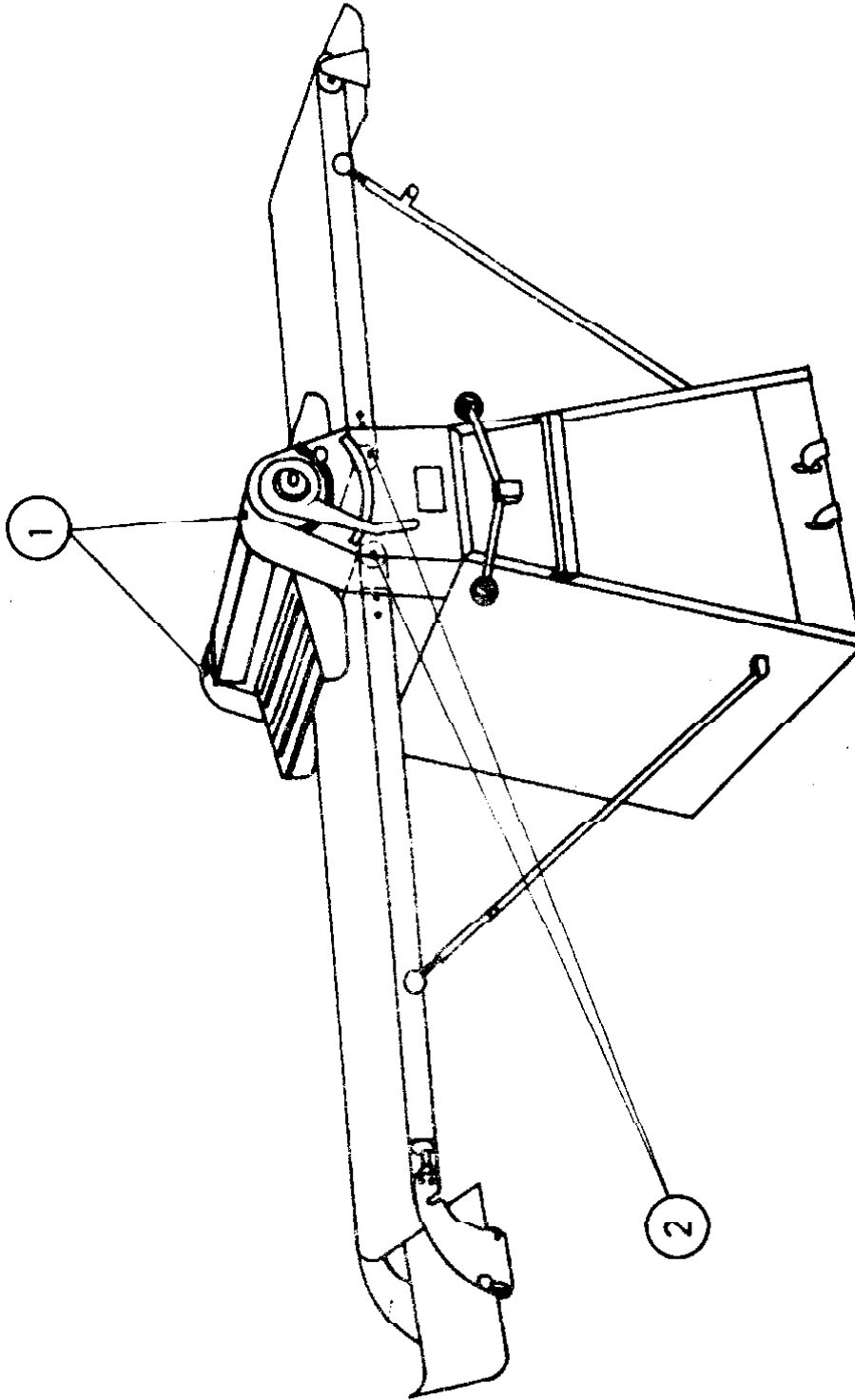
If this is not the case meter from contactor C1 terminal 14 to terminal 24 and 34.

If there are 380 VWs in each case check whether motor is purring in right-handed run or left-handed run. Exchange contactor accordingly.

If there are right voltage on terminal 11, 12, 13 check motor terminal strip whether right voltage are at the motor. If this is the case and the motor keeps purring then exchange the motor.

n.c. = neutral conductor

LUBRICATION CHART

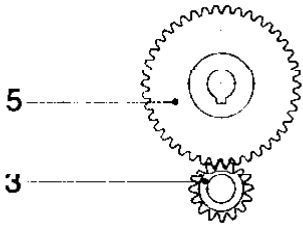
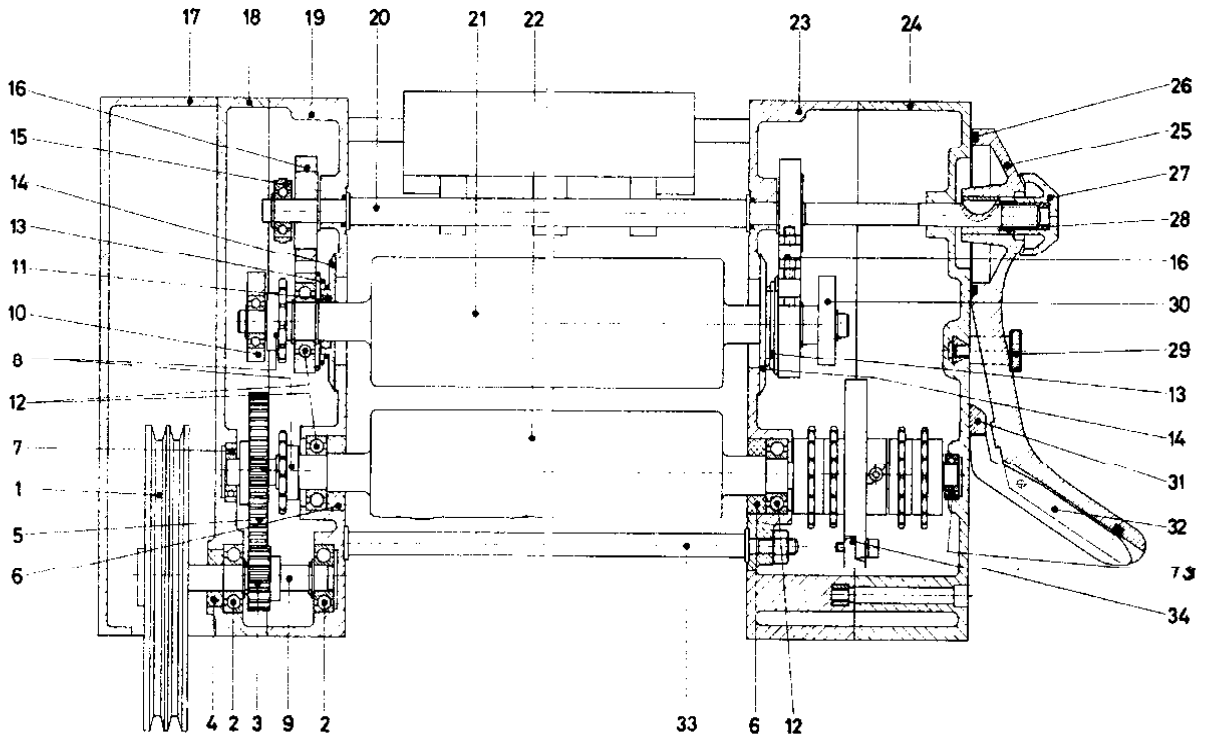


1. Will be replenished with heavy-duty semi-fluid grease, when the machine is serviced or otherwise every year and a half or two years.
2. Monthly 2drops of non-resinous oil

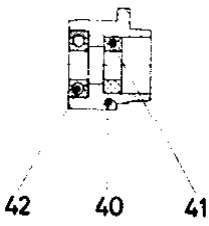
Spare Part Lists for MACHINE HEAD

<u>POS.</u>	<u>PART</u>	<u>POS.</u>	<u>PART</u>
1	V-belt pulley	32	Locking lever
2	Ball bearing 6204	33	Spacer rod
3	Small gear z = 16	34	Clutch assembly compl
4	Oil seal ring ϕ 20/40	34a	Clutch liner
5	Large gear z = 42	35	Brake assembly compl
6	Oil seal ring ϕ 28/52	36	Brake disc
7	Ball bearing 16004	37	Adjusting ring
8	Sprocket wheel z = 13	38	Sprocket, lateral serr.
9	Driving shaft	39	Sprocket without serr.
10	Lateral guide, right	40	Conical bushing
11	Oil seal ring ϕ 25/35	41	Oil seal ring ϕ 15/30
12	Ball bearing 6205	42	Ball bearing 6202
13	Scraper disc spring	47	Pointed bolt
14	Scraper disc	64	Spring for point. bolt
15	Reversing roller	65	Revers. roller bolt
16	Supporting plate	66	Clutch bolt
17	Cover	67	Sprocket 10 teeth
18	Housing AV	68	Sprocket 18 teeth
19	Housing AR	69	Draw spring
20	Eccentric shaft	70	Adjusting bolt
21	Top pressure roller	71	Right brake shoe
22	Bottom pressure roller	72	Left brake shoe
23	Housing KR	73	Eccentric bolt
24	Housing KV	74	Ball bearing 6202
25	Roller adjust lever	75	Eccentric disc
26	O-ring	76	Set of sprocket-wheels right
27	Cap nut	77	Set of sprocket-wheels left
28	Spring for oap nut	78	Chain 50 links
29	Strake bolt		Chain 30 links
30	Lateral guide, left		Chain 26 links
31	Serrated section	79	Ball bearing 6002

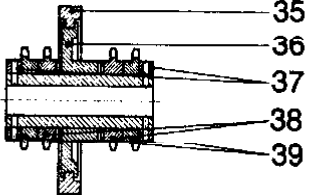
Sectional view of machine head



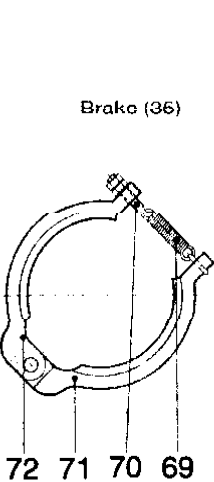
Spur-gears



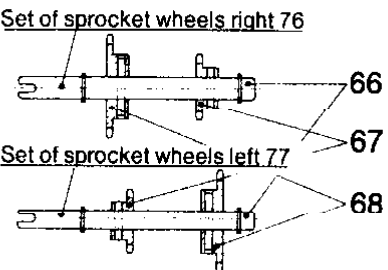
Conical bushing



Clutch assembly compl. (34)

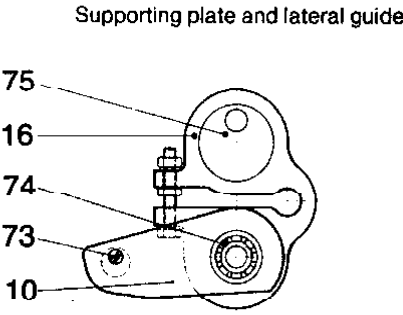


Brake (36)

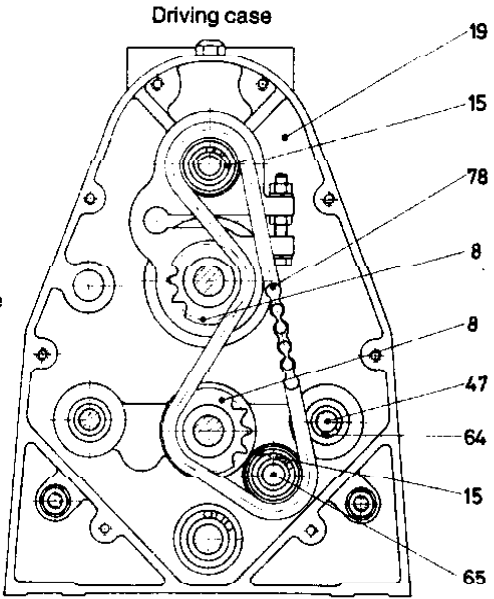


Set of sprocket wheels right 76

Set of sprocket wheels left 77

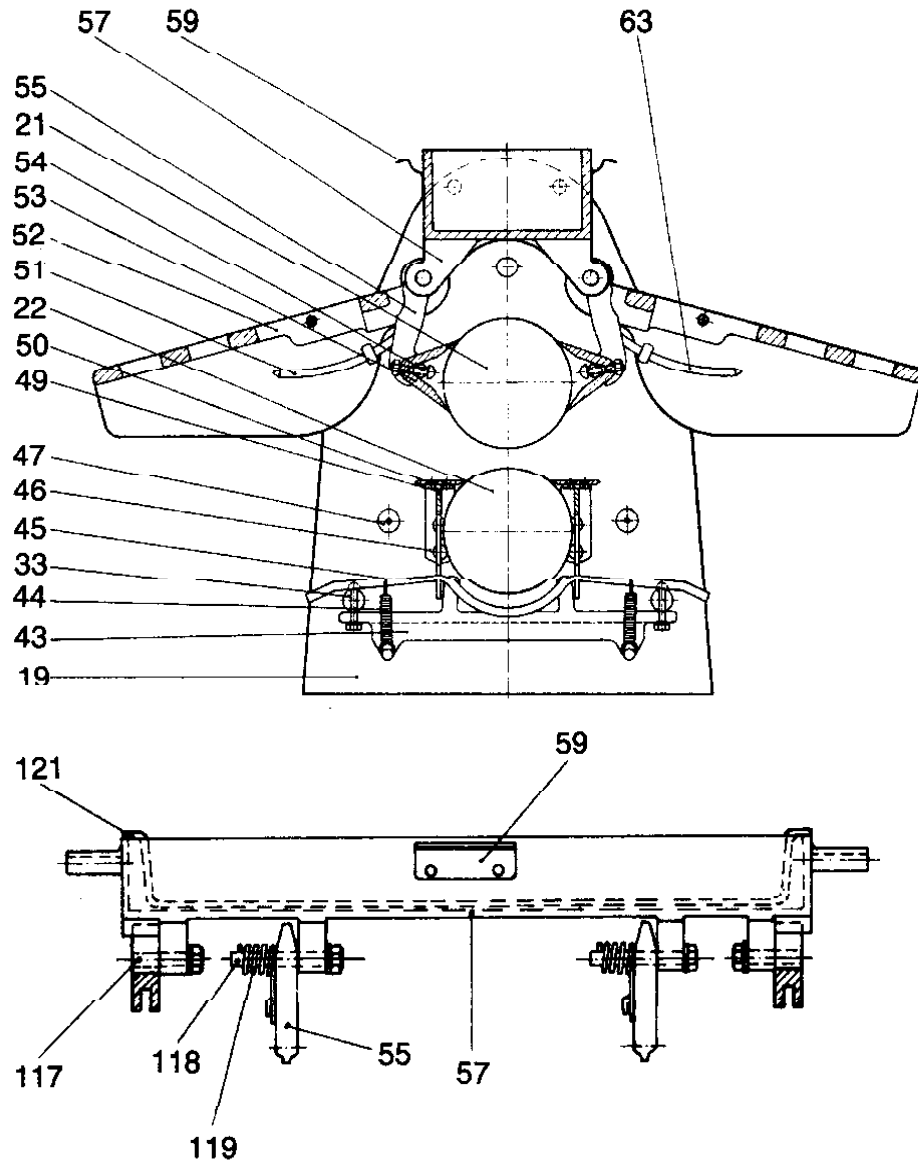


Supporting plate and lateral guide



Driving case

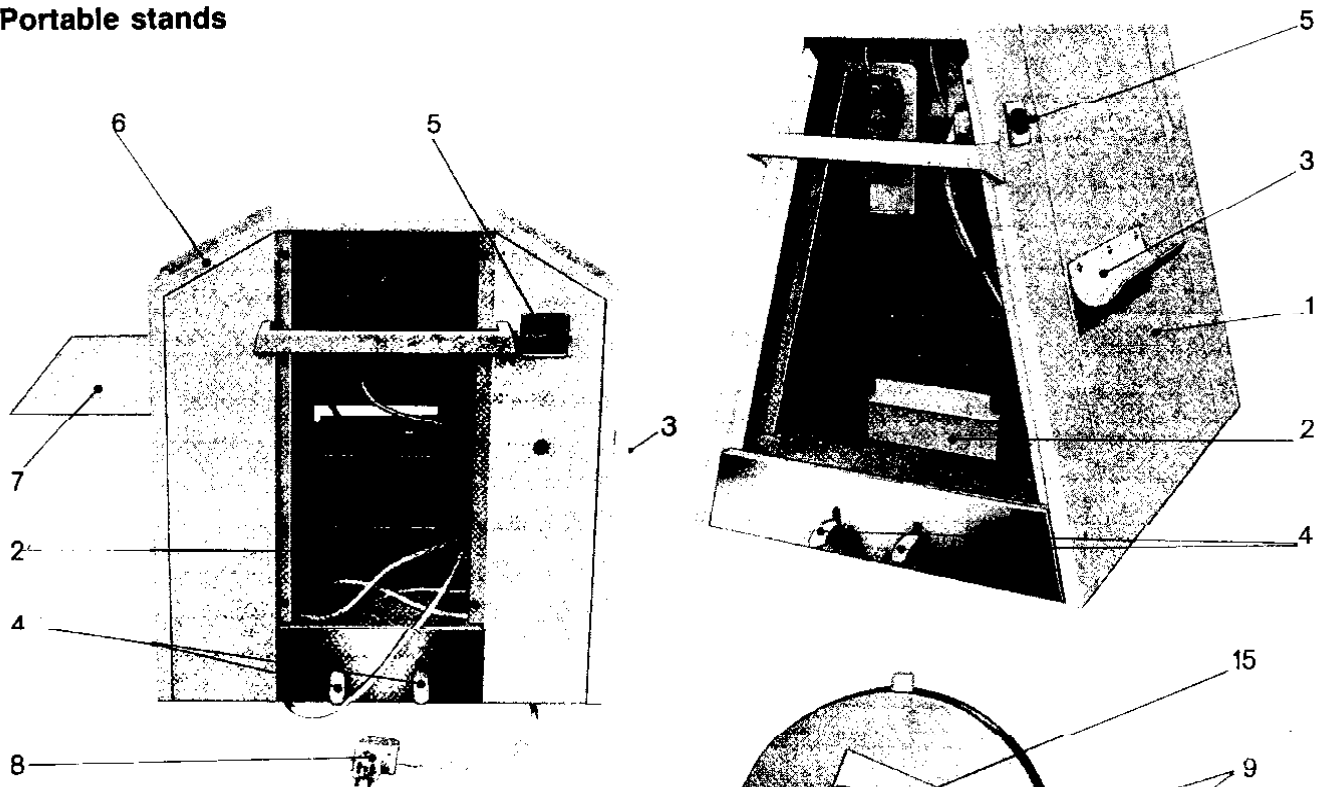
Sectional view of machine head



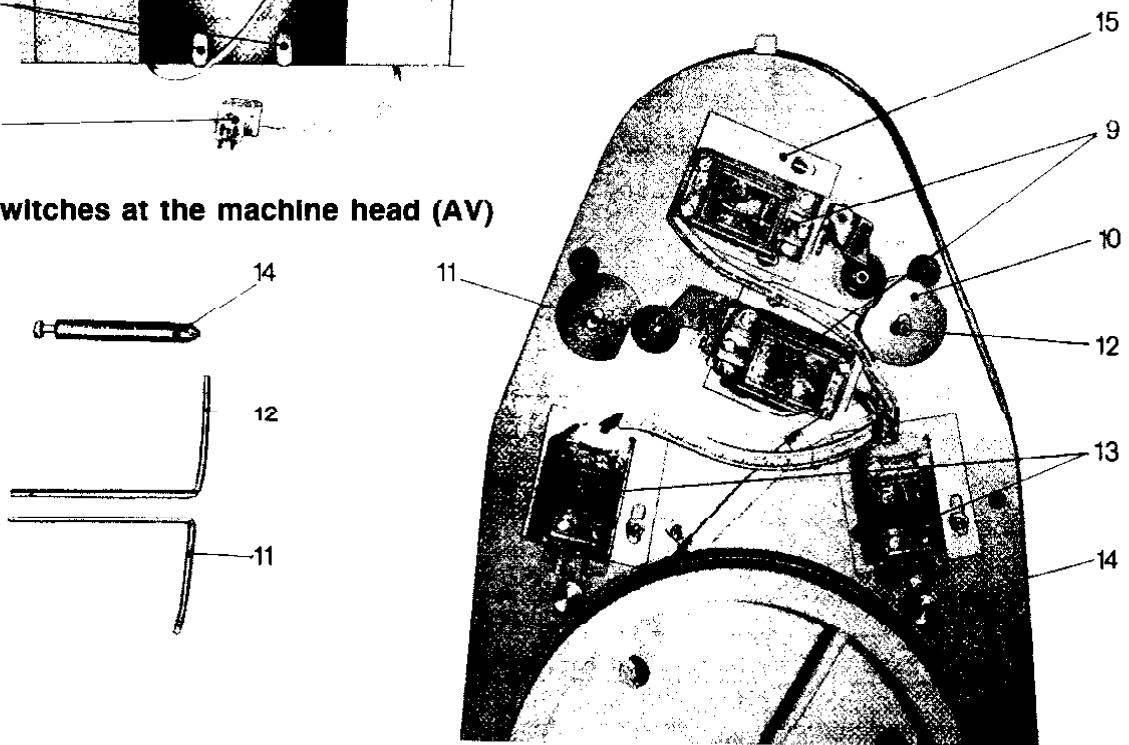
Spare Parts List for MACHINE HEAD and Extensible Conveyor Table

<u>POS.</u>	<u>PART</u>		
43	Retaining strip	105	Conveyor table 0.5m
44	Bottom scraper spring	106	Tensioning screw for conveyor belt
45	Spring supported joke for bottom scraper	107	Table bracket, tapered
46	Holder for plexiglass bracket	108	Driving roller
47	Pointed bolt	109	Idling roller
49	Lower plexiglass bracket	110	Holder for reversing roller
50	Plexiglass strip	111	Holder for idling roller
51	Left-hand shift lever	112	Slide pipe
52	Protective grille	113	Stroke angle
53	Plexiglass angle	114	Table support
54	Vibration damper	115	Locking screw
55	Holding lever	116	Conveyor belt
57	Flour box	117	Shank screw short
59	Retaining spring for protective grille	118	Shank screw long
63	Right-hand shift lever	119	Spring
		121	Plexiglass flour box

Portable stands



Switches at the machine head (AV)

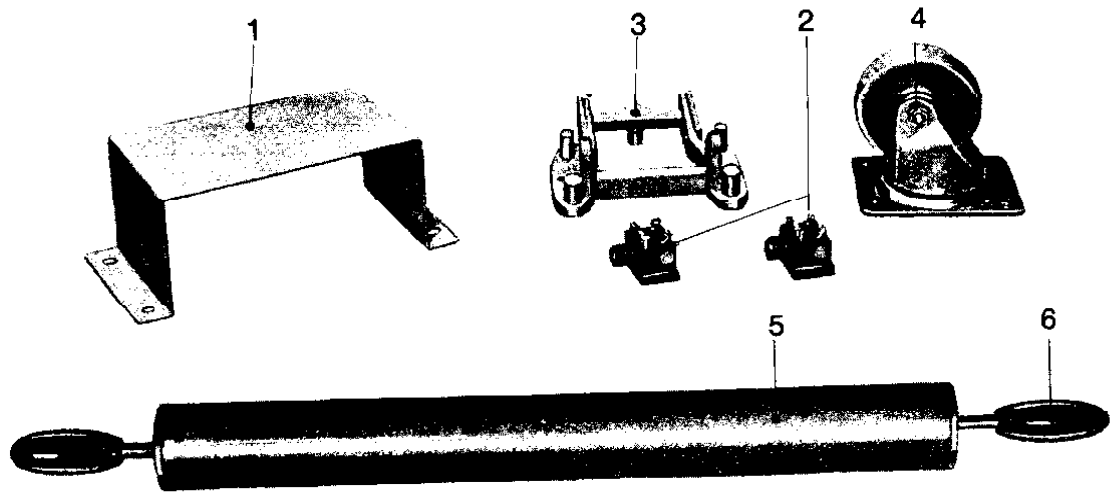


Spare parts list

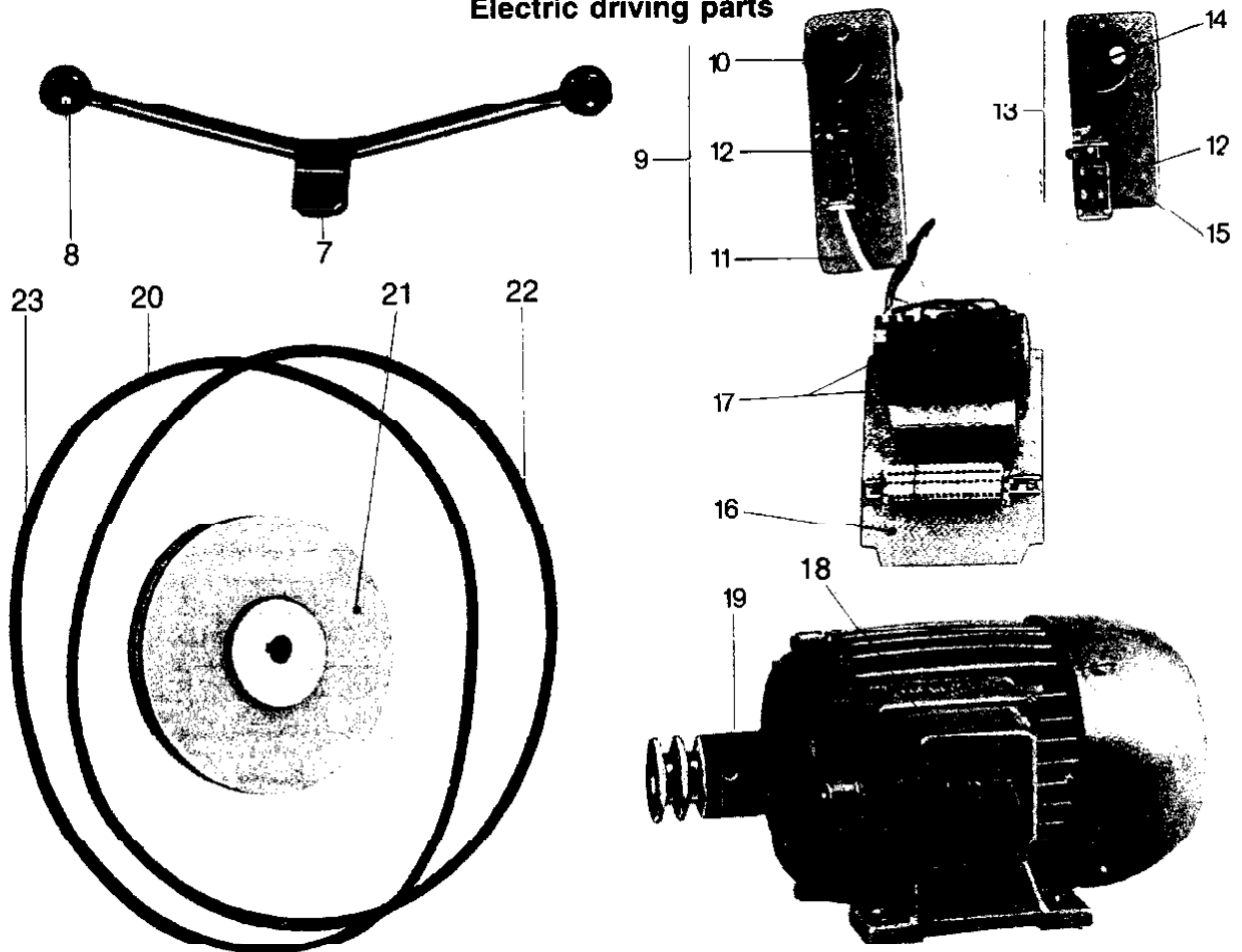
Portable stands and switches at the machine head

<u>POS.</u>	<u>PART</u>	<u>POS.</u>	<u>PART</u>
1	Portable stand	9	Limit switch
2	Electric case	10	Control disc
3	Place of deposit for hand-roller	11	Shift lever right
4	Foot operated switch pedal	12	Shift lever left
5	Main switch	13	Limit switch
7	Place of deposit	14	Point bolt
8	Earth contact plug, 5 pole	15	Holding plate for switch

Accessories for portable stands



Electric driving parts



Spare parts list

Accessories for portable stands and electr. driving parts

POS.	PART		
1	Protective cover	10	Switch bolt with eccentric disc
2	Limit switch	11	Control panel
3	Frame for foot-operated switch	12	Limit switch
4	Swivel caster with plastic wheel	14	Switch bolt with eccentric disc
5	Hand roller, complete	15	Control Panel
6	Plastic handle	16	Montage plate for sarel-case
7	Switch lever, complete	17	Contactor
8	Ball handle, black ϕ 40	18	Motor 0.75 Kw
9	Control panel, compl.	19	V-belt pulley on motor
		20	V-belt DIN 2215