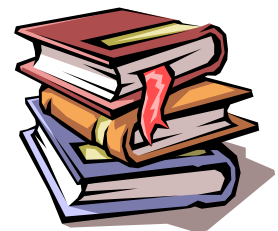


LONG MOULDER

USAGE-MAINTANENCE-ASSEMBLY AND TECHNICAL SERVICE GUIDE

**BEFORE USING THIS MACHINE,
READ CAREFULLY THE PRESENT
INSTRUCTIONS MANUAL**



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PREMISE

Thanks you for choosing its machine and, in order to obtain the best performance, describes in detail all that is necessary to set the machine up and the required devices for a correct and prolonged use. We invite you to read carefully this manual and follow it thoroughly, PANEMOR does not answer of any damage to persons and/or things, caused by a misuse of the machine due to the non-observance of the suggestions contained in this manual

PANEMOR Bakery Machinery Co. has established in 2016. PANEMOR is a leading manufacturer, producing more than fifty different models of bakery machines and equipments to be able to meet many craftsman baker's and confectioner's needs in the entire world.

PANEMOR produces high quality and qualified to apply ISO 9001:2000 Quality Management System. The machine has been built according to the required TSE, TSEK, CE and GOST-R.

WARRANTY

PANEMOR guarantees that the machine has been tested and that the guaranteed warranty is of 12 (twelve) months, excluded all the electrical parts. To cancel protective parts of the machine, especially to the safety devices, makes the guarantee lapse and consequently does not answer for any damage to persons and/or things due to this pilfering or cancellation.

When delivered, check immediately if the machine has been damaged during the transport and, in such case inform the forwarder;

- Transportation Company
- Insurance Company
- Agency

Check that the eventual required optional are complete and if this is not the case inform writing within and beyond 3(three) days.

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1. MACHINE DESCRIPTION

1.1 General Premise

The machine has been built according to the required safety and hygienic norms of the MACHINES DIRECTIVE 89/392 CEE (and following modifications 91/368/ CEE and 93/68/CEE) and according the EN REGULATIONS (European Norms) referred to the Long Moulder for the productions of bread, pastry and other oven products.

All the machine data are written on an aluminum plate applied on the back side of the Long Moulder, as described in FIG.1

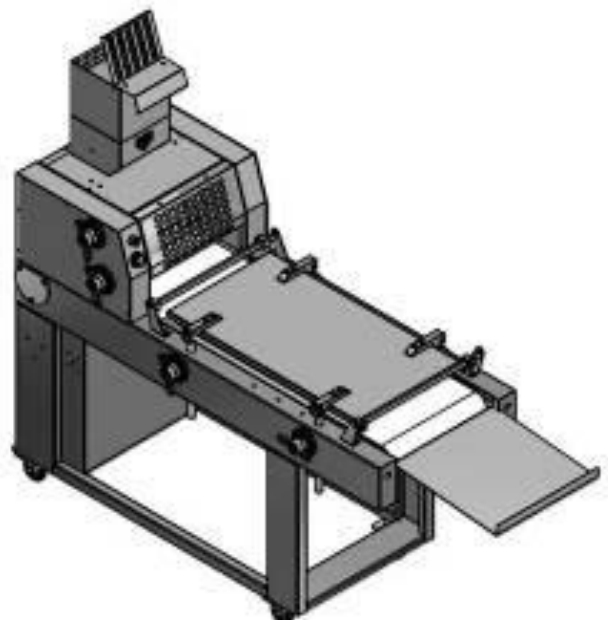


Figure – 1

1.2 General Information

This manual should be used while the maintenance and operations of machine.

1.1 Read the instructions before you operate the machine, and take in to consideration about security precautions.

1.2 Keep this manual near to machine in order not to cause misusing and faulty operations or maintenance.

1.3 This instructions booklet has been prepared according to the last design of the dividing machine.

1.4 Manufacturer is not responsible for the following cases:

- Operation of machine in the proper conditions and places.
- Wrong electrical connections and operations.
- Not caring about the maintenance.

1.3 Use of Machine

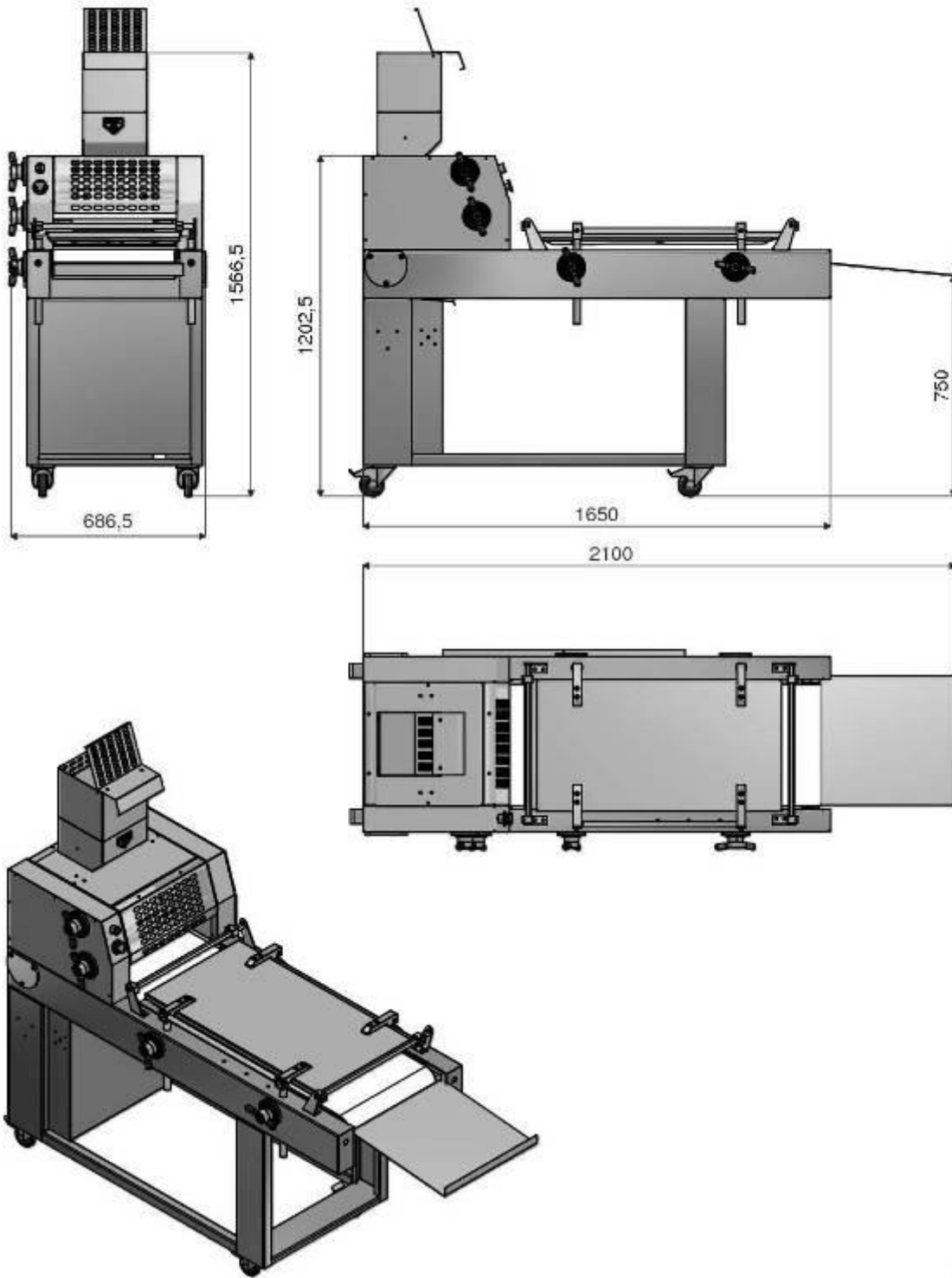
Panemor LM 3000 Long Moulder machine has been designed for all types of dough handling in the medium - sized bakeries. The stainless steel centering flaps feeds the dough pieces in to the centre of moulding head rollers. All moving parts have ball bearings and small wheels make the machine move easily.

Long Shaping Machine has a capacity of 3000 pieces dough per hour. **Minimum dough weight is 200 gram and maximum weight is about 1200 gram.** In this range rolling process is cylindrical and length is about 420 mm. All Panemor Long Moulders are more efficient on those dough types which contains 50 % water. For harder dough types (more solid) moulder is not so efficient and precise.

1.4 Usage Restrictions

There are no particular use restrictions, apart from the dough hardness, requiring at last **50%** of water on flour weight, expressed in kg.

1.5 Technical Data



2. SAFETY DEVICES

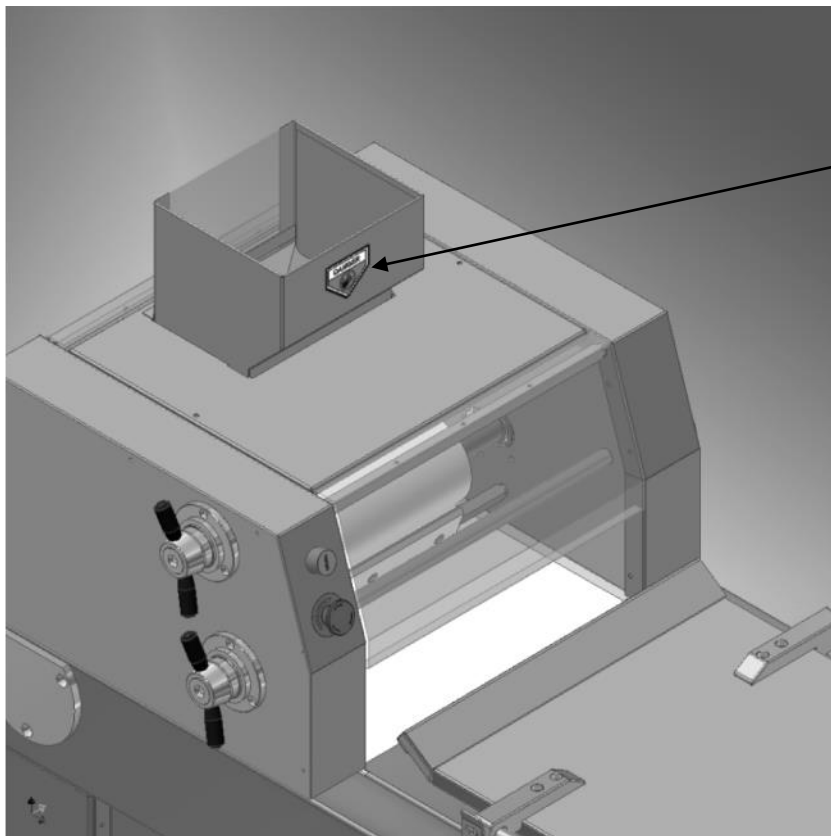
2.1 Electrical Devices

Electrical circuit diagram of Long Moulder machine can be examined as attached to this manual.

2.2 Sound Level

Machine runs according to wheel and V-belt principle therefore the noise level is almost 70 dB and complies with CE regulations.

2.3 Safety Warnings



- The most dangerous parts of the shaping machine are rollers.
- Never operate the machine unless you assemble the up cover on it.

3. TRANSPORT, LIFTING AND INSTALLATION

3.1 Transportation Instruction

The net weight of Long Moulder machine is 220 kg. Machine should be carried on these palette and packaging with nylon.

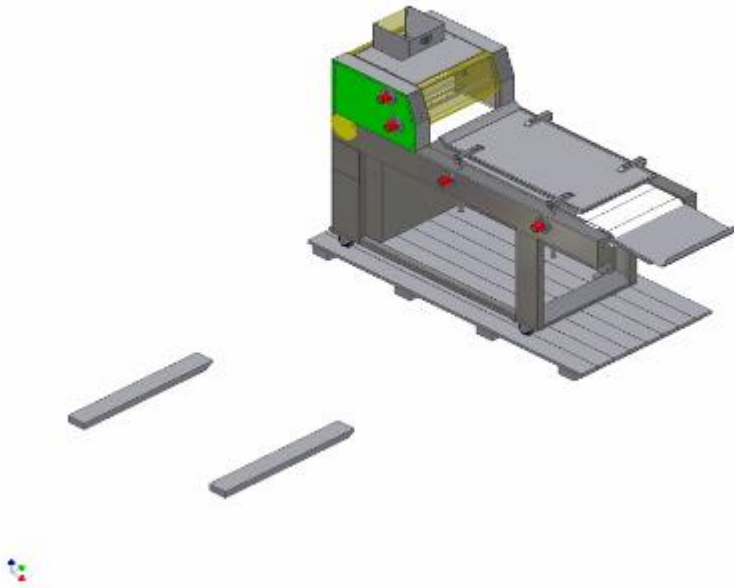


FIG.2

3.2 Installation Instruction

- Place the Long Moulder in a suitable area for its use, in safe conditions. The room will have to be sufficiently ventilated and lighted.
- Respect the minimum distance from walls, as shown in FIG.3 to have the necessary space for the working, cleaning and maintenance operations.
- This will allow operating in safe conditions, avoiding possible scrapings between the machine and the wall. The Long Moulder is self-standing and does not require floor anchorage after accommodate the machine you can move with special trollers.

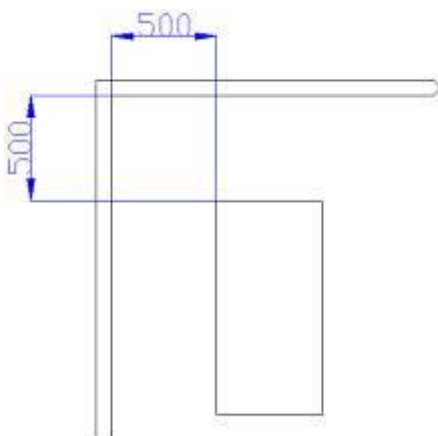


FIG. 3

3.3 Electrical Link

Power supply should be (3x380 VAC –50 Hz). Before operating the machine make sure that electrical source values are suitable for the machines electrical

specifications and check network tension and security appliances and safety system. The machine should be grounded properly before being connected to the main power source.

The energy connections must be done in a proper phase sequence. In the case of wrong rotation change the two phases A –B that are located on the switch plug. (See FIG 4.) This process should not be done with the switch plug located on the oven.

You may see the electrical entry provided by a cable behind the machine. When necessary, in order to cut the connection between the machine and the network voltage, you may use the manual cutoff switch located on the machine (While cleaning)

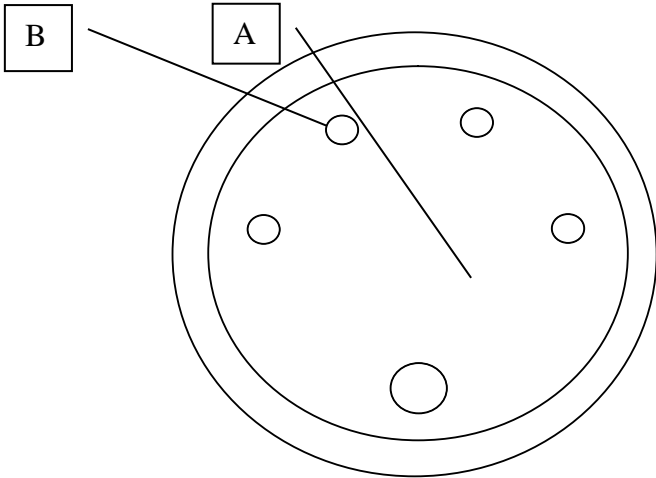


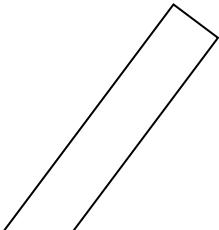
FIG. 4

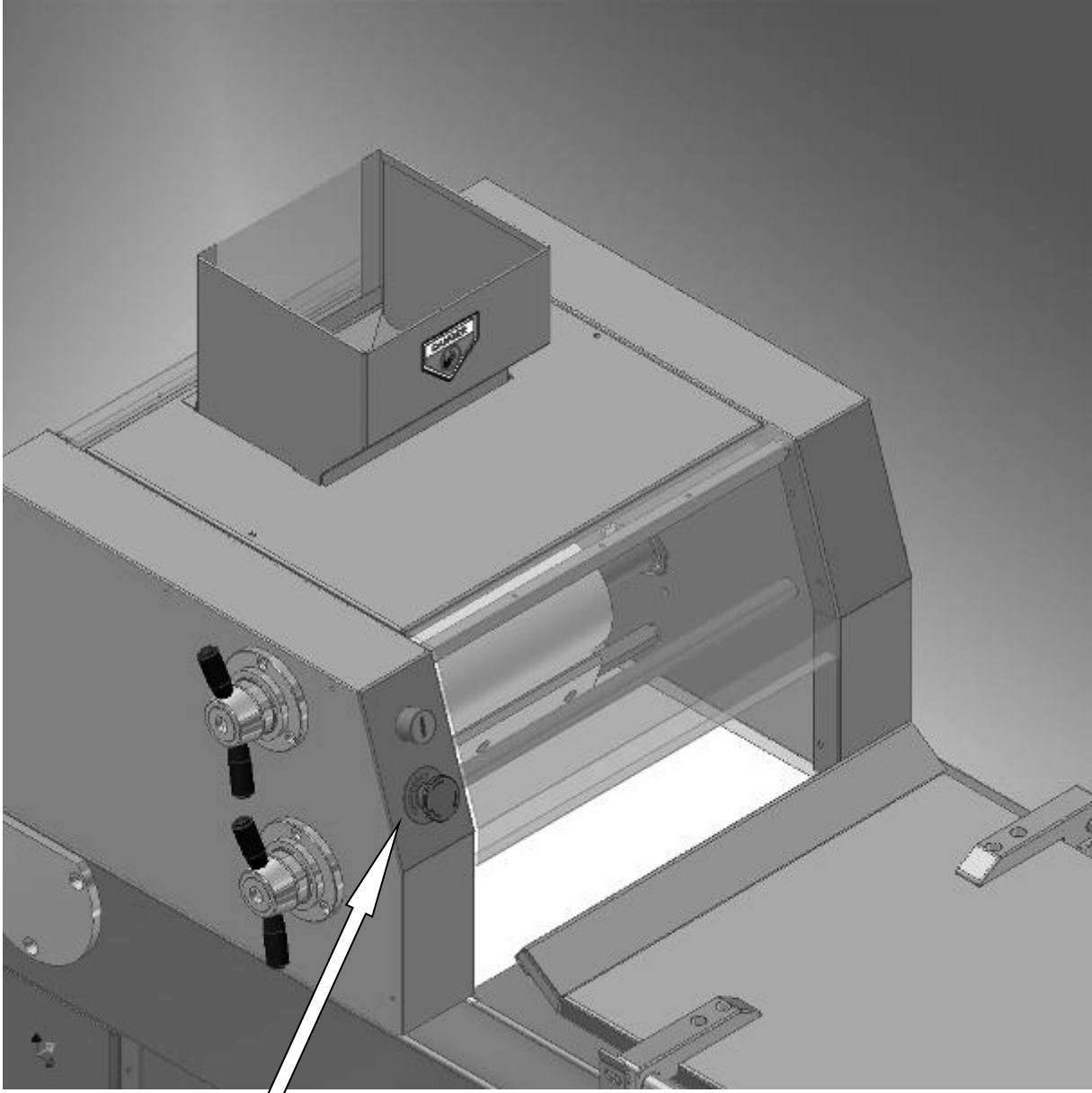
WARNING: If the machine’s horn runs continuously, change the machine linking sockets phases sequence. You must be sure change on the socket not from the machine side.

4. USE OF THE MACHINE

4.1 Controls

START BUTTON





EMERGENCY STOP

The machine has only one connection to the mains electricity supply, 3 phases 380 VAC 50 Hz.

DANGER: Make sure that the values of your mains electricity supply comply with the power specifications of the machine. Electrical hazards make sure the machine is adequately grounded before making any other connection to the mains power supply.

4.2 Out Of Service Case

In this case, always keep the rollers and forming plate clean. Do not leave any particles of dough inside the machine.

5. MAINTENANCE AND CLEANING

5.1 General Information

Due to its construction characteristics, heavy maintenance operations will not be necessary for this machine.

CAUTION: Any check up or maintenance operations should only be carried out when the machine is switched off and disconnected from the electric power supplies. After you finish controlling the machine, protective lids that had been disassembled should be detached and fixed in their original positions.

Two types of maintenance:

- Ordinary maintenance, to be done periodically respecting the specified expirations;
- Extraordinary maintenance, when pieces of the machine must be substituted.

IMPORTANT:

- Before you start the maintenance or revision process cut the electrical connection and do not let any electrical currency until you finish the process.
- Check all of the safety systems are active before start daily use.
- Although stainless steel panels and smooth surfaces ensure easy cleaning all dough touching surfaces should be cleaned every day.
- Do not use steel scrapers and some poisonous chemicals or soap for cleaning purposes.
- Outer sides can be cleaned by a wet cloth.

5.2 Ordinary Maintenance

- Chain should be greased monthly.
- Conveyor belt adjustment should be done if necessary.
- Main motor gear oil should be checked.
- Ball bearings should be greased monthly.
- Main motor and transfer V-belt tensions must be controlled for every month.

5.3 Extra Ordinary Maintenance

Specialized and trained staff who have a command of operating and setting up the machines and who follows the instructions given in this manual, must carry out extraordinary maintenance.

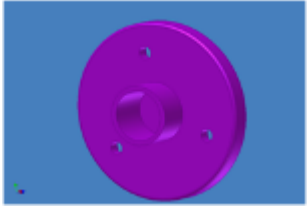
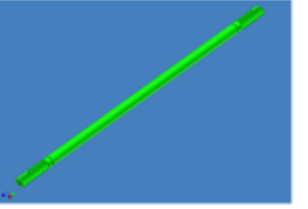
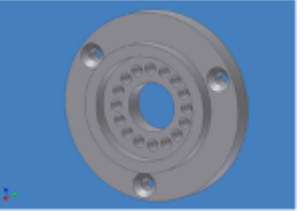
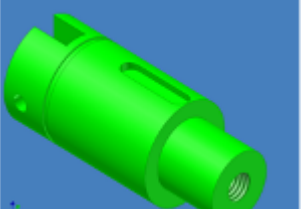
6. SPARE PARTS

6.1 How to Order

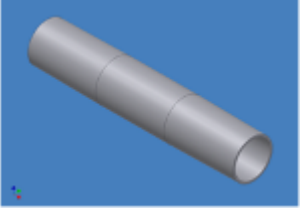
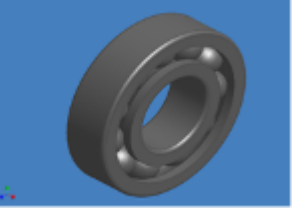
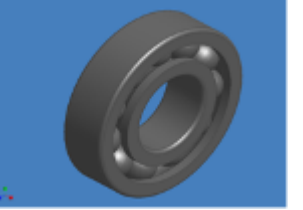

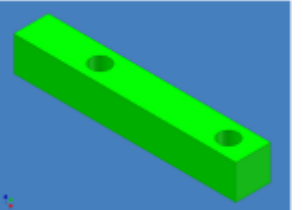
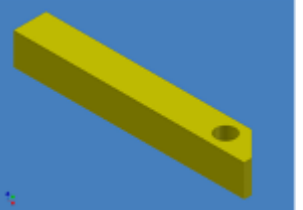
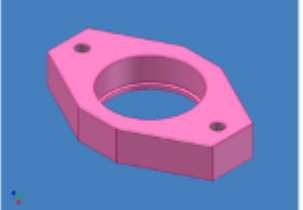
Please give this following information when you will orders to spare parts.



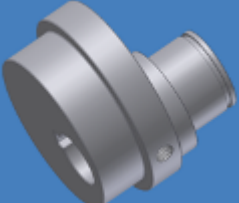
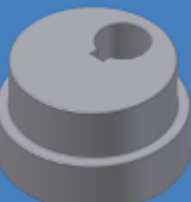

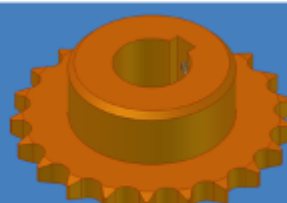

- Model and serial number of the machine.
- Motor voltage and speed.
- Name of spare part.
- Specify the kind of transport required.
- Write clearly your delivery address


6.2 Spare Parts Table

PART NAME	PART CODE	USAGE SUPPLY	DESCRIPTION	PICTURE
MİL YATAĞI GUDGEON BED	052.081	4		
GRAMİYER GUDGEON	052.049	2		
KİLİTLEME ALT PARÇASI LOCKING DOWN PART	052.116	4		
KİLİTLEME GÖBEĞİ LOCKING BELL	052.118	4		

KİLTLEME DIŞ PARÇASI LOCKING OUT PART	052.117	4		
KİLİTLEME KAPAĞI LOCKING COVER	052.130	4		
PARÇA ADINI GİRİNİZ	052.042	2		
YASTIK MENTEŞELERİ1 BED HINGES	052.043	2		
YASTIK KİLİTLEME PARÇASI BED LOCKING PART	052.120	2		
YASTIK PİMİ BED GUDGEON	052.122	2		
MERDANE RULMAN YATAKLARI MERDANE ROLLER BEDS	052.035	2		

<p>ÖN-ARKA MER. B.(Ø89 Ø68X440)</p> <p>FRONT AND BACK MERDANE</p>	50.125-4	2		
<p>6206 ZZ C3 ORS RULMAN</p> <p>ROLLER</p>	RUL.012	12		
<p>6206 2RS V ORS RULMAN</p> <p>ROLLER</p>	RUL.026	2		
<p>1/2" 21-CH ZİNCİR DİŞLİSİ KAMALI</p> <p>CHAIN GEAR SPLINE</p>	052.087	1		
<p>EKSANTRİK RAYI</p> <p>ECCENTRIC RAIL</p>	052.015	4		
<p>DİŞLİ RAYI 2</p> <p>GEAR RAIL 2</p>	052.016	4		
<p>MİL YATAKLAMA PARÇASI</p> <p>GUDGEOR BED PART</p>	052.008	4		

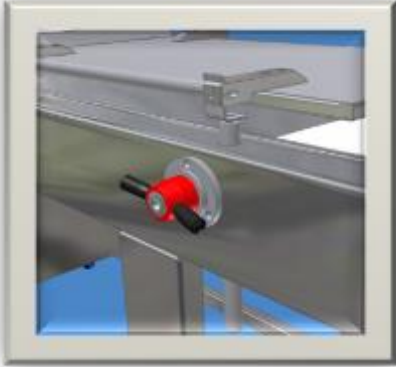
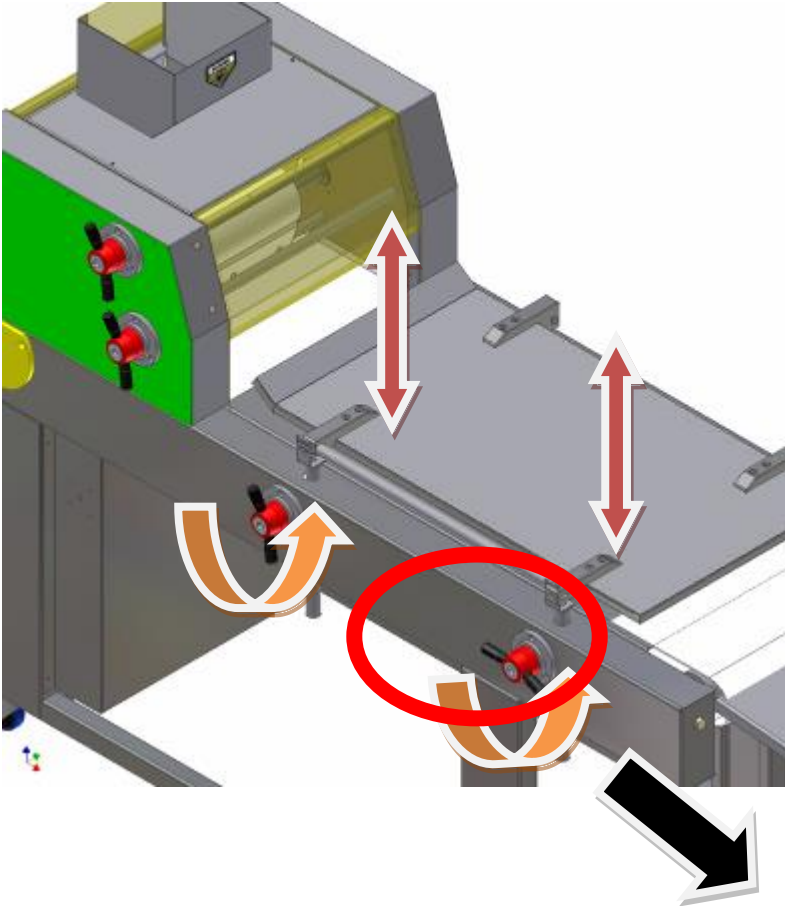
HALKA RING	052.010	4		
MERDANE AYAR MİLİ ROLLER ADJUSTING GUDGEOR	052.014	2		
EKSANTRİK DÖNER PARÇA ECCENTRIC TURNABLE PART	052.006	2		
EKSANTRİK DÖNER PARÇA ECCENTRIC TURNABLE PART	052.007	2		
1/2" 21-CH ZİNCİR DİŞLİSİ RULMANLI CHAIN GEAR ROLLER	052.005	2		
1/2" 21-CH ZİNCİR DİŞLİSİ KAMALI CHAIN GEAR SPLAIN	052.001	2		
1/2" 17 CH ZİNCİR DİŞLİSİ KAMALI CHAIN GEAR SPLAIN	052.002	1		

1/2" 2-17 CH ZİNCİR DİŞLİSİ KAMALI CHAIN GEAR SPLAIN	052.082	1	
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6. MACHINE ADJUSTMENT

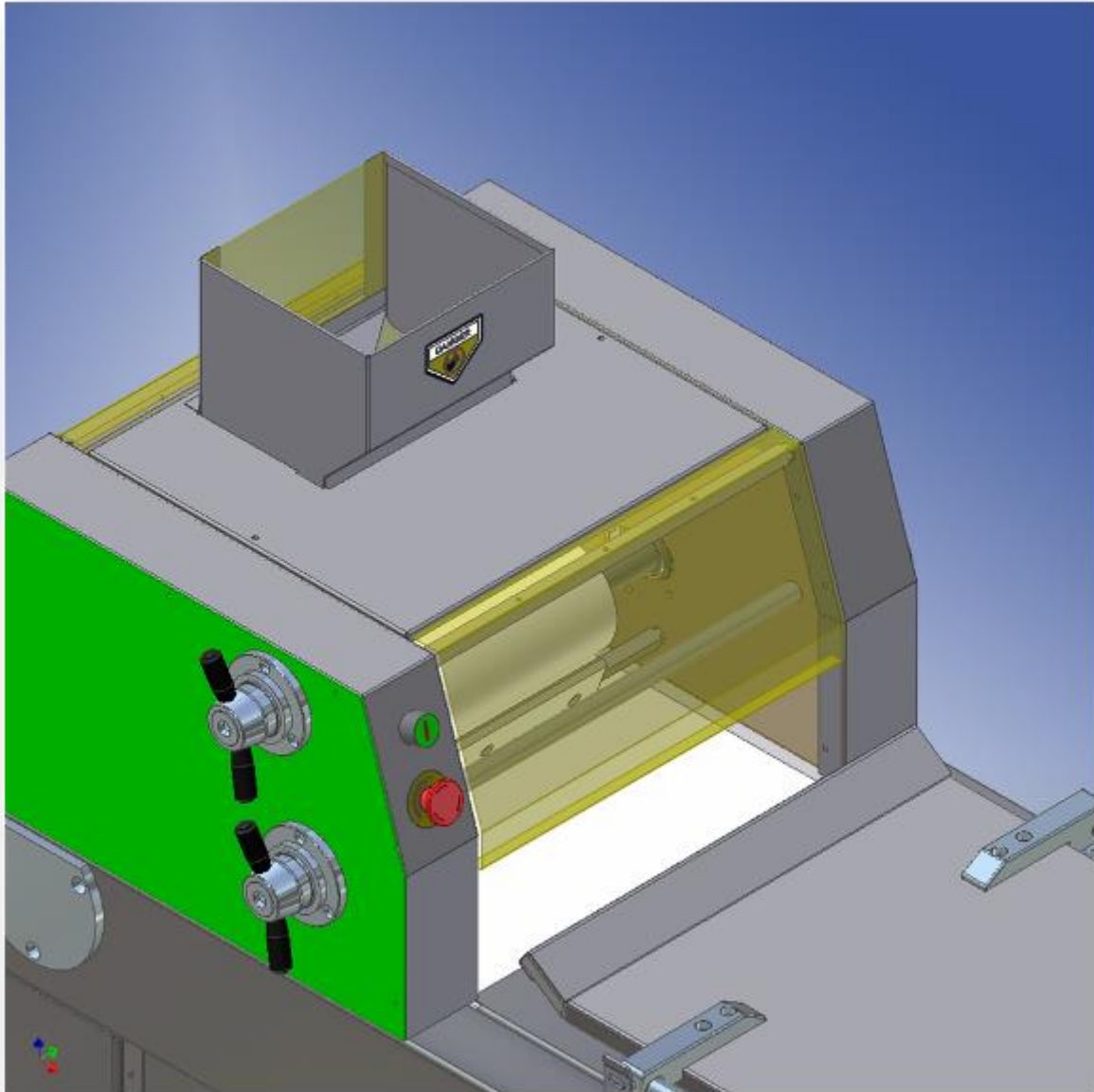
6.1 Adjustment of Forming Plate

PLM 3000 long shaping machine has an advantage of easy adjustment of forming plate you can adjust front side and backside separately. While you are adjusting you can observe the height of plate at four points. These numbers are relative and don't have any unit.



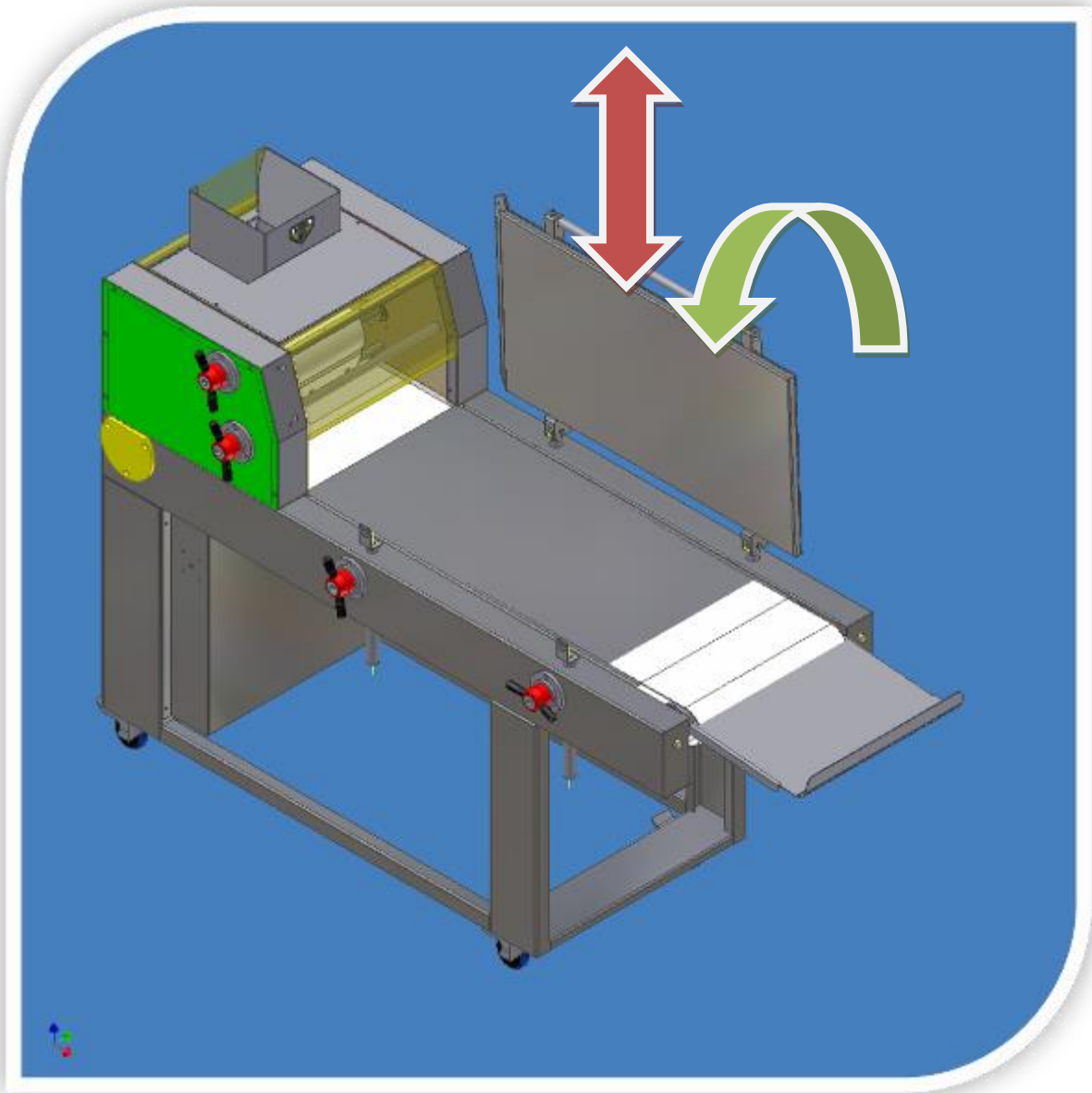
6.2 Adjustment of Roller Gap

This roller can be adjusted by the help of adjusting knob on top side of the machine. The gap between the top rollers should be larger than the bottom roller.



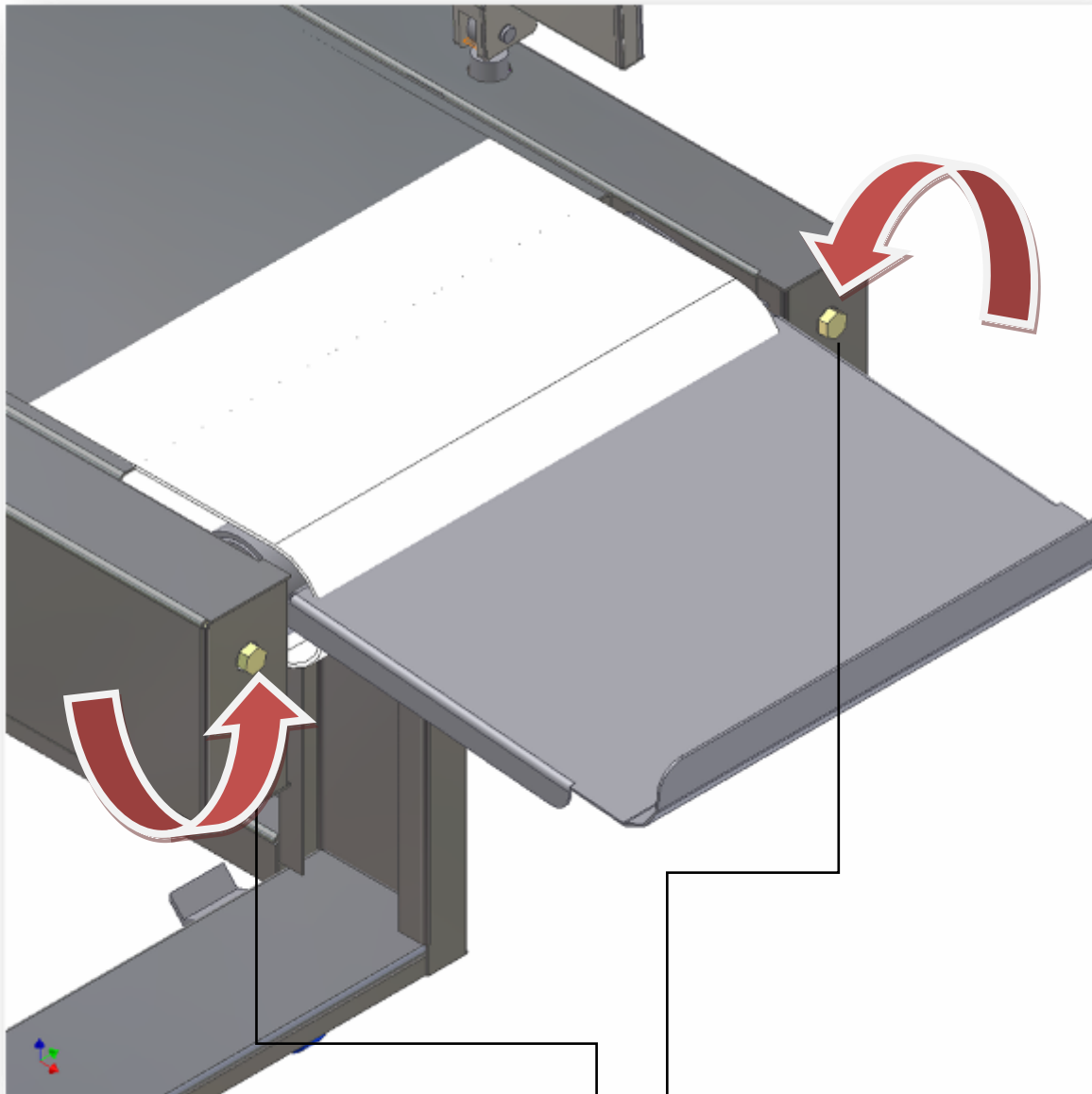
6.3 How to Open the Forming Plate

Forming plate, which is covered by a polyethylene material can be easily opened one side. This specification makes the machine more useful.



6.4 Band Tension Process:

The Required tension is provided by two tension bolts located in front of the machine.



Tension Bolts

6.5 Pressure Board

As you see above, this pressure board can be lifted up and fixed in order to make the maintenance clean interior part of the board.

