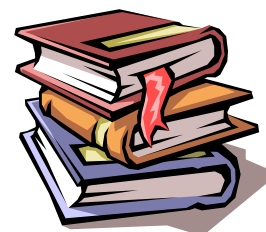


CONICAL RAUNDER

USAGE-MAINTANENCE-ASSEMBLY AND TECHNICAL SERVICE GUIDE

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



PREMISE

GGM 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, GGM 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

GGM 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.

GGM 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

GGM 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 Conical Rounder for the productions of bread, pastry and other oven products.

All the machine data are written on an aluminum plate applied on the backside of the Conical Rounder, as described in FIG.1



FIG.1

1.2 General Information

The conical rounder is made of a main steel frame a rotating cone and adjustable tracks around it. Dough pieces perfectly rounded while moving from bottom to top. Flour duster does not produce any noise while running. The weight range of processed dough is from 100 gram to 1200 gram.

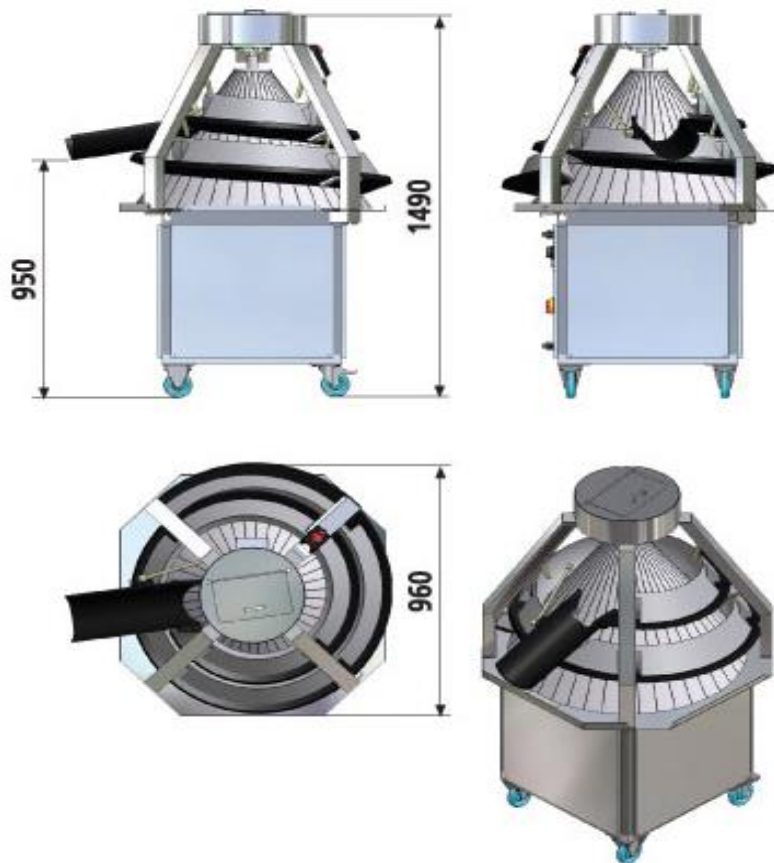
1.3 Use and Restrictions

The machine has been designed and built to round the wheat dough pieces. Other products are considered improper and not to be used with this machine.

Restriction: This machine must be exclusively used by operators over **18 years of age** and professionally qualified.

Restriction: There are no particular use restrictions, apart from the dough hardness, requiring at least **50%** of water on flour weight.

1.4 Technical Data



MODEL	Standard rounding track	Weight	Weight Ranges	Motor power	External dimensions
	Meters	Kg	gr	Kw	A x B x H
TBRMP100	3	205	100 – 1200	0.55 kw 220 / 380 VAC	950 x 960 x 1490

2. SAFETY DEVICES

During the design and construction of this machine the manufacturer has adopted the criteria and devices needed to satisfy the essential safety requirements imposed by the Machinery Safety Directive 89/392/EEC and subsequent amendments, by the Low Voltage Directive 73/23/EEC and subsequent amendments and by the Electromagnetic Compatibility Directive 89/336/EEC and subsequent amendments. The careful analysis of risks carried out by the manufacturer has eliminated most of the risks (predicted or reasonably predictable) linked to the machine operation conditions.

The manufacturer strongly recommends careful observation of the instructions; procedures and recommendations contained herein as well as strict observation of the current safety regulations regarding the work environment. This also applies to the use of both the correct personal safety equipment and machine protection devices.

DANGER: Do not wear loose clothing, ties, chains, or watches that could get caught in the moving parts of the machine.

NOTE: GGM will not be liable for any damage or injury to persons, animals or things caused by non-observance of the safety rules and/or recommendations given in the documentation supplied.

2.1 Mechanical Devices

The flour duster in which there is a moving arm protected by means of a stainless steel lid on top and a safety switch. In the case of opening lid machine will stop working. To start again it is necessary to press the START button.

DANGER: Don't touch inside the tracks while the machine running.

All the transmission elements are closed inside the structure of the conical rounder, and can be reached only removing the safety devices with particular spanners or screw drivers.

2.2 Electrical Devices

All of the electrical components subject to rated power are placed inside a case with protection of IP 54 the Conical Rounder should be earthed against direct contact risks, although the leakage current precaution realized on the machine. The power and control circuit is equipped with its own protection devices against short circuit and overloading.

2.3 Sound Level

The conical rounder noise, either empty or fully loaded is strictly maintained within the admissible limits foreseen by the current CE regulations.

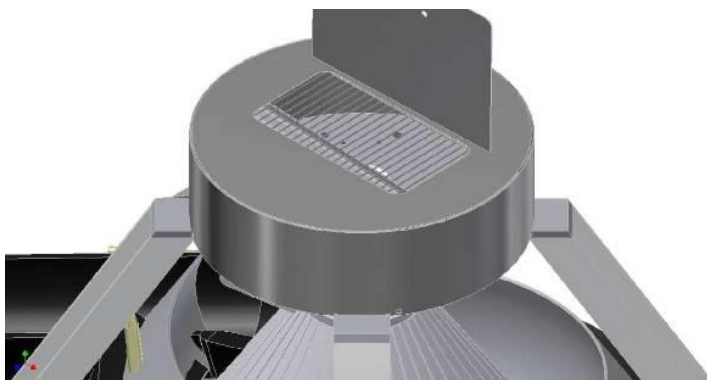
2.4 Safety Warnings

DANGER: The most dangerous mechanical group of the machine is flour duster and rotating cone.

- Do not touch this group of the machine unless you obey the above mentioned rules.
- Do not cancel any security elements on the machine.
- Never put your hands in to the flour duster and cone tracks

ATTENTION: Don't touch to the moving parts while machine running and never cancel lid safety switch by pressing your hand. Switch

ATTENTION: Never touch to the cone tracks while machine running.



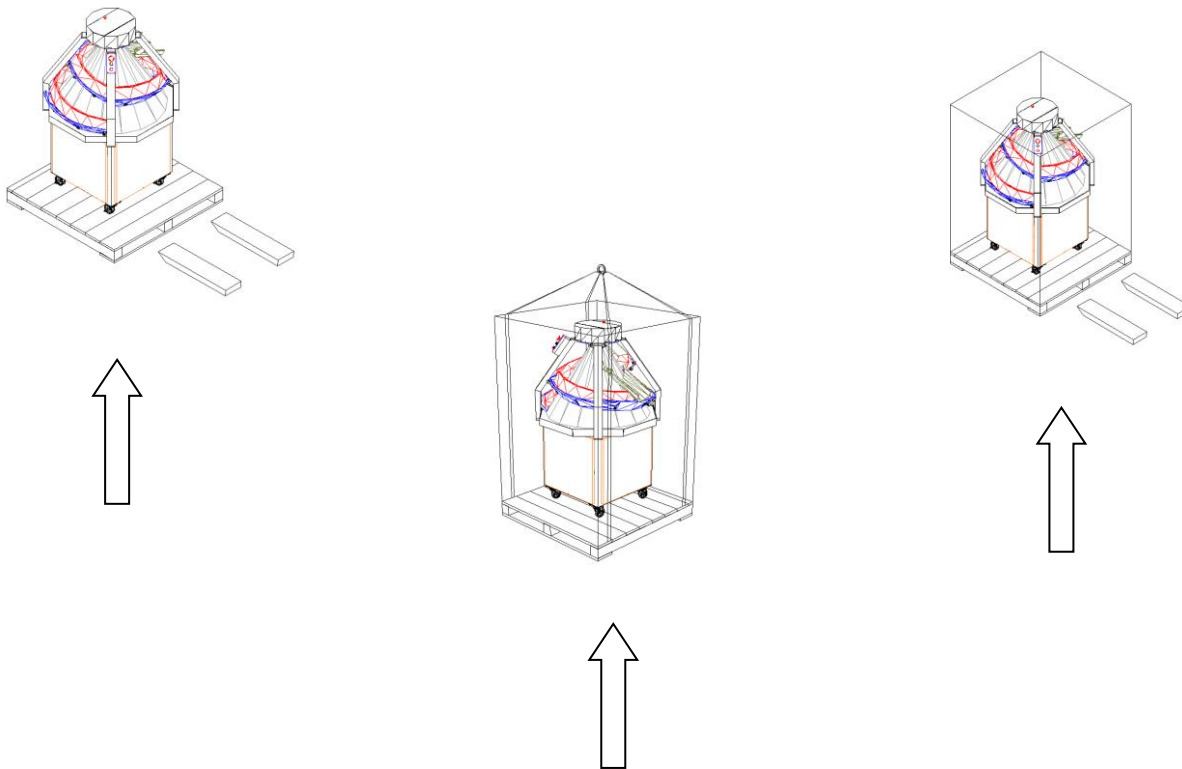
There is a flour duster grid under the cover, in order not to reach flouring unit by hands. Panemor will not be liable harms because of putting out this grid.

3. TRANSPORTS AND LIFTING

3.1 Instructions

The net weight of rounding machine is 205 kg. The conical rounder is delivered with a nylon and craft paper packing it can be lifted as shown in Figure-2 or by means of ropes as shown in Figure-3.

On request the conical rounder can be packed with a box pallet refer to Figure-4.

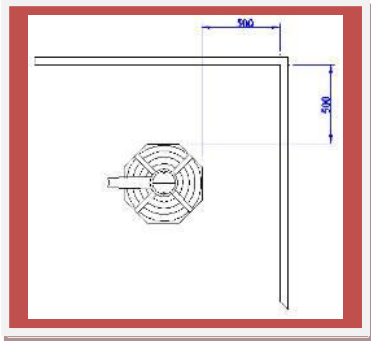


3.2 Installation

Place the Conical Rounder 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.5 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. After placing the machine in site, fix it with the fixing pedal on the wheels

and fixing feet. The Conical Rounder is self-standing and does not require floor anchorage.



3.3 Electrical Link

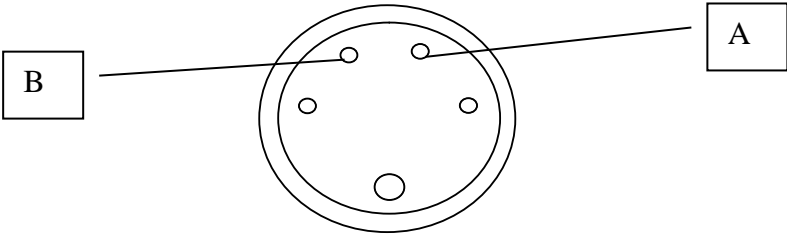
Power supply should be 3x380 VAC –220 VAC 50 Hz .The energy connections must be done in a proper phase sequence. In the case of wrong rotation change the two phases A –B see FIG 6.

The machine is equipped with a unique electrical link with cable situated on the back side of the Conical Rounder.

Check that the plate tension corresponds to the mains voltage, that the plate power is the same of interior to that of the mains.

The link must be done through the connection with a manual tension sectioning device, in order to allow the separation, when necessary, between the machines electrical equipment and the feeder mains (When cleaning)

This device must be able to transmit the plate rated current; the linking cables of the principal mains and of the external protection (earthing) must be of the proportional section to the rated current.



4. MACHINE USAGE

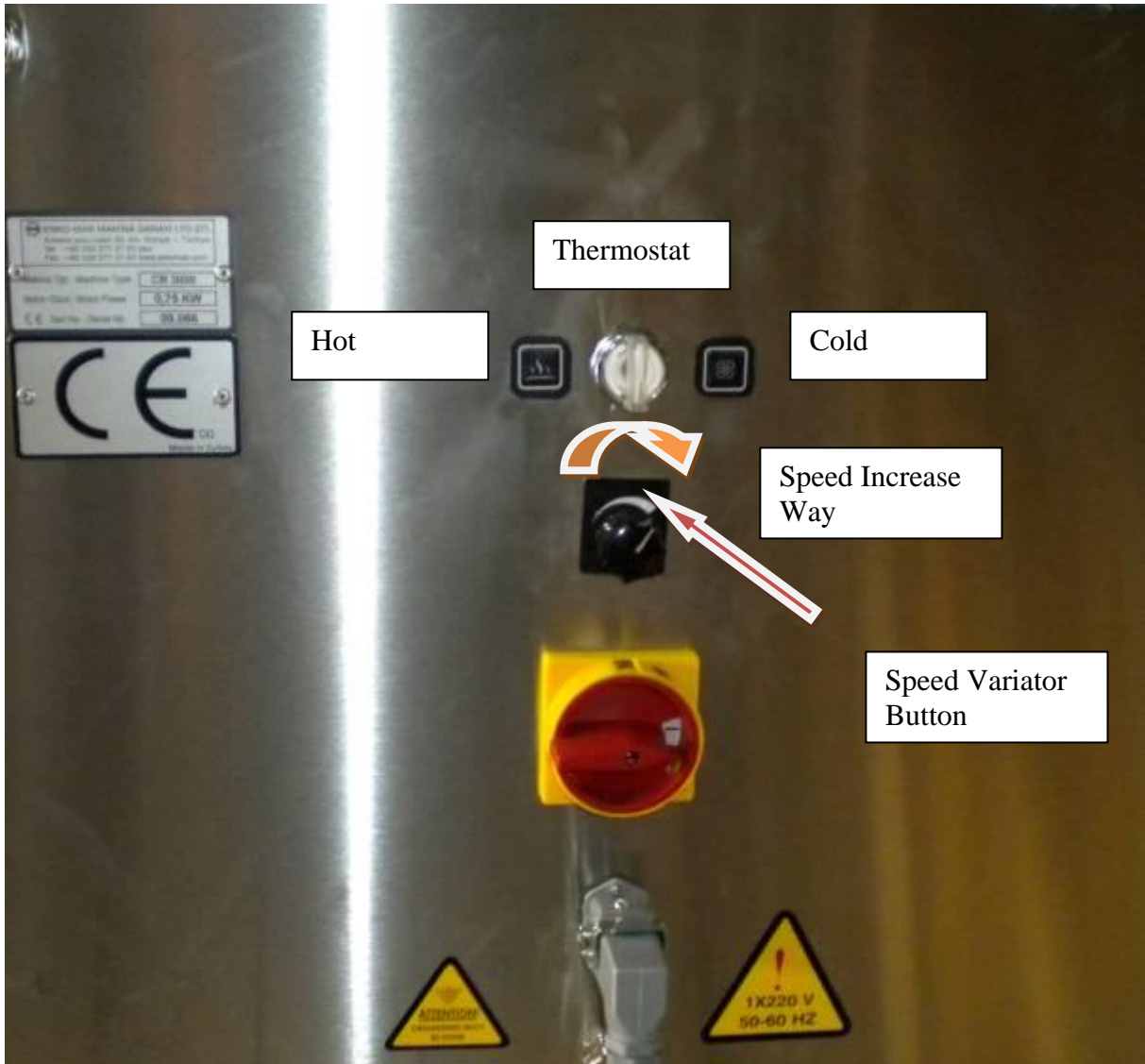


4.1 Functions of Switches

1- Emergency Button	1	RED
2- Start Button	3	GREEN
3- Hot / Cold Air Button	2	WHITE

4.2 Speed Variator

By means of speed variator, it is possible to adjust rounding speed and this allows to fix speed with other machines operating speed.



4.3 Setting Up

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

DANGER: Make sure that the value of your mains electricity supply complies with the power specifications of the machine. Make sure the machine is adequately earthed before making any other connection to the mains power supply.

4.4 Out Of Service

In the case of out service empty the flour from flour duster. Keep closed the flour duster lid and leave the machine rounding channels as cleaned from flour and dough. Also keep clean waste flour tank.

5. MAINTENANCE AND CLEANING

5.1 General Information

Due to the construction characteristics, the machine does not need many maintenance operations.

DANGER: Any check or maintenance operation should be carried out only when the appliance is unplugged from the mains supply; when finished control that the protections that had been disassembled are replaced and fixed in their original position.

Maintenance to be carried out on the machine is divided into:

Ordinary maintenance, to be done periodically respecting the specified expirations;

Extraordinary maintenance, when pieces of the machine must be substituted.

5.2 Ordinary Maintenance

Every day: Check all of the safety systems are active before start daily use. All dough touching surfaces should be cleaned every day.

Don't use steel scrapers and poisonous chemicals or soap for cleaning purposes.

Every week: Outer sides can be cleaned by a wet cloth.

DANGER: Cleaning operations should only be carried out with the machine switched off and disconnected from the electric power supplies.

BEWARE:

Don't use jets of water to clean the control panels and the electric control box.

Don't use solvents, which could damage the paint and synthetic materials.

Avoid especially petrol derivate materials such as nitro-per chlorate, thinners and tri-chloromethane.

Every two months: Motors, electrical components and steel structural work parts should be controlled.

5.3 Extraordinary Maintenance

Specialized and trained personnel must carry out extraordinary maintenance, who know how to operate and set-up the machine and who have carefully read the instructions given in this manual.

6. TROUBLE SHOOTING AND ADJUSTMENT

This chapter deals with some of the most common problems that can arise during the machine operation.

NOTE: Please contact the after sales service for any other problems not mentioned in the following list or in the event of malfunctioning which still persists of the suggested action has been taken.

PROBLEM	POSSIBLE CAUSE	SOLUTION
When the start button is pressed, the machine does not start.	-Flour lid is open -Emergency button has pressed. -Thermal relay has intervened to protect the system.	- Close the flour lid - Place the emergency button by turning left side. - Reset the thermal relay and find out why it has intervened.
When the start button is pressed the fault current has.	Check the grounding	Do the grounding

7. SPARE PARTS

7.1 How to Order

Please order spare parts on the basis of the following items.

-Model and serial number of the machine.

-Motor voltage and speed.

-Name of spare part.

-Specify the kind of transport required.

-Explain the delivery address.

7.2 Spare Parts Table

Please contact our After Sales Department for an up to date spare parts list.