



# INSTRUCTION MANUAL



# FLOOR MODEL PASTRY SHEETER MODEL: 650F

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# 1. General Information:

## 1.1 Documentation supplied

- Instruction manual
- Spare parts list
- Wiring diagrams

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## 1.2 Contact Details

International Bakery Equipment Pty Ltd (I.B.E.)

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## 1.3 Use of this Manual

Please read carefully the information supplied in this manual before installing, operating or carrying out maintenance on this machine.

This manual must be kept in good condition and stored where it can be easily found when required.

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## 1.4 Intellectual Property Rights

This manual contains copyright information. All rights are reserved. No part of this manual can be reproduced or photocopied without prior written permission of International Bakery Equipment Pty Ltd. Permission to use this documentation has only been given to the customer who this manual has been supplied as part of the machine's equipment and only for the purpose of installation, operation and maintenance of the machine to which the manual refers.

International Bakery Equipment Pty Ltd declares that the information contained herein is in accordance with the technical and safety specifications of the machine to which the manual refers. International Bakery Equipment Pty Ltd will not be held responsible for direct or indirect damage or injury to people or objects resulting from the misuse of this documentation or the machine for which it has been intended.

The manufacturer reserves the right to introduce technical modifications or improvements both to the documentation and to the machines without prior notice. The information contained herein refers in particular to the machine specified in section 1.7 "Machine identification details".

## 1.5 Warranty Terms and Conditions

- Warranty becomes effective from date of delivery.
- Warranty claims may be made by telephone, letter, email or fax. However all verbal claims must be confirmed in writing. I.B.E. Pty Ltd Reserves the right to require return of all claimed defective parts.
- I.B.E. Pty Ltd will ship the part(s) in an expeditious manner as requested.
- Mechanical and Electrical parts are warranted for a period of 12 months from date of delivery.
- During the first 12 months, I.B.E. Pty Ltd will reimburse the Authorized Agent or Purchaser for the cost of reasonable labour during normal working hours, 8.00a.m. – 5.00p.m., to remove the failed part(s) and install the replacement(s). After 12 months all charges will be the Purchasers responsibility.
- After the initial 12 months warranty, any replacement parts are warranted for 3 months excluding labour.
- This Warranty may not be changed or modified and is not subject to any other Warranty expressed or implied by any other Agent, Dealer or Distributor unless approved in writing by I.B.E. Pty Ltd in advance of any claim being filed. This Warranty gives you specific legal rights which vary from State to State.

**Note:**

I.B.E. Pty Ltd reserves the right to make the final decision on all Warranty coverage questions. The decision of the Company is final.

### What is covered under this Warranty:

- Parts that fail due to defects in material workmanship.
- Parts that fail due to faulty assembly by I.B.E. Pty Ltd
- Parts that fail due to improper set-up by I.B.E. Pty Ltd

### What is not covered under this Warranty:

- Parts that fail due to improper usage or overloading of the machine.
- Parts that fail due to lack of maintenance.
- Parts that fail due to abuse, misuse or modification.
- Mixer attachments - Bowl, whisk, beater and/or hook.
- Normal wear parts, such as, Conveyor belts, 'v' belts, 'o' rings and scraper and slicer blades. The Warranty on these parts is, they will be in satisfactory operating condition at time of delivery and initial start-up. Claims in such parts must be made immediately.
- Loss of time, potential revenue and/or profits.
- Personal injury or property damage resulting from the operation of the machine.

## 1.6 Specifications

### Crate Dimensions:

Length (cm)	Width (cm)	Height (cm)	Weight (Kg)
77.5	109	195	210

### Machine Specifications

Model	Motor H.P.	Dimensions			Weight Kg (Net)
		L cm	W cm	H cm	
650F	1	240	99	113	160

### Power Supply Details:

3 Phase, 10amp 4-pin plug top (supplied)

#### Note:

The Manufacturer will not be Liable for electrical defects, breakdowns or malfunctioning of the machine for the non compliance with the power supply stated.

## 1.7 Machine Identification Details

Type: Floor Model Dough Sheeter

Model: 650F

Position of Serial Number Identification Plate (Fig 1.1)



Serial number  
Identification  
plate

Fig 1.1

**Note:**

When requesting spare parts please state the serial number found on the serial number identification plate.

## 1.8 Main Machine Components

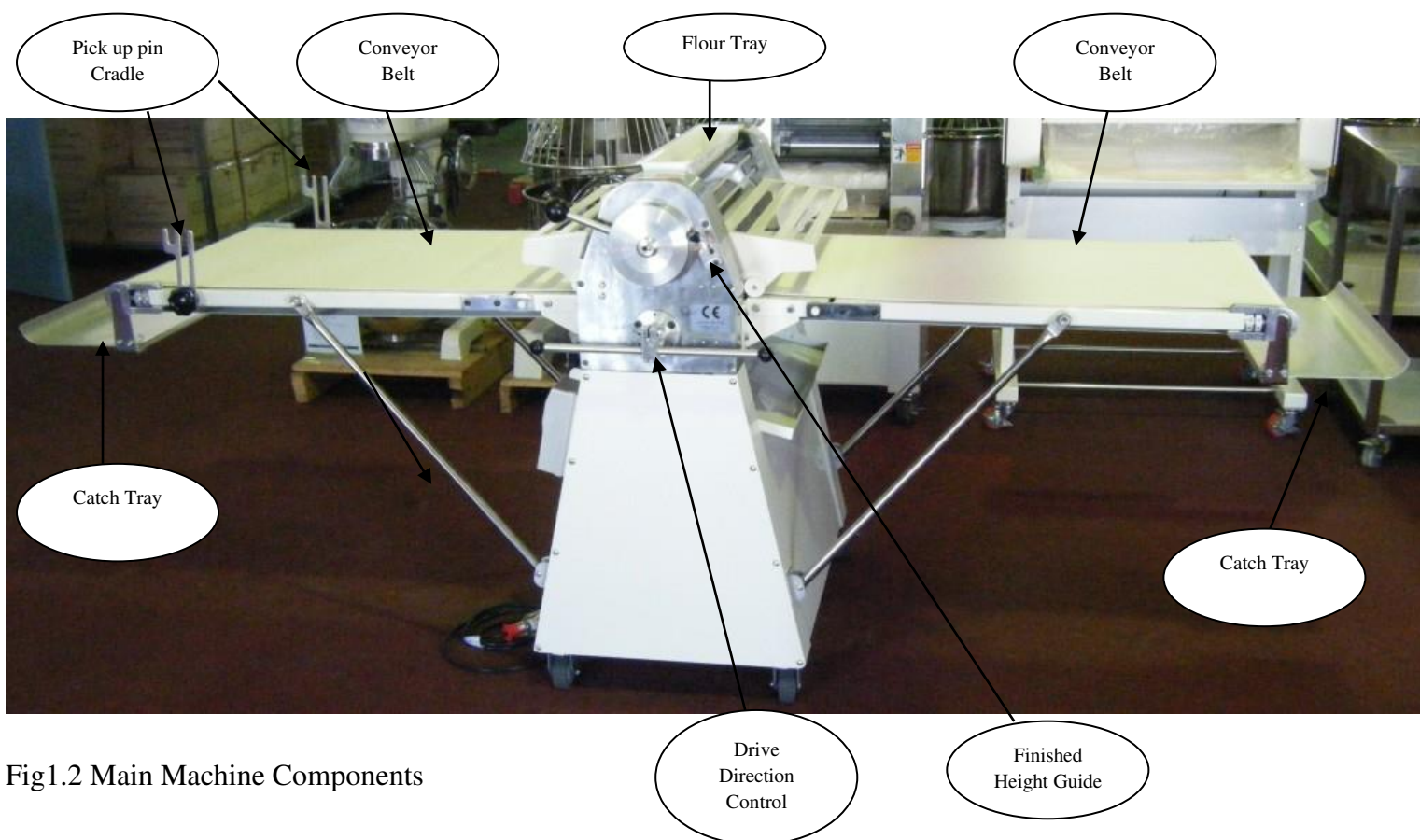


Fig1.2 Main Machine Components





## 1.9 Safeguards

This machine has been fitted with safeguards to ensure safe operation of this machine, in accordance please ensure the following;

- Do not place foreign objects on or under the belts.
- Ensure training in the safe operation of this machine is carried out with all operators.
- Do not wear loose clothing, ties, chains, or watches that could get caught into the moving parts of the machine.
- Ensure safeguards are in operable order before using the machine on a daily basis.
- Tampering with the safety devices creates hazards for the machine operator, for which International Bakery Equipment Pty Ltd or its agents will not be liable.

**Note:**

In the event that one or more of the safe guards do not operate or fail contact your supplier immediately. **DO NOT OPERATE THE MACHINE.**

Tampering with or modifying the machine will void warranty.

### **Limit switched safety guards.**

The guards over the rollers are fitted with limit switches, when raised the machine will stop immediately, when lowered the green start button must be pressed for the machine to operate again. (Fig 1.7)



Fig1.7 Safety guard in the raised position

## 2. Transport and Installation:

### 2.1 Transport

The instructions given in this section must be carefully followed when transporting the machine. This operation may include but is not limited to the following:

- Storage of the machine
- Installation of the machine
- The machine comes supplied in a secure packing crate which needs to be handled with care to protect the machine.
- When being transported the machine crate should be secure to the transporting vehicle using approved tie down straps to avoid the machine tipping over.
- The machine should not be placed on top of other items during transport.
- When lifting the machine ensure all persons are at a safe distance.
- The forklift operator is to hold the appropriate qualifications.
- Do not climb on or place body under machine crate when it is being lifted from the ground or transport vehicle.
- When lifting the machine crate ensure forks are spread to the maximum width of the crate and the crate is against the cradle of the forklift (Fig2.1).



Fig 2.1

## 2.2 Installation

- Ensure transport crate and all protective packaging is removed.
  - Carefully clean the machine using a damp clean cloth, removing dust on all surfaces.
  - When the machine has been unpacked, check the condition of the machine. Any visible damage indicates that the machine has been dropped or hit by something during transport. This could lead to malfunctioning. If damage has occurred during transport it should be attributed to the carrier and International Bakery Equipment Pty Ltd or its agent should be informed immediately of the situation.
  - Locate the sheeter in a convenient position on a flat level surface, where the operation of the machine is safe and accessible.
  - Lower the sheeter arms down ensuring the belts are central to the nib guards.
  - Before making the electrical connections check the specifications found in section 1.6 of this manual and ensure they match those of your electrical service.
  - Make certain the electrical supply is correct and the correct breaker is in place to ensure protection from a short circuit.
  - Ensure the three phase connection of the sheeter is correct. When the operation handle is pushed in either direction the belts should run in the direction required.
  - A qualified person should correct electrical connection if required.
  - Train all operators in the safe operation of this machine.
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## 2.3 Testing the safeguards

Before starting the machine, the safety devices should be checked according to the following procedure:

- Correct operation of the safety guard limit switch (Fig 1.6, page.9);  
While the machine is operating, lift the safety guard, the machine should stop immediately. Repeat process with other safety guard.
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## **3. Machine Operation:**

### **3.1 Intended Operation**

This machine has been designed and manufactured for the safe sheeting of dough's (i.e puff pastry, Danish and croissant dough's) with the use of a reversible motor to drive the pressure rollers and sheeter conveyor belts utilising a synchronized two speed in/out feed prevents the stretching and tearing of the dough. The thickness guide assists in giving a uniformed and even thickness product on a day to day basis.

The roller gap is controlled by the setting handle on the front of the machine and when the machine this setting will not change thus giving a continued even thickness. (Fig 1.2, page 8)

This machine has been designed and built to operate indoors.

## 3.2 Control Components

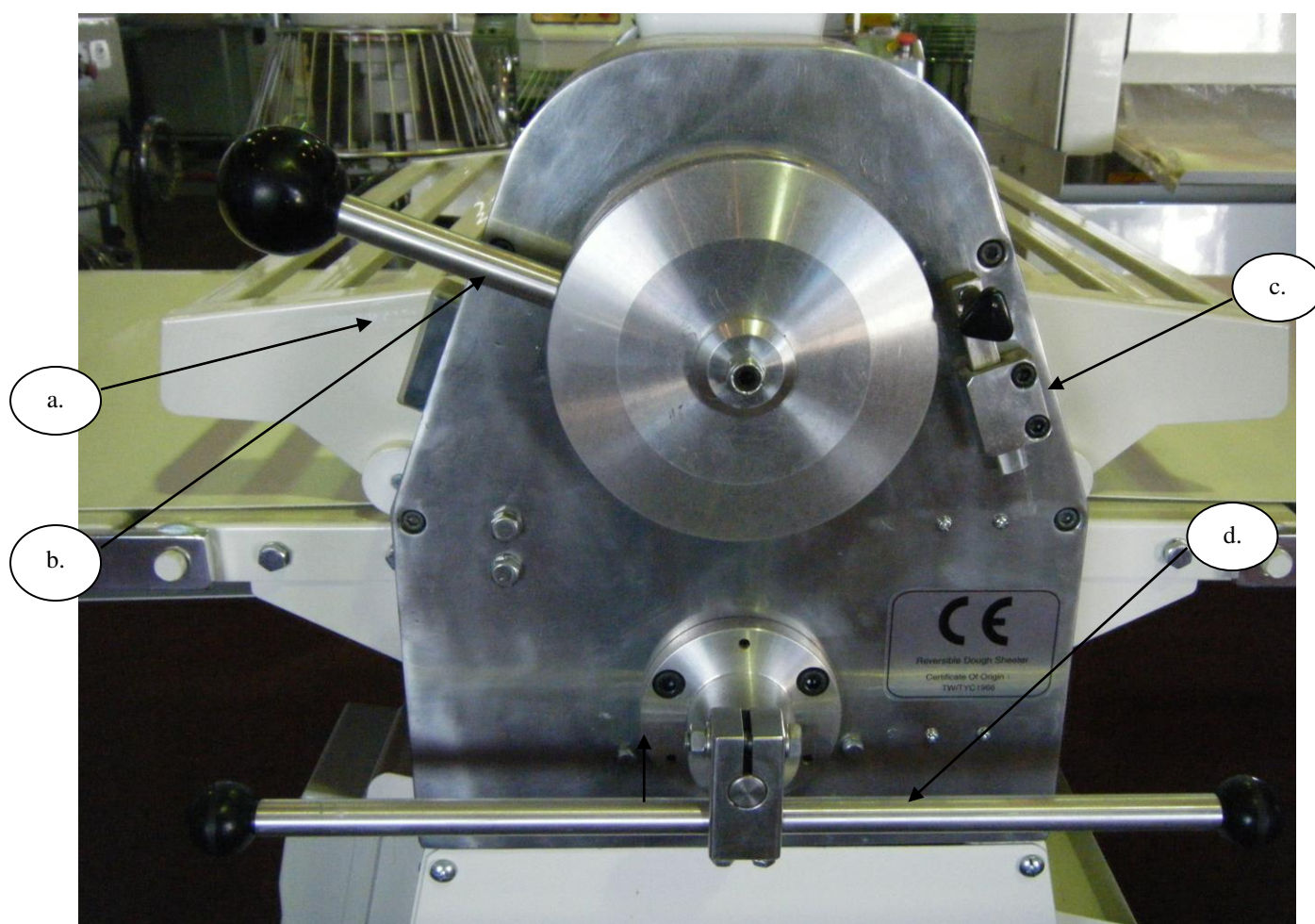


Fig 3.1 650F Control Components

Location	Description	Operation Performed
a	On / Off Switch	When the green switch is pressed the power is turned on. When the red switch is pressed the power is turned off.
b	Setting Handle	Sets the gap between the rollers as determined by the operator.
c	Thickness guide	Can be set to achieve consistent final product thickness.
d	Directional Handle	Controls the direction of the conveyor belts Down right, belts move to the right. Down left, belts move to the left.

### 3.3 Sheeter Operation

- Please note: **Maximum weight is 8kg (room temperature only)**
- Place dough product to be sheeted on the conveyor belt and lightly dust with flour.
- Adjust the roller gap between the upper and lower rollers using the setting handle, (b) to the desired thickness according to the starting thickness of the dough piece to be sheeted.
- Turn the power on using the green power switch (a).
- Using the directional handle (d), lower in the direction that the dough piece is required to move.
- When the pastry is through the rollers and approx 10mm -, stop the machine and adjust the roller gap in small increments, maximum 3mm, using the directional handle (d), lower in the opposite direction for the dough piece to move through the rollers.
- Repeat above steps until the dough piece reaches the desired thickness, occasionally dust the dough piece with flour during the sheeting process.
- The last pass should be from the right to left using the safety guard to stop the machine, (this will ensure that the desired thickness is maintained), when the dough sheet is between the pick up cradle (Fig1.2) Place the pick up pin in the cradle and wrap the dough over the pick up pin.
- Start the machine again and the dough sheet will roll on to the pick up pin, when the dough sheet is completely on the pin stop the machine and remove for further application of the dough sheet.

**Note:**

DO NOT use knives, cutters or any sharp tools on the belts of the machine as this will damage them,

## 4. Cleaning & Maintenance:

### 4.1 Cleaning

- Always turn power off at the wall and unplug machine prior to any cleaning or maintenance procedures to be carried out.
- Keeping the machine cleaned helps to maintain the efficient hassle free operation of the machine.
- This machine should be cleaned at the end of every day, to prevent a build up of dough crumb and flour dust.
- Remove excess flour dust with a soft brush.
- Roller scrapers should be released to remove flour build up from rollers
- Wipe over the entire machine with a damp cloth with a neutral detergent, (Harsh chemicals will damage the machine).
- The arms of the machine can then be folded for compact storage.



Fig.3.2 Sheeter arms folded.

#### Note:

Do not use water jets or hoses to clean this machine as excess water can damage the machine, and the safe operation of the electrical components.

### 4.2 Maintenance



It is recommended that this machine should be serviced once every 12 months by a qualified technician to maintain hassle free operation.

If in the event the machine does not operate correctly it is recommended that you contact your supplier to ensure a qualified technician services the machine for you.

It is not advisable to attempt any repairs without prior knowledge of the mechanical or electrical systems used in the manufacture of this machine, use only qualified technicians.

**Note:**

Any attempt to modify this machine in any way will result in the warranty being voided.

Tampering with the mechanical or electrical systems in this machine will void warranty.

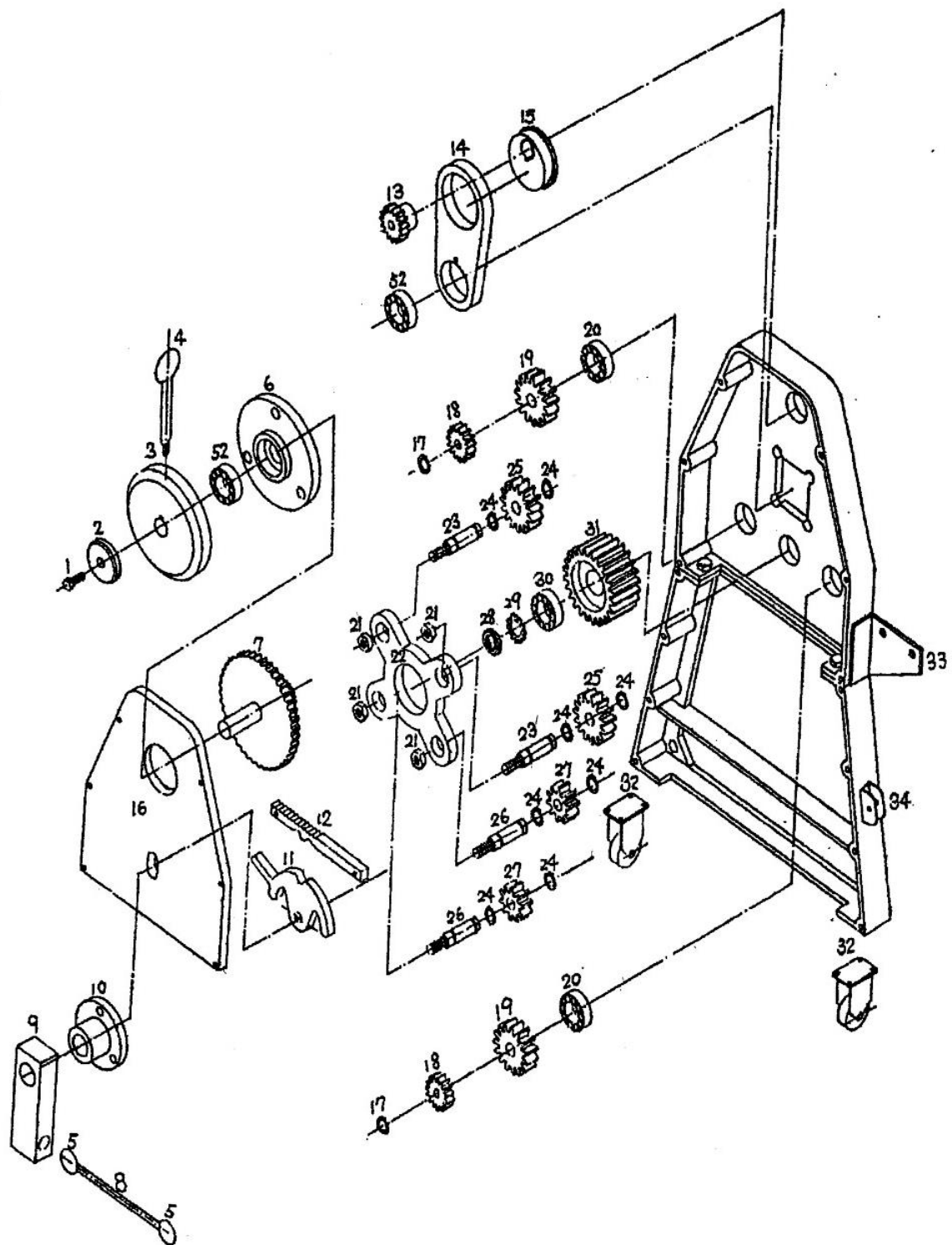
## 4.3 Spare Parts List

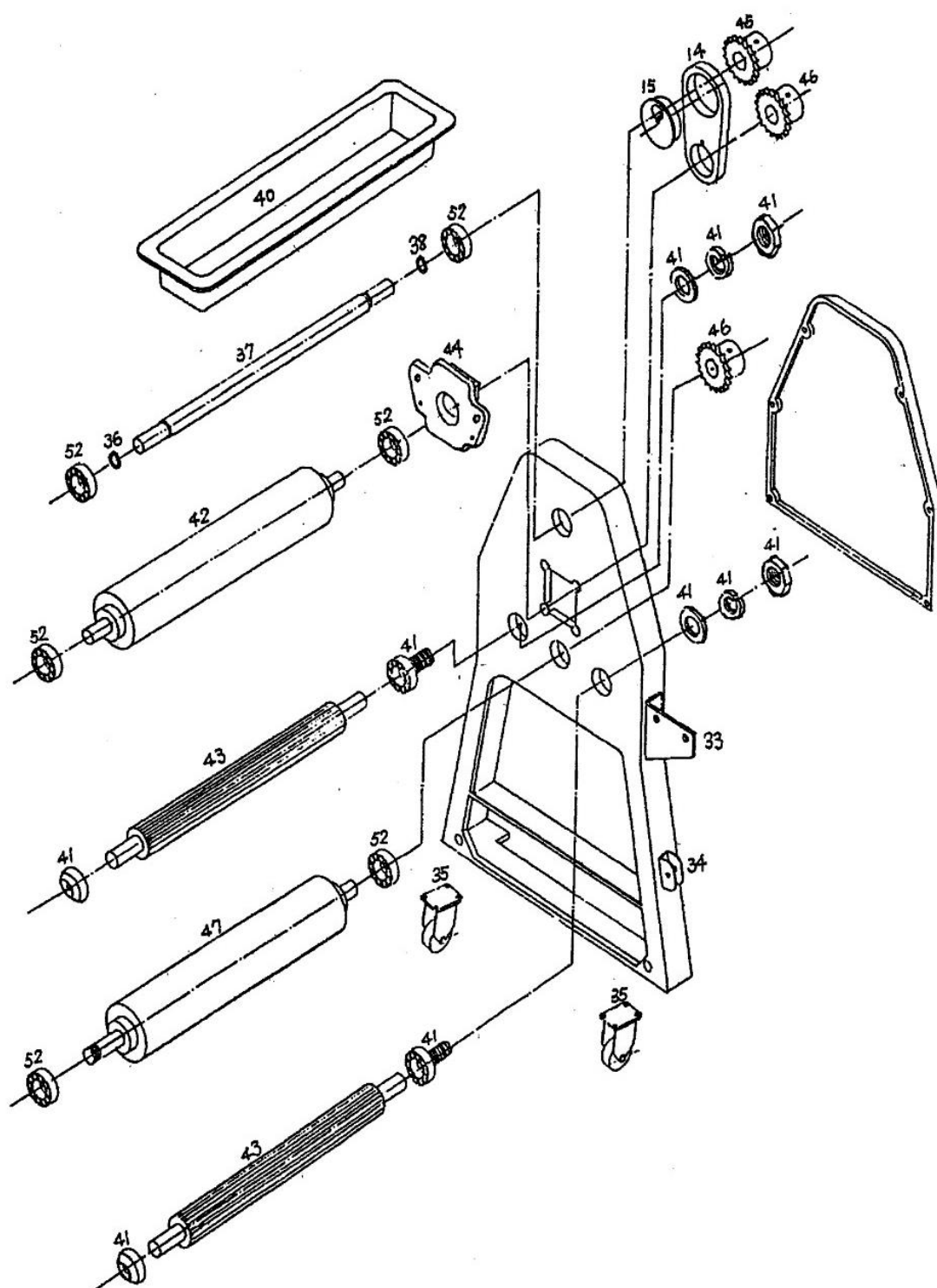


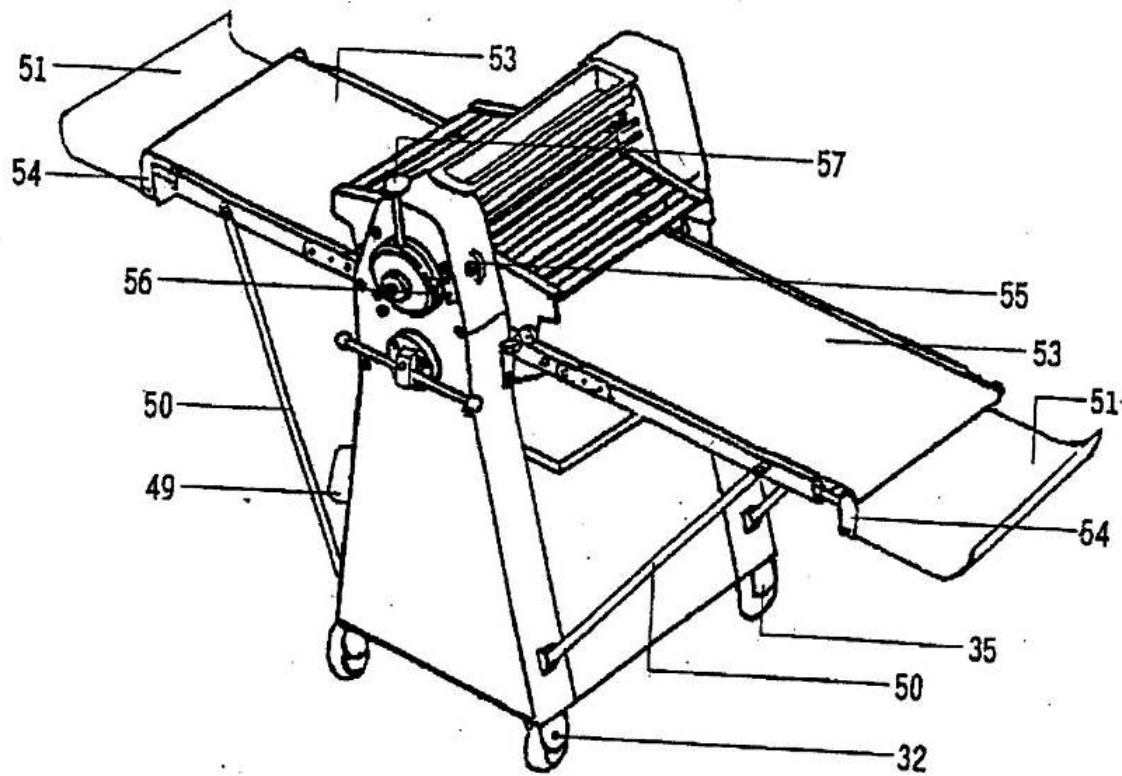
<b>No.</b>	<b>Description</b>
<b>1</b>	Hexagon screw
<b>2</b>	Washer
<b>3</b>	Aluminium stand
<b>4</b>	Roller adjusting Handle
<b>5</b>	Plastic knob
<b>6</b>	Gear fixing stand
<b>7</b>	Gear
<b>8</b>	Reversible handle
<b>9</b>	Reversible handle stand
<b>10</b>	Fixing stand
<b>11</b>	Cam
<b>12</b>	Rack gear
<b>13</b>	Gear
<b>14</b>	Cam stand
<b>15</b>	Cam
<b>16</b>	Aluminium cover
<b>17</b>	Stop spring
<b>18</b>	Gear
<b>19</b>	Gear
<b>20</b>	Bearing
<b>21</b>	Nut
<b>22</b>	Gear stand
<b>23</b>	Shaft
<b>24</b>	Stop spring
<b>25</b>	Gear
<b>26</b>	Shaft
<b>27</b>	Gear
<b>28</b>	Nut
<b>29</b>	Stop washer

<b>No.</b>	<b>Description</b>
<b>30</b>	Bearing
<b>31</b>	Gear
<b>32</b>	Wheel
<b>33</b>	Conveyor plate holder
<b>34</b>	Supporting pole stand
<b>35</b>	Wheel
<b>36</b>	Stop spring
<b>37</b>	Rolling gap adjusting shaft
<b>38</b>	Top scraper
<b>39</b>	Bottom scraper
<b>40</b>	Flour tray
<b>41</b>	Bearing
<b>42</b>	Top roller
<b>43</b>	Transmission shaft
<b>44</b>	Con stand
<b>45</b>	21T gear for chain
<b>46</b>	18T gear for chain
<b>47</b>	Bottom roller
<b>48</b>	Motor
<b>49</b>	Magnetic contactor
<b>50</b>	Supporting pole
<b>51</b>	Catch pan
<b>52</b>	Conveyor belt
<b>53</b>	Conveyor belt
<b>54</b>	Passive roller
<b>55</b>	On / Off switch
<b>56</b>	Final fixing stand
<b>57</b>	Roller setting handle

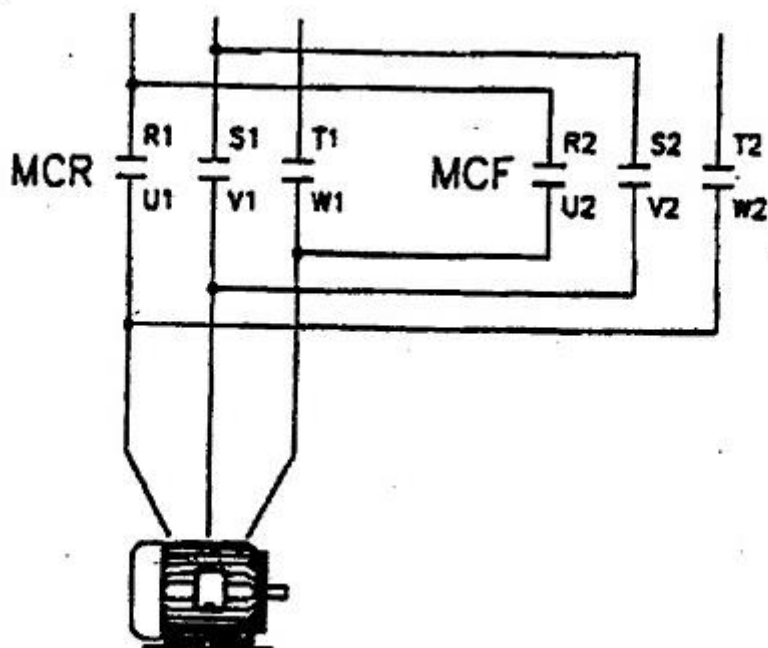
#### 4.4 Exploded Parts Drawing

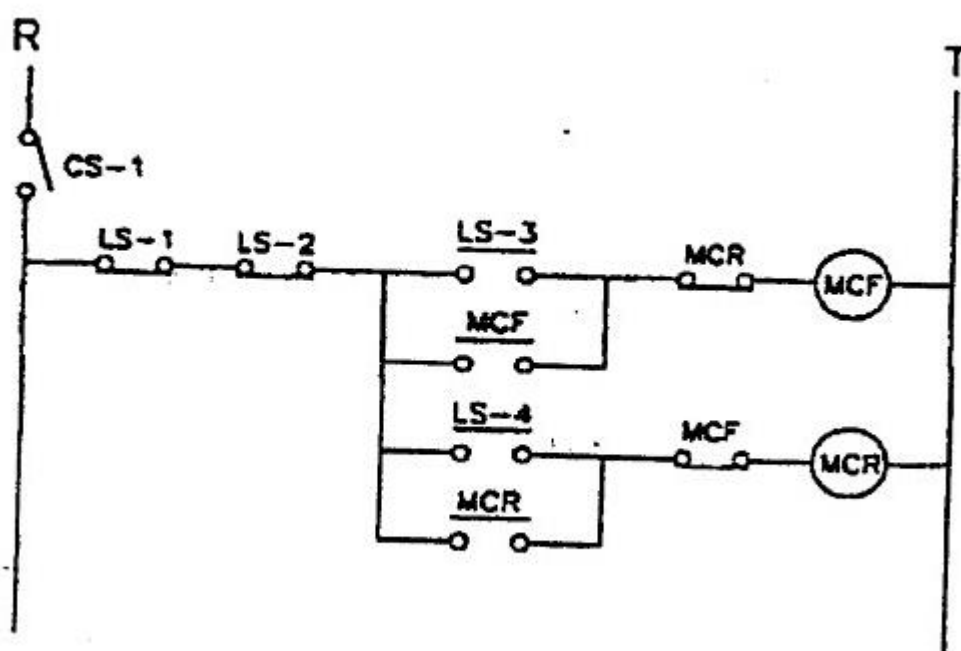






## 4.5 Electrical Wiring Diagrams





No.	Description
<b>CS-1</b>	On / Off Switch
<b>LS-1</b>	Micro Switch for safety guard
<b>LS-2</b>	Micro Switch for safety guard
<b>LS-3</b>	Micro Switch for left turning
<b>LS-4</b>	Micro Switch for right turning
<b>MCR</b>	Magnetic contactor for left
<b>MCF</b>	Magnetic contactor for right