



International Bakery Equipment Pty. Ltd.

INSTRUCTION MANUAL



FRENCH STICK MOULDER

MODEL: FSM750

Contents

1. General Information:

- 1- Documentation supplied
 - 2- Contact details
 - 3- Use of this manual
 - 4- Intellectual property rights
 - 5- Warranty terms and conditions
 - 6- Machine specifications
 - 7- Machine identification details
 - 8- Main components of the machine
 - 9- Safeguards
-

2. Transport and Installation:

- 1- Transport
 - 2- Installation
 - 3- Testing & Safeguards
-

3. Machine Operation:

- 1- Intended operation
 - 2- Control components
 - 3- Sheeter operation
-

4. Cleaning & Maintenance:

- 1- Cleaning
- 2- Maintenance
- 3- Spare parts list

- 4- Exploded parts drawings
- 5- Electrical diagrams

1. General Information:

1.1 Documentation supplied

- Instruction manual
- Spare parts list
- Wiring diagrams

1.2 Contact Details

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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.

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)
126.5	89	105	250

Machine Specifications

Model	Motor H.P.	Dimensions			Weight Kg (Net)
		L cm	W cm	H cm	
FSM750	1	970	820	1570	210

Power Supply Details:

Three 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: French Stick Moulder

Model: FSM750

Position of Serial Number Identification Plate (Fig 1.1)



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

In-feed roller
gap Control

Forming belt



Moulding
Pressure
control



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.

Emergency Stop Button.

The machine is equipped with a red emergency stop button located on the left panel of the machine and allows the operator to stop the machine in case of emergency see Fig 1.2

Limit switched in-feed chute.

The in-feed chute of the machine is fitted with a limit switch, when the in-feed chute is pressed down the machine will stop immediately; the green start button must be pressed for the machine to operate again. (Fig 1.3)



Fig1.3 In-feed chute in operating 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.

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 moulder on a flat surface in a convenient position of the production area where the operation of the machine is safe and accessible and lock the castors.
 - 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.
 - A qualified person should correct electrical connection if required.
 - Train all operators in the safe operation of this machine.
-

2.3 Testing the safeguards

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

- Correct operation of the in-feed chute limit switch (Fig 1.3, page.9);
While the machine is operating press down on the front of the in-feed chute, the machine should stop immediately.
- Correct operation of the emergency stop button (Fig 1.2, page.8);
While the machine is operating, press the emergency stop button, the machine should stop immediately.

3. Machine Operation:

3.1 Intended Operation

This machine has been designed and manufactured for the final moulding of dough pieces for bread baguettes', French sticks, long rolls etc with the use of two rollers to express the air from the dough piece, pressure belts to form the dough into a cylinder and moulding belts to give the desired length of the final product and to seal the seam.

This machine has been designed and built to operate indoors.

3.2 Control Components



Fig 3.1 FSM-750 Control Components

Location	Description	Operation Performed
a	On Switch	When the green switch is pressed the power is turned on.
b	Emergency stop Button	When pressed it stops the machine completely.
c	In-feed gap Control wheel	Adjusts the space between the in-feed rollers depending on the size of the dough piece, this should be adjusted with the machine running.
d	Moulding pressure Control wheel	Adjusts the space between the moulding belts depending on the final length of the dough piece desired, this should be adjusted with the machine running.

3.3 French Stick Moulder Operation

These operating procedures are to be used as a guide, as every bakeries dough consistency is different.

These steps should be used to set up the FSM750 to your specific product and by keeping records of the settings it will assist in the day to day operation of this machine, be aware though you may still need to fine tune the settings that you record as your dough can change i.e. longer than normal bench rest, or a slacker dough.

- Set the in-feed gap control knob (c) to suit the dough piece.
- If the dough piece tears the rollers are to close, open rollers further until dough piece does not tear.
- If the dough piece is too loose and the finished baked product has air holes in it the rollers need to be brought in closer.
- Dough piece should be firm once through the rollers.
- The pressure belt which lies on the top of the top moulding belt assists in forming the dough into the final shape prior to the dough piece dropping and going between the moulding belts.
- Bottom dial opens and closes the gap between the moulding belts.
- These belts determine the final length of the product and helps seal the seam of the product.
- If your product is too long open the gap wider.
- If your product is too short the gap should be brought in closer.

4. Cleaning & Maintenance:

4.1 Cleaning

- Always turn power off at the wall and unplug machine prior to cleaning or maintenance.
- This machine should be cleaned at the end of every day, to prevent a build up of dough crumb and flour dust.
- Fold down upper cover.
- Clean any hard dough crumb from pressing rollers with a plastic scraper flour dust can be removed with a brush
- Wipe over with a damp cloth (not dripping wet)
- While cover is off the machine it can be dusted off with a brush and wiped over with a damp cloth.
- Body of the machine can be dusted off and wiped over with a damp cloth.
- Replace upper cover.
- While cleaning the machine check for any wear on belts.
- If the machine starts operating strangely (different sound, belt slipping) during normal operation please contact a qualified technician as soon as possible

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.

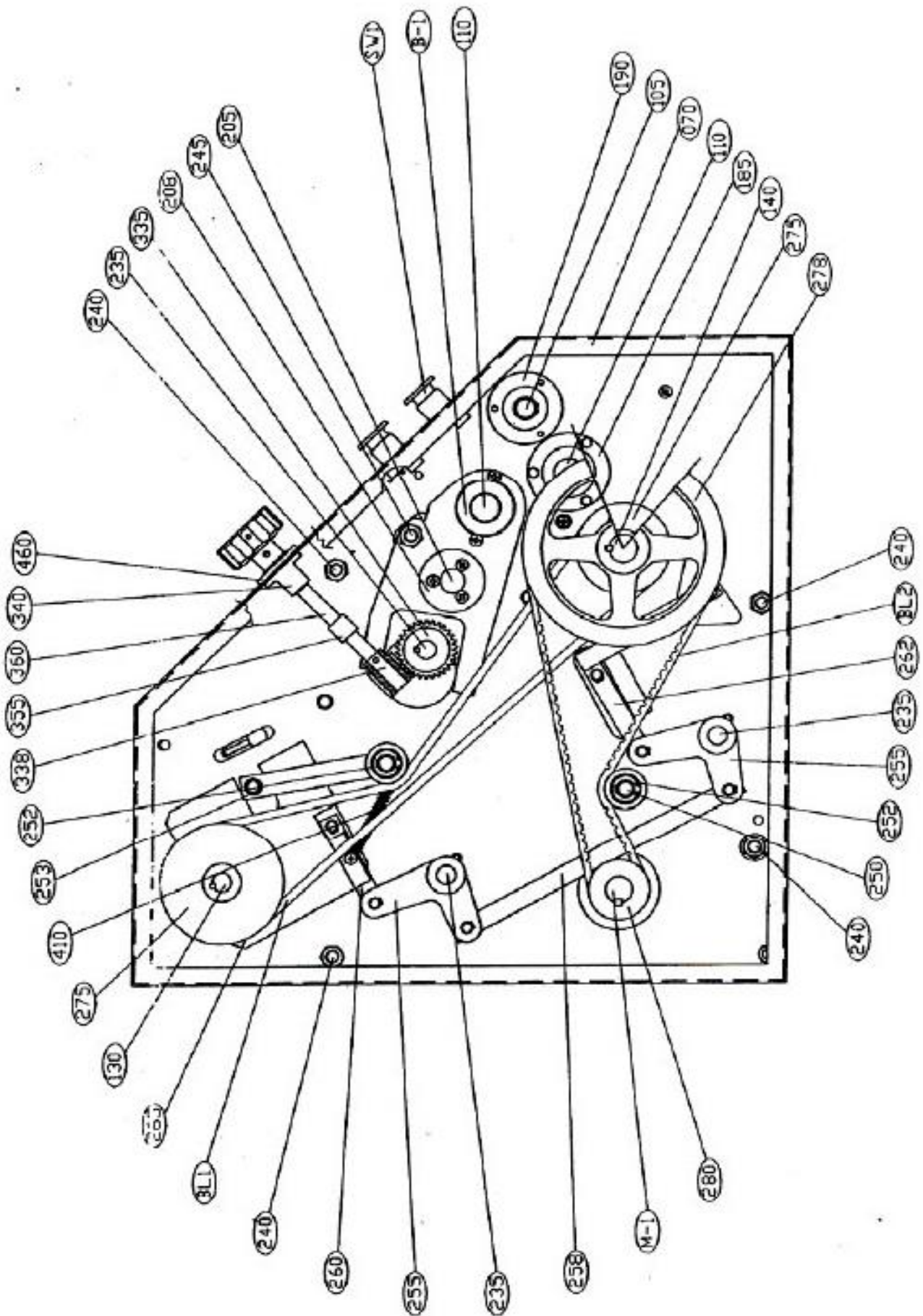
Tampering with the mechanical or electrical systems in this machine will void warranty.

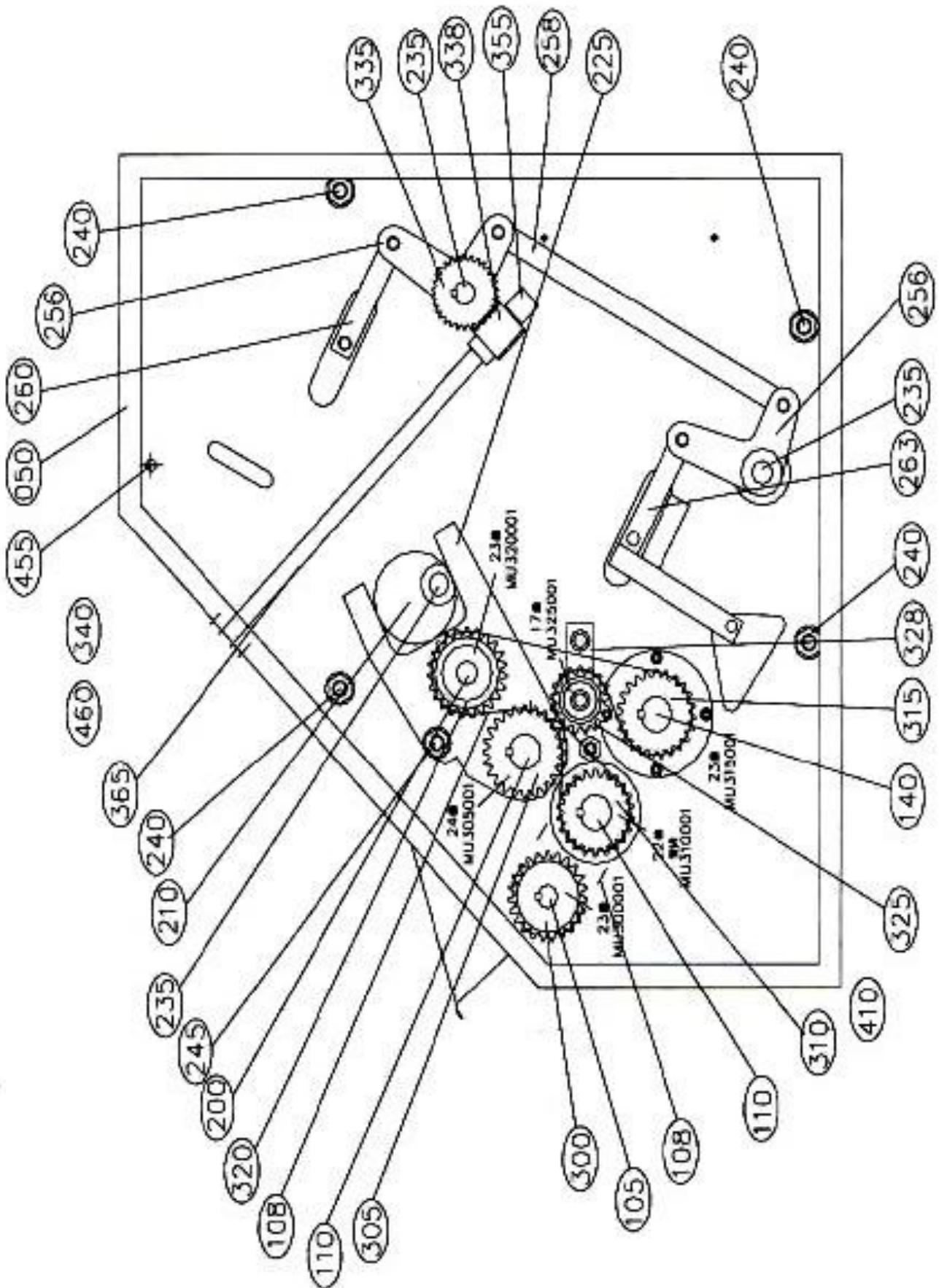
4.3 Spare Parts List

No.	Description
050	Right machine wall
07	Left machine wall
105	Roller
110	Roller
130	Roller
140	Roller
185	Bearing Fixing Plate
190	Bearing housing
200	Bearing housing
205	Fixing holder of adjusting rack
208	Cover for fixing holder of adjusting rack
210	Eccentric wheel
225	Adjusting rack for moulding plate
235	Rotary adjusting shaft
240	Fixing shaft of machine body
245	Fixing shaft of machine body
250	Idle wheel holder
252	Idle wheel
253	Idle wheel rack
255	Link rack
256	Link rack
258	Link
260	Link
262	Link

No.	Description
263	Link
265	Cover of adjusting plate
278	Belt pulley
280	Belt pulley of motor
300	Sprocket
305	Sprocket
310	Sprocket
315	Sprocket
320	Sprocket
325	Sprocket
335	Worm gear
338	Worm
340	Fixing holder of adjusting rod
355	Fixing holder of rotary shaft
360	Rotary shaft
365	Rotary shaft
410	Extension spring
455	Round rod
460	Washer for adjusting knob
BL1	Belt
BL2	Belt
M-1	Motor
B-1	Bearing
SW1	Switch

4.4 Exploded Parts Drawing





4.5 Electrical Wiring Diagrams

