



**LIAN HUAT MACHINERY SDN. BHD.** (362589A)  
Specialist in Bakery Equipment



**LONG MOULDER**

**Office & Factory**

P.S.39, Lot 1921, Jalan Batu Putih, 56, Kampung Peserai Kecil, MK 3, Simpang Lima, 83020 Batu Pahat, Johor, Malaysia  
Tel: 607-4138300, 4138303, 4130833 (Hunting Line) Fax: 607-4137600 URL: <http://lianhuat.com>  
Email: [lh\\_lmhk@streamyx.com](mailto:lh_lmhk@streamyx.com)

**K.L. Branch**

No. 17-G, 17-C, Jalan Pandan Indah, 3/3B, Pandan Indah, 55100, Kuala Lumpur, Malaysia  
Tel: 603-42967106, 42967107, 42970812 Fax: 603-42967108

**Penang Branch**

No. 15, Lorong Impian Ria 4, Taman Impian Ria Alma, 14000 Bukit Mertajam, Seberang Prai, Penang, Malaysia  
Tel: 604-5872007, 5872008 Fax: 604-5872009

---

## PREMISE

Lian Huat invites you to read carefully this manual and follow it thoroughly.

We do 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.

## WARRANTY

Lian Huat guarantees that the machine has been tested and that the guaranteed warranty is of 12 (twelve) month, 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 delivery, check immediately if the machine has damage during the transport and, in such case inform the forwarder at your earliest convenience; check that the eventual required optional are complete and if this is not the case inform writing within and beyond 3 days.

BEFORE USING THIS MACHINE,  
READ CAREFULLY THIS PRESENT  
INSTRUCTION MANUAL



# TABLE OF CONTENT

1	CONDITION.....	1
1.1	SAFETY PRECEPTS.....	1
1.2	DEFINITIONS.....	2
2	OPERATION CONTROL.....	3
2.1	TECHNICAL SPECIFICATION.....	3
2.2	FEATURE.....	3
2.3	GENERAL.....	4
2.3.1	BREAD MOULDING.....	5
2.3.2	DOUGH SHEETING.....	5
2.4	CONTROL.....	6
3	MAINTENANCE AND CLEANING.....	7
3.1	BREAKDOWN MEASURES.....	7
3.2	EXTENDED DOWNTIME MEASURES.....	7
3.3	MAINTENANCE.....	8
4	SAFETY.....	9
4.1	ELECTRICAL DEVICE.....	9
4.2	SOUND LEVEL.....	9
4.3	SAFETY WARNING.....	9
5	ELECTRICAL DRAWING.....	11

# 1 CONDITION

- ✓ Read carefully all the safety precautions.
- ✓ Before starting, familiarize yourself with the operation of the equipment.
- ✓ Successful and safe use of this machine depends on the correct: installation, commissioning, operation and maintenance.
- ✓ This machine works on 415V (3 phases + N + E) alternating voltage and contains parts with electrical connection.
- ✓ Only personnel with appropriate qualifications should work with this equipment.
- ✓ Installation and preparing of this equipment should only be executed by persons with the right qualifications.
- ✓ This persons must be acquainted with all the warnings and operating procedures described in this manual.

## 1.1 SAFETY PRECEPTS

- ✓ Make sure that the location selected for the equipment is safe, protected from moisture and splash and drip-proof.
- ✓ Children and the general public must be prevented from accessing or approaching the equipment.
- ✓ This equipment may only be used for the purpose specified by the manufacturer.
- ✓ Unauthorized modifications and the use of spare parts or accessories that are not sold or recommended by the manufacturer of the equipment are not permitted.
- ✓ Keep this manual within easy reach and give it to all users.

## 1.2 DEFINITIONS

### **\*\*\*\*\*QUALIFIED PERSONS\*\*\*\*\***

For the purpose of this manual:

A qualified person is someone who is familiar with the installation, construction, operation and maintenance of the equipment and with hazards involved.

In addition, the person must be trained and authorized.

### **\*\*\*\*\*DANGER\*\*\*\*\***

For the purpose of this manual:

Danger indicates that loss of life, severe personal injury or substantial property damage will result if proper precautions are not taken.

### **\*\*\*\*\*WARNING\*\*\*\*\***

For the purpose of this manual:

Warning indicates that loss of life, severe personal injury or substantial property damage can result if proper precautions are not taken.

### **\*\*\*\*\*CAUTION\*\*\*\*\***

For the purpose of this manual:

Caution indicates that minor personnel or property damage can result if proper precautions are not taken.

### **\*\*\*\*\*NOTE\*\*\*\*\***

For the purpose of this manual:

Notes merely call attention to information that is especially significant in understanding and operating the machine.

## 2 OPERATION CONTROL

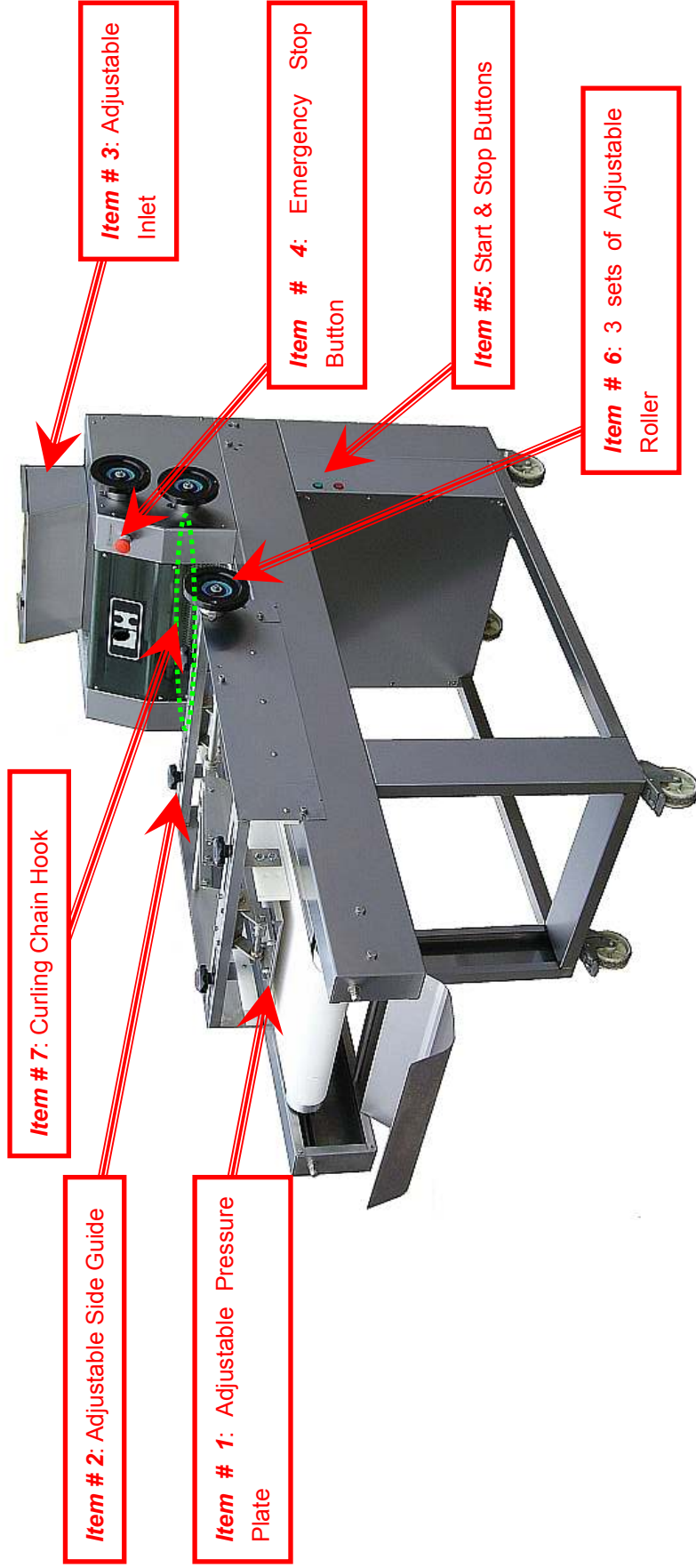
### 2.1 TECHNICAL SPECIFICATION

Electric Power	: 415 Vac Three Phase; 50 Hz
Current Ampere	: 7A
Motor	: 1 HP
Dimension (W x L x H)	: Approx. 714 x 2057 x 1080 mm
Weight	: Approx. 280 kg
Product Weight	: 200 – 1200 grams

### 2.2 FEATURE

- ✓ Two set of adjustable rollers
- ✓ Stainless steel curling chain
- ✓ Adjustable pressure plate
- ✓ Adjustable side guiding
- ✓ Adjustable inlet
- ✓ Wheels OR Handles for easy moment

## 2.3 GENERAL



### **2.3.1 BREAD MOULDING**

Remove excess flour dust from conveyor belt when changing from various pressure plate sizes. Space is provided for storing pressure plates under the conveyor table when certain sizes not used.

The bread moulding attachment will fit the machine and production table models. Position the bread moulding attachment slots to the conveyor table studs. Slide the bread moulding attachment away from the sheeting head. Place the appropriate curling chain onto front scraper hook → light for buns and rolls and heavy for larger bread products.

You are ready to begin bread moulding!

To mould bread, place the dough pieces on the item #3 “Adjustable Inlet”, using the side guides for positioning. It may be necessary to flatten the dough slightly to allow for smooth flow into the sheeting rollers. The dough will be sheeted through the sheeting rollers and will exit onto conveyor belt. The sheeted dough pieces will be “curled” as it travels under the curling chain and the pressure plate will “mould” the product as it passes under the bread moulder attachment.

Due to the difference in nature of various dough, it may be necessary to do some experimenting with the position of the pressure plate relative to the conveyor belt. The correct setting is determined when the sheeted dough piece is moulded to the exact width of the pressure plate. When correct setting is determined, it should be noted so that product can have that same starting point.

### **2.3.2 DOUGH SHEETING**

There are two independent sets of sheeting rollers on Machine. Regardless of the product being sheeted, the machine rollers should be set progressively.

The Machine may require several passes be completed. Before each pass, the roller setting should be reduced until desired thickness is achieved.



The machine requires the first set of rollers be set with slightly wider gap than the second set. In most cases, the top set of rollers should not be set more than one half points larger than the lower set of rollers. In this manner, the dough piece is sheeted down in two gentle stages.

To obtain uniformity of the finished product, it is important that uniform pieces are prepared for feeding to the machine. The dough should be taken from the bowl in approximately 10 pound pieces, put on a bench and shaped into rectangle. With the least amount of handling, the pieces should be shaped uniformly in length, width, and thickness, and should fit 2/3 of the width and full length of a standard baking sheet. Keep pieces as free from wrinkles as possible (let it have 20-30 minutes intermediate proof before feeding the machine).

## 2.4 CONTROL

This machine is operated by a set of simple designed buttons, which are:

- ✓ Emergency Stop Button, *Item #4*.
  - This button is used to stop the machine immediately if any danger happen.
- ✓ Start Button, *Item #5*.
  - This button is use to start the machine.
- ✓ Stop Button, *Item #5*.
  - This button is use to stop the operation.

## 3 MAINTENANCE AND CLEANING

This machine need to be cleaned regularly in order to maintain the cleanliness and hygienic level. Therefore it is advised to clean the machine at the end of each production.

The following must carry out before any cleaning take place:

- ☑ Running the equipment so that the press rollers and conveyor is moving.
- ☑ Blow out the dough leavings at the press rollers and conveyor by using an air gun.
- ☑ Cut off the power when finish the air blower cleaning process and before cleaning the press rollers using damp cloth.

The outer steel surface of the equipment may be cleaned using a damp cloth, with common household cleansers if needed, then dried. We do not recommend using scratchy, abrasive or corrosive products, which could damage the surfaces. Additional care may be taken by using products specifically developed for cleaning steel. In this case, follow the label instructions for the product.

**\*\*\*\*\*DANGER\*\*\*\*\***

*Do not cleaning the press rollers without disconnect the electric power.*

### 3.1 BREAKDOWN MEASURES

Should a breakdown occur despite proper use of the equipment, shut off the equipment, close all connections and call an authorized technician from the customer service centre.

### 3.2 EXTENDED DOWNTIME MEASURES

Whenever the equipment is to remain unused for prolonged periods (seasonal closing, vacation, etc.), we recommend cleaning it according to the instructions above and drying it immediately. Disconnect all electrical devices!

### 3.3 MAINTENANCE

The following points should be maintained periodically.

- ✓ 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.

**\*\*\*\*\*WARNING\*\*\*\*\***

*Any cleaning or maintenance operation should be carried out only when the appliance is unplugged from the mains supply;*

## 4 SAFETY

This machine is equipped with several important safety features.

*Warning: Do not operate this machine without all of these safety features installed and operational.*

### 4.1 ELECTRICAL DEVICE

Electrical circuit diagram of long moulder machine can be examined as attached to this manual.

### 4.2 SOUND LEVEL

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

### 4.3 SAFETY WARNING



The most dangerous parts of the moulder machine are rollers.

*Warning: Never operate the machine unless you assemble the up cover on it.*



**\*\*\*\*\*WARNING\*\*\*\*\***

*Please be ware of the warning sign!! Do not put your hands into the moulder's inlet during operation or without cut off the power of equipment.*



**\*\*\*\*\*NOTE\*\*\*\*\***

*Please make sure that the blade are properly fixed before operate the equipment.  
Fail to do so may damage the conveyor.*

## 5 ELECTRICAL DRAWING

