



AUTOMATIC PISTON DOUGH CUTTER

OPERATION'S MANUAL



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GENERAL SAFETY INSTRUCTIONS

WARNING: To reduce the risk of injury, read all instructions properly.

Failure to follow the instructions listed below can cause electric shock, fire, serious injuries, mutilation and/or damage to the equipment.

A. SAFETY IN THE WORK AREA.

- * Keep the work area clean and lit. Crowded or dark areas lead to accidents.
- * Keep children, customers, and non-company personnel away from the electrical and mechanical operation area of the equipment.
- * It is recommended to have a minimum space of one meter or three feet around the machine for safety measure and to optimize work.

B. ELECTRICAL SAFETY.

- * Machinery connections must be adapted to the power outlets.
- * Do not use adapters for the switches: since you run the risk of receiving an electric shock.
- * Do not expose the switches and/or electrical connections to rain or humidity. If water enters these elements, there is a risk that they will break down or suffer an electric shock.
- * Use cable in a single piece, if there are joints in the connections these can produce a short circuit.
- * Do not expose cables or electrical connections to heat, oil, sharp edges, or moving parts, as damaged cables can cause electric shock or short circuit.

C. PERSONAL SAFETY.

- * Do not operate the equipment if you are tired, under the influence of alcohol or drugs.
- * Wear appropriate clothing, do not wear loose clothing, or necklaces, earrings, watches, if you have long hair wear a tie to keep it up.
- * Do not climb on the structure of the machine for any reason, falls or injuries may occur.
- * Avoid using headphones, cell phones or any other equipment that works as a distraction to the operator.
- * Make correct use of personal protective equipment if any maintenance is to be carried out on the machine.
- * If any change is made to the model or component of the equipment, be it electrical or mechanical related, it must be de-energized and stop the machine completely to avoid accidents.
- * Keep limbs away from all moving parts.

CAUTION

The following symbols indicate the safety measures that must be taken before and after starting up the equipment.



ELECTRICAL RISK In which you can suffer electric shocks, if you do not comply with the electrical safety provisions.



GEAR RISK Keep your hands away from the chains and gears of the machine.



CUTTING HAZARD Keep hands away from the cutting blade.



RISK OF ROTATING BLADES. Keep hands away from auger inside the hopper

ELECTRICAL INSTALLATION

Verify that the electrical connection is 220v. No short circuits, no loose or bare wires.
Ensure that all cables are isolated and without contact, and check contactors and switches are in good condition.
It is recommended to use a 12 gauge cable for the installation of the machine.



ELECTRICAL INSTALLATION	
A	220v electrical installation
B	12 gauge cable (conduit cable).

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COMPRESSED AIR INSTALLATION

Compressed Air Supply Requirements:

Minimum Air Pressure: 50 PSI

Maximum Air Pressure: 110 PSI

Air Connection: The installation must include a compressed air supply capable of maintaining a pressure between 50 and 110 PSI during equipment operation.

Connection Nozzle: Install the appropriate connection nozzle or pneumatic flow control valve for the equipment's pneumatic system. Ensure that the connection is properly sealed to prevent air leaks.

Installation Requirement: The compressed air supply must be clean, dry, and free of contaminants that could affect the operation of the pneumatic system.



A

If using an air supply connection with a hose, install a 1/4" male air hose coupler.



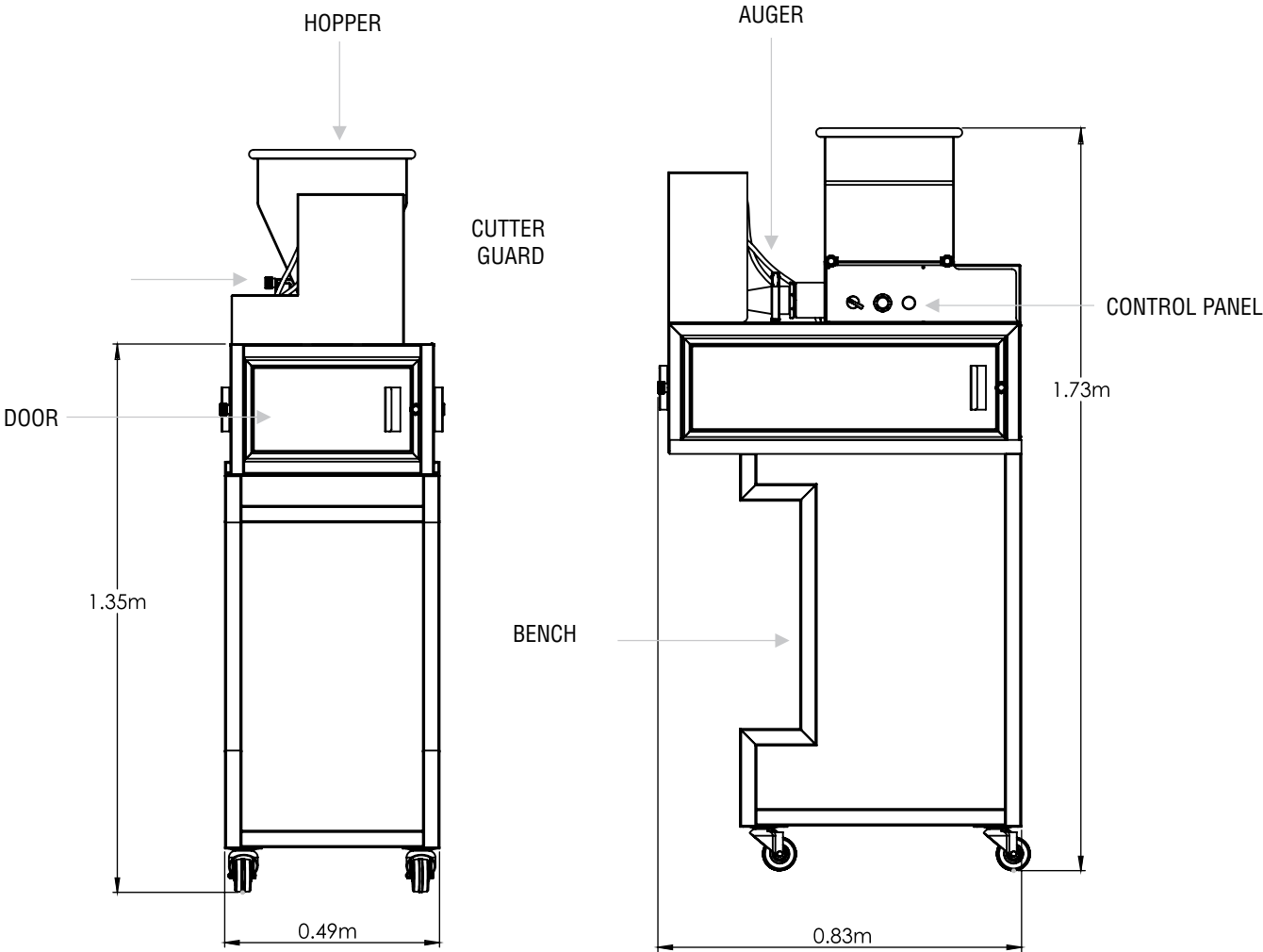
B

If connecting directly to a fixed compressed air piping system, install a pneumatic flow control valve.

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COMPONENTS



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- 1** Connect the Machine to the Electrical Outlet.



- 2** Keep the Compressed Air Supply Disconnected While Handling and Calibrating the Cutter.



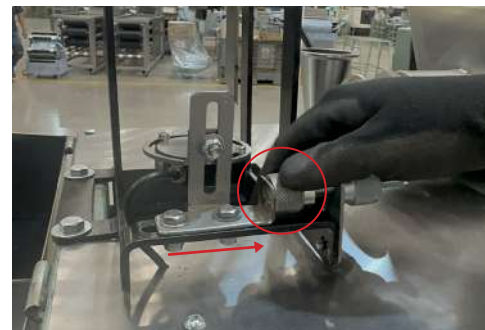
- 3** Install the Nozzle.



- 4** Adjust the Blade Against the Nozzle Stop.



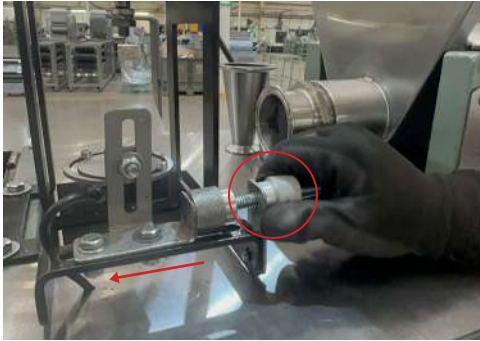
- 5** It features a laser that indicates where to make the cut. It must be adjusted to determine the dough ball position.



- 6** Turn the center knob to loosen the slide.

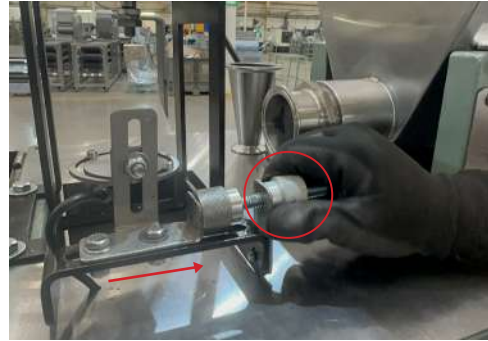
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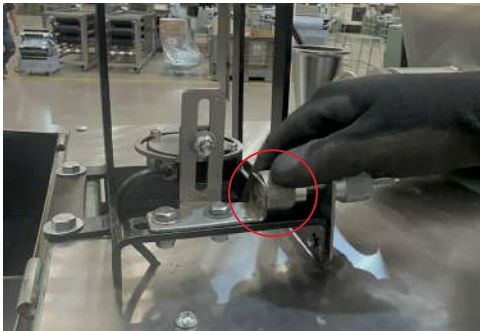
7

To increase the dough ball size, unscrew the knob toward the outer end, i.e., toward the edge.



8

To reduce the dough ball size, turn the knob toward the center.



9

Once the desired size has been set, tighten the center knob to secure the slide and prevent it from moving.



10

Connect the Compressed Air Supply.



11

Release the Emergency Stop.



12

Turn On the Motor Switch.

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- 13** The Equipment Operating Indicator Light will turn on, and the Cutter will begin operating.



- 14** Verify Counterclockwise Rotation of the Cutter Auger.



- 15** Place the Flour Dough in the Cutter Hopper.



- 16** The Blade will actuate and begin cutting the dough. Verify the dough ball size before starting production.

CLEANING PROCEDURE

WARNING: Cleaning must be done with the machine completely stopped to avoid accidents such as crushing.

1. Remove dough from the hopper of the cutter.
2. Loosen the clamp screw, and remove the gasket and nozzle.
3. Disassemble the hopper by removing the 4 knobs that hold it.
4. Rotate the cutter auger clockwise and remove it.
5. Clean the hopper, auger, and nozzle with a brush, water, and soap.
6. Dry the hopper, auger, and nozzle with a dry cloth.
7. Assemble the hopper holding it with the 4 knobs.
8. Place the auger in the cutter.
9. Place gasket and nozzle.

MAINTENANCE

Clean the machine before and after using it.

The duration of the spare parts will depend on the preventive maintenance and care taken to the machine.

The more frequently this maintenance is done, the parts will have a longer life.

LUBRICATION

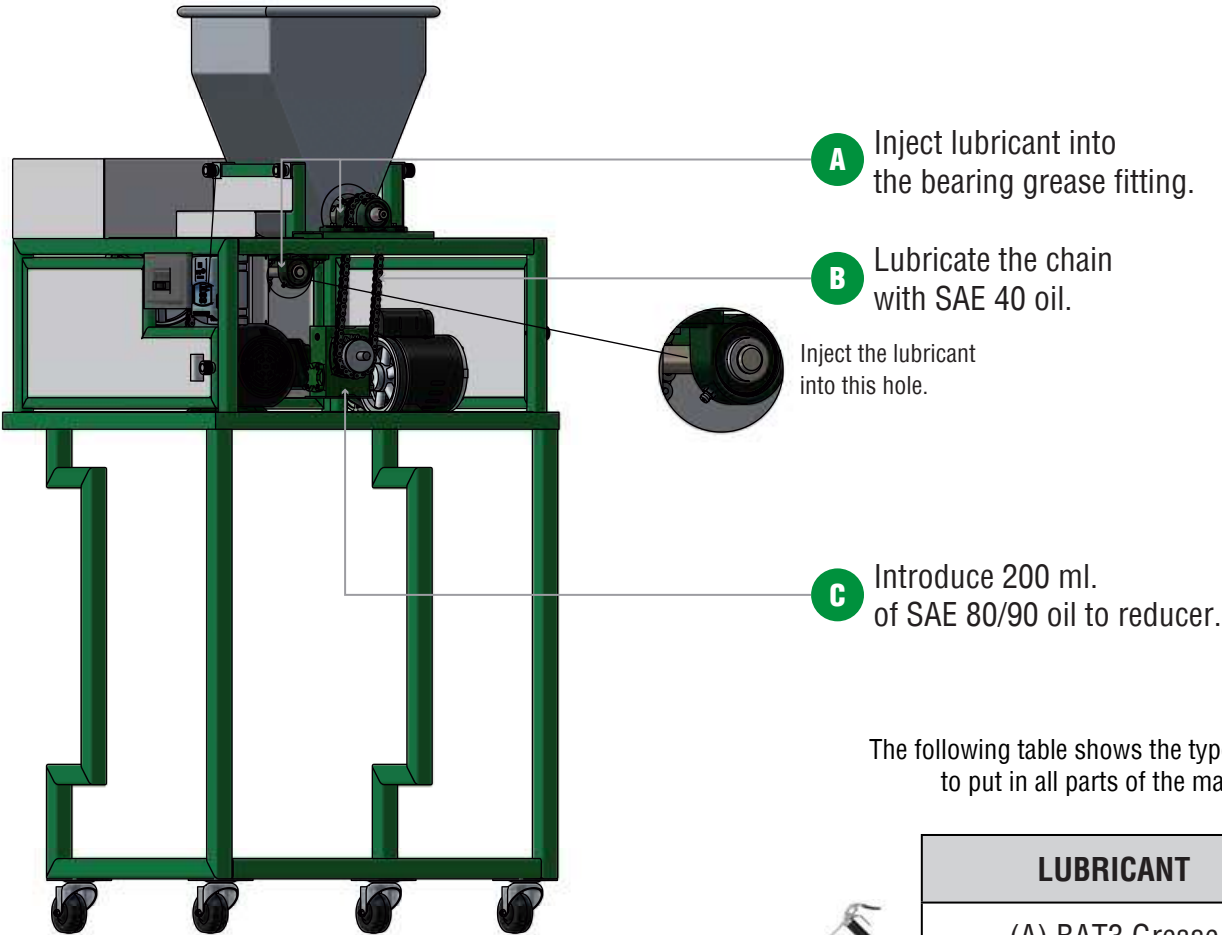
The following table shows the parts, the type of lubricant, and the frequency with which the machines and their parts must be lubricated.

PART	LUBRICANT	PERIOD
Bearing	BAT3 Grease	Every 3 days
Chain	SAE 40 Oil	Every 3 days
Reducer	SAE 80/90 mineral oil	Every 3 months

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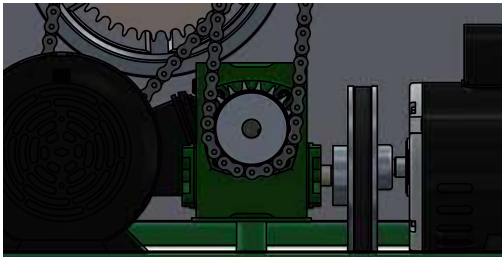
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The following figures show the schematic location of the parts that require lubrication.



The following table shows the type of lubricant to put in all parts of the machine.

	LUBRICANT
	(A) BAT3 Grease
	(B) SAE 40 Oil
	(C) SAE 80/90 mineral oil



It is recommended to change the oil every three months. The used oil must be drained and 200ml of new SAE 80/90 Oil must be poured.



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