DOUGH SHEETER
User Manual

Please read the manual carefully before using.
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Chapter1

1.1 INTRODUCTION

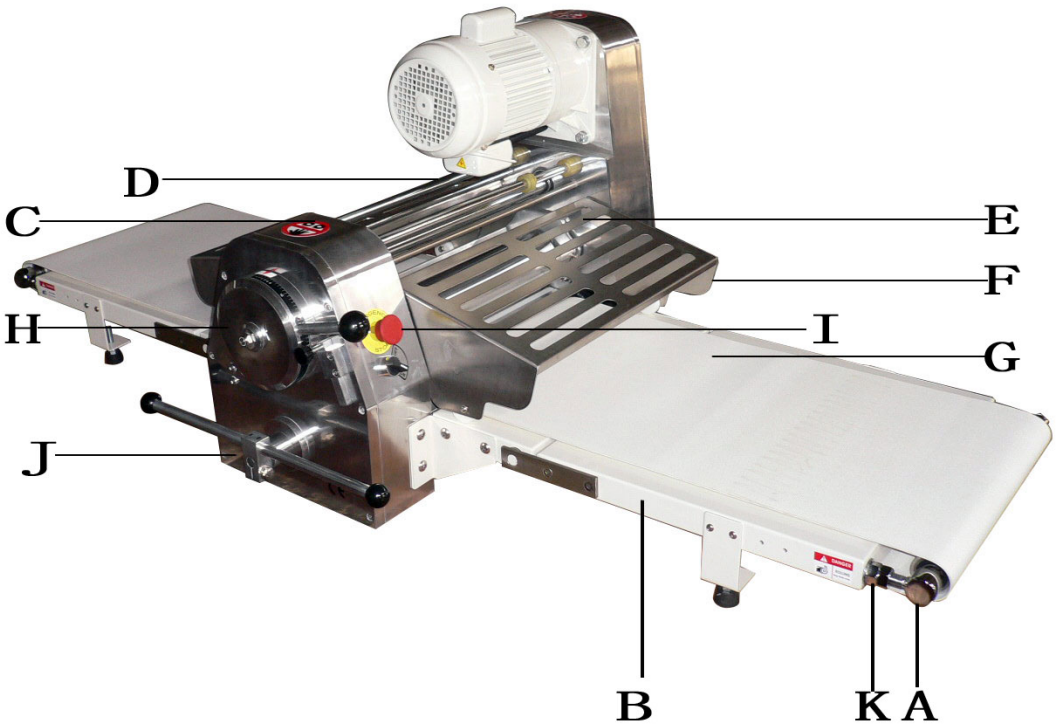
TABLE TOP REVERSIBLE SHEETER: TT-D18A
Thanks for using this high performance reversible, it will be your excellent assistant to make Danish bread, cheese cade and many other products.
Before using this machine, please carefully read this manual and follow the procedures to operate to operate the machine.

1.2 INSTALLATION

This is a new machine at a level and long table, dry place , ordinary temperature environment. Pull conveyor straight, put down table and then both safety guards
Start level or pedal switch, press left-hand side, the conveyors move left, press right-hand side, the conveyors move right .if the movement is opposite, change any two wires of the power supply and re-lest the machine
Please look this machine remark about electrical before you operate this machine

Chapter2

OPERATION



A: Roller(Active X2,Passive X2)
B:Table(Small X2.Big X2)
C:Upper Machine Body
D:Flour Tray
E:Upper pressing Roller ,Upper scraper X2
Lower pressing Roller ,Upper scraper X2
F:Safety Guard:Left&Right
G:Conveyor:2pcs.
H:Thickness Handle
I:Power switch
J:Start Level
K:Conveyor Adjusting Nut:4pcs

2.1 OPERATION

1. When using machine, set up the thickness handle (H) to the most left position.
2. Note : do not put hands into safety guard.
3. Switch off power when cleaning.
4. Lift up safety guards (F) after operation and then turn off power switch (I).

2.2 SAFETY GUARDS

All the safety devices must be checked before operation .Maintenance should be made immediately when defects or malfunction found.

1. Check the warning sings on the machine.
2. Clean up the water, oil and resin on the machine and its foundation immediately. it avoid slide and injury.
3. Keep your body away from any moving part of the machine.
4. Beware of foreign objects fall into the machine while operating.
5. Do not climb onto the machine while it is running.
6. In case any fault occurs in the process of operation, press Emergency Stop button.

3.1 TROUBLE SHOOTING

1. MACHINE CAN NOT WORK :

a. power supply is on ?
b. power switch is on ?
c. Safety guard (F) has put down ?
d. Lift safety guard if hear click from limit switch.
e. Lift up safety guard, start level (J) and check if hear click from limit switch.

2. ELECTRICAL CABINET VIBRATES CONTINUOUSLY:

a. Belt loose ?
b. Wires do not connect well ?
c. Something inside the electrical cabinet ?

3. MACHINE ONLY WORKS IN ONE SIDE :

a. Breaker failed ?
b. The wiring of Level (J) or limit switch failed ?
c. The wiring of motor is not good ?
d. Electricity is not three phase ?

4. CONVEYOR ONE SIDE WORKS, THE OTHER SIDE STOP :

a. The gear wore out .
b. Conveyor belt (G) is not tight enough .

5. THICKNESS HANDLE (H) CAN NOT FIX AND SLIP DOWNWARD :

If machine words smoothly when toward right-hand side but jump when toward Left-hand side , it means the chain inside rear machine body is too loose, set the handle at scale 15-20 ,and use screw driver to open cover. Apply spanner to adjust motor plate to tighten chain. Check handle (H) if it can be operated smoothly.

6. CONVEYOR (G) MOVES TOWARD ONE SIDE DURING PRODUCTION :

Adjusting nuts (K) to let the belt move straight for example , if belt moves toward rear Side, loose the front nut, when adjusting nuts, make sure that the speed of belt is the same as roller and no slip between roller and belt.

7. NOISE FROM ROLLER :

a. Bearing wore out.
b. If noise comes from pressing roller & scraper and conveyor .it means something sticks on active roller. To clean the active roller simple lift table can break down. Refer to assembly drawing for active roller and passive roller .

8. CONVEYOR (G) TOO TIGHT :

Machine locates at a humid place may cause conveyor becomes shorter. If conveyors arc too tight, loose nuts (K) during regular inspection.
If conveyors (G) are too tight, it may.

a. Has not sufficient horse power.
b. Damage bearing & shaft of active roller and passive roller .
c. Over load and damage driving gear .

Chapter 3

MAINTENANCE

1. CHANGE GEAR :

Switch off power, applying screw driver to dismantle side plate of lower machine body disconnect 3 electrical wires on the connecting box. Lift up safety guards and switch off
Power switch off, then set the thickness handle to scale “o” apply alan-key M5 to open cover take out gear housing ,then replace the gears, after replacement, reverse the procedures and set the thickness handle to scale “ o “.

2. REPLACE DRIVING ROLLER AND BEARING :

Switch off power , lift up safety guards and switch off power switch off. Then apply alan-key
To open cover, loose the nuts of bearing , use a cress type screw driver to move bearing through the joint or roller and bearing ,replace the roller and assembly by
Reversing procedures.

3. CHARGE CONVEYORS :

a. Remove the roller by following the procedures mentioned above.
b. Apply spanner M 12 to take the belts on roller and remove product tray .
c. Apply spanner M 23 to loose the nuts of roller.
d. Use spanner M 19 to loose the belts of support and separate the table.
e. Use spanner M 14 to take away the belts of table holder and separate them.
f. Dismantle the table and belts for replacement .
g. Assembly by reversing the processes .
h. The tightness of belts should be properly , when machine is running , press the belts slightly and check if slip happened between belts and roller.

4. CLEANING:

Wash the conveyor belt by clean water when working is finished everytime.the machine can not use until the conveyor belt become dry.

5. DAILY MAINTENANCE:

Please fill with oil when working is over everyday.