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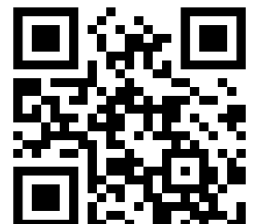
**BF110**

**BAGEL FORMER**

**OPERATIONS & SAFETY MANUAL**

FOR MACHINES BUILT AFTER 2022

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## Cautions

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### **⚠ CAUTION:**

**DO NOT OPERATE, CLEAN, OR SERVICE THIS MACHINE BEFORE YOU READ THIS MANUAL AND ARE FAMILIAR WITH THE SAFETY INSTRUCTIONS IN THIS MANUAL AND THOSE ON THE LABELS ON THE MACHINE. KEEP THIS MANUAL AND OTHER MATERIALS DELIVERED WITH THE MACHINE ACCESSIBLE TO THE OPERATORS FOR EASY REFERENCE DURING USE.**

**NOTE: PICTURES AND DIAGRAMS MAY BE 3D REPRESENTATIONS AND MAY NOT DIRECTLY REPRESENT YOUR MACHINE.**

## Owners Responsibility



### **NOTE:**

**THE PARTS AND EQUIPMENT DESCRIBED IN THIS MANUAL MAY BE COVERED BY ONE OR MORE U.S. AND FOREIGN PENDING PATENTS.**

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FOLLOW ALL INSTALLATION INSTRUCTIONS.

MAKE SURE INSTALLATION CONFORMS TO ALL APPLICABLE LOCAL, STATE, AND FEDERAL CODES, RULES, AND REGULATIONS SUCH AS STATE AND FEDERAL OSHA REGULATIONS AND ELECTRICAL CODES.

CAREFULLY CHECK THE UNIT FOR CORRECT INITIAL FUNCTION.

READ AND FOLLOW THE SAFETY INSTRUCTIONS. KEEP THEM READILY AVAILABLE FOR MACHINE OPERATORS.

MAKE CERTAIN ALL OPERATORS ARE PROPERLY TRAINED, AND THAT THEY KNOW HOW TO OPERATE THE UNIT AND ARE PROPERLY SUPERVISED SAFELY AND CORRECTLY.

ALLOW UNIT OPERATION ONLY WITH ALL PARTS INCLUDING SAFETY EQUIPMENT, IN PLACE AND OPERATING SAFELY.

CAREFULLY INSPECT THE UNIT ON A REGULAR BASIS AND PERFORM ALL MAINTENANCE AS REQUIRED.

SERVICE AND MAINTAIN THE UNIT ONLY WITH AUTHORIZED OR APPROVED REPLACEMENT PARTS.

KEEP ALL INSTRUCTIONS PERMANENTLY WITH THE UNIT ALONG WITH ALL DECALS AND WARNING LABELS ON THE UNIT CLEAN AND VISIBLE.

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## Introduction

**READ AND FAMILIARIZE YOURSELF WITH THIS MANUAL BEFORE OPERATING THIS MACHINE.**

**FOLLOW ALL THE INSTRUCTIONS BEFORE USE.**

The AM Manufacturing Bagel Former, model BF110, is designed to give you optimum time and labor-saving service with a high bagel production speed. This machine can be taught to new and current employes in a short period of time, resulting in safe and efficient operation. We urge you to study this operation and safety manual for full benefits.

### **CAUTION:**

- ALL OPERATORS MUST BE FULLY TRAINED AND INSTRUCTED IN SAFETY PROCEDURES BEFORE BEGINNING PRODUCTION.

### **IMPORTANT:**

AM MANUFACTURING COMPANY RESERVES THE RIGHT TO MAKE CHANGES IN DESIGN, SPECIFICATIONS OR MANUFACTURING TO IMPROVE THEIR PRODUCTS WITHOUT NOTICE AND WITHOUT OBLIGATION TO CHANGE OR IMPROVE PREVIOUSLY BUILT PRODUCTS, INCLUDING MANUALS AND CATALOGS.

DIAGRAMS AND FIGURES WITHIN THIS MANUAL ARE OFTEN 3D REPRESENTATIONS AND MAY NOT REPRESENT YOUR MACHINE IN IT'S ENTIRETY.

ONLY USE FACTORY SUPPLIED REPLACEMENT PARTS TO MAINTAIN MACHINE SAFETY, PERFORMANCE AND SANITARY CONDITIONS. USE OF NON-APPROVED PARTS MAY VOID MANUFACTURERS' WARRANTY.

KNOW YOUR UNIT. COMPARE DIAGRAMS IN THIS MANUAL WITH THE UNIT BEFORE STARTING SERVICE TO OBTAIN MAXIMUM SAFETY AND PERFORMANCE.

### **WARNING:**

THIS MANUAL CONTAINS CRITICAL SAFETY INSTRUCTIONS. READ AND FOLLOW THEM CAREFULLY. FAILURE TO FOLLOW WARNINGS AND INSTRUCTIONS MAY LEAD TO SERIOUS PERSONAL INJURY. THE OWNER IS RESPONSIBLE FOR MAINTAINING THE UNIT, ITS INSTRUCTIONS, AND DECALS FOR OPERATION REFERENCE. FOR ADDITIONAL COPIES CONTACT AM MANUFACTURING: (800) 342-6744

# Specifications

All dimensions below are approximate.

BAGEL FORMER	
LENGTH	8'-9"
WIDTH	2'-7 7/8"
HEIGHT	4'-1 5/8"

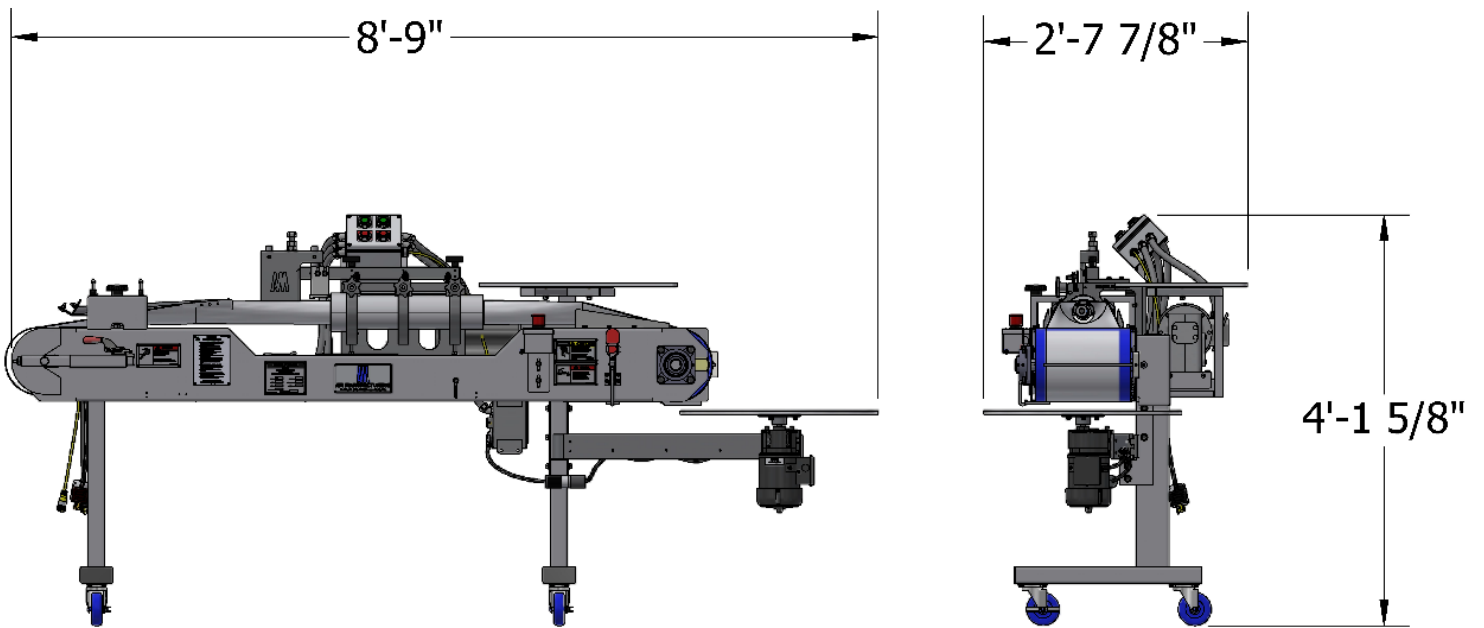


Figure 1: Specifications

## Installation Instructions for Location

Select location carefully. The area should provide the operator with enough space to use the equipment in a safe manner. The floor area selected should be a flat surface, easy to clean, and should be free of oil, grease, etc.

### **CAUTION:**

**PROPER UNIT INSTALLATION IS NECESSARY FOR SAFE AND EFFICIENT OPERATION. PROPER INSTALLATION ALSO HELPS PROTECT THE UNIT FROM DAMAGE AND MAKES SERVICE EASIER. ALL MOVING PARTS, WITH EXCEPTION OF NECESSARY CONVEYING SURFACES, SHOULD BE COVERED AND GUARDED WHEN THE MACHINE IS IN OPERATION.**

1. Open the crate and remove all packing materials, packing slips, documents, and other loose materials. Make certain to remove all manuals and schematics from the crate.
2. Move the unit to the desired location.
3. Lock the bottom two locking casters using their levers.

## Safety Rules



- READ AND FOLLOW THESE SAFETY RULES. THEY ARE FOR YOUR PROTECTION AND THE PROTECTION OF THOSE WORKING WITH YOU.
- DO NOT OPERATE THIS MACHINE BEFORE YOU HAVE READ AND UNDERSTOOD THE OPERATIONS AND SAFETY MANUAL.
- FOLLOW ALL INSTRUCTIONS DURING USE OF THIS MACHINE.
- LEAVE ALL GUARDS IN PLACE. INSTALL ALL GUARDS IF THEY WERE REMOVED FOR CLEANING, MAINTENANCE, REPAIR OR OTHER REASONS.
- NEVER OPERATE THE MACHINE IF YOU HAVE NOT BEEN TRAINED TO OPERATE THE MACHINE PROPERLY.
- NEVER OPERATE THE MACHINE IF YOU ARE TIRED, ILL, ON MEDICATION, OR UNDER THE INFLUENCE OF ALCOHOL OR DRUGS.
- WEAR TIGHT-FITTING CLOTHES. MAKE SURE THAT LONG HAIR, JEWELRY, OR LOOSE PERSONAL ITEMS ARE SECURED SO THEY CANNOT GET CAUGHT IN THE MACHINE. THIS CAN LEAD TO SERIOUS INJURIES.
- MAKE SURE YOU CAN EASILY REACH ALL CONTROLS. IF NOT, A STABLE AND SAFE ELEVATED PLATFORM OR OTHER WORK-AID MUST BE PROVIDED.
- ALWAYS DISCONNECT THE MAIN ELECTRICAL POWER SOURCE AND TURN THE MACHINE SWITCH TO THE OFF POSITION BEFORE CLEANING, IF MAINTENANCE OR SERVICE IS PERFORMED, OR IF THE MACHINE IS OUT OF SERVICE.
- NEVER LEAVE THIS MACHINE RUNNING UNATTENDED.

### **IMPORTANT:**

**IF YOU HAVE ANY QUESTIONS ABOUT THESE SAFETY RULES, SEE YOUR SUPERVISOR OR CALL AM MANUFACTURING CO. TOLL FREE: (800) 342-6744**

## Safety Signal Words

THIS MACHINE IS DESIGNED TO PROVIDE SAFE OPERATION IF NORMAL OPERATING PROCEDURES AND SAFETY MESSAGES LOCATED ON THE MACHINE AND IN THIS MANUAL ARE FOLLOWED.

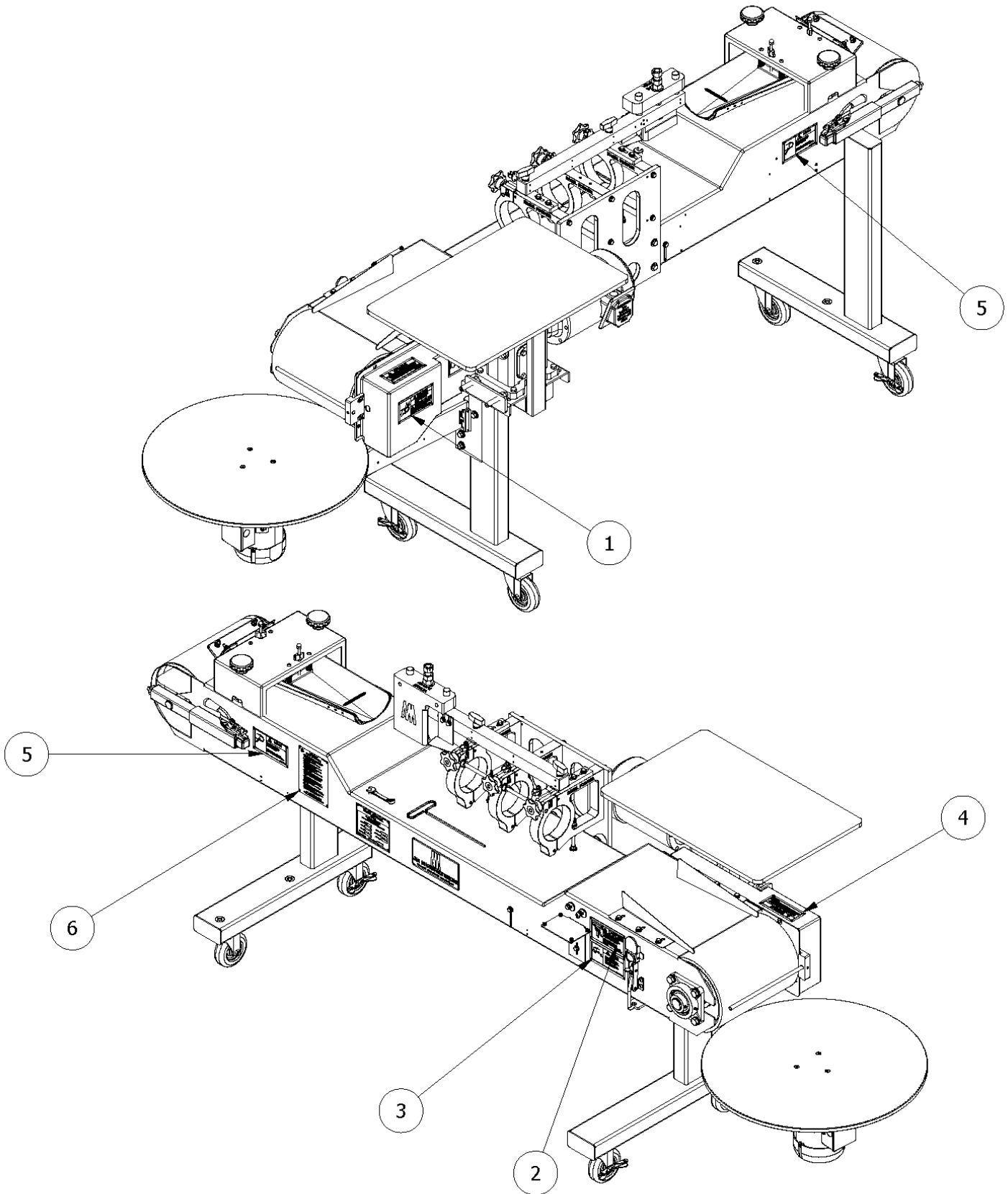


THIS IS A SAFETY ALERT SYMBOL. YOU WILL FIND IT ON VARIOUS SAFETY LABELS ON THE MACHINE AND IT WILL ALSO APPEAR IN THIS MANUAL WHEREVER SAFETY MESSAGES ARE GIVEN.

### GET FAMILIAR WITH SIGNAL WORDS:

- **CAUTION:**
  - INDICATES A POTENTIALLY HAZARDOUS SITUATION WHICH, IF NOT AVOIDED, MAY RESULT IN MINOR OR MODERATE INJURY. IT MAY ALSO BE USED TO ALERT AGAINST UNSAFE PRACTICES.
- **WARNING:**
  - INDICATES A POTENTIALLY HAZARDOUS SITUATION WHICH, IF NOT AVOIDED, COULD RESULT IN DEATH OR SERIOUS INJURY.
- **DANGER:**
  - INDICATES AN IMMINENTLY HAZARDOUS SITUATION WHICH, IF NOT AVOIDED, WILL RESULT IN DEATH OR SERIOUS INJURY. THIS SIGNAL WORD IS TO BE LIMITED TO THE MOST EXTREME SITUATIONS.
- **NOTE:**
  - A NOTE PROVIDES KEY INFORMATION TO MAKE PROCEDURES EASIER AND CLEARER.

# Warning Label Locations - Former



# Warning Labels on the BF110 Former

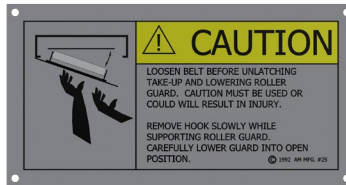
## 1) AMTAG24MF:

LOCATED ON CHAIN GUARD COVER AND BEHIND CHAIN GUARD COVER



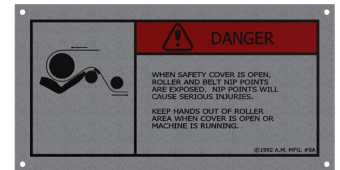
## 2) TAG #25:

LOCATED NEAR SWING PLATE



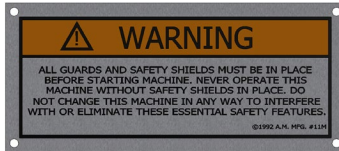
## 3) TAG9BM:

LOCATED NEAR SWING PLATE



## 4) TAG11M:

LOCATED ON TOP OF CHAIN GUARD COVER



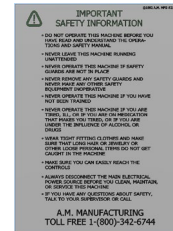
## 5) TAG14M:

LOCATED ON BOTH SIDES OF CABINETS NEAR TENSIONERS



## 6) TAG21M:

LOCATED ON ONE SIDE



## Divider Operating Instructions

### **WARNING:**

UNIT MUST BE PROPERLY OPERATED AND MAINTAINED TO PREVENT MACHINE DAMAGE OR PERSONAL INJURY. REVIEW INSTRUCTIONS WITH ALL EMPLOYEES BEFORE USE.

### **IMPORTANT:**

BEFORE BEGINNING START-UP, READ ALL THE INSTRUCTIONS AND FAMILIARIZE YOURSELF WITH THE LOCATIONS OF ALL CONTROLS. KNOW HOW TO SHUT DOWN THE UNIT IMMEDIATELY IN CASE OF TROUBLE. MAKE CERTAIN ALL PERSONNEL NOT INVOLVED IN THE START-UP ARE SAFELY AWAY FROM THE MACHINE BEFORE ANY SYSTEMS ARE STARTED.

## Start-up Procedures

---

1. Ensure the machine and its components are clear of packing material, packing slips, documents, and other obstructions.
2. Position the Bagel Former into the desired location and lock the two locking casters with their levers.
3. Ensure that the former's table motor is connected.
4. Plug the power cord from the former into the proper outlet.
5. Push the green Bagel Former Start Push-button to turn the machine on. If you have an SAB802 divider and former combination, or an RK2201 divider and former combination; consult those manuals for the correct power on procedures.

## Operation Procedures

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1. Ensure the bagel former is properly in place with the belt, forming tubes, and mandrel parts properly installed.
2. Form a dough piece in a cylindrical shape, placing the piece horizontal on the belt.
3. The dough piece will be deposited onto the rotating table assembly at the end of the machine.

**NOTE: When the former is not in use, it is recommended to release tension from the belt by dropping the swing plate and lifting the tension clamps. See the instructions on page 12.**

## General Cleaning Instructions

**⚠ WARNING:** Before attempting to clean the former, make certain that the machine has been properly powered down and the plug has been removed from the power source. Failure to do so could result in serious injury.

All AM Manufacturing machines are tested with dough during the quality audit procedure. Although the machine has been cleaned, some evidence of dough may be detected, this is normal.

All parts in contact with dough should be washed thoroughly after operation with a mild soap and water solution. Disassembly of this machine for cleaning is outlined and illustrated for your convenience.

Cleaning the AM Manufacturing divider is essential to ensure sanitary conditions and proper machine function. Regular cleaning will extend the life of various components within the machine.

## Bagel-former Belt Removal & Cleaning

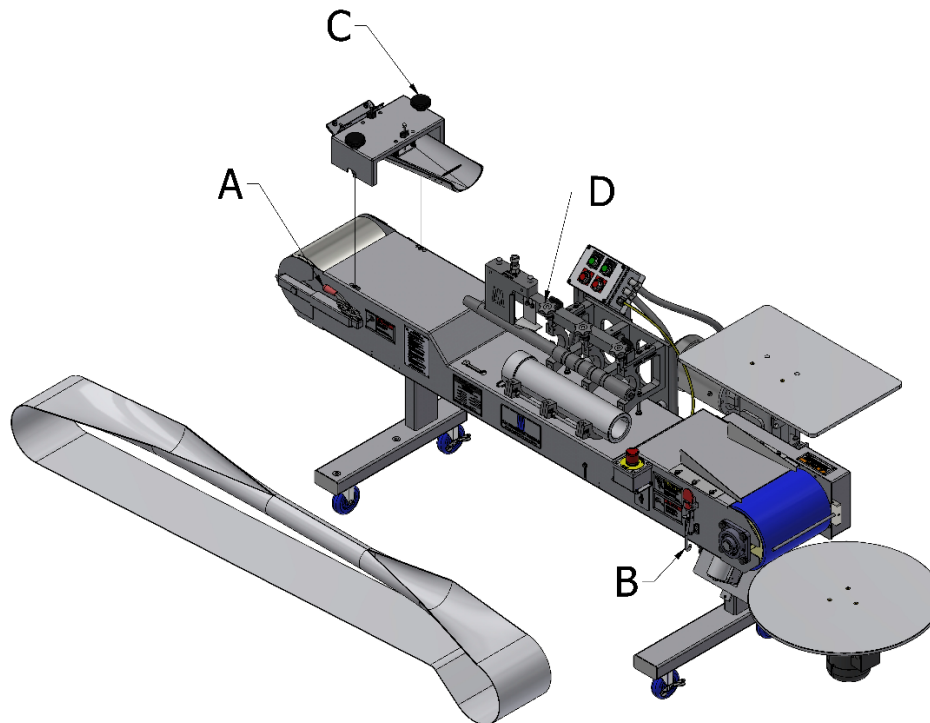


Figure 2: Belt Removal

### Removing the Bagel Belt

- A. Lift the two red handled clamps (Figure 2, A.) on the drive roller end and push the drive roller inwards.
- B. Locate the red handled swing plate latch on the opposite end (Figure 2, B).
  - a. Push in the small red lever and pull the larger red handle away to disengage the swing plate assembly.
- C. Locate the two black knobs on top of the pressure plate bridge (Figure 2, C).
  - a. Loosen both knobs until the bridge and pressure plate assembly can be removed from the machine.
- D. Locate the three (3) star knobs on the mandrel support area (Figure 2, D).
  - a. Loosen two of the knob until the rods that the knobs are threaded onto can lift into their latches.
  - b. Loosen the last knob, ensuring that the clamps are supported by hand, so they do not fall.
  - c. Remove the forming tubes and the belt.

### **Tensioning and Aligning the Bagel Belt**

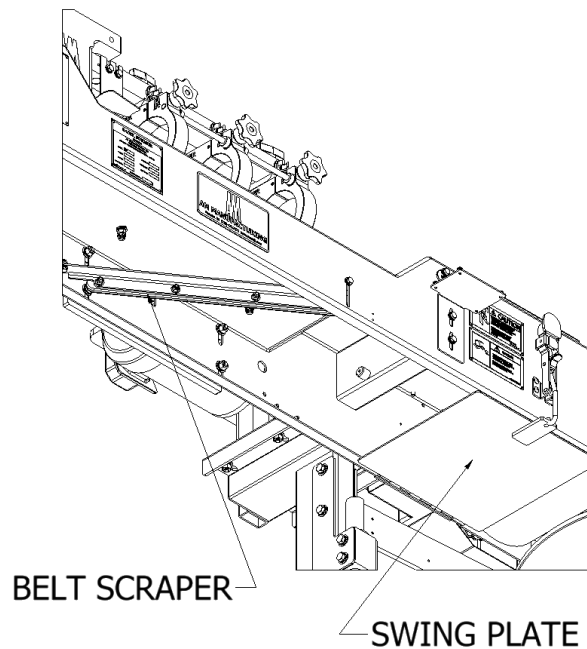
The bagel belt must be properly installed, aligned, and tensioned for the belt to track in the center of the rollers and to prevent premature wear. If reinstalling the bagel belt, perform the previous section for Figure 2 in reverse.

1. The hex nuts found at the very end of the lifting clamps in Figure 2, A are used to adjust the tension.
  - a. The hex nuts must be turned clockwise to loosen the belt and counterclockwise to tighten it.
  - b. Never adjust one nut independently of the other for more than five rotations.
2. During the tightening or loosening process, alternate from the right side to the left side for equal adjustment.

### **Cleaning the Bagel Former**

1. Loosen and remove the forming belt, cleaning off any built-up dough residue.
  - a. Follow the instructions in the **Removing the Bagel Belt** section to remove the belt.
2. Remove the forming tubes from the machine and gently wash with soap and water, using a nonabrasive cloth.
3. Clean the swing plate tensioner below the machine of any excess dough buildup. (Figure 3).
4. Clean any dough built up along the dough scraper below the bagel former. (Figure 3).

**NOTE: THE BAGEL FORMING BELTS SHOULD REMAIN LOOSE WHEN MACHINE IS NOT IN USE TO AVOID STRETCHING.**



*Figure 3: Scraper & Swing Plate*

## General Maintenance

Read and follow the maintenance instructions below to keep the unit in good operating condition. Regular inspections and maintenance are essential to help prevent accidents and injuries.

**⚠ WARNING:** Before attempting maintenance on this machine, make certain that the machine has been properly powered down and the plug has been removed from the power source. Failure to do so could result in shock or injury.

Before making any inspection, adjustment, or repair, be certain power source is disconnected, and all moving parts are blocked out to prevent injury. Wear protective clothing.

- All working surfaces should be cleaned regularly.
- The cabinet and other working surfaces should be cleaned regularly.
- Make sure that all fasteners are tightened securely.
- Make certain that all guards and covers are in place.
- Check for worn, damaged or missing parts including belts, safety guards, and protective covers.
- Inspect the unit and check to be certain that all systems are operating normally daily.

**⚠ CAUTION:** Replace any damaged or missing safety labels. These are available from the manufacturer.

Maintenance for this equipment always begins with keeping the machine clean. Proper cleaning procedures start on pages 12 of this manual. Standard long-term maintenance consists of lubricating main wear points of the machine with an all-purpose synthetic base grease. A grease gun with a flexible hose is needed.

## Grease Points

There are various grease points around the machine that should be regularly lubricated on a bi-weekly basis for optimum bearing life. The grease points are shown in the following figures.

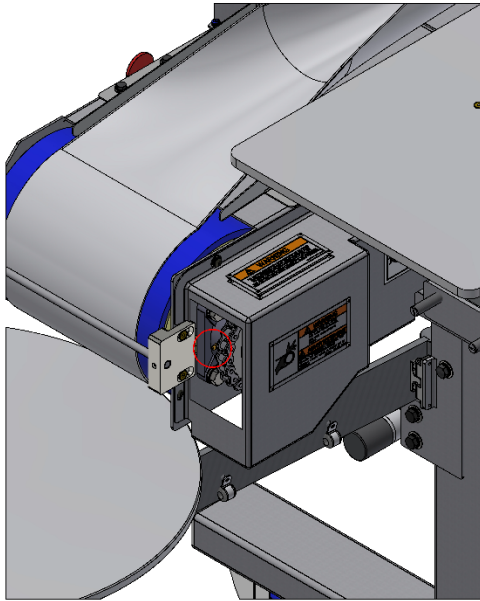


Figure 4: Grease Points

The bagel former has a grease point on the two bearings on each side of the discharge end.

- Ensure these bearings are regularly greased along with the chains and sprockets behind the chain guard.

## Basic Trouble Shooting Guide

Issue	Probable Cause	Solution
Bagels not tying	Excess dough weight, pressure plate needing adjustment, or incorrect bagel setup sizes.	Check that infeed dough is of the expected weight. Adjust the black plastic wing nuts on the pressure plate assembly to push down or lighten up as needed.
Bagels are lop-sided	The mandrel mount bar holding the mandrel bar and sleeve is off center with the forming tubes.	Adjust the mandrel bar's position from side to side, centering it as needed.
Machine Not Powering On	Main Power to machine, safety circuit.	Check the safety circuit on all guards. Open the panel, check for power light on safety relay. If light is off, check the fuses.
Former motor does not run	Broken connection, parts, or bad motor	Check the overloads, replace the motor as needed.
Table motor does not run	Broken connection, parts, or bad motor	
Both former motors not running	Power disconnected, bad contactor.	Verify connections and check the contactor. Ensure the E-stop is not activated.

## **AM Manufacturing Service Department Contact Information**

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Monday through Friday, 7AM to 3:30PM (CST)

Phone: [219-472-6417](tel:219-472-6417)

Monday through Friday, 3:30PM to 7AM (CST)

and Saturday or Sunday

Phone: [708-328-3400](tel:708-328-3400)

[support@ammfg.com](mailto:support@ammfg.com)

# Bagel Forming Belt Setups

On the AM Manufacturing Bagel Former, there are various optional sized parts that allow for different raw bagel weight ranges. The chart below shows the standard sizes of these bagel forming set-ups, which are guidelines to reach specific weight ranges. Some of these parts can be changed to achieve more custom bagels, but not all will be guaranteed to form correctly. Pushing too much dough through a smaller setup may cause issues tying the bagels together, and dough weights may change if using a smaller mandrel bar and sleeve but a much larger forming tube and belt.

- The mandrel bar and mandrel sleeve play a direct role in how the hole of the bagel will look after it is formed.
- The forming tube affects the outer shape of the bagel.
- Keeping the right amount of dough balanced to satisfy the sizes of the setup is key to forming a bagel.
- **The bagel belt size much match its corresponding set-up size so the belt can fit the forming tube correctly.**
  - For example, a 9-3/4" BDP22 belt will not fit inside a standard BFM21 forming tube, the belt will overlap. If used with a larger tube, the belt will not fully meet inside the forming tubes. The BFM21 forming tube will only work with an 8-7/8" wide belt.

The chart below shows the setups along with the components that make up with them. The weight column on the right shoes the weight ranges for those setups, but these can vary if parts are mixed and matched.

SETUP	SET UP SIZE	TUBE #	TUBE ID	BELT#	BELT WIDTH	MANDREL BAR PART#	MANDREL BAR DIA	MANDREL SLEEVE PART#	MANDREL SLEEVE DIA	WEIGHTS OZ
MICRO	5"	BFM54	1.625"	BDP27	5"	BFM37D	3/4"	N/A	N/A	1/2-3/4 OZ
COCKTAIL	6"	BFM40	1.91"	BDP23	6"	BFM37E	1-1/8"	N/A	N/A	3/4-1-1/2 OZ
MINI	7"	BFM50	2.33"	BDP25	7"	BFM37F	1-1/4"	N/A	N/A	1-1/2-2 OZ
BLACK	8"	BFM51	2.646"	BDP26	8-3/8"	BFM23	1-1/2"	BFM34	1-1/2"	2-3 OZ
STANDARD	9"	BFM21	2.866"	BDP21	8-7/8"	BFM55	1-3/4"	BFM35	1-7/8"	3-3.8 OZ
BULL	10"	BFM41	3.182"	BDP22	9-3/4"	BFM55	1-3/4"	BFM37	2"	4-5 OZ
MAXI	11"	BFM53	3.615"	BDP24	11"	BFM56	2"	BFM37-B	2-1/4"	5-6 OZ

ADDITIONAL MANDREL SLEEVES	
MANDREL SLEEVE #	MANDREL SLEEVE DIA
BFM36	1-3/4"
BFM37A	2-1/8"
BFM37C	2-3/8"

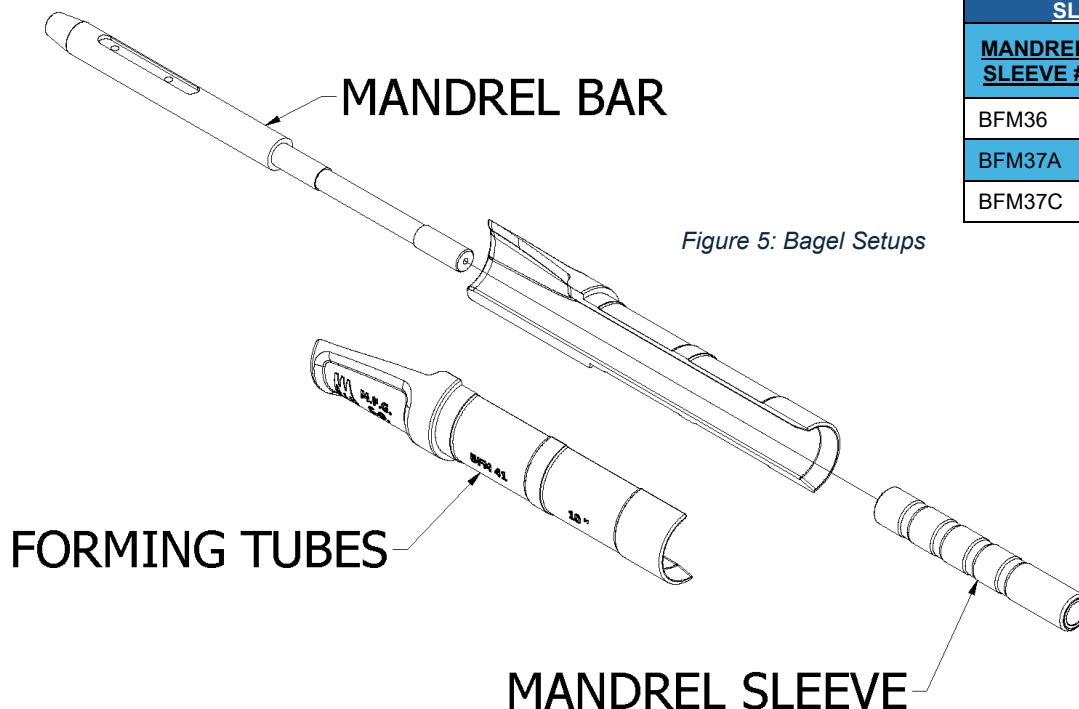
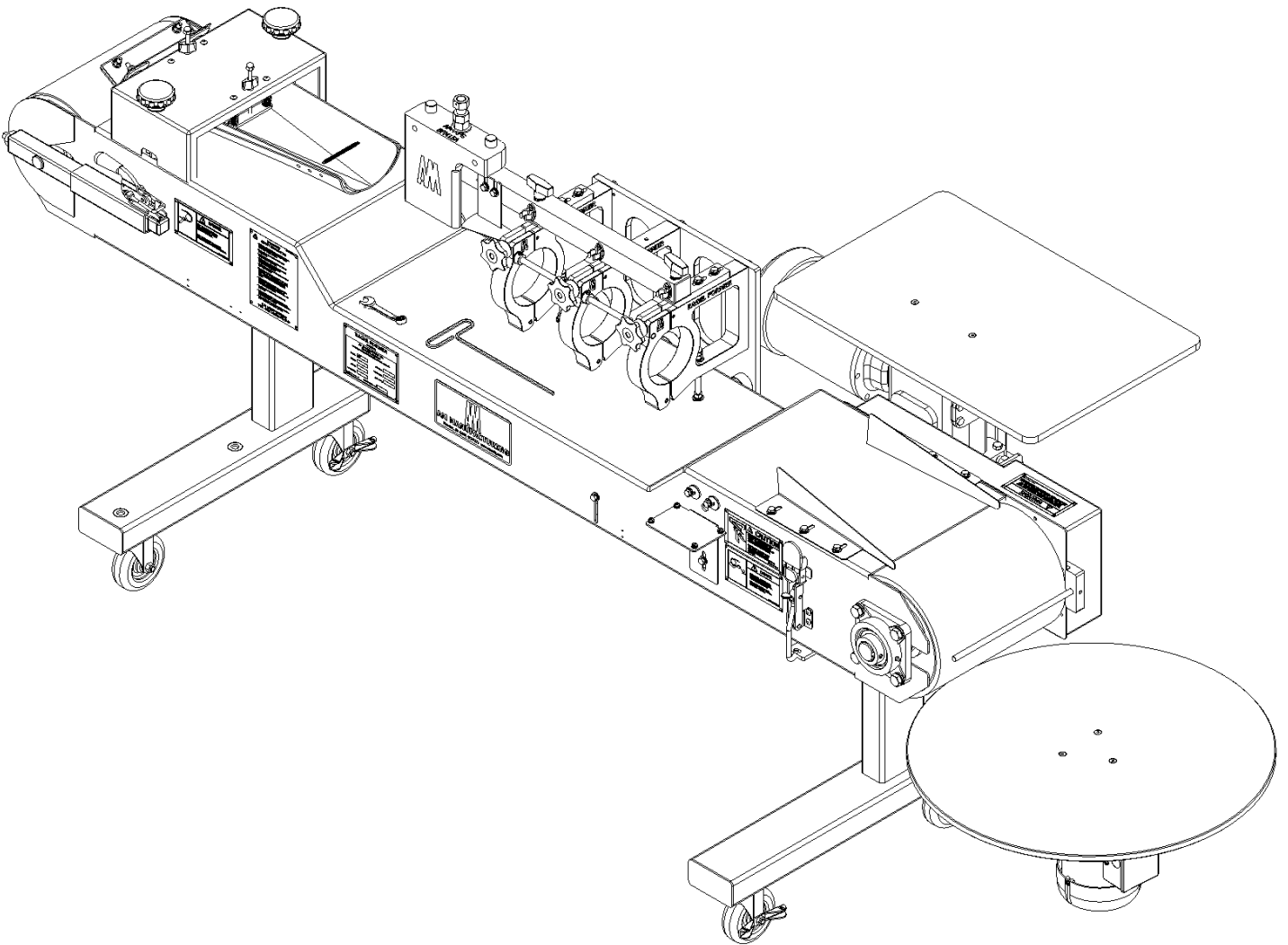
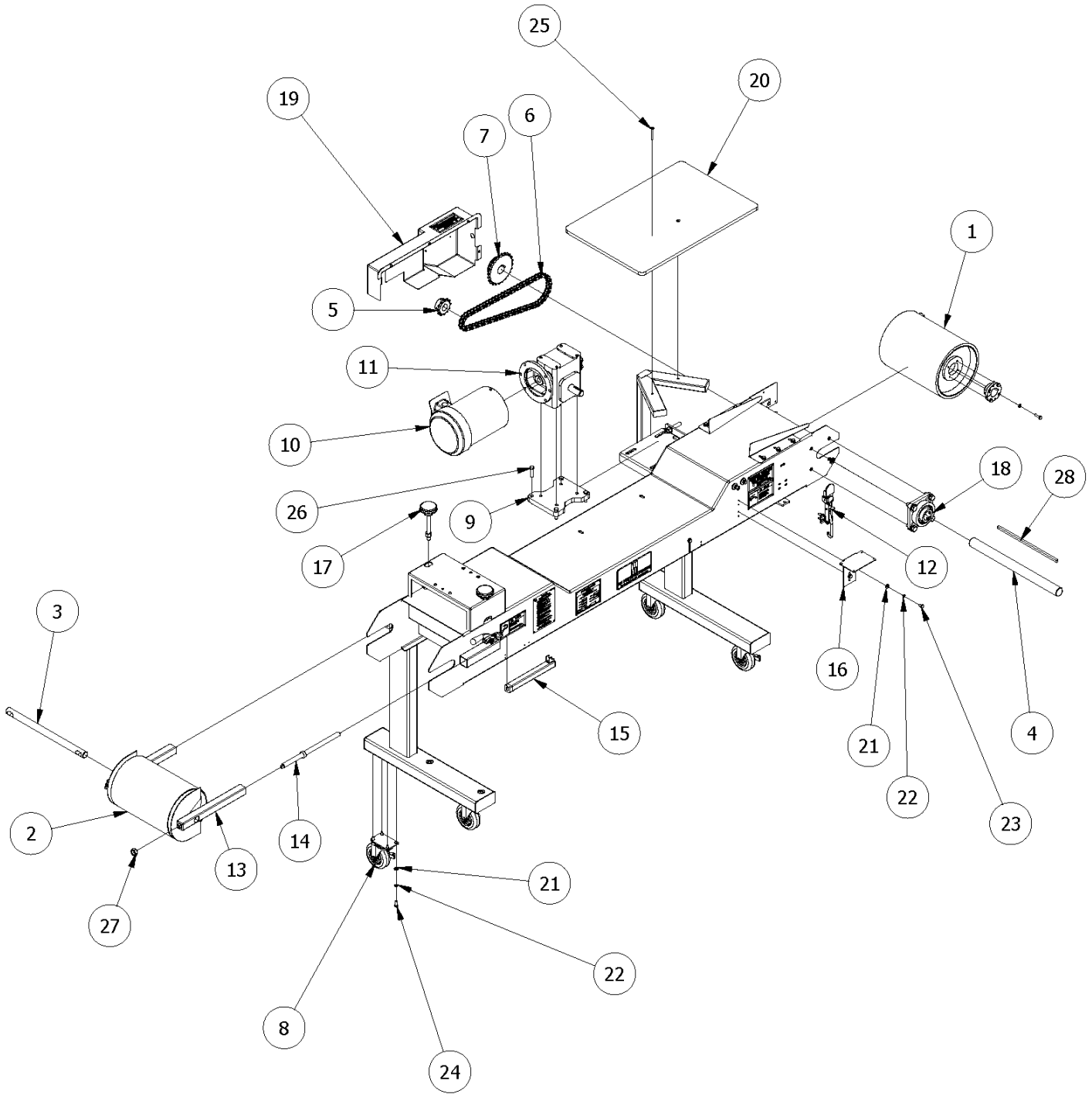


Figure 5: Bagel Setups

# Bagel Former Parts Catalogue



# Bagel Former Body Parts Breakdown



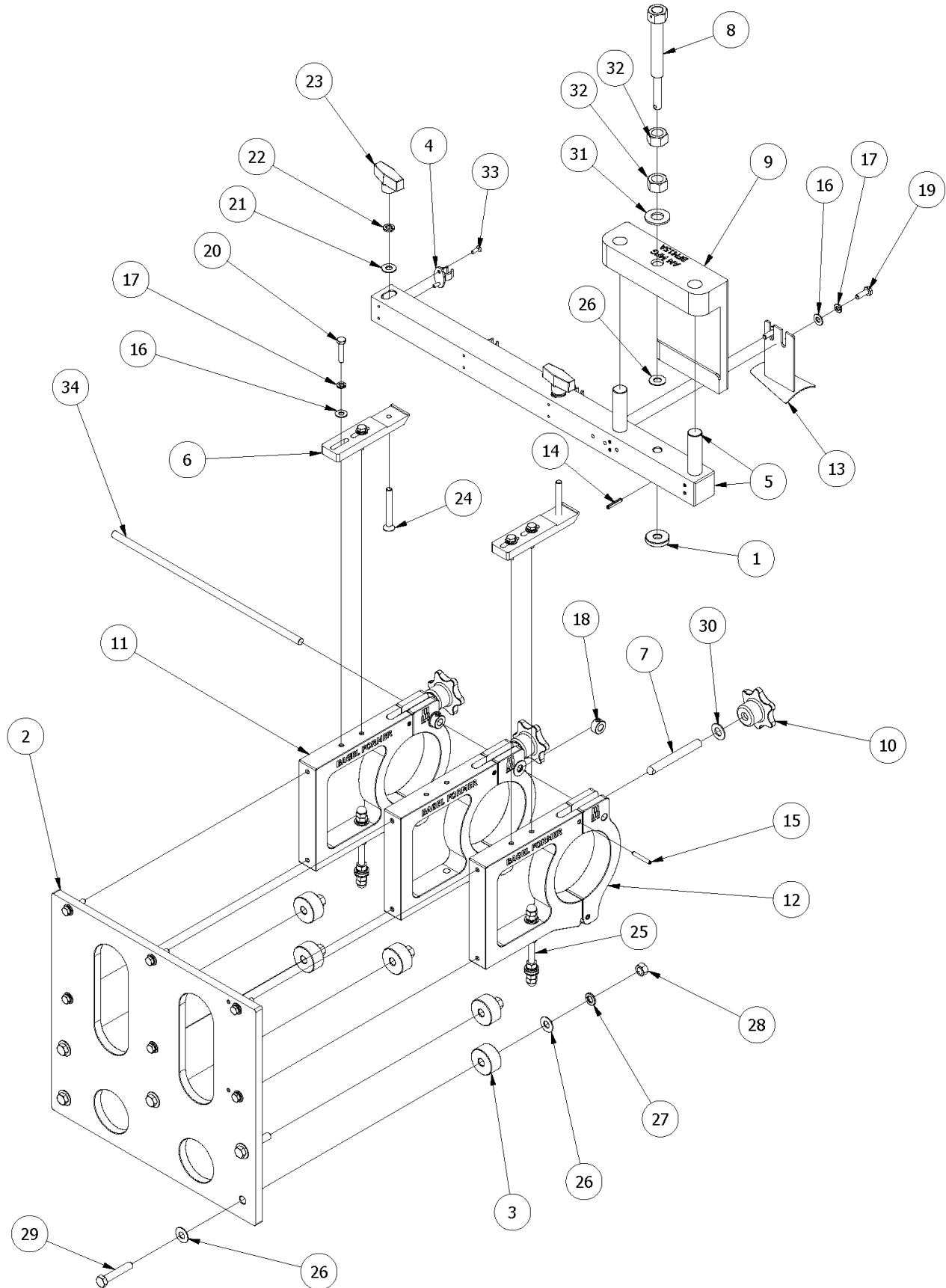
**Bagel Former Body Parts List**

ITEM	PART NO	DESCRIPTION	QTY
1	100DR	ROLLER DRUM DRIVE PULLEY	1
2	100IR	IDLER ROLLER ASSEMBLY	1
3	101IR-A	TAKEUP ROLLER SHAFT	1
4	102DR	DRIVE ROLLER SHAFT	1
5	106DR	MOTOR SPROCKET (50B12X1)	1
6	107DR	#50 CUT CHAIN, 31 LINKS W/ MASTER	1
7	117DR	BAGEL FORMER DRIVE SPROCKET	1
8	621CA1	CASTER, LOCKING 4" DIA	2
9	11208	SPECIAL MOTOR MOUNT PLATE	1
10	11900	1 HP MOTOR, 1750 RPM 56C/WASHDOWN	1
11	12444	GEARBOX (25:1 RIGHT HAND)	1
12	12822	BELT TENSION SWING PLATE DESTACO CLAMP	1
13	20918-C2	ROLLER TAKE-UP MIDDLE TUBE ASSEMBLY	2
14	20918-C4	ADJUSTMENT STUD ASSEMBLY	2
15	20918-C6	ROLLER TAKE-UP INNER TUBE ASSEMBLY	2
16	33535	E-STOP MOUNT BRACE	1
17	A107IR	BRIDGE HOLEDOWN ASSEMBLY	2
18	BDP10	4 HOLE FLANGE BEARING (1-3/8" SHAFT)	2
19	*SEE NOTE*	CHAIN GUARD	1
20	BRT11	STATIONARY TABLE	1
21	F0400FW	FLAT WASHER, 1/4"	55
22	F0400LW	LOCK WASHER, 1/4"	51
23	F0402HHCS	HEX HEAD CAP SCREW, 1/4-20X1/2" LG.	6
24	F0403HHCS	HEX HEAD CAP SCREW 1/4-20 X 3/4"	22
25	F0408FSH	FLAT SOCKET HEAD, 1/4 X 2" LG.	2
26	F0606HHCS	HEX HEAD CAP SCREW 3/8-16 X 1-1/2"	4
27	F1000JN	NUT, JAM 5/8-11	2
28	KEY STOCK .3125SQ X 12LG	5/16" KEY STOCK (12" LONG)	1

**NOTE:** Bagel Formers may face the left or right, **when facing the flow direction of the dough**, depending on the machine it is paired with or the direction requested at the time of order.

CHAIN GUARD		
POSITION	PART NUMBER	DESCRIPTION
Guard mounted on the <b>LEFT side</b>	BFM148-002L	CHAIN GUARD – LEFT SIDE
Guard mounted on the <b>RIGHT side</b>	BFM148-002R	CHAIN GUARD – RIGHT SIDE

# Mandrel Support Parts Breakdown



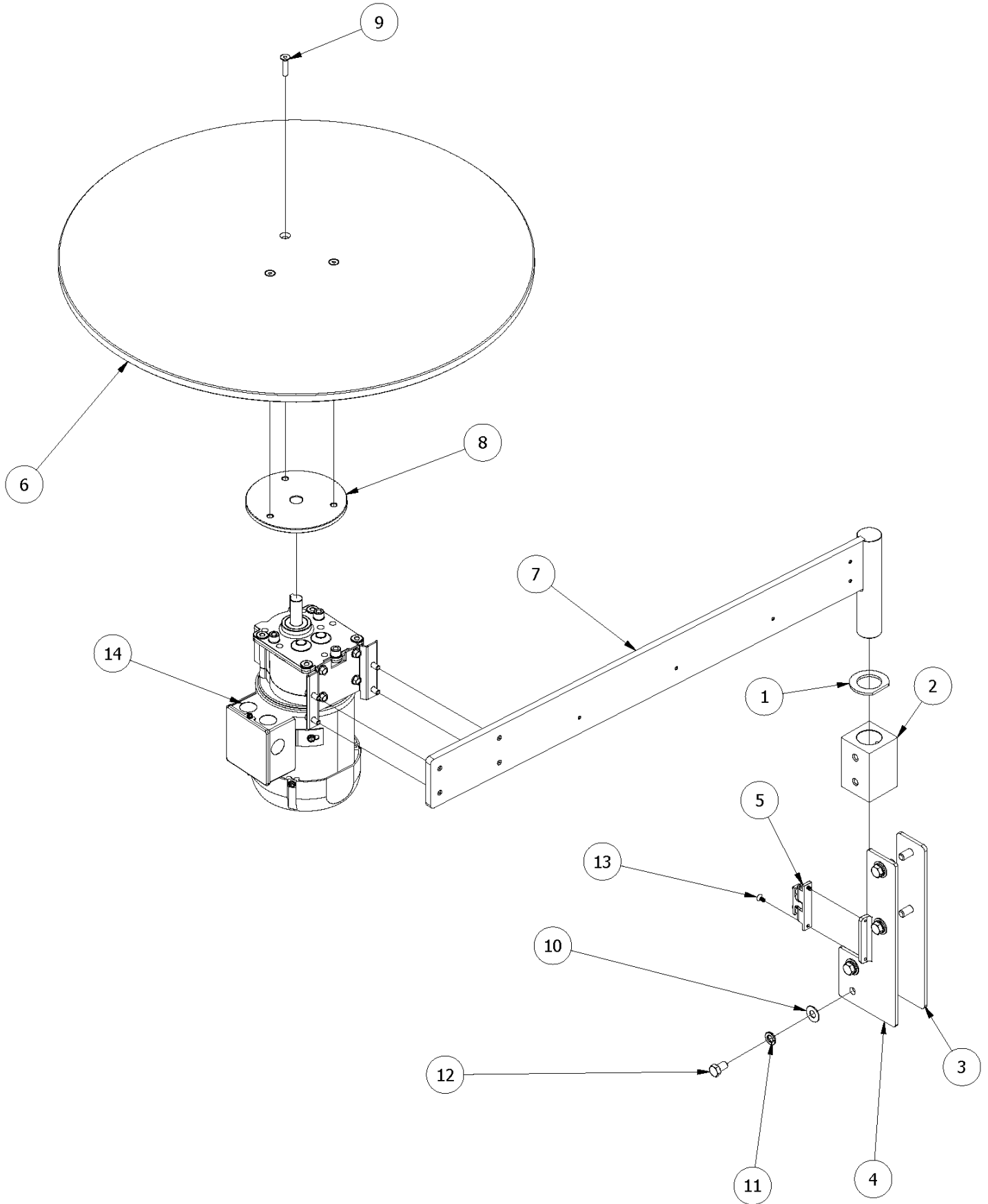
**Mandrel Support Parts List**

ITEM	PART NO	DESCRIPTION	QTY
1	21375	SPACER-1-1/4ODX1/4LGX13/32ID, SS	1
2	22579	MANDREL BAR ASSEMBLY SUPPORT PLATE	1
3	22879	SPACER - 1-1/2 OD X 3/4 LG X 13/32 ID, SS	5
4	22973	TOOL HOLDER (7/16" - 9/16")	3
5	ABFM2	MANDREL SUPPORT ASSY	1
6	BFM4	HORIZONTAL ADJUSTING BLOCK	2
7	BFM6	STUD-LOCKING HINGE	3
8	BFM12	MANDREL BAR HEIGHT ADJUSTMENT SCREW ASSEMBLY	1
9	<b>*SEE NOTE*</b>	MANDREL SUPPORT & ADJUSTMENT	1
10	BFM19	STAR KNOB 7/16-14 THUR HOLE	3
11	BFM27	FORMING TUBE HOLDER	3
12	BFM31	CLAMP - FORMING TUBE	3
13	<b>*SEE NOTE*</b>	DOUGH SHIELD	1
14	<a href="#">F0304RP</a>	3/16" DIA X 1" LONG ROLL PIN	1
15	<a href="#">F0305RP</a>	3/16" DIA X 1-1/4" LONG ROLL PIN	3
16	<a href="#">F0400FW</a>	FLAT WASHER, 1/4"	12
17	<a href="#">F0400LW</a>	LOCK WASHER, 1/4"	12
18	<a href="#">F0401SS</a>	SET SCREW 1/4-20 X 1/4"LG.	4
19	<a href="#">F0403HHCS</a>	HEX HEAD CAP SCREW 1/4-20 X 3/4"	2
20	<a href="#">F0405HHCS</a>	HEX HEAD CAP SCREW 1/4-20 X 1-1/4"	10
21	<a href="#">F0500FW</a>	FLAT WASHER, 5/16"	10
22	<a href="#">F0500LW</a>	LOCK WASHER, 5/16"	10
23	<a href="#">F0500PWN</a>	PLASTIC WING NUT (5/16-18)	2
24	<a href="#">F0510FSH</a>	FLAT SOCKET HEAD 5/16 X 2-1/2" LG.	2
25	<a href="#">F0518SD</a>	THREADED ROD (5/16-18 X 4-1/2" LONG)	2
26	<a href="#">F0600FW</a>	FLAT WASHER 3/8"	16
27	<a href="#">F0600LW</a>	LOCK WASHER 3/8"	5
28	<a href="#">F0600NC</a>	3/8-16 HEX NUT	5
29	<a href="#">F0608HHCS</a>	HEX HEAD CAP SCREW 3/8-16 X 2" LG	5
30	<a href="#">F0700FW</a>	FLAT WASHER 7/16"	3
31	<a href="#">F1000FW</a>	5/8" FLAT WASHER	1
32	<a href="#">F1000NC</a>	5/8" HEX NUT	2
33	<a href="#">F9702FH</a>	8-32 X 1/2 SLOTTED FLAT HEAD SCREW	6
34	RS .375X13.75 SS	3/8" OD ROUND STOCK X 13-3/4" LG, SS	1

**NOTE:** Bagel Formers may face the left or right, **when facing the flow direction of the dough**, depending on the machine it is paired with or the direction requested at the time of order.

MANDREL SUPPORT & DOUGH SHIELD		
POSITION	MANDREL SUPPORT PART #	DOUGH SHIELD PART #
Tube Clamps are facing the <b>RIGHT</b> side	BFM15A	BFM52R
Tube Clamps are facing the <b>LEFT</b> side	BFM15	BFM52L

# Table Assembly Parts Breakdown



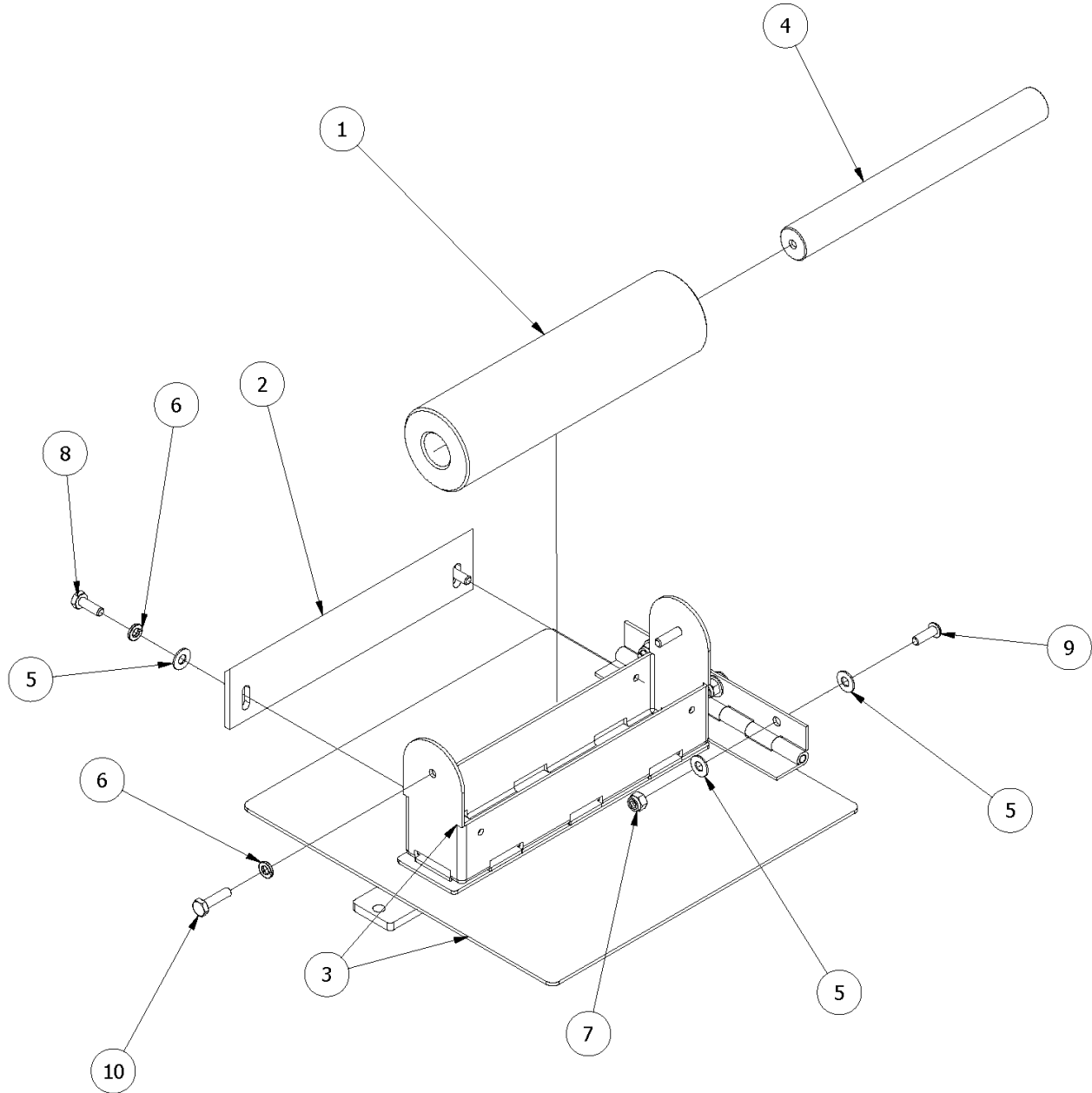
**Table Assembly Parts List**

ITEM	PART NO	DESCRIPTION	QTY
1	416CDF	SPACER BUSHING	1
2	32869	TABLE ARM MOUNT BRACKET	1
3	32870	TABLE ARM MOUNT BRACKET HOLDER	1
4	<b>*SEE NOTE*</b>	TABLE ARM MOUNT BRACKET HOLDER (EXTEND SIDE)	1
5	33337	BALL STYLE GRAB LATCH (MULTI-DIRECT	1
6	BRT32	ROTARY TABLE	1
7	BRT34	SWING ARM MOTOR MOUNT ASSY.	1
8	BRT-36	ROTATING TABLE FLANGE	1
9	F0404.5FSH	FLAT SOCKET HEAD 1/4-20 X 1.125" LG.	3
10	F0600FW	FLAT WASHER 3/8"	8
11	F0600LW	LOCK WASHER 3/8"	8
12	F0602.5HHCS	HEX HEAD CAP SCREW 3/8-16 X 5/8"	4
13	F9701.5FH	FLAT HEAD, HEX DRIVE (8-32 X 3/8" LONG, S.S.)	4
14	SS267	GEAR MOTOR (1/12HP, 7.8RPM, 320in-lb Torque)	1

**NOTE:** Bagel Formers may face the left or right, **when facing the flow direction of the dough**, depending on the machine it is paired with or the direction requested at the time of order.

CHAIN GUARD		
POSITION	PART NUMBER	DESCRIPTION
Table mounted on the <b>Right side of the frame.</b>	33329	TABLE ARM MOUNT BRACKET HOLDER RS
Guard mounted on the <b>LEFT side of the frame.</b>	33338	TABLE ARM MOUNT BRACKET HOLDER LS

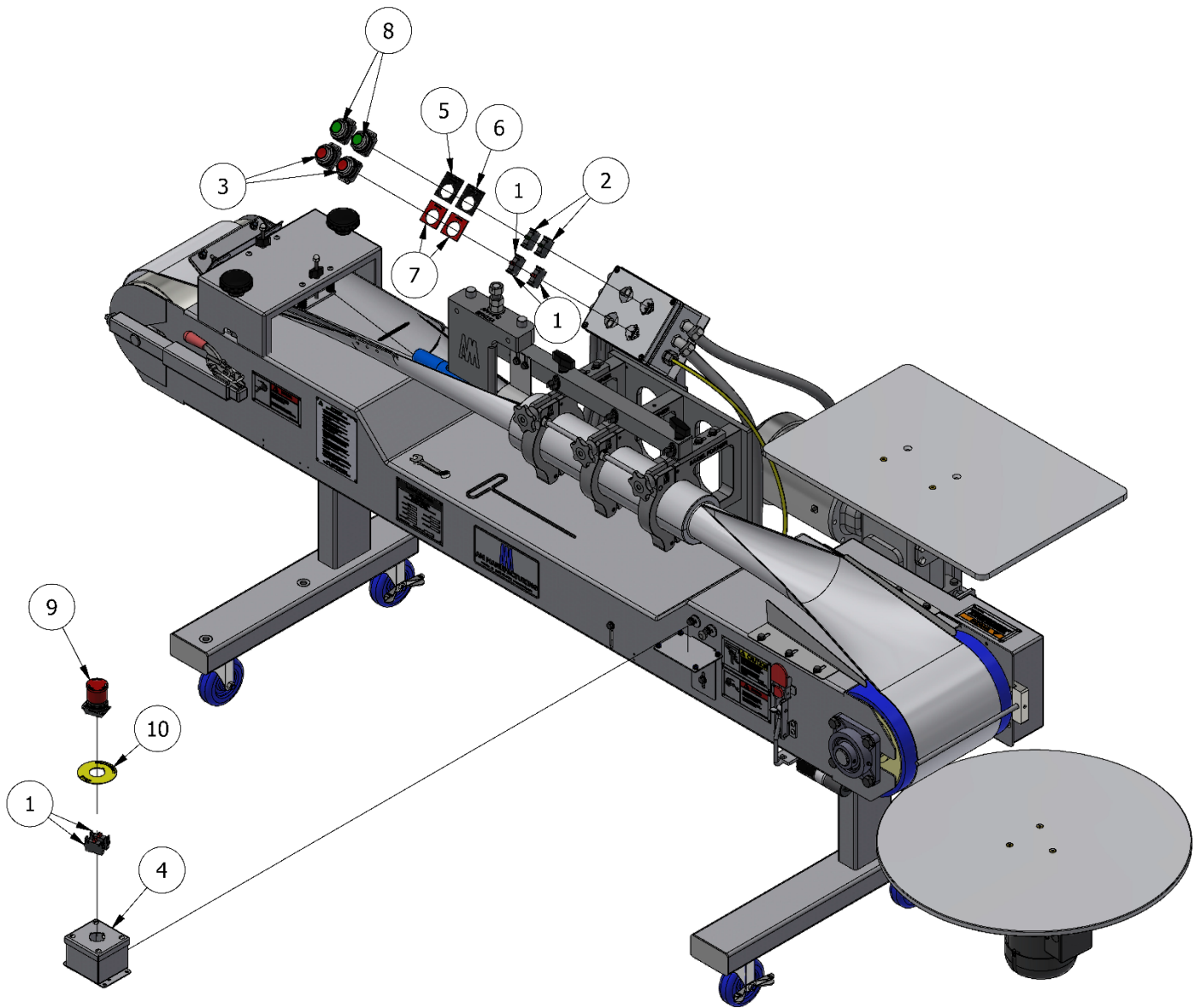
# Swing Plate Assembly Parts Breakdown



**Swing Plate Assembly Parts List**

ITEM	PART NO	DESCRIPTION	QTY
1	110DR	BELT ROLLER	1
2	111DR	ROLLER SCRAPER (BELT TENSION ASSY.)	1
3	115DR-A	BELT TENSIONING SWING PLATE	1
4	116DR	BELT ROLLER SHAFT	1
5	F0400FW	FLAT WASHER, 1/4"	8
6	F0400LW	LOCK WASHER, 1/4"	4
7	F0400NLN	NUT, NYLOCK 1/4"	3
8	F0403HHCS	HEX HEAD CAP SCREW 1/4-20 X 3/4"	2
9	F0403SB	BUTTON HEAD, SOCKET 1/4-20 X 3/4" L	3
10	F0404HHCS	HEX HEAD CAP SCREW 1/4-20 X 1"	2

# Pushbutton and E-Stop Parts Breakdown



**Pushbutton and E-Stop Parts List**

ITEM	PART NO	DESCRIPTION	QTY
1	<a href="#">400038</a>	CONTACT BLOCKS, 1 N.C.	4
2	<a href="#">400039</a>	CONTACT BLOCK 1 N.O.	2
3	<a href="#">EL-0409</a>	PUSH BUTTON, RED	2
4	EL-1970-MH	PUSHBUTTON ENCLOSURE	1
5	EL-2007	NAMEPLATE, "BAGEL DIVIDER START (I)"	1
6	EL-2008	NAMEPLATE, "BAGEL FORMER START (I)"	1
7	SS122	NAMEPLATE, "STOP (O)"	2
8	<a href="#">SS184</a>	START BUTTON, GREEN	2
9	<a href="#">SS185</a>	MAINTAINED BUTTON - TWIST TO RELEAS	1
10	<a href="#">SS425</a>	EMERGENCY STOP NAMEPLATE	1

## Electrical Schematics

**The following schematics include diagrams on a 208Vac-230Vac 3PH machine. If your machine is not listed or you have any questions, do not hesitate to contact A.M. Manufacturing's Service department at:**

Monday through Friday, 7AM to 3:30PM (CST)

Phone: [219-472-6417](tel:219-472-6417)

Monday through Friday, 3:30PM to 7AM (CST)

and Saturday or Sunday

Phone: [708-328-3400](tel:708-328-3400)

[support@ammfg.com](mailto:support@ammfg.com)

## Ordering replacement parts

### **IMPORTANT:**

Only use factory supplied replacement parts to maintain machine safety, performance, and sanitary conditions.

Use of non-approved parts may void manufacturer's warranty.

### **TO ORDER REPLACEMENT PARTS ALWAYS:**

1. Check the machine to identify missing, damaged, or non-functional parts including guards, warning labels, and instructions.
2. Compare the list with the parts diagrams supplied.
3. Record the complete model and serial number of the unit.
4. Call A.M. Manufacturing (219) 472-7273 and provide all the information noted above to expedite order processing and help reduce shipping costs.
5. Provide complete details for (ship to) and (bill to) information. To assist prompt delivery, specify the type of carrier speed for shipment.

**AM Manufacturing accepts Visa, Mastercard, and American Express.**

