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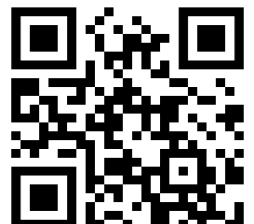
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S302

DOUGH DIVIDER AND ROUNDER
OPERATIONS & SAFETY MANUAL

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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 Scale-O-Matic dough divider, model S302, is designed to give you optimum time and labor-saving service with a speed of approximately 2000 pieces per hour. The S302 can accurately scale from 1 oz. To $32 \pm \frac{1}{4}$ oz depending on the proper attachments. New and current employees can be taught to operate this machine efficiently and safely in a short period of time. 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.

LENGTH	5'-3 1/4"
WIDTH	2'-5 1/2"
HEIGHT	5'-8 1/2"
HEIGHT (STANDARD HOPPER – LID OPEN)	6'-4 1/4"
HEIGHT (EXTENDED HOPPER – LID OPEN)	7'-4 3/4"

VOLTAGES:

- 3 PHASE, 208 - 230 VOLTS (STANDARD)
- 3 PHASE, 380 – 480 VOLTS
- SINGLE PHASE, 208/220 VOLT (OPTIONAL)
- VARIABLE SPEED DIVIDER (OPTIONAL)

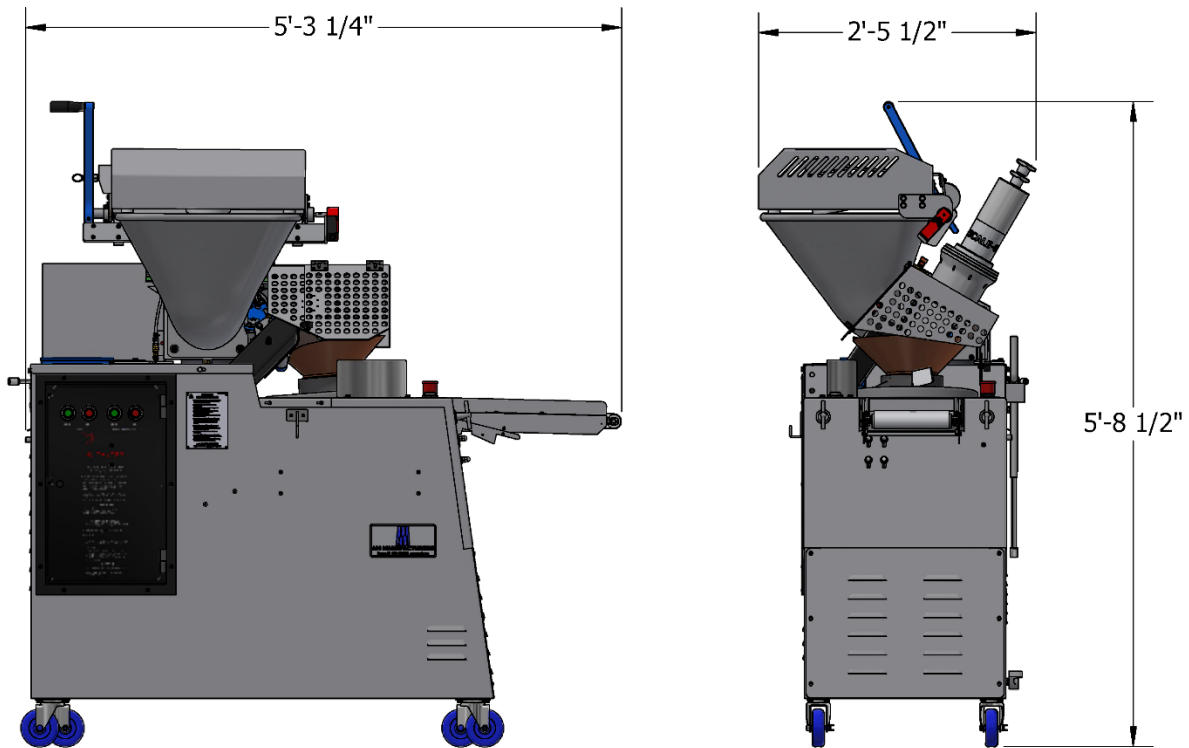


Figure 1: Specifications

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

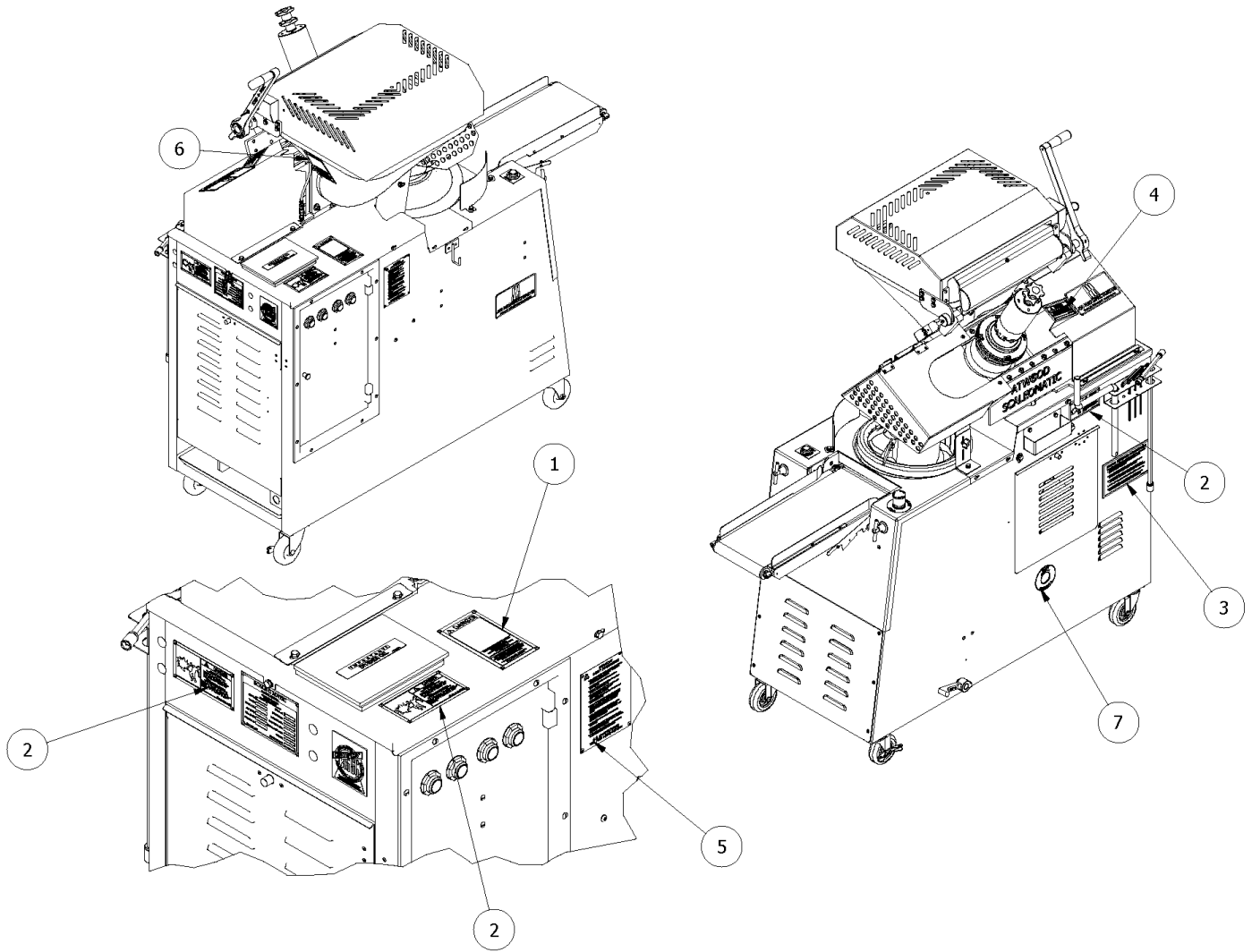


Figure 2: Warning Label Locations

Warning Labels Typically Found on the S302

1) AMTAG#27MF:

LOCATED ON TOP OF THE CABINET



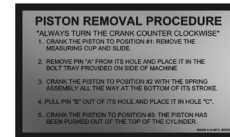
2) AMTAG10AMF:

LOCATED REAR, TOP, & LEFT SIDE



3) AMTAG203S:

LOCATED ON THE LEFT SIDE OF THE CABINET



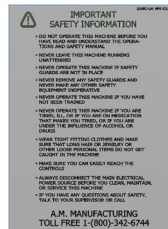
4) TAG11M:

ON THE ROCKER ARM COVER



5) TAG21S:

ON RIGHT SIDE OF CABINET



6) TAG27SF:

ON RIGHT SIDE OF CABINET



7) TAG202S:

ON LEFT SIDE OF CABINET



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 S302 in the desired location and lock the two locking casters with their levers.
3. Plug the power cord into the proper outlet.
4. Push the green Divider Start Push-button to turn the machine on.
5. Check rotation of the divider by looking through small inspection door. The large gear should be turning clockwise.
NOTE: If the Machine is turning counterclockwise, contact a professionally trained electrician.
6. Check power supply to rounder and discharge conveyor by pressing the start button labeled “conveyor / rounder” on the control panel. The rounding drum should be turning in a counterclockwise rotation, and the discharge conveyor should be running forward, out from machine.

Operation Procedures

1. Fill the oil reservoir with lightweight mineral oil. Make sure to clean any oil spilled around machine. These surfaces become slippery.
2. With the squirt bottle supplied, apply a small amount of mineral oil to the inside sides of the dough hopper. The hopper should be oiled every time you place new dough in it.
3. Open the valve located on the top gib bar approximately 1/8 of a turn.
4. Remove back cabinet door.
5. Fill the hopper with dough by loading with pieces not exceeding 20 pounds. Dough pieces above 20 pounds could cause serious lower back injury.
6. Close hopper cover, pull the spring pin, and set the hopper paddle on top of the dough.
7. Press the Conveyor / Rounder start button.
8. Press the Divider Button

Dough Dividing

1. Dough is portioned by the measuring cup, which is bolted to the divider slide.
2. To adjust the weight, stop machine. Turning the measuring cup handle in a counterclockwise motion causes the dough weight to increase. Turning the handle in a clockwise motion decreases the dough weight.
3. Find your desired dough weight by weighing the dough piece.
4. Once you have achieved this, adjust the locking star knob (529ms-2d) to the top of the measuring cup to keep scaling accurate.
5. Note the number position on the star knob stud. This can be referenced in the future when setting back up for the same dough weight.

General Overview of the S302

The S302 machine has various components that are important to familiarize yourself with to effectively operate, maintain, and clean your machine.

General Components

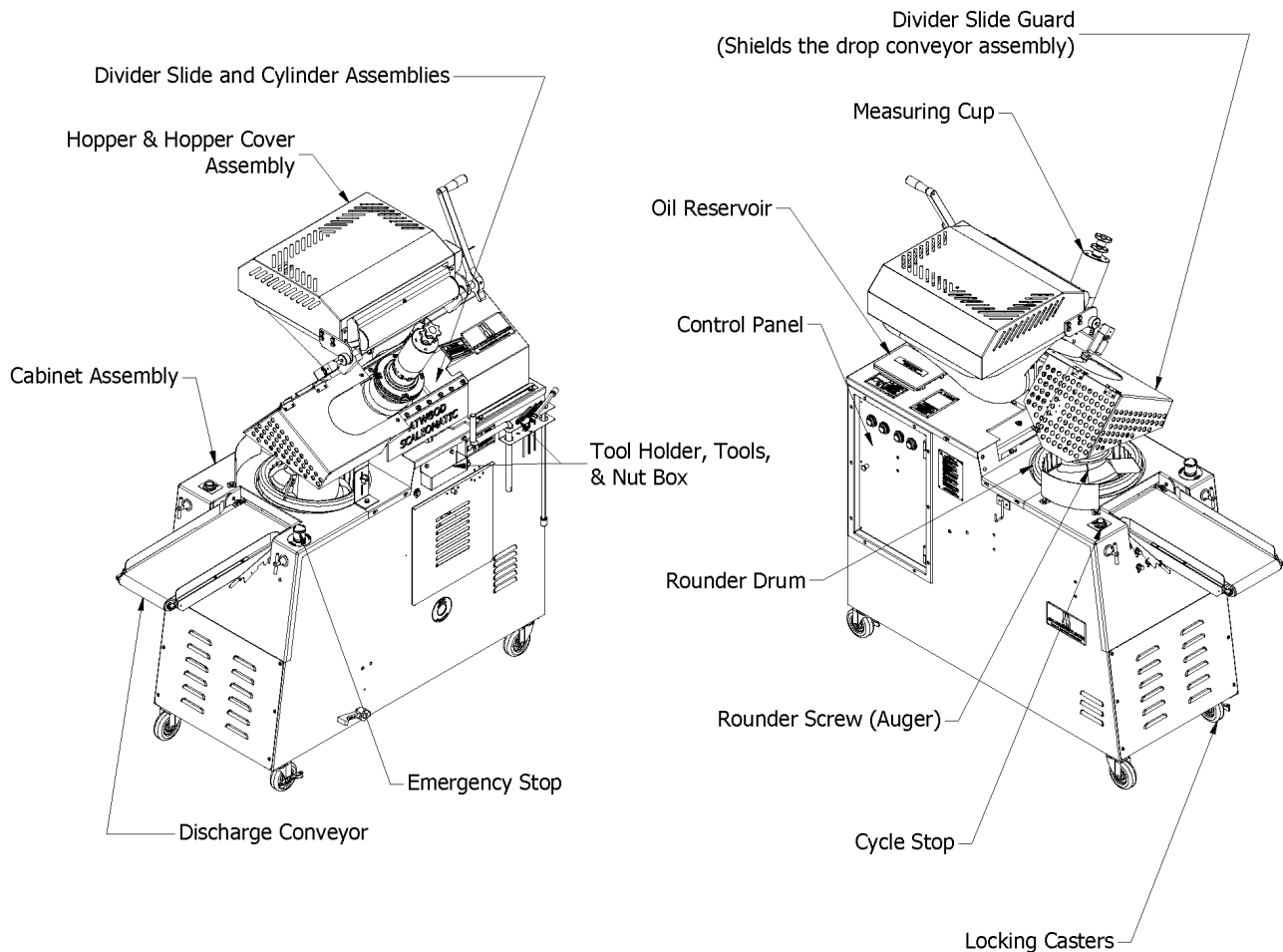


Figure 3: S302 Overview

Divider Slide and Cylinder Assemblies

- The divider slide and Cylinder Assemblies are the core components of the S302 that allows the machine to scale.
- The Divider Cylinder has a metal scraper ring and O-Ring which sits on top where the divider slide rides.
 - These two rings are wearable components that are vital to machine scaling and suction.
- Within the cylinder is the piston assembly. This helps to create suction and push the dough up towards the measuring cup.
 - The piston contains a piston cup and O-ring, which is vital to the machine's scaling and suction.

Hopper & Hopper Cover Assembly

- This is the assembly where dough chunks are fed and pushed down towards the cylinder.

Cabinet Assembly

- Includes the doors and accessible areas for maintaining, cleaning, and accessing various components in the machine.
- Equipped with safety sensors to allow for machine shut off in the event a door or guard is removed during operation.

Tool Holder, Tools, & Nut Box

- The S302 comes with various T-handle Allen wrenches, a T shaped socket assembly, and a crank handle.
- The nut box allows for easy storage of nuts and bolts removed during disassembly for cleaning or maintenance.

Discharge Conveyor

- The discharge conveyor allows dough to leave the machine after the dough balls are guided out of the rounder.

Divider Slide Guard

- Guards the area around the divider slide to prevent injury.
- Covers the small conveyor (drop conveyor) assembly.
 - This drop conveyor assembly drops the divided dough into the dough rounder.

Measuring Cup

- Allows for adjustment of dough weight.

Oil Reservoir

- Where oil is added and distributed by an oil pump to the machine.

Rounder Drum & Rounder Screw

- This area allows for dough to drop into a funnel where it lands in the bottom of the rounder screw.
- Dough is then carried up through the outside of the screw by the drums rotation while being rounded.

Locking Casters

- These casters lock in place so the machine cannot roll away.

Pushbutton Controls



Figure 4: Control Panel

Control Panel

- The control panel, pictured above, includes the pushbuttons used to operate the machine.
 - The left side green pushbutton above the “Divider” text will start the divider portion of the machine.
 - The left side red pushbutton above the “Divider” text will stop the divider portion of the machine.
 - The right-side green pushbutton above the “Conveyor/Rounder” text will start the rounder and conveyor portion of the machine.
 - The right-side red pushbutton above the “Conveyor/Rounder” text will stop the rounder and conveyor portion of the machine.

The Emergency Stop

- On the top left corner, when facing the back of the machine, is the Emergency Stop button.
- This button allows for a quick stop of the machine in case of emergency.

General Cleaning Instructions

⚠ WARNING: Before attempting to clean the S302, 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 S302 is essential to ensure sanitary conditions and proper machine function. Regular cleaning will extend the life of various components within the machine.

General Cleaning

- The drip pan below the machine should be emptied and cleaned off daily.
- The front of the cylinder has a Scale-O-Matic name plate that allows excess oil to drain to the drip pan.
 - This plate can be removed by loosening the small Allen head bolt in the center of the plate.
 - Regularly clean out the channels on this plate and ensure it is free of any sediment so oil can continue to drain properly.
- Wipe excess dough from the inside of the dough hopper.
 - **NOTE: Never use a metal edges scraper for cleaning any part. These tools can result in damage to coatings and parts.**
- The inside of the divider should be cleaned out occasionally.
 - Remove any buildup around the main drive gear (Part # [S0113CD](#)) inside the machine.
 - Remove any build up around the bronze shoe (Part # [448CD](#)) that the main drive gear sits inside of.

Divider Cleaning and Disassembly

1. **Shut off and disconnect all power to the machine.**
2. Remove the cover over the drive end of the slide above the rocker arm. Slide back to remove it.

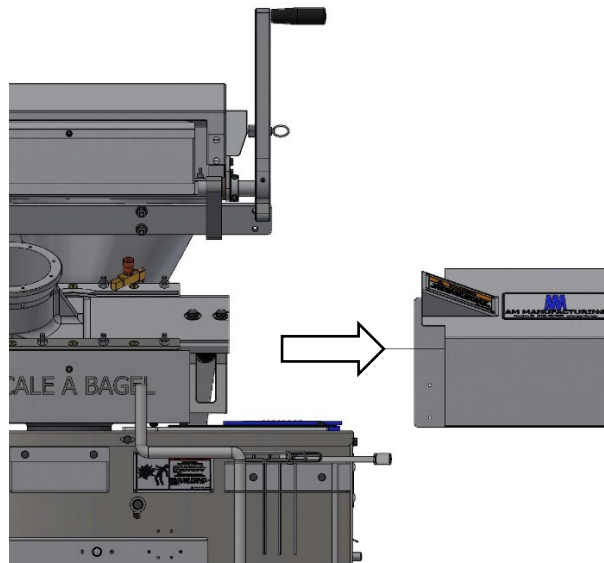


Figure 5: Rocker Arm Cover Removal

3. Break loose the 4 socket screws at the top of the measuring cup on the divider slide. Twist and pull to remove the cup.

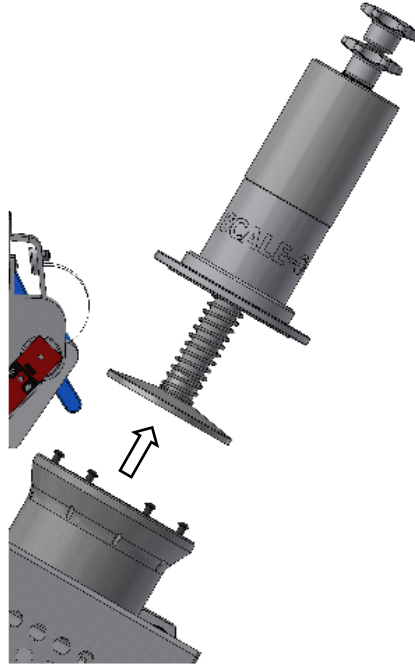


Figure 6: Measuring Cup Removal

4. Remove the measuring cup and clean.
5. Remove and clean the measuring cup insert, if the plunger at the bottom of the measuring cup is 5" in diameter, there will be no insert to remove.
6. Loosen the 8 hex head nuts at the top of the gib bars (the bars on the top and bottom of the slide which the divider slide rides against). Two of the nuts are holding the divider slide guard.
7. Remove the divider slide guard that is above the rounder screw by removing the wing nut and lifting it up and out.
8. Remove the gib bar assemblies by lifting them off the cylinder studs. Clean any dough residue from them.
9. Remove the divider slide by lifting it up and out. Clean thoroughly.

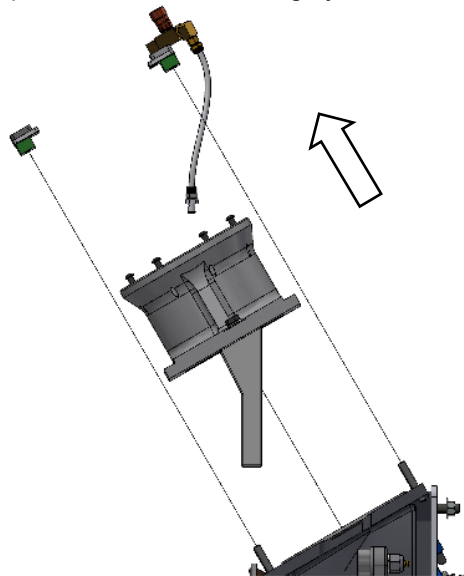


Figure 7: Divider Slide Removal

10. Remove the side door on the left-hand side of the machine when facing the rear of the machine. This uncovers the hole where the crank handle enters.

Removing the Piston

Be sure to gain familiarity with the parts in the diagram below prior to removing the piston for cleaning or maintenance.

- **Only rotate the crank handle (Figure 8, 1) counterclockwise.**
- The arrows are painted white, alongside their respective numbers, and the signal which position the main drive gear (Figure 8, 9) is in. When the arrow is pointing down towards the crank handle, the main drive gear is in that position.
 - For example, **Figure 8** below is in position 1.

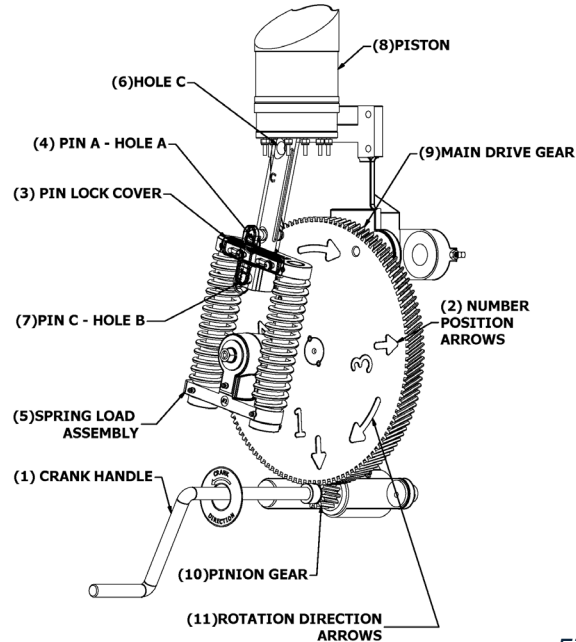


Figure 8: Piston Parts

Follow the steps below to remove the piston:

1. Insert the Crank Handle (Figure 8, 1) into the hole on the side of the cabinet where the crank direction sticker is located.
2. Remove the measuring cup and the divider slide from the top of the machine.
3. Turn the Crank Handle counterclockwise until the gear is in the 1 position as shown in Figure 8.
4. Loosen the two bolts on the Pin Lock Cover (Figure 8, 3) so it can slide to the right, revealing the pins behind the cover.
5. Remove Pin A (Figure 8, 4) from the assembly and place in the bolt tray attached to the outside of the cabinet.
6. Continue to rotate the Crank Handle counterclockwise until the Spring Load Assembly (Figure 8, 5) is at its lowest position with the rod above extended. This will reveal hole C (Figure 8, 6)
7. Remove Pin B from Hole B, and insert it into Hole C (Figure 9).
8. Continue to crank counterclockwise until the Piston has been pushed out of the top of the machine, allowing it's removal.

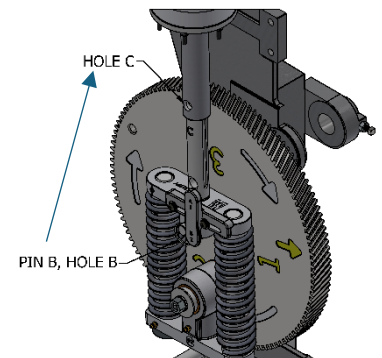


Figure 9: Pin B to Hole C

NOTE: The prior steps are only to be done after following the steps on the previous page.

The steps prior highlight the procedure to remove the piston for cleaning and maintenance.

- Ensure that any excess dough is removed from face of the cylinder and that the scraper ring and O-ring that were removed in Step 7 (Figure 8 above) have been cleaned.
- Ensure that any dough residue has been cleaned from the inside and outside of the dough cylinder.
 - Make sure to clean out the hole where the oil valve feeds inside the cylinder.
- Clean all surfaces around the piston from dough.

Reinstalling the Piston

1. Replace the piston.
 - a. Ensure the piston is in an extended position with the pin in the upper hole.
 - b. Put the piston into the cylinder, guiding the shaft into the spring assembly.
 - ⚠ WARNING: ENSURE THAT THE PISTONS ANGLED FACE IS FACING YOU, PUTTING THE PISTON IN BACKWARDS WILL DAMAGE IT WHEN THE MACHINE IS IN OPERATION.**
 - c. Take the other pin and put it in the lower hole through the spring assembly.
 - d. Rotate the crank until the upper pin is visible and remove it.
 - e. Turn the crank until the shaft collapses and the two upper holes meet, then insert the pin.
 - f. Push the “plus sign” shaped pin lock slide over and tighten the 2 socket head bolts.
 - g. **Verify that the piston collapses by making one full rotation with the crank and note that the piston does not come above the upper cylinder. If the piston is backwards, it could be destroyed during operation.**
2. Place the divider slide back on top and bolt the cam arm slide back to the divider slide.
3. Reinstall the Gib Bars with the 8 hex nuts.
4. Reinsert the measuring cup and cup insert (if applicable). Turn the cup and tighten the 4 bolts to lock in place.
 - ⚠ WARNING: Failure to reinstall the insert on measuring cups where it is required will result in damage.**
5. Remove the hand crank.

Rounder Cleaning

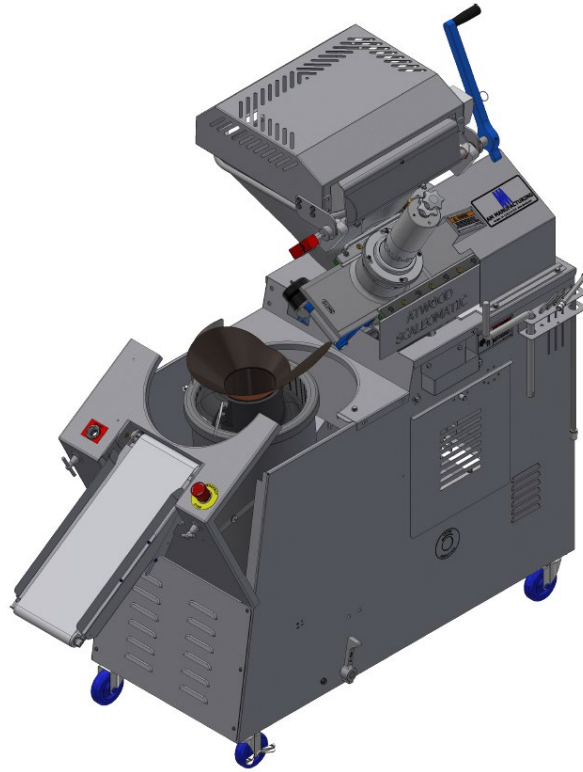


Figure 10: Rounder Cleaning

1. **Shut off and disconnect all power to the machine.**
2. Remove the divider slide guard by loosening the 2 hex head nuts, assuming the guard is not already removed.
3. Twist the two T-handles to unlock the front guarding. Pull forward to allow it to tilt on its hinges.
4. Lower the handle on the bottom left side that has the smaller door, this unlocks the rounder assembly to and allows it to tilt forward.
5. Remove the funnel that sits on top of the rounder screw.
6. Remove and clean the rounder screw. Do not drop or bump it as this can cause burrs or damages to the coating.
 - a. The rounder screw should be cleaned with warm water and a non-abrasive pad. Remove all dried dough. Dry completely.
7. Remove and clean the rounder drum.
 - a. The rounder screw should be cleaned with warm water and a non-abrasive pad. Remove all dried dough.
8. Remove the plastic seal ring and clean any excess dough from the rounder base below it.
9. Allow all parts to dry.
10. Reassemble the parts the same way they were disassembled.
11. Ensure the rounder drum is inserted with the slots over the pins.
12. Check that the exit ramp on the rounder screw is facing the discharge end of the machine.
13. Tilt the rounder assembly backward and lock back in place.
14. Tilt the front of the cabinet back in place and lock with the T handles.
15. Wipe dough from the conveyor belt and areas around the rounder.

NOTES:

- **All parts and areas mentioned must be cleaned every day.**
- **When cleaning the rounder drum, the water temperature must not exceed 190°**

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 the S302, 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.

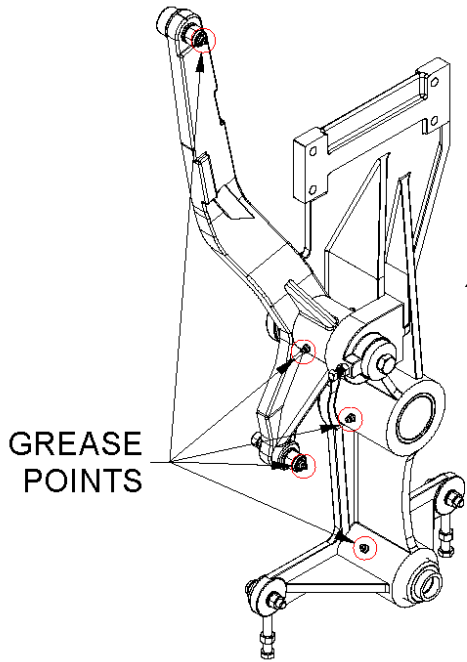
- All working surfaces should be cleaned regularly.
- The cabinet and other working surfaces should be cleaned regularly.
- Make sure that all fasteners are tightened securely.
- Make certain that all guards and covers are in place.
- Check for worn, damaged or missing parts including belts, safety guards 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 the Scale-O-Matic S302 always begins with keeping the machine clean. Proper cleaning procedures start on pages 15 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.



There are 5 grease fittings located on the rocker arm and divider frame:

- 1 on the cam roller at the top of the rocker arm.
- 1 on the cam shoe bolt at the bottom of the rocker arm.
- 3 total on the bronze bearing locations on the rocker arm and main frame.

The piston and spring load assembly, pictured on the right, have a total of 4 grease fittings.

- Three of these fittings are found on the lower casting of the spring load.
 - Apply a small amount of grease to these fittings once a week.
- The same procedure should be followed for the grease fitting under the piston at the top of the figure on the right.
 - This fitting will require a flexible hose grease gun or removal of the piston to access.

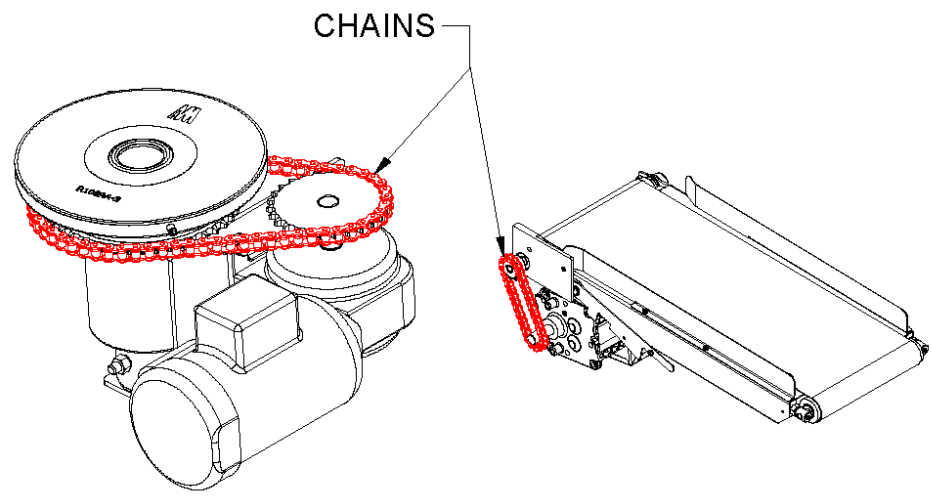
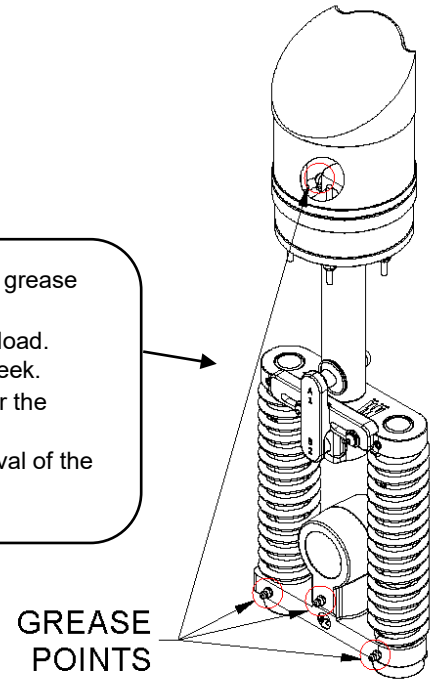


Figure 11: Grease Points

Adjusting the Measuring Cup Depth

Following any disassembly of the Measuring Cup assembly, the measuring cup must be properly set. Setting the measuring cup means adjusting the distance of the bottom of the plunger base. Setting the Measuring Cup allows for the Cup and the Divider Slide to slide freely. **The depth of the measuring cup will need to be adjusted any time the cup is disassembled, or a component is replaced.**

⚠ CAUTION: Failure to properly set the Measuring Cup will result in damaged components!

The instructions below are assuming the cup is already partially disassembled.

To adjust the depth of the plunger on the Measuring Cup Assembly:

1. Set the measuring cup components on a flat surface.
2. Remove the divider slide and place it on a flat surface with the other components.
3. Loosen the $\frac{3}{4}$ " long socket head bolt from the slot nut on the measuring cup.
4. Place the measuring cup on the divider slide.
5. Turn the slot nut to the right to bring the plunger base up, or to the left to bring it down.
6. Feel beneath the divider slide and adjust until there is about a $\frac{1}{16}$ th inch space from the bottom of the slide to the bottom of the plunger base inside the slide.
 - The gap allows it to avoid wear or damage when the slide is traveling.
7. After the slot nut is adjusted to where there is adequate depth, reinstall the $\frac{3}{4}$ " long socket head bolt.
 - Apply blue thread locker to the bolt and tighten down all the way so the slot nut can lock onto the thread.
8. Reassemble the Measuring Cup Assembly.

NOTES:

- The diagram shown is for a 5" diameter plunger base, which does not use a divider cylinder insert.
- For measuring cups 1-1/2" (Part # [AMS1](#)), 2" (Part # [AMS2](#)), and 3-1/4" (Part # [AMS3](#)):
 - Adjust the plunger to be flush with the bottom of the divider cylinder insert (Figure 11) that sits inside the divider slide.
 - **The divider cylinder insert must be placed into the divider slide before operation.**

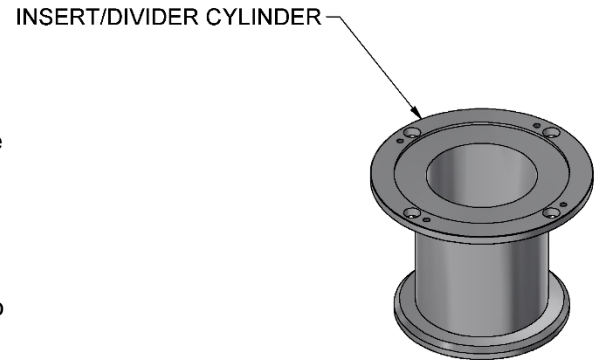


Figure 12: Insert/Divider Cylinder

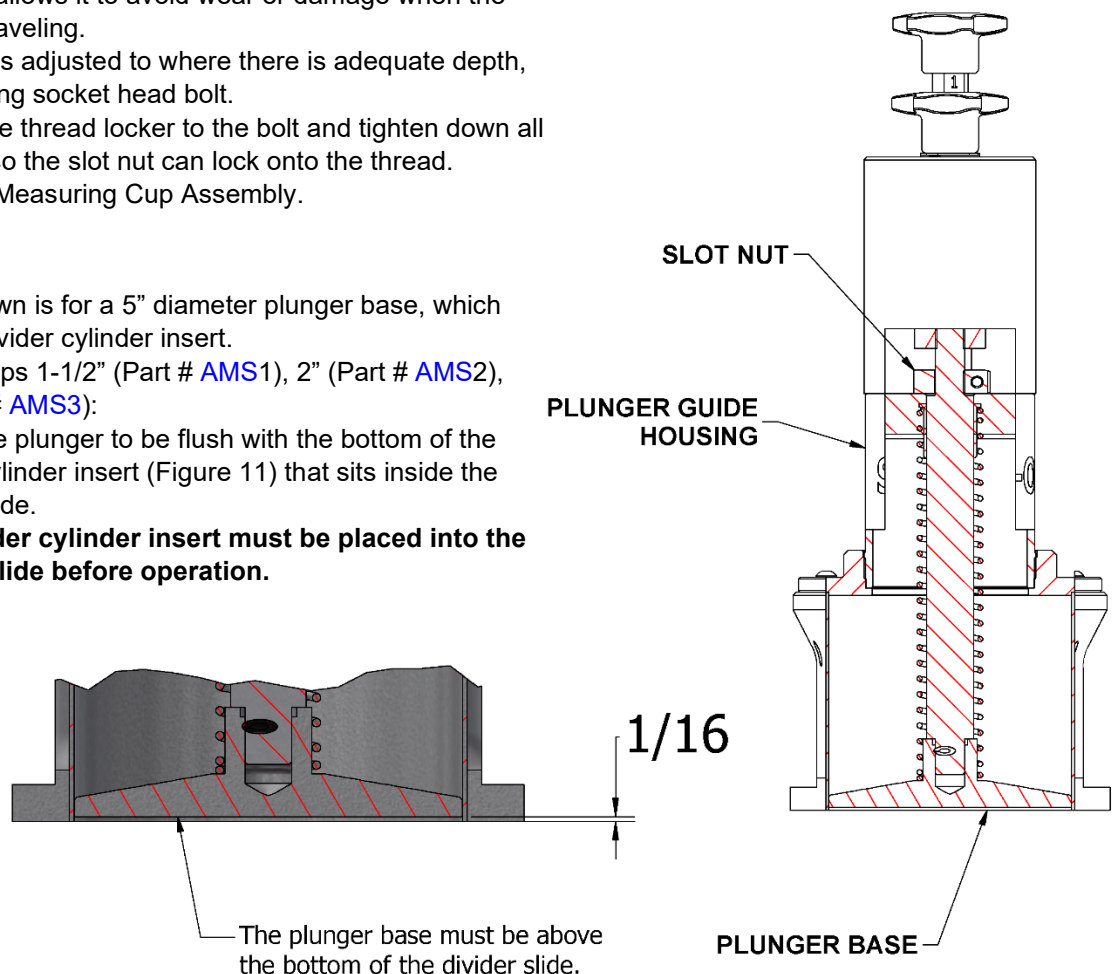


Figure 13: Measuring Cup Depth

Basic Trouble Shooting Guide

Issue	Probable Cause	Solution
Loss of suction.	Wear within the scaling area of the divider.	Replace the Cylinder Scraper Ring, Cylinder O-Ring, Piston Cup, Piston O-Ring. If problem persists, contact manufacturer. *See notes below*
Noise from bottom of the machine	Bearing wear, motor/gearbox issues	Remove the chain and run the machine. If noise persists, inspect the motor and gearbox. If noise stops, inspect the bearings within the rounder base and replace if necessary.
Uneven drum wear	Bearing wear	Inspect the bearings and replace them if necessary.
Rounder Screw Assembly Stuck	Lack of cleaning causing dough to harden and glue the post of the screw into the rounder base.	If freshly stuck, add a small amount of water to the area where the screw inserts into the base. If this does not loosen it, call AM Manufacturing at the number provided below.
Rounder Base Assembly Stuck	Lack of cleaning causing dough to harden and glue the spindle of the rounder base into the frame.	Call AM Manufacturing at the number provided below.
Rounder Drum Notches Broken	Dropping the rounder drum into the machine or not locking the drum in place prior to operation.	Replace rounder drum.
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.
Individual motor does not run	Bad circuit breakers, bad motor.	Check the circuit breakers. Replace motor if necessary.

Note: The following items may cause suction problems after excessive wear or incorrect adjustment.

- The Cylinder Scraper Ring, Cylinder O-Ring, Piston Cup, Piston O-Ring.
- The wear strips and components that make up the gib bars that sit on the divider slide. These are held on by the eight cylinder studs.
- The measuring cup plunger.

AM Manufacturing Service Department Contact Information

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

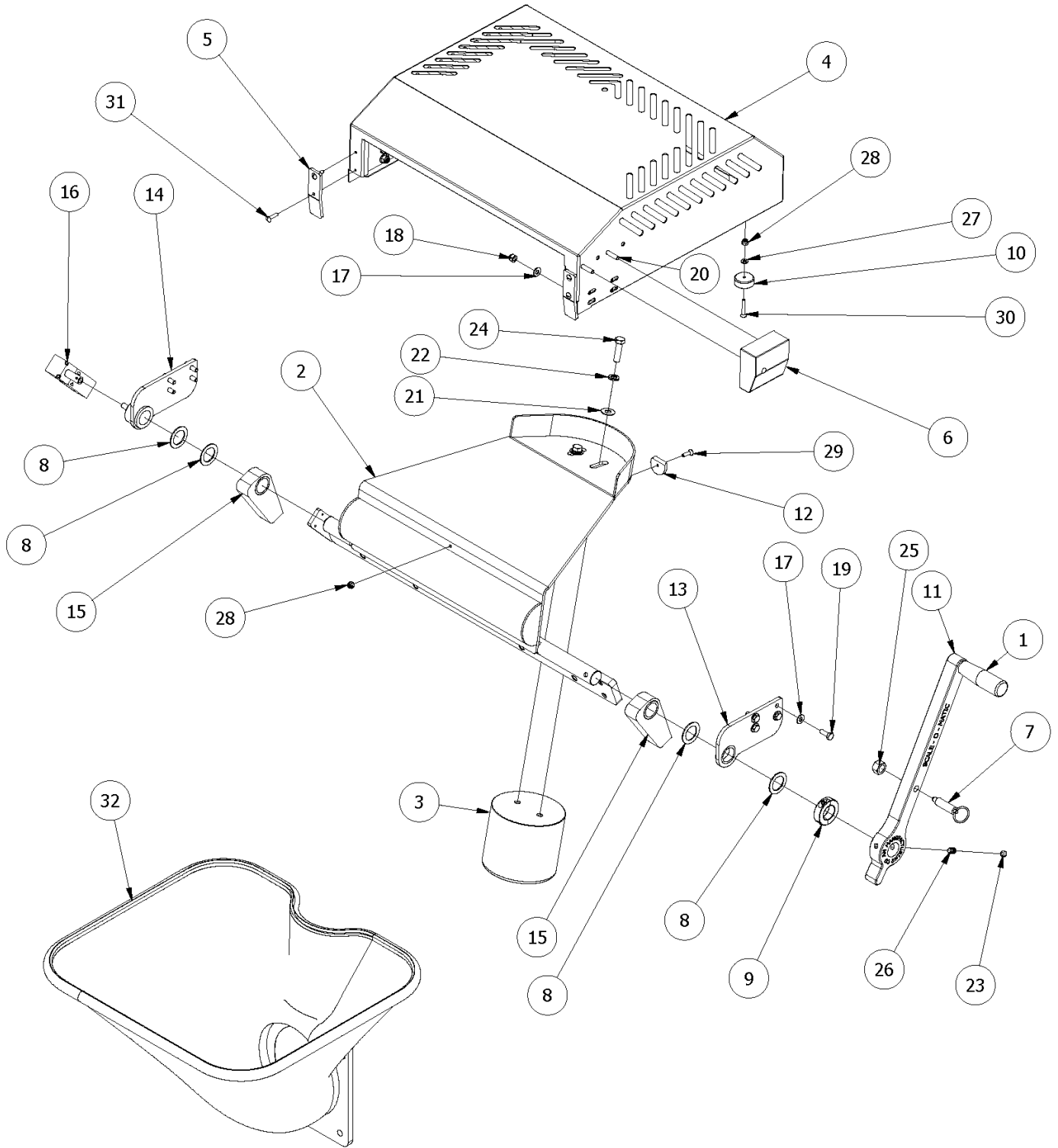
Phone: [708-328-3400](tel:708-328-3400)

support@ammfg.com

Parts Catalogue



Standard Hopper Cover Assembly Parts Breakdown



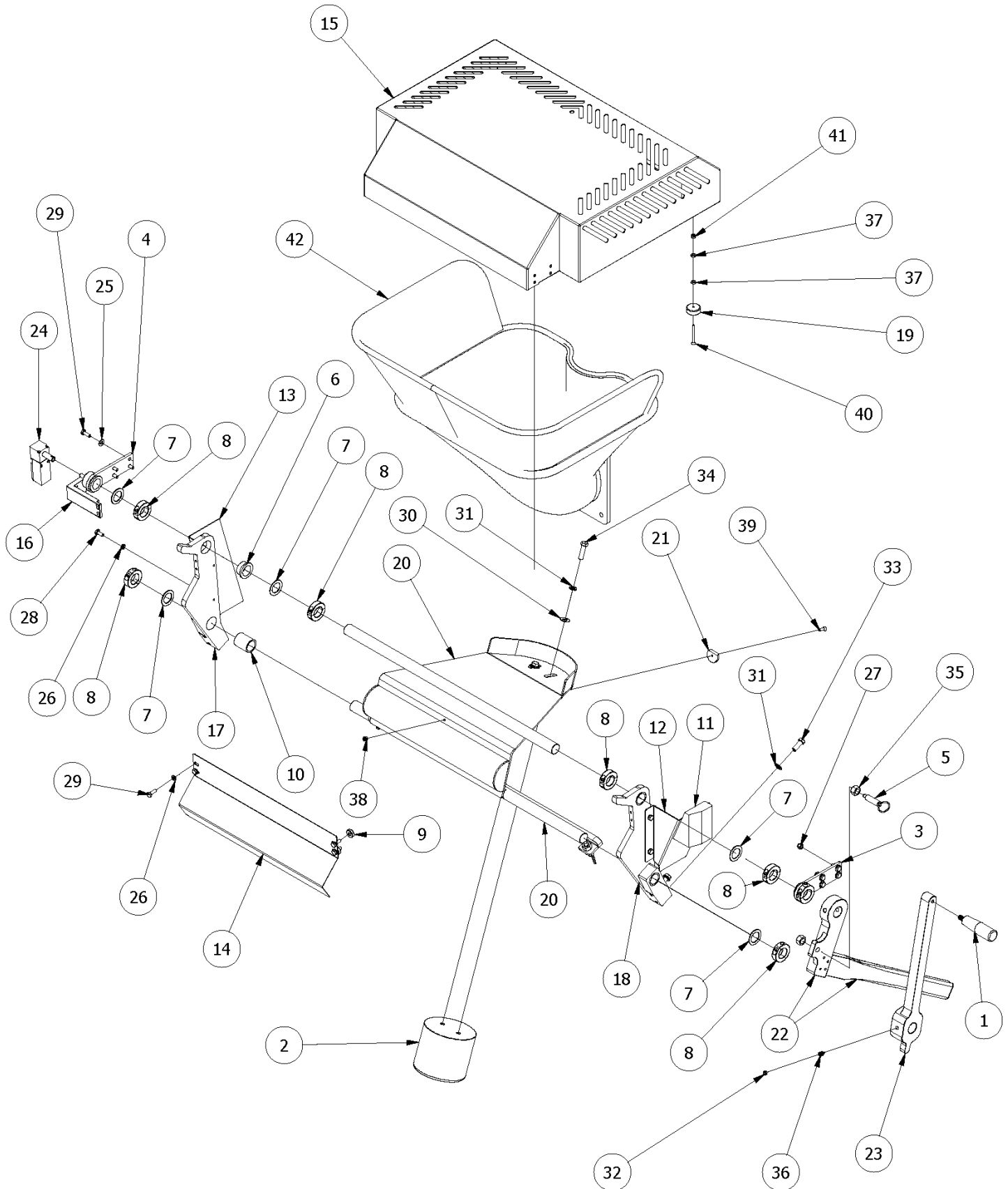
Standard Hopper Cover Assembly Parts List

ITEM	PART NO	DESCRIPTION	QTY
1	11467	Easy-Turn Revolving Handle 3/8"-16	1
2	17827	DOUGH FEED PLATE ASSEMBLY	1
3	17833B	SAFETY COVER PLASTIC DOUGH PLUNGER	1
4	17834	HOPPER SAFETY COVER	1
5	17834-4	HOPPER SAFETY COVER STOP	2
6	19475	SAFETY COVER PIVOT LOCK BLOCK	1
7	20432	SPRING PLUNGER (1/2-13) S.S.	1
8	20615	NYLON WASHER	4
9	20616	1" S.S. SPLIT SHAFT COLLAR (2 PIECE)	1
10	20671	HOPPER COVER BUMPER	2
11	22850	SAFETY COVER & DOUGH PADDLE HANDLE	1
12	27061	DOUGH FEED PLATE BUMPER	1
13	34530-L	HOPPER SAFETY COVER HINGE LS	1
14	34530-R	HOPPER SAFETY COVER HINGE RS	1
15	A17828	HOPPER HINGE ASSEMBLY W/ BUSHING	2
16	EL-1320	SAFETY SWITCH - ROTARY HINGE - 2NC	1
17	F0400FW	FLAT WASHER, 1/4"	16
18	F0400NLN	NUT, NYLOCK 1/4"	8
19	F0403HHCS	HEX HEAD CAP SCREW 1/4-20 X 3/4"	8
20	F0404SB	BUTTON HEAD, SOCKET 1/4-20 X 1" LG	2
21	F0600FW	FLAT WASHER 3/8"	2
22	F0600LW	LOCK WASHER 3/8"	2
23	F0601SS	3/8-16 S.S. SET SCREW 1/4" LONG	2
24	F0605.5HHCS	HEX HEAD CAP SCREW 3/8-16 X 1-3/8"	2
25	F0800NC	NUT COURSE, 1/2-13	1
26	F0802DPSS	SET SCREW (3/8-16 X 1/2" LONG) w/ DOGPOINT	2
27	F9800FW	FLAT WASHER #10	2
28	F9800NLN	NYLOCK NUT, #10 (10-24)	3
29	F9803FSH	10-24 X3/4" LONG FLAT SOCK HEAD SCR	1
30	F9804FSH	10-24X1LG FLAT SOCKET HEAD	2
31	F9903TH	10-32 X 3/4" LONG TRUSS HEAD	4
32	445CD	STANDARD HOPPER	1

NOTES:

- When ordering 34530-L and 34530-R, the hopper cover hinges, check the style used on the machine, 34530-L and 34530-R were introduced in machines starting in January of 2024.
 - If the dimensions are 1-1/2" wide on the rectangular side, order:
 - 17842-L, Hopper Safety Cover Hinge, Left Side.
 - 17842-R, Hopper Safety Cover Hinge, Right side.
 - If the dimensions are 2-1/2" wide on the rectangular side, order:
 - 34530-L, Hopper Safety Cover Hinge, Left Side.
 - 34530-R, Hopper Safety Cover Hinge, Right Side.

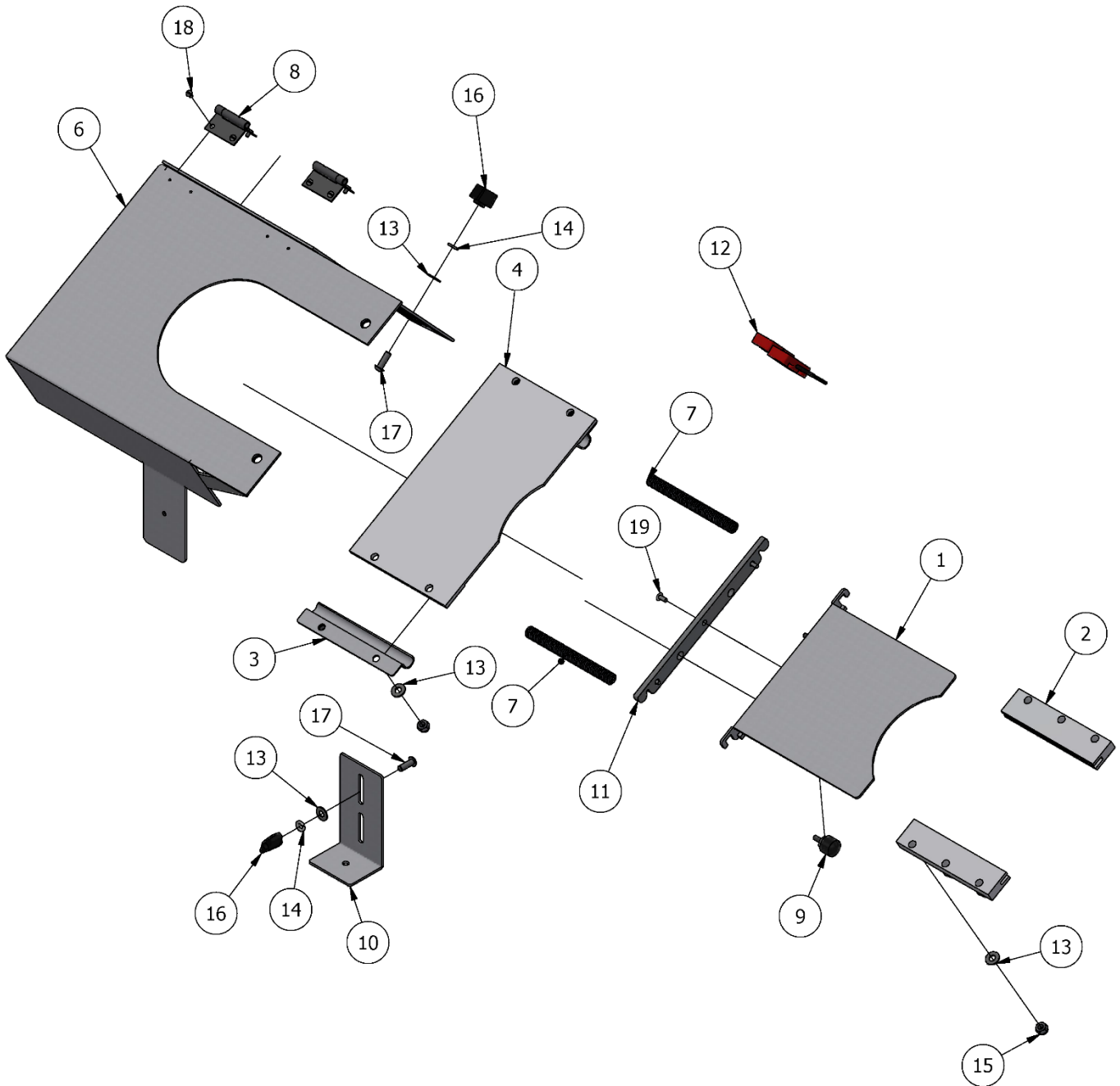
Extended Hopper Cover Parts Breakdown



Extended Hopper Assembly Parts List

ITEM	PART NO	DESCRIPTION	QTY
1	11467	Easy-Turn Revolving Handle 3/8"-16	1
2	17833B	SAFETY COVER PLASTIC DOUGH PLUNGER	1
3	17842-L	HOPPER SAFETY COVER HINGE LS-EXTENDED	1
4	17842-R	HOPPER SAFETY COVER HINGE RS-EXTENDED	1
5	20432	SPRING PLUNGER (1/2-13) S.S.	2
6	20453	FLANGE BUSHING - 1"IDX1.253"ODX3/4"	2
7	20615	NYLON WASHER	6
8	20616	1" S.S. SPLIT SHAFT COLLAR (2 PIECE)	6
9	20645	SPACER - 3/4 OD X 1/4 LG X 9/32 ID	2
10	20649	SLEEVE BUSHING (1.002 ID X 1.253 OD X 1.5" LONG)	2
11	20650	SPRING PIN LOCK BLOCK	1
12	20657	HOPPER GUARD (LEFT SIDE)	1
13	20658	HOPPER GUARD (RIGHT SIDE)	1
14	20661	HOPPER BACK GUARD	1
15	20665	EXTENDED HOPPER SAFETY COVER ASSEMB	1
16	20666	INTERLOCK SWITCH MOUNT BRACKET	1
17	20669	SAFETY COVER HINGE BAR (RIGHT SIDE)	1
18	20670	SAFETY COVER HINGE BAR (LEFT SIDE)	1
19	20671	HOPPER COVER BUMPER	2
20	20810	DOUGH FEED PLATE & SHAFT ASSEMBLY	1
21	27061	DOUGH FEED PLATE BUMPER	1
22	27251	SAFETY COVER HANDLE ASSY.	1
23	28324	SAFETY COVER & PADDLE HANDLE, EXT'D HOPPER	1
24	EL-1320	SAFETY SWITCH - ROTARY HINGE - 2NC	1
25	F0400FW	FLAT WASHER, 1/4"	16
26	F0400LW	LOCK WASHER, 1/4"	8
27	F0400NLN	NUT, NYLOCK 1/4"	8
28	F0402.5HHCS	HEX HEAD CAP SCREW 1/4-20 X 5/8"	4
29	F0403HHCS	HEX HEAD CAP SCREW 1/4-20 X 3/4"	12
30	F0600FW	FLAT WASHER 3/8"	2
31	F0600LW	LOCK WASHER 3/8"	6
32	F0601SS	3/8-16 S.S. SET SCREW 1/4" LONG	2
33	F0604HHCS	HEX HEAD CAP SCREW 3/8-16 X 1"	4
34	F0605.5HHCS	HEX HEAD CAP SCREW 3/8-16 X 1-3/8"	2
35	F0800NC	NUT COURSE, 1/2-13	4
36	F0802DPSS	SET SCREW (3/8-16 X 1/2" LONG) w/ DOGPOINT	2
37	F9800NC	NUT COURSE, #10-24	4
38	F9800NLN	NYLOCK NUT, #10 (10-24)	1
39	F9803FSH	10-24 X3/4" LONG FLAT SOCK HEAD SCR	1
40	F9808FSH	10-24 X 2" LONG FLAT SOCK HEAD SCREW	2
41	F9900NLN	NYLOCK NUT, #10-32	2
42	445CDE	EXTENDED HOPPER	1

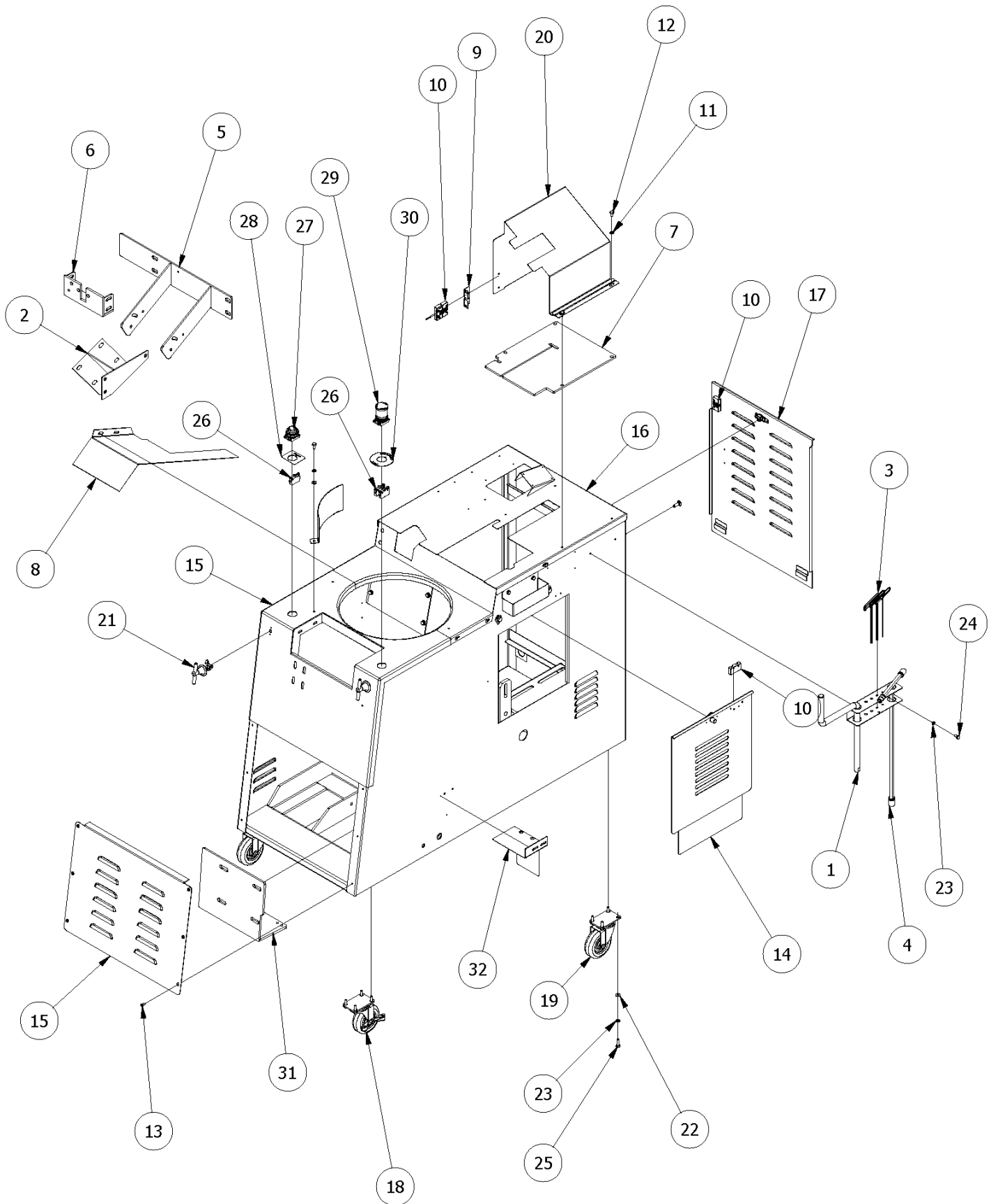
Divider Slide Guard Breakdown



Divider Slide Guard Parts List

ITEM	PART NO	DESCRIPTION	QTY
1	11823	GUARD SLIDE ASSEMBLY	1
2	11824	GUARD SLIDE TRACK	2
3	11825	SPRING RETAINER	2
4	11826	SLIDE SPACER	1
5	11827	GUARD CAGE DOOR	1
6	11828	GUARD CAGE ASSEMBLY	1
7	11830	SPRING 1/2" OD X 5" LG	2
8	11831	HINGES, SS, CONCEALED SPRING	1
9	11832	BUMPER, THREADED STUD W/HEX SHOULDE	2
10	11877	GUARD BRACE #2	1
11	12114	GUARD SLIDE ADAPTER	1
12	EL-1308	SAFETY SWITCH	1
13	F0400FW	FLAT WASHER, 1/4"	12
14	F0400LW	LOCK WASHER, 1/4"	2
15	F0400NLN	NUT, NYLOCK 1/4"	10
16	F0400PWN	1/4 PLASTIC WING NUT	2
17	F0403SB	BUTTON HEAD, SOCKET 1/4-20 X 3/4" L	2
18	F9601FH	Pan Head, Slotted, 6-32 UNC x 0.25	8
19	F9701.5TH	8-32 X 3/8" LONG TRUSS HEAD	3

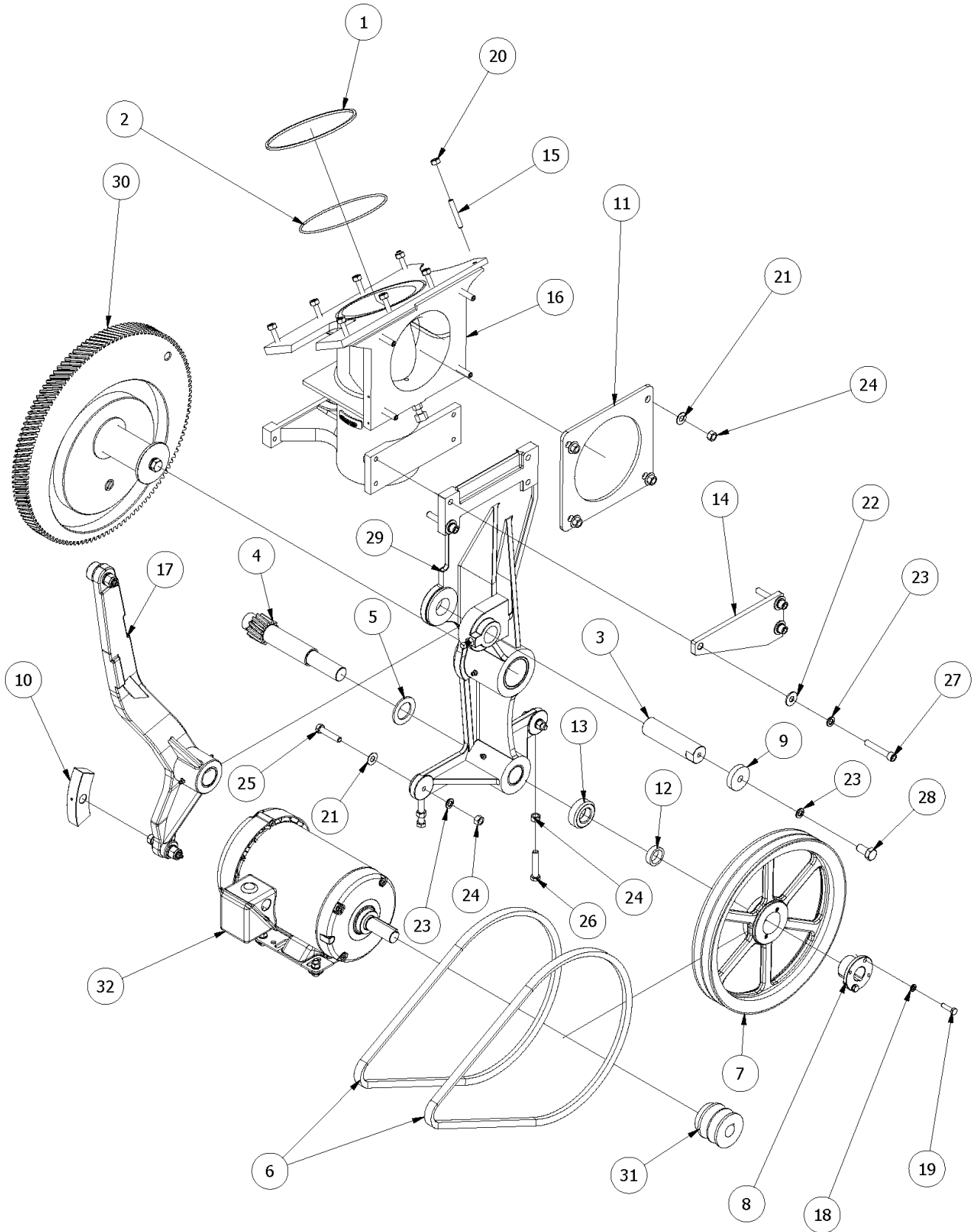
Cabinet Assembly Parts Breakdown



Divider Slide Guard Parts List

ITEM	PART NO	DESCRIPTION	QTY
1	426CD	CRANK HANDLE	1
2	462CD	TAKE-OFF BRACKET WELDMENT ASSEMBLY	1
3	530MSW	ALLEN WRENCH SET	1
4	542MSW-E	"T" HANDLE ASSY.	1
5	605CA1	LARGE PUMP BRKT. WELDMENT ASSEMBLY	1
6	605CA2	OIL PUMP BRACKET (SMALL)	1
7	641CA1	ROCKER ARM COVER GASKET	1
8	643CD	V BELT GUARD	1
9	19968	ROCKER ARM INTERLOCK SWITCH BRACKET	1
10	EL-1308	SAFETY SWITCH	4
11	F0400LW	LOCK WASHER, 1/4"	26
12	F0402HHCS	HEX HEAD CAP SCREW, 1/4-20X1/2" LG.	9
13	F9902PHS	PAN HEAD, SLOTTED,10-32X1/2"LG	6
14	11810	FRONT CABINET DOOR ASSEMBLY (NEW STYLE)	1
15	652CA	ROUNDER COVER FRONT HINGE ASSEMBLY	1
16	602CA	CABINET TOP COVER	1
17	615CA	REAR CABINET DOOR	1
18	621CA1	CASTER, LOCKING 4" DIA	2
19	621CA2	CASTER, SWIVEL 4" DIA	2
20	641CA	ROCKER ARM COVER ASSEMBLY	1
21	646CA3	T- HANDLE DOOR LOCK	2
22	F0400FW	FLAT WASHER, 1/4"	16
23	F0400LW	LOCK WASHER, 1/4"	20
24	F0402HHCS	HEX HEAD CAP SCREW, 1/4-20X1/2" LG.	4
25	F0404HHCS	HEX HEAD CAP SCREW 1/4-20 X 1"	16
26	400038	CONTACT BLOCKS, 1 N.C.	3
27	EL-0409	PUSH BUTTON, RED	1
28	SS126	STOP CYCLE NAMEPLATE	1
29	SS185	MAINTAINED BUTTON - TWIST TO RELEAS	1
30	SS425	EMERGENCY STOP NAMEPLATE	1
31	SR139RA	PIVOT BASE	1
32	SR141RA	PIVOT BASE GUARD ASSEMBLY	1

Main Drive Assembly Parts Breakdown

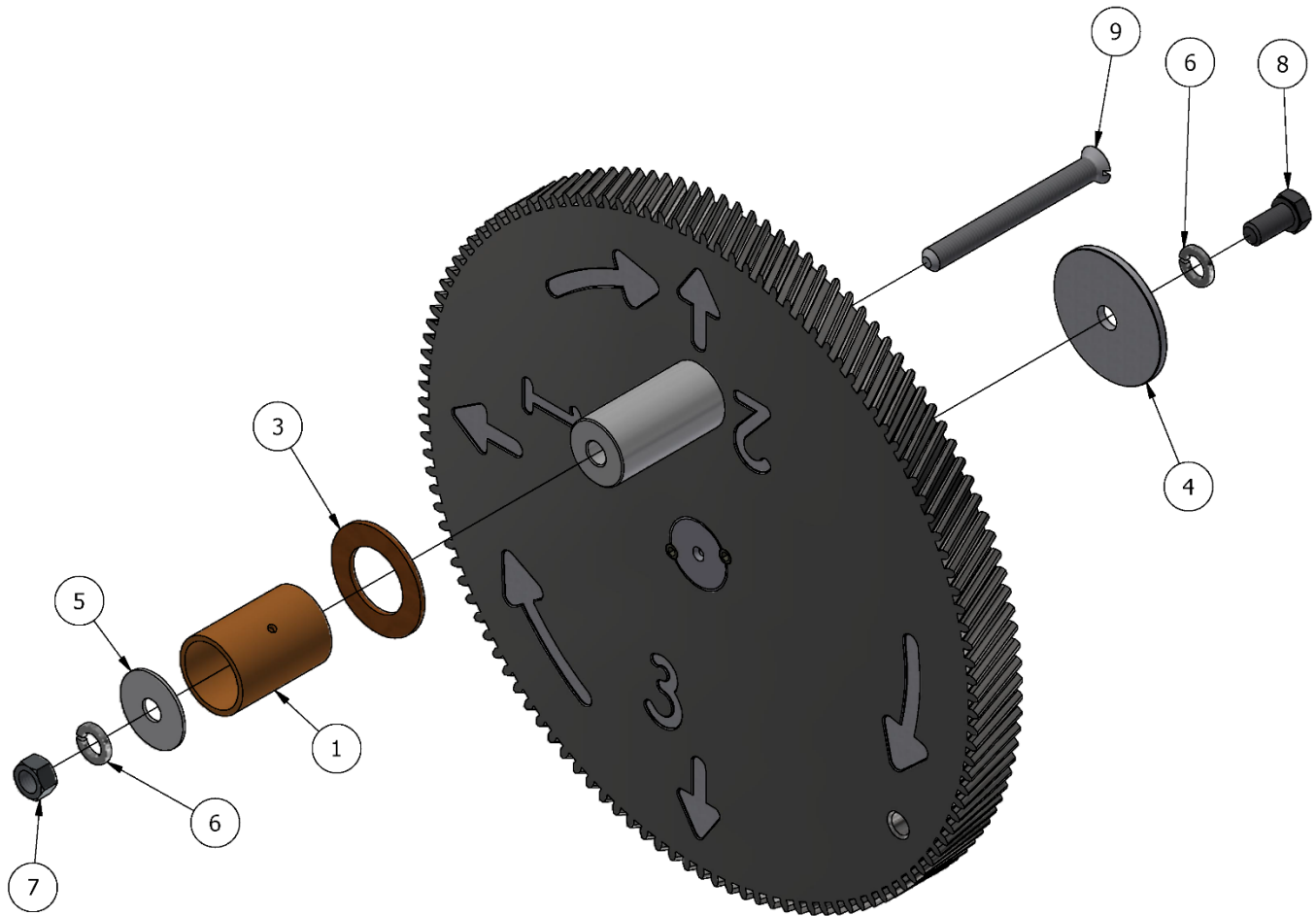


Main Drive Assembly Parts List

ITEM	PART NO	DESCRIPTION	QTY
1	401CD	SCRAPER RING	1
2	402CD	CYLINDER SLIDE "O" RING	1
3	412CD	CAM ARM PIN	1
4	415CD-H	PINION DRIVE GEAR (HELIX)	1
5	416CD	BRONZE SPACER WASHER, 1-1/4 ID	1
6	434CD49	"V" BELT 49"	2
7	435CDA	DRIVE PULLEY (DOUBLE GROOVE)	1
8	436CD	H BUSHING (1" BORE)	1
9	442CD	WASHER, STEEL, 1-3/4 X 3/8	1
10	448CD	BRONZE SHOE	1
11	449CD	HOPPER GASKET	1
12	464CD	SPACER	1
13	465CD	THRUST BEARING	1
14	29287	MOTOR SPACER (DROP CONVEYOR)	1
15	F0508SD	5/16-18 X 2 LG THRD, S.S.	8
16	AS0107CD	CYLINDER ASSEMBLY (STUDS & NUTS INCLUDED)	1
17	AS0110CD	ROCKER ARM ASSY *SEE PAGE 37 FOR PARTS*	1
18	F0400LW	LOCK WASHER, 1/4"	26
19	F0404HHCS	HEX HEAD CAP SCREW 1/4-20 X 1"	2
20	F0500HNC	5/16" HEX NUT, HVY DUTY SS	8
21	F0600FW	FLAT WASHER 3/8"	6
22	F0600FW-Large	FLAT WASHER 3/8" (LARGE)	6
23	F0600LW	LOCK WASHER 3/8"	22
24	F0600NC	3/8-16 HEX NUT	16
25	F0607HHCS	HEX HEAD CAP SCREW 3/8-16 X 1-3/4"	2
26	F0608HHCS	HEX HEAD CAP SCREW 3/8-16 X 2" LG	4
27	F0609SH	SCREW, SOCKET HEAD 3/8-16 X 2-1/4" LG	4
28	F0804HHCS	HEX HEAD CAP SCREW 1/2-13 X 1"	1
29	S0109CD	MAIN DRIVE FRAME ASSEMBLY *PAGE 36 FOR PARTS*	
30	S0113CD	MAIN DRIVE GEAR / HELIX *SEE PAGE 35 FOR PARTS*	1
31	458CD	DOUBLE GROOVE PULLEY	
32	MAIN DRIVE MOTOR	*SEE TABLE BELOW*	1

MAIN DRIVE MOTOR TABLE			
ELECTRICAL SPECS.	PART NO	DESCRIPTION	QTY
208-220, 3PH	SS265	2HP/3PH 208-220 MAIN DRIVE MOTOR	1
208-220, 1PH	19908	2HP/1PH 208-220 MAIN DRIVE MOTOR	1
380V, 400V, 415V 50HZ	15265	2HP/3PH 50HZ 380V MAIN DRIVE MOTOR	1
380V 60HZ	19540	2HP/3PH 60HZ 380V MAIN DRIVE MOTOR	1

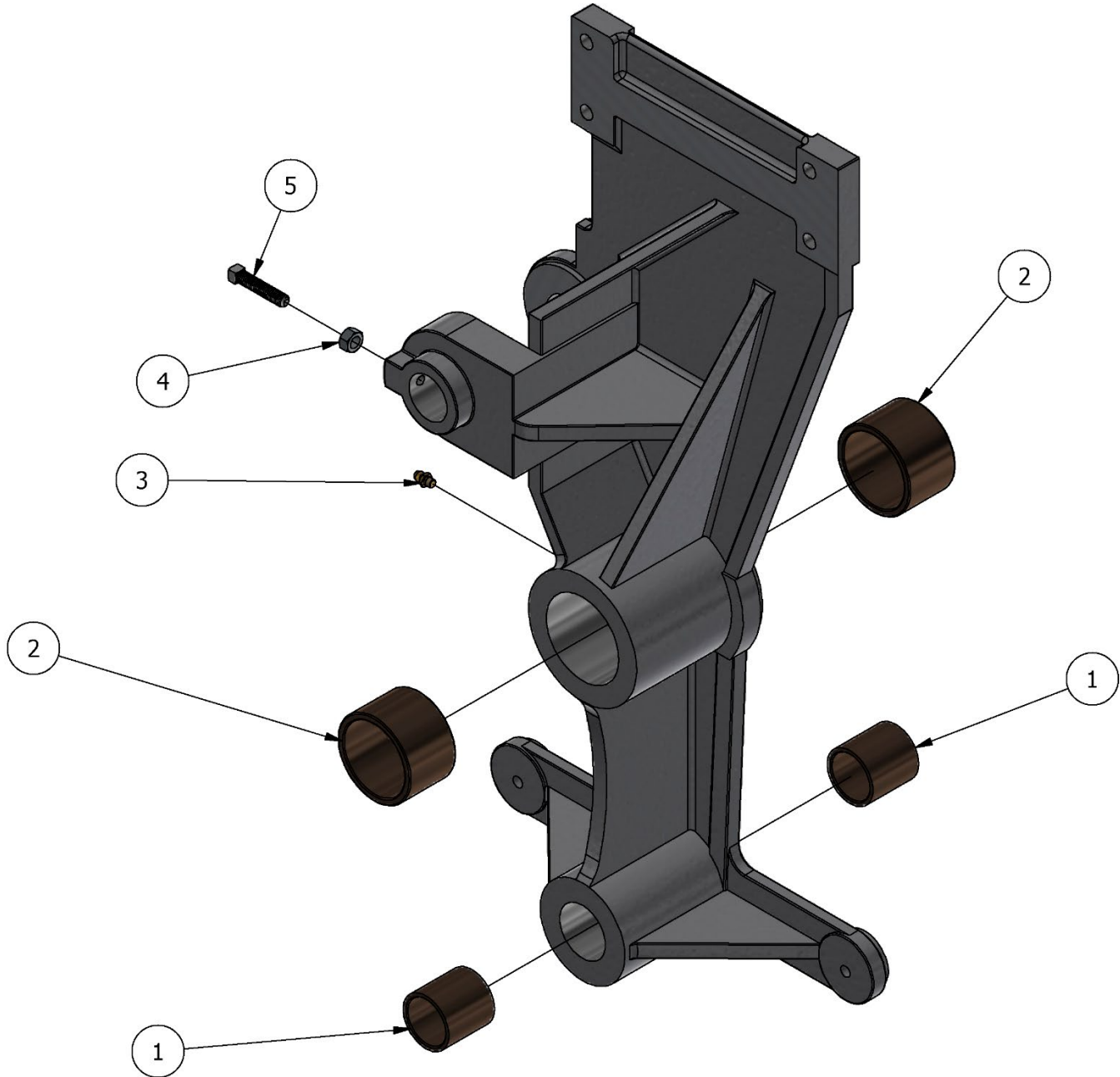
Main Drive Gear Breakdown



Main Drive Gear Parts List

ITEM	PART NO	DESCRIPTION	QTY
1	312PY	DRIVE BEARING	1
2	411CD	SPACER WASHER- 2" ID (BRONZE)	1
3	413CD	SPACER WASHER- 1-1/2" ID (BRONZE)	1
4	439CD	WASHER, 3" X 3/16" THICK	1
5	459CD	WASHER - STEEL, 1 -3/4 OD X 1/2 ID	1
6	F0800LW	LOCK WASHER 1/2"	2
7	F0800NC	NUT COURSE, 1/2-13	1
8	F0804HHCS	HEX HEAD CAP SCREW 1/2-13 X 1"	1
9	F0819FH	1/2" X 4-3/4" FLAT HEAD BOLT	1

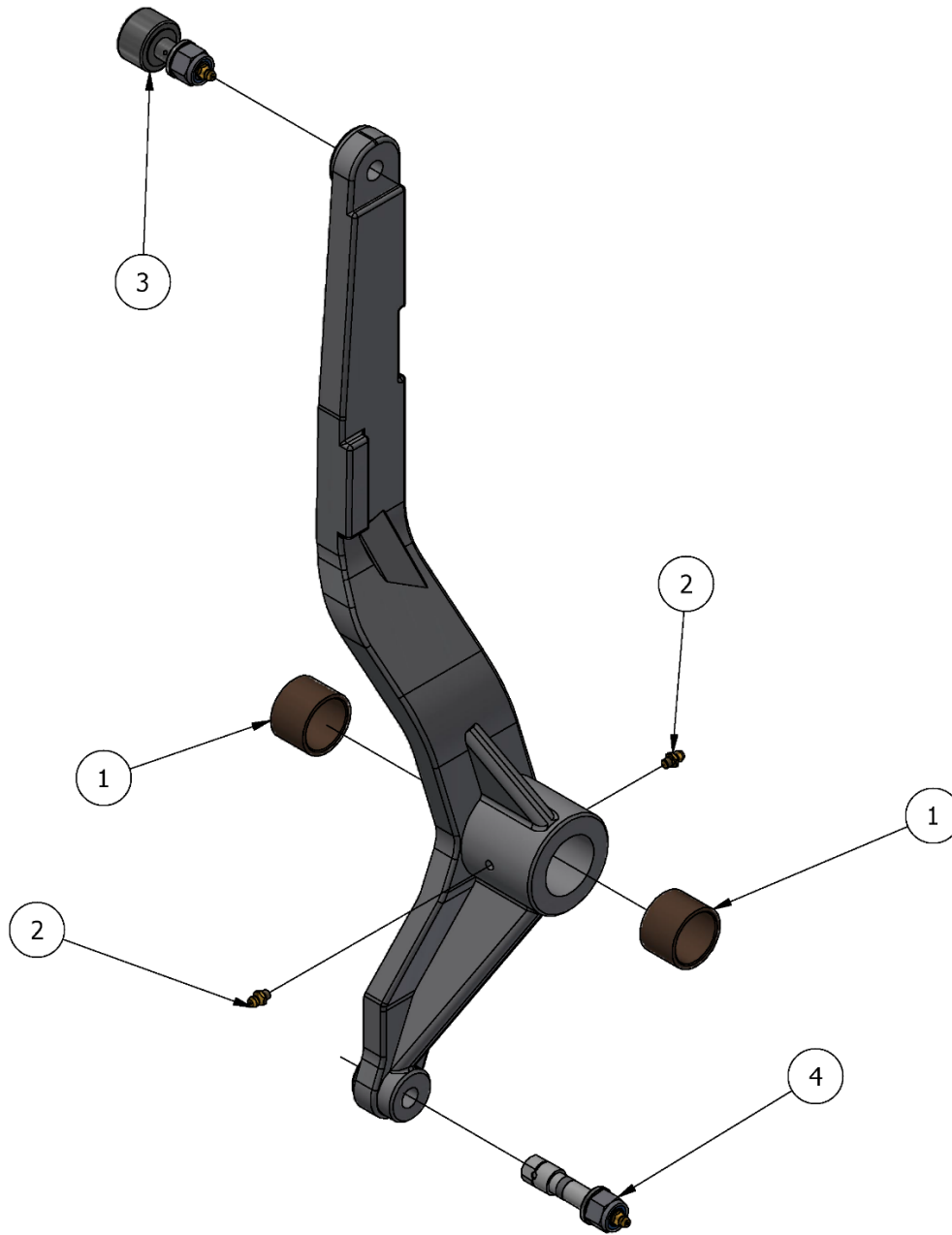
Main Frame Assembly Breakdown



Main Frame Assembly Parts List

ITEM	PART NO	DESCRIPTION	QTY
1	437CD	PINION SHAFT BEARING	2
2	440CD1	MAIN FRAME BEARING-BRONZE, 2-3/8	2
3	3038-B	1/4-28 UNF STRAIGHT GREASE FITTING	2
4	F0500NC	NUT COURSE, 5/16-18	1
5	F0506SQ	5/16 X 1-1/2" SQUARE BOLT	1

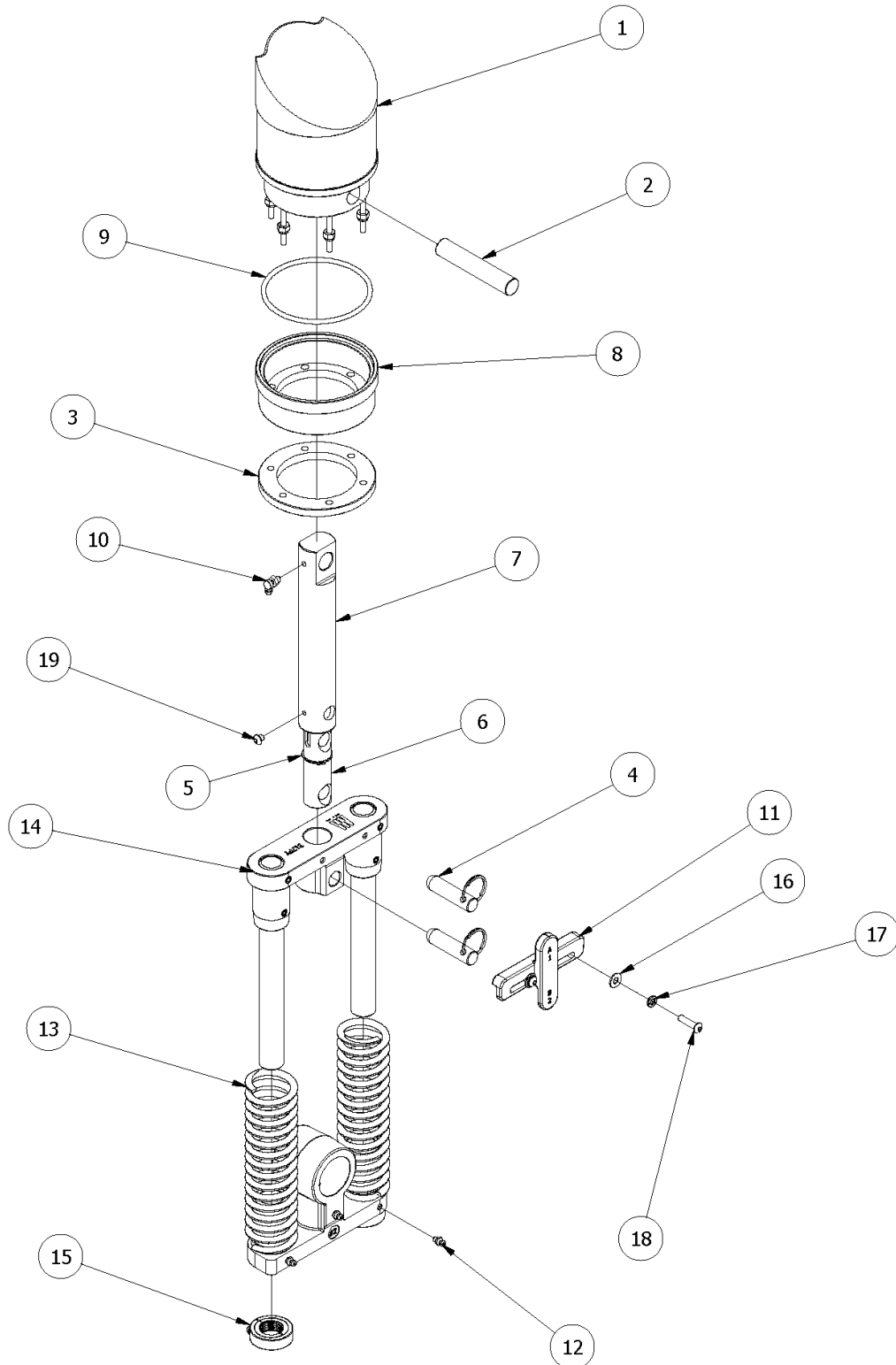
Rocker Arm Assembly Breakdown



Rocker Arm Assembly Parts List

ITEM	PART NO	DESCRIPTION	QTY
1	422CD	ROCKER ARM BEARING	2
2	3038-B	1/4-28 UNF STRAIGHT GREASE FITTING	2
3	A427CD	CAM ROLLER ASSEMBLY	1
4	A452CD	SHOE BOLT ASSEMBLY	1

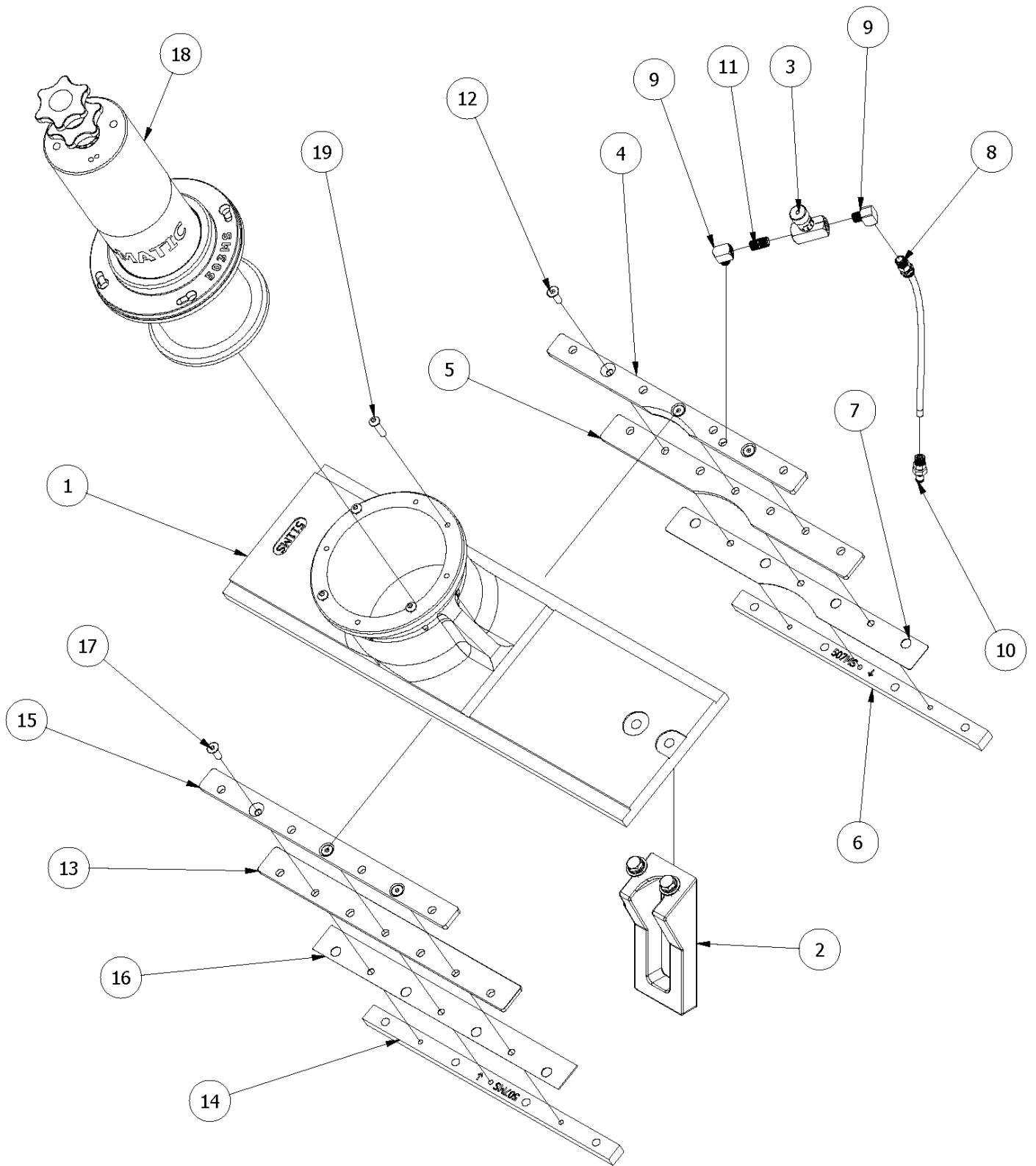
Piston and Spring Load Assembly Breakdown



Piston and Spring Load Assembly Parts List

ITEM	PART NO	DESCRIPTION	QTY
1	300PY1	PISTON ONLY W/STUDS & NUTS	1
2	301PY	WRIST PIN	1
3	302PY	PISTON RING BACKUP WASHER	1
4	304PY	CONNECTING ROD PIN W/ KEY RING	2
5	318PY	SNAP RING	1
6	319PY	CONNECTING ROD - LOWER	1
7	322PY	CONNECTING ROD - UPPER	1
8	323PY	PISTON CUP	1
9	324PY	O-RING (PISTON) 4-1/8"ID X 4-1/2"OD	1
10	23128	1/4-28 UNF 90 DEGREE GREASE FITTING	1
11	306PY	LOCK CONNECTING PIN	1
12	310PY	LOWER SPRING LOAD CAST ASSEMBLY	1
13	316PY	COMPRESSION SPRING, 10" LONG FREE L	2
14	317PY	UPPER SPRING LOAD	1
15	33799	1"-14 THRD'D SHAFT COLLAR, BLK OXIDE	2
16	F0400FW	FLAT WASHER, 1/4"	2
17	F0400LW	LOCK WASHER, 1/4"	2
18	F0404SB	BUTTON HEAD, SOCKET 1/4-20 X 1" LG	2
19	F0401SB	1/4 X 1/4" BUTTON SOCKET HEAD	1

Divider Slide Parts Breakdown



Divider Slide Parts List

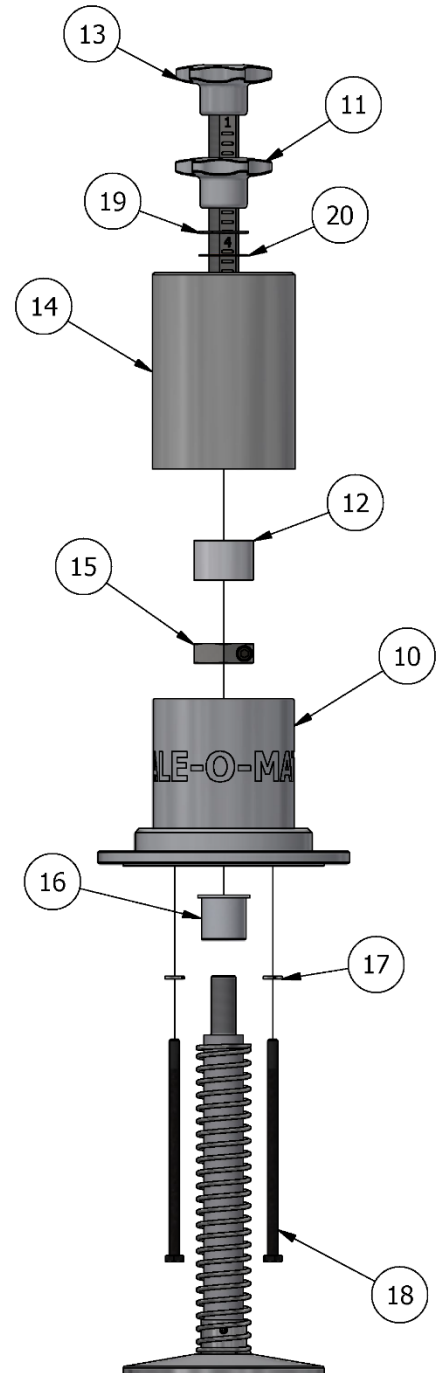
ITEM	PART NO	DESCRIPTION	QTY
1	511MS	DIVIDER SLIDE	1
2	517MS	CAM SLIDE ARM ASSMB.	1
3	14393	OIL VALVE - NEEDLE	1
4	505MS	GIB BAR, TOP	1
5	506MS-T	GIBB BAR PTFE PLASTIC INSERT BOTTOM	1
6	507MS	GIBB BAR - SPACER BAR, TOP, OR BOTTOM	1
7	521MS	WEAR STRIP LINER (SET ONLY)	1
8	7220S	MALE CONNECTOR- HOSE	1
9	7240S	90 STREET ELBOW - BRASS	2
10	7260S	MALE QUICK CONNECT	1
11	7370S	NIPPLE 1/8 X CLOSE SCH 40 SST304	1
12	F0403FSH	FLAT SOCKET HEAD 1/4-20 X 3/4" LG.	3
13	506MS-B	GIBB BAR PTFE PLASTIC INSERT, BOTTOM	1
14	507MS	GIBB BAR - SPACER BAR, TOP, OR BOTTOM	1
15	520MS	GIB BAR - LOWER	1
16	521MS	WEAR STRIP LINER (SET ONLY)	1
17	F0403FSH	FLAT SOCKET HEAD 1/4-20 X 3/4" LG.	3
18	MEASURING CUP	SEE NEXT PAGE	1
19	F0404SB	BUTTON HEAD, SOCKET 1/4-20 X 1" LG	4

Measuring Cup Notes:

The measuring cup assemblies scale dough within certain weight ranges. The weight ranges on these measuring cups are determined by the plungers on the bottom. For the three smaller measuring cups, these plungers require an insert to fit in the divider slide.

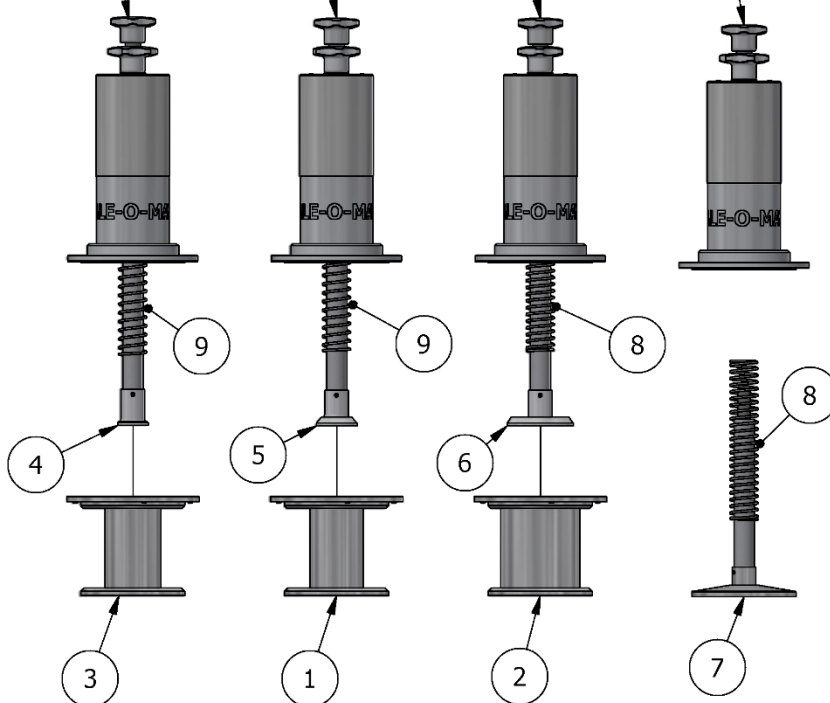
Measuring Cup Assembly Parts Breakdown

ITEM	PART NO	DESCRIPTION	QTY
1	509MS	2" INSERT, DIVIDER CYLINDER	1
2	510MS	3-1/4" INSERT, DIVIDER CYLINDER	1
3	512MS	1-1/2" INSERT, DIVIDER CYLINDER	1
4	513MS-1	1 1/2" PLUNGER & SHAFT ASSEMBLY	1
5	513MS-2	2" PLUNGER & SHAFT ASSEMBLY	1
6	513MS-3	3" PLUNGER & SHAFT ASSEMBLY	1
7	513MS-5	5" PLUNGER & SHAFT ASSEMBLY	1
8	516MSH	COMPRESSION SPRING (HEAVY)	2
9	516MSL	COMPRESSION SPRING (LIGHT)	2
10	503MS	PLUNGER GUIDE HOUSING	1
11	529MS-2D	STAR KNOB 3/4-16 THUR HOLE	1
12	529MS-2E	PLASTIC STOP PLUG	1
13	529MS-2F	ADJUSTING HANDLE & STUD ASSEMBLY	1
14	529MS-2-M	PLUNGER GUIDE EXTENSION HOUSING	1
15	531MS	NUT, SLOTTED 5/8-18	1
16	539MS-P	PLASTIC BUSHING	1
17	F0400LW	LOCK WASHER, 1/4"	2
18	F0422HHCS	HEX HEAD CAP SCREW 1/4-20 X 5-1/2"	2
19	F1200RW	3/4" RETAINING WASHER	1
20	F1200WF	FIBER WASHER (3/4" I.D X 1-1/4" O.D.)	1

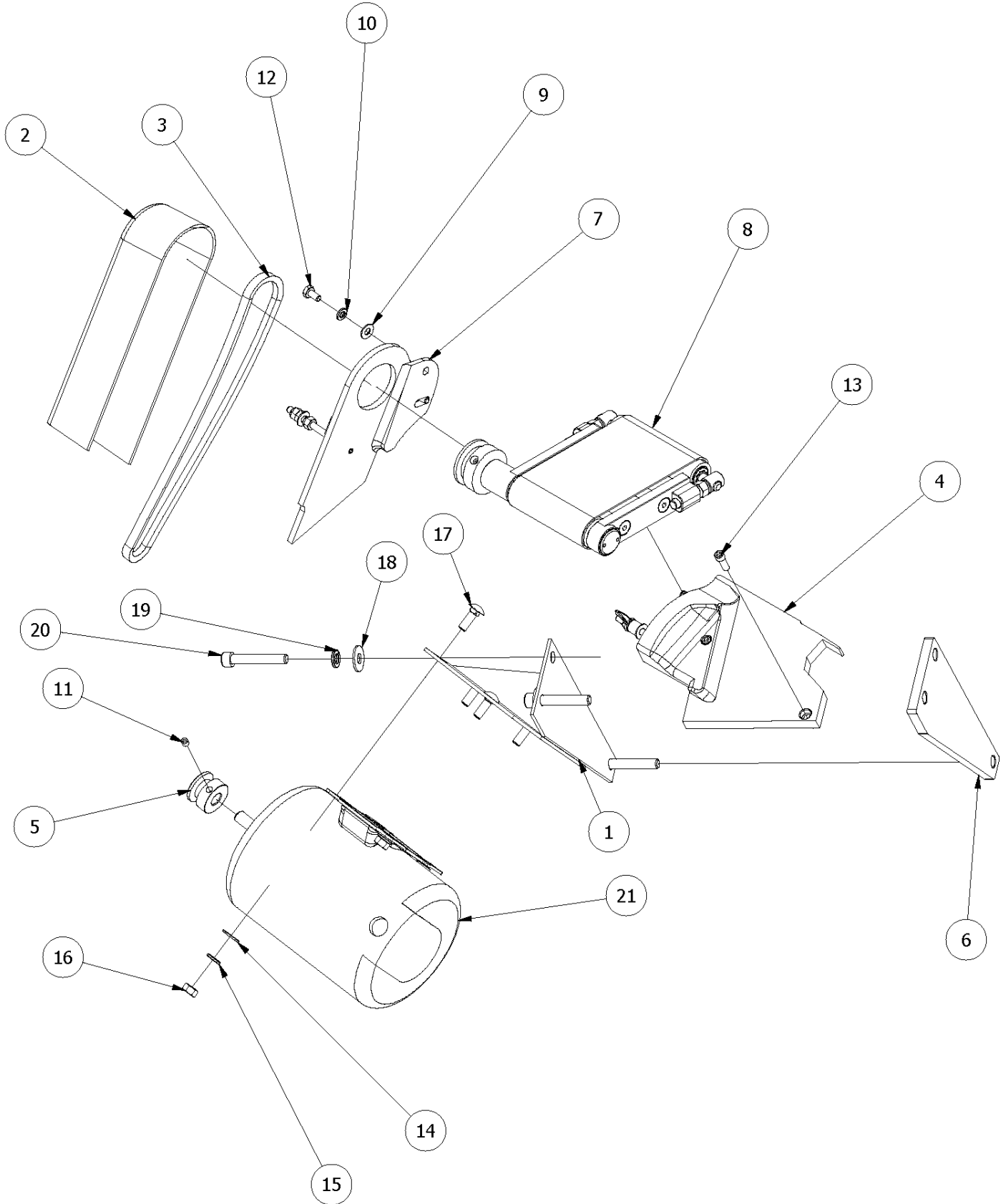


Individual Measuring Cup Assembly Part Numbers and Dough Weight Ranges:

PN: AMS1 1-2 OZ PN: AMS2 2-4 OZ PN: AMS3 4-10 OZ PN: AMS5 10-32 OZ



Drop Conveyor Assembly Parts Breakdown

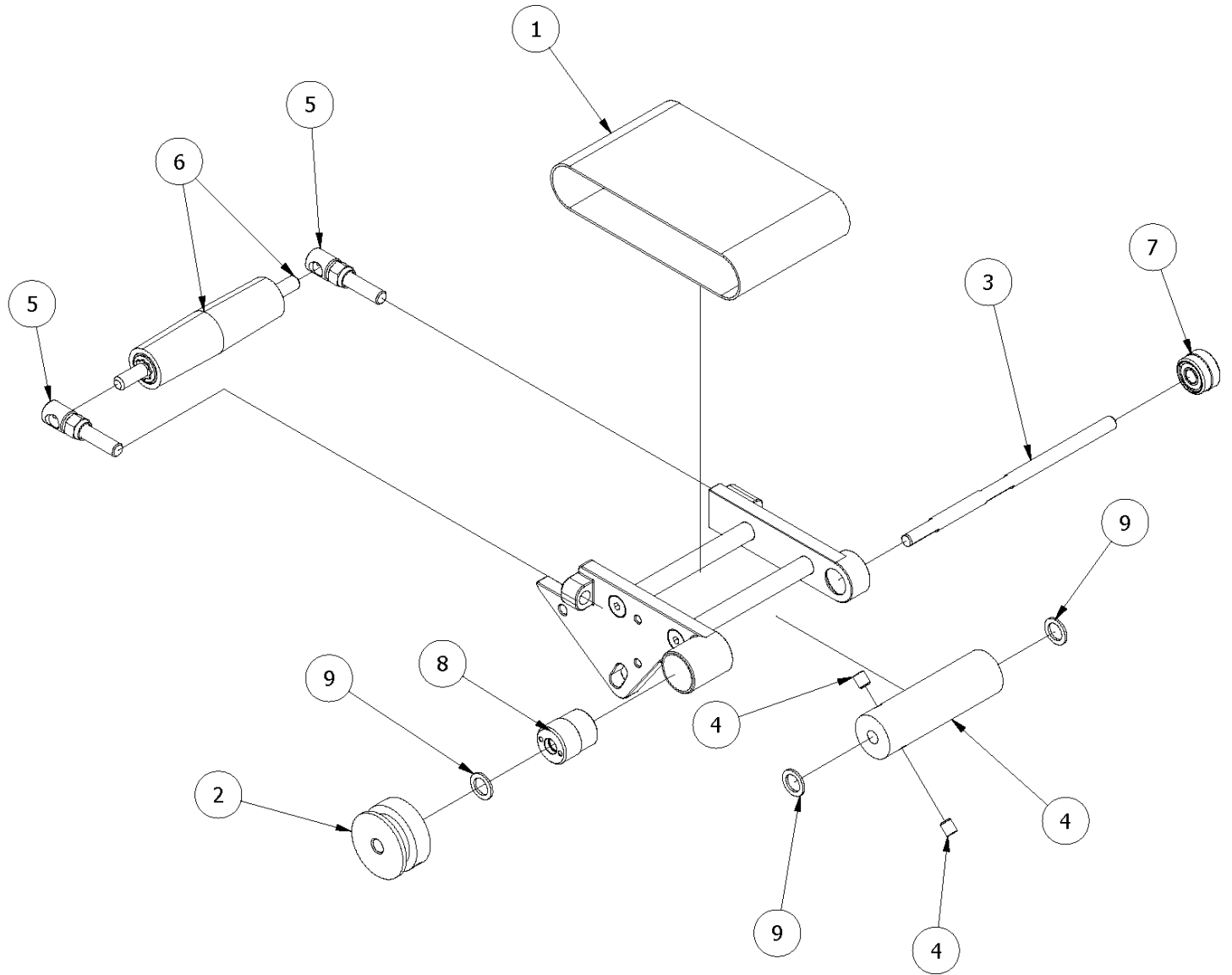


Drop Conveyor Assembly Parts List

ITEM	PART NO	DESCRIPTION	QTY
1	462CD	TAKE-OFF BRACKET WELDMENT ASSEMBLY	1
2	608SC	SMALL CONV. BELT COVER	1
3	609SCB	V BELT 28"	1
4	621SC	CONVEYOR SUPPORT BRACKET ASSEMBLY	1
5	638SC	V- PULLEY- DRIVE	1
6	29287	MOTOR SPACER (DROP CONVEYOR)	1
7	A610SC	COVER SUPPORT ASSY *SEE PAGE 45 FOR PARTS*	1
8	A620SC-0	SMALL CONVEYOR ASSEMBLY	1
9	F0400FW	FLAT WASHER, 1/4"	10
10	F0400LW	LOCK WASHER, 1/4"	26
11	F0401SS	SET SCREW 1/4-20 X 1/4"LG.	1
12	F0402HHCS	HEX HEAD CAP SCREW, 1/4-20X1/2" LG.	9
13	F0403SH	SCREW, SOCKET HEAD 1/4-20 X 3/4"LG	1
14	F0500FW	FLAT WASHER, 5/16"	12
15	F0500LW	LOCK WASHER, 5/16"	14
16	F0500NC	NUT COURSE, 5/16-18	14
17	F0503CB	CARRIAGE BOLT 5/16 X 3/4" LG	4
18	F0600FW-Large	FLAT WASHER 3/8" (LARGE)	6
19	F0600LW	LOCK WASHER 3/8"	22
20	F0609SH	SCREW, SOCKET HEAD 3/8-16 X 2-1/4" LG	4
21	DROP MOTOR	SEE TABLE BELOW	1

DROP CONVEYOR MOTOR TABLE			
ELECTRICAL SPECS.	PART NO	DESCRIPTION	QTY
208-220, 3PH	SS266	1/4 HP MOTOR 208-240V/60HZ DROP MOTOR	1
208-220, 1PH	SS266	1/4 HP MOTOR 208-240V/60HZ DROP MOTOR	1
380V, 400V, 415V 50HZ	15264	1/3HP 1PH MOTOR 380V/50HZ DROP MOTOR	1
380V 60HZ	13338	1HP MOTOR 190/380V/60HZ DROP MOTOR	1

Small Conveyor Assembly Parts Breakdown



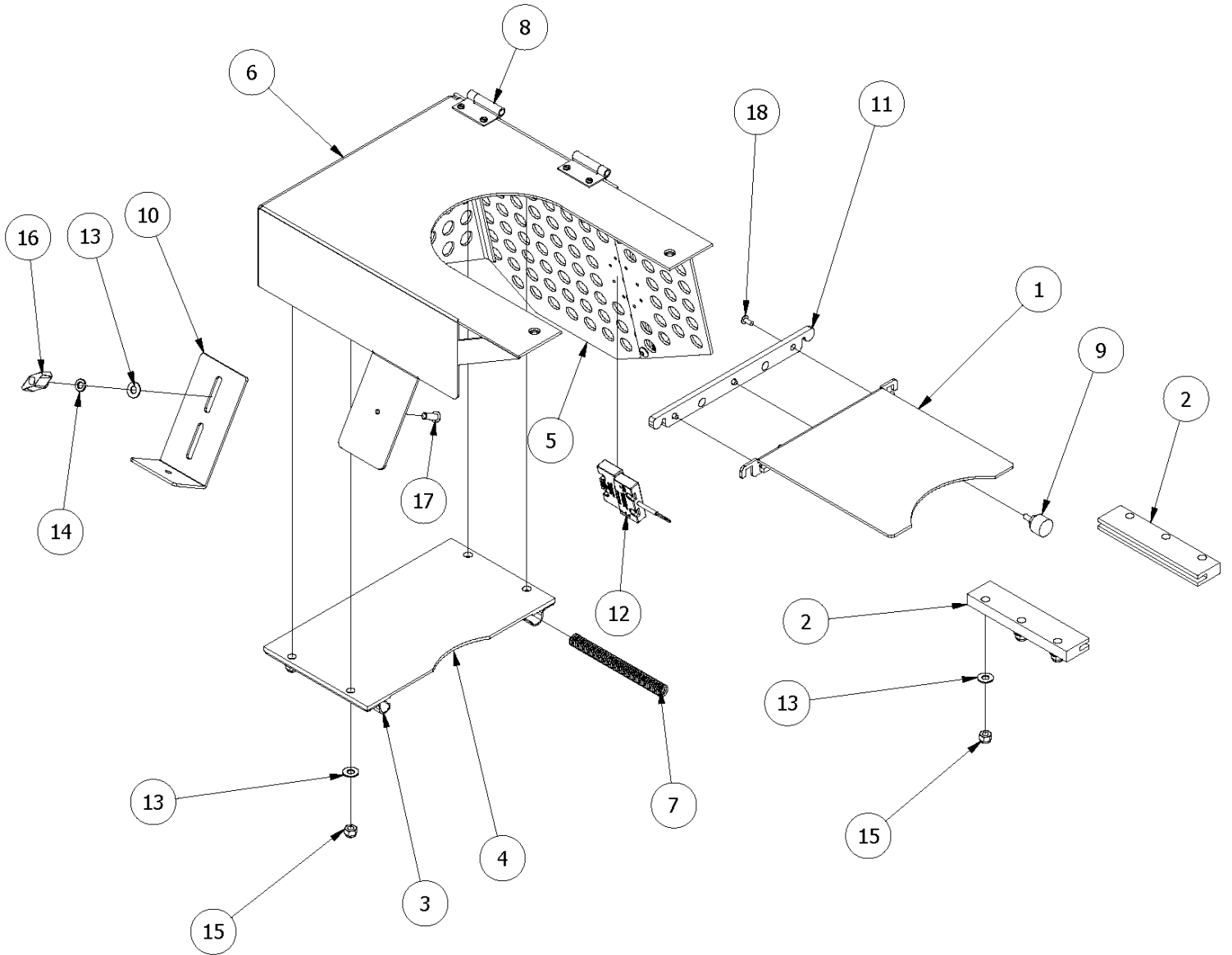
Small Conveyor Assembly Parts List

ITEM	PART NO	DESCRIPTION	QTY
1	605SC	SMALL CONVEYOR BELT	1
2	616SC	PULLEY - SMALL BELT	1
3	618SC	SHAFT-ROLLER DRIVE	1
4	619SC	LOWER ROLLER W/SET SCREWS	1
5	A600SC	ROLLER SUPPORT ASSEMBLY	2
6	A604SC	IDLER ROLLER ASSY. SM. CONVEYOR	1
7	A620SC-2	SMALL CONV. CARTRIDGE WITH BEARING	1
8	A620SC-3	SMALL CONV. LARGE CART. W/ BEARINGS	1
9	F0800WF	1/2 FW, 1/2 X 3/4" X.062 NYLON	3

Note:

- The conveyor frame can be ordered as an assembly with the bearing cartridges included. Use part number **A620SC-1**.
- The entire conveyor assembly can be ordered under part number **A620SC-0** as shown on page 43.

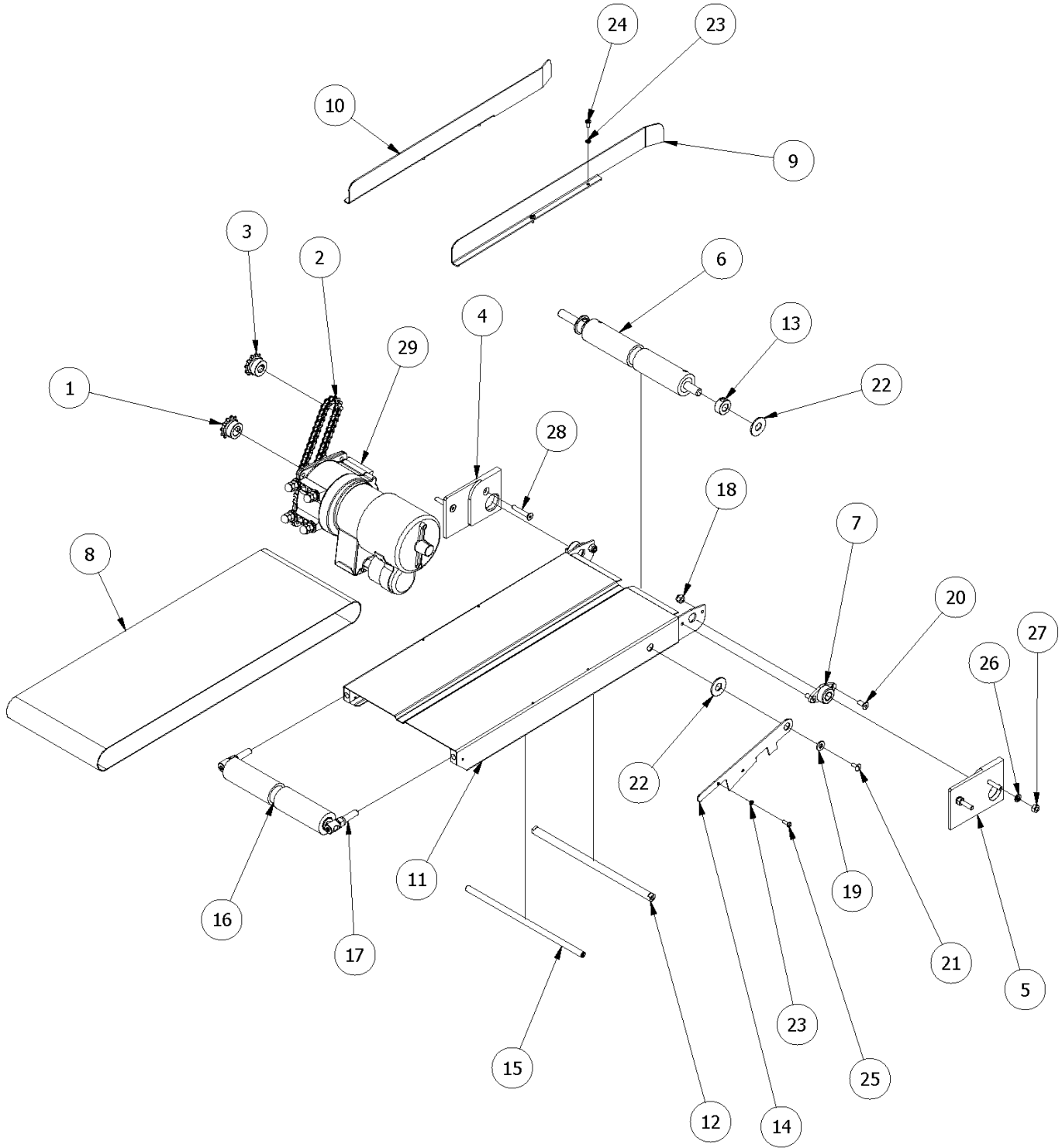
Divider Guard Assembly Parts Breakdown



Divider Guard Assembly Parts List

ITEM	PART NO	DESCRIPTION	QTY
1	11823	GUARD SLIDE ASSEMBLY	1
2	11824	GUARD SLIDE TRACK	2
3	11825	SPRING RETAINER	2
4	11826	SLIDE SPACER	1
5	11827	GUARD CAGE DOOR	1
6	11828	GUARD CAGE ASSEMBLY	1
7	11830	SPRING 1/2" OD X 5" LG	2
8	11831	HINGES, SS, CONCEALED SPRING	1
9	11832	BUMPER, THREADED STUD W/HEX SHOULDE	2
10	11877	GUARD BRACE #2	1
11	12114	GUARD SLIDE ADAPTER	1
12	EL-1308	SAFETY SWITCH	1
13	F0400FW	FLAT WASHER, 1/4"	12
14	F0400LW	LOCK WASHER, 1/4"	2
15	F0400NLN	NUT, NYLOCK 1/4"	10
16	F0400PWN	1/4 PLASTIC WING NUT	2
17	F0403SB	BUTTON HEAD, SOCKET 1/4-20 X 3/4" L	2
18	F9701.5TH	8-32 X 3/8" LONG TRUSS HEAD	3

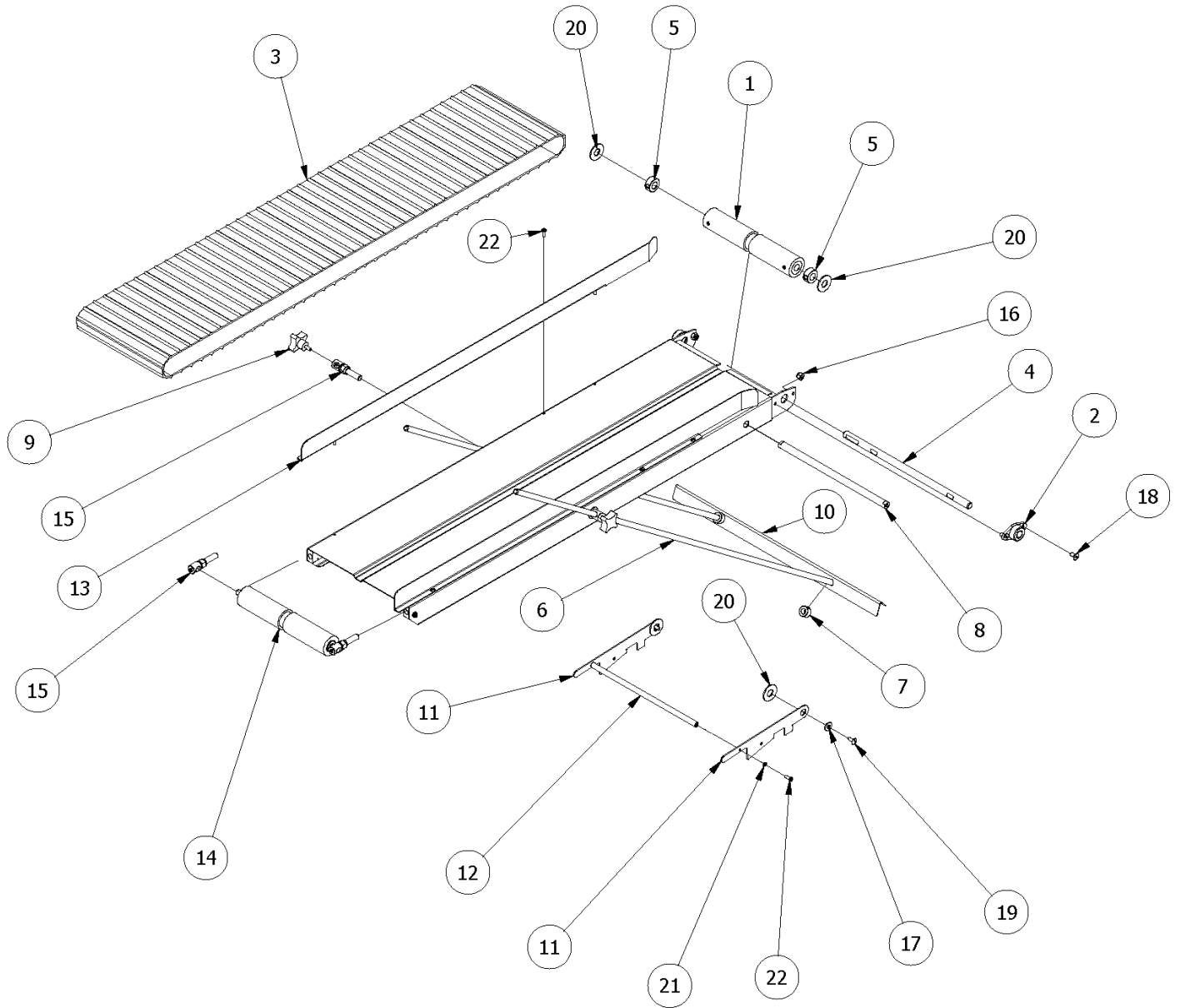
Discharge Conveyor Assembly Breakdown



Discharge Conveyor Assembly Parts List

ITEM	PART NO	DESCRIPTION	QTY
1	112CA	SPROCKET, 35B11 X 5/8" BORE	1
2	113CA	CHAIN NO.35 AT 16 LINKS PLUS MASTER LINK	1
3	116CA	SPROCKET, 35B11 X 1/2" BORE	1
4	11959	CONVEYOR MOUNTING PLATE (RIGHT)	1
5	11960	CONVEYOR MOUNTING PLATE (LEFT)	1
6	101CA	DRIVE ROLLER ASSEMBLY	1
7	102CA	ALUM. MTG, BRONZE BEARING, 2 HOLE F	2
8	104CA	CONVEYOR BELT (8-3/8"W X 48-1/8" LONG)	1
9	106CAL	LEFT CONVEYOR GUIDE	1
10	106CAR	RIGHT CONVEYOR GUIDE	1
11	118CA	CONVEYOR FRAME ASSEMBLY	1
12	11958	CONVEYOR ELEVATOR SHAFT	1
13	119CA	SHAFT COLLAR, 1/2" ONE PIECE, S.S.	2
14	105CA	CONVEYOR ELEVATOR BRACKET S302	2
15	17915	CONVEYOR ELEVATOR BRACKET SUPPORT SHAFT	1
16	A109CA	IDLER ROLLER ASSEMB.	1
17	A600SC	ROLLER SUPPORT ASSEMBLY	2
18	F0400NLN	NUT, NYLOCK 1/4"	4
19	F0400NW	NYLON FLAT WASHER 1/4"	2
20	F0402.5FSH	FLAT SOCKET HEAD SCREW, 1/4-20 X 5/8" LG.	4
21	F0404TH	1/4-20 X 1/2" LONG TRUSS HEAD	2
22	F0800NW	1/2"ID X 1-1/4"OD NYLON FLAT WASHER	4
23	F9700LW	LOCK WASHER #8	6
24	F9701.5RH	ROUND HEAD, SLOTTED, #8-32 X 3/8"LG	4
25	F9702RH	ROUND HEAD, SLOTTED, #8-32 X 1/2"LG	2
26	F0400LW	LOCK WASHER, 1/4"	26
27	F0400NC	NUT COURSE, 1/4-20	7
28	F0406FSH	FLAT SOCKET HEAD, 1/4 X 1-1/2" LG.	4
29	SS252	1/15HP,70RPM,115-230V MOTOR	1

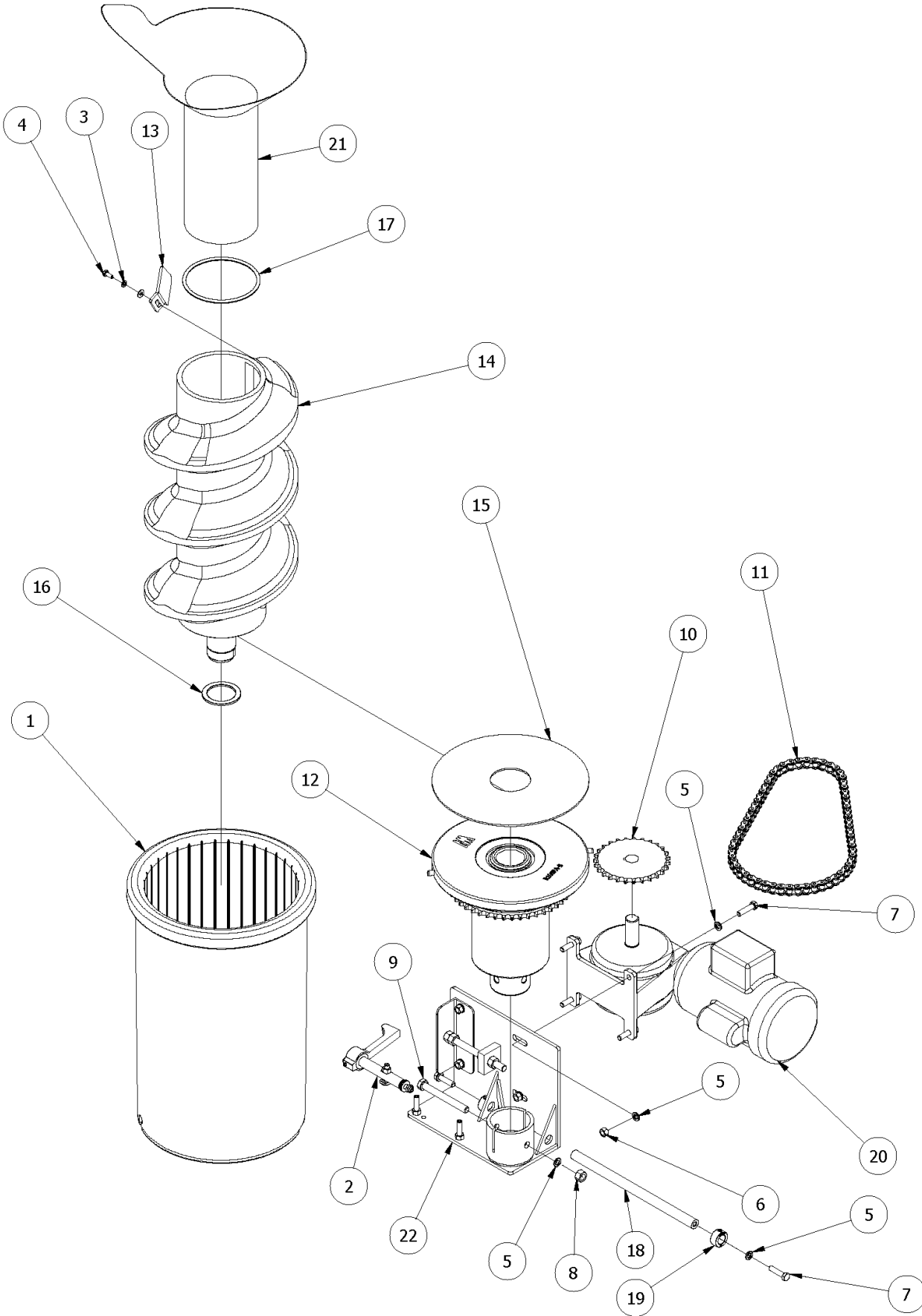
Extended Discharge Conveyor Parts List



Extended Discharge Conveyor Parts List

ITEM	PART NO	DESCRIPTION	QTY
1	101CA	DRIVE ROLLER ASSEMBLY	1
2	102CA	ALUM. MTG, BRONZE BEARING, 2 HOLE F	2
3	104CAL	LONG OUTFEED CONVEYOR BELT, 8-3/8"W X 37-3/4"LG	1
4	115CA	CONVEYOR SHAFT	1
5	119CA	SHAFT COLLAR, 1/2" ONE PIECE, S.S.	2
6	158CAL	CONVEYOR SUPPORT ROD, LONG	2
7	161CA	SHAFT COLLAR, 3/8" ID, ONE PIECE	2
8	11958	CONVEYOR ELEVATOR SHAFT	1
9	14841	STAR KNOB (ROUNDER POSITION BRACKET	2
10	15243	EXTENDED CONVEYOR CABINET MOUNT BRACE	1
11	17914	CONVEYOR ELEVATOR BRACKET	2
12	17915	CONVEYOR ELEVATOR BRACKET SUPPORT SHAFT	1
13	17917	LONG CONVEYOR GUIDE - (R)	1
14	A109CA	IDLER ROLLER ASSEMB.	1
15	A600SC	ROLLER SUPPORT ASSEMBLY	4
16	F0400NLN	NUT, NYLOCK 1/4"	4
17	F0400NW	NYLON FLAT WASHER 1/4"	2
18	F0402FSH	1/4: 20 X 1/2 SOCKET FLAT HEAD	4
19	F0404TH	1/4-20 X 1/2" LONG TRUSS HEAD	2
20	F0800NW	1/2"ID X 1-1/4"OD NYLON FLAT WASHER	4
21	F9700LW	LOCK WASHER #8	4
22	F9702RH	ROUND HEAD, SLOTTED, #8-32 X 1/2"LG	10

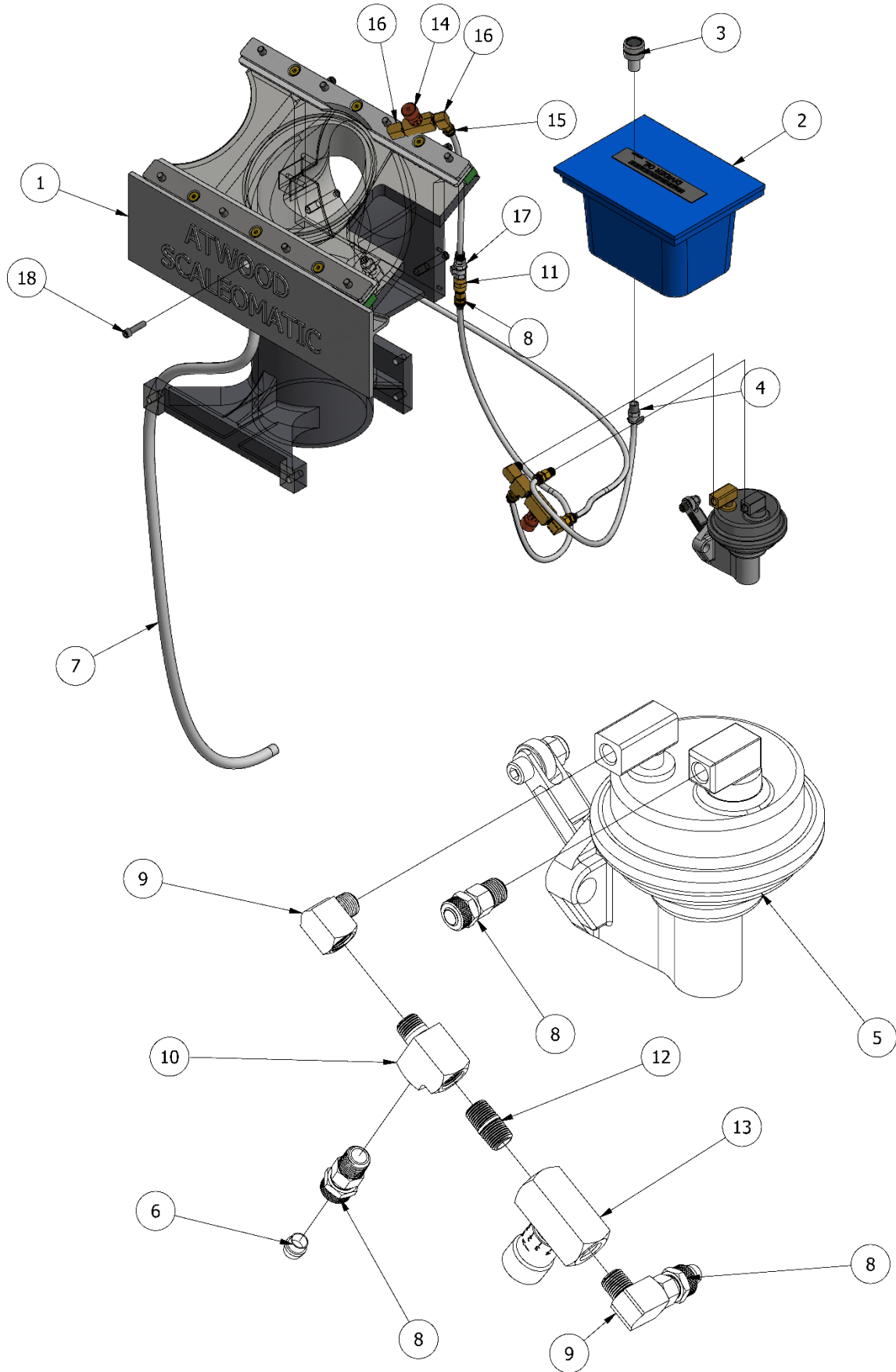
Rounder Assembly Breakdown



Rounder Assembly Parts List

ITEM	PART NO	DESCRIPTION	QTY
1	19900	PLASTIC ROUNDER DRUM	1
2	AR148RA	PIVOT SHAFT ASSEMBLY	1
3	F0400LW	LOCK WASHER, 1/4"	26
4	F0402.5HHCS	HEX HEAD CAP SCREW 1/4-20 X 5/8"	4
5	F0600LW	LOCK WASHER 3/8"	22
6	F0600NC	3/8-16 HEX NUT	16
7	F0606HHCS	HEX HEAD CAP SCREW 3/8-16 X 1-1/2"	8
8	F0800NC	NUT COURSE, 1/2-13	5
9	F0818HHCS	HEX HEAD CAP SCREW 1/2-13 X 4-1/2"LG	1
10	R103RA	SPROCKET, 50B27 X 1" BORE W/SET SCR	1
11	R105RA	DRV CHN#50, 31 LINKS W/MASTER LINK	1
12	R108RA	ROUNDER BASE ASSEMBLY	1
13	R121RA	EXIT RAMP	1
14	AR122RA	METAL ROUNDER SCREW ASSY. (INCLUDES R121RA AND FASTENERS)	1
15	R141RA	PLASTIC SEAL RING	1
16	R142RA	WASHER (SCREW)	1
17	R143RA	"O" RING FOR FUNNEL	1
18	R146RA	SWIVEL SHAFT	1
19	R147RA	SHAFT COLLAR	2
20	SS256	1 HP/ 100 RPM AC GEARMOTOR (THREE PHASE)	1
21	SR135RA	FUNNEL (TEFLON COATED)	1
22	SR139RA	PIVOT BASE ASSEMBLY	1

Oiling System Breakdown



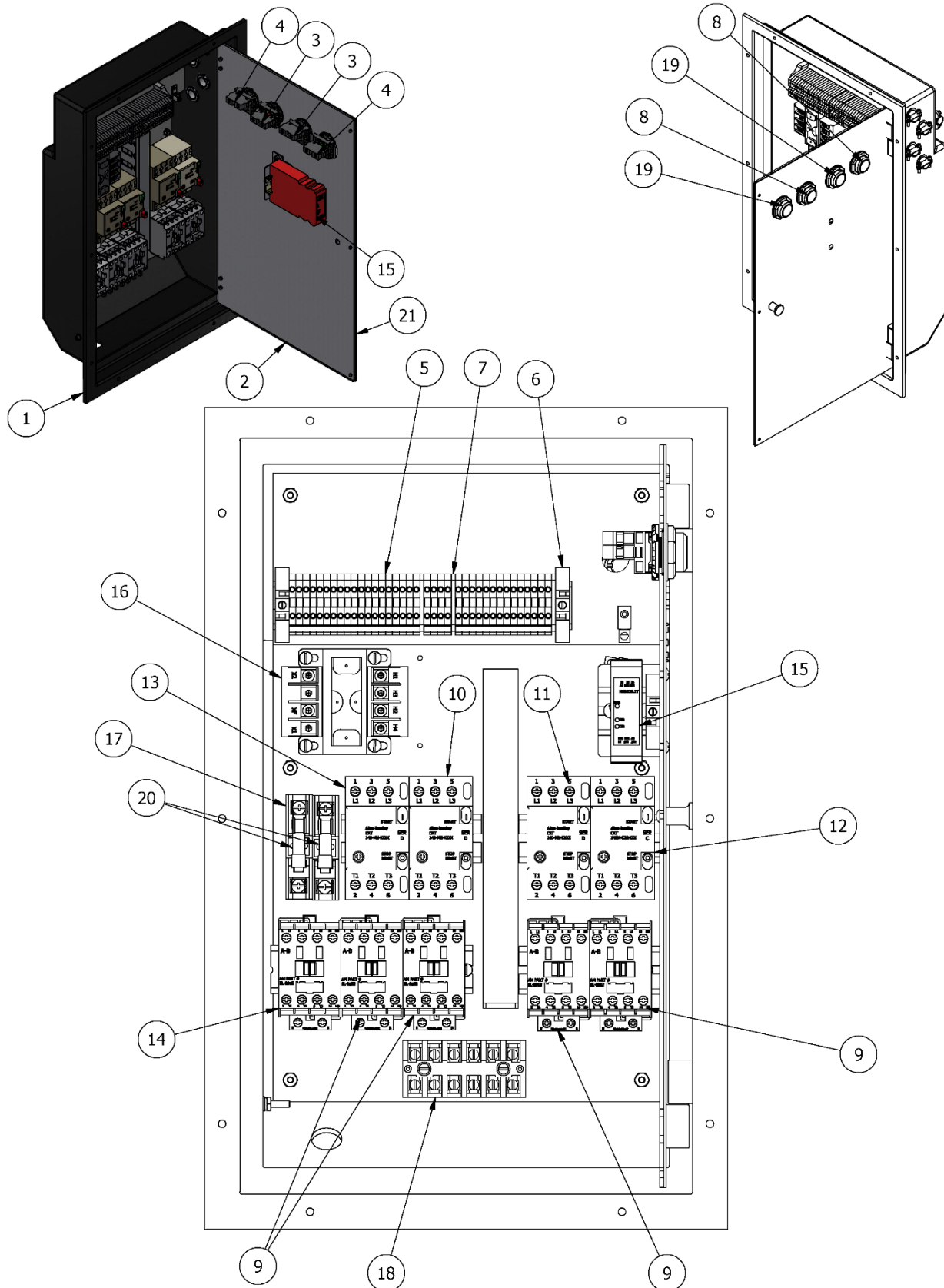
Oiling System Parts List

ITEM	PART NO	DESCRIPTION	QTY
1	518MS	SCALE O MATIC OIL RETURN	1
2	604CA	COMPLETE OIL BOX	1
3	7130S	AERATOR, PLASTIC INSERT W/STRAINER	1
4	7270S	FEMALE QUICK CONNECT	1
5	7000S	OIL PUMP ASSEMBLY	1
6	7090S	PLASTIC FERRULES	3
7	7110S	OIL LINE	4 FT
8	7220S	MALE CONNECTOR- HOSE	4
9	7240S	90 STREET ELBOW - BRASS	2
10	7250S	STREET T 1/8" BRASS	1
11	7310S	1/8 BRASS COUPLING	1
12	7370S	NIPPLE 1/8 X CLOSE SCH 40 SST304	1
13	14393	OIL VALVE - NEEDLE	1
14	14393	OIL VALVE - NEEDLE	1
15	7220S	MALE CONNECTOR- HOSE	1
16	7240S	90 STREET ELBOW - BRASS	2
17	7260S	MALE QUICK CONNECT	1
18	F0404SH	SCREW, SOCKET HEAD 1/4-20 X 1"LG	2

Extended Hopper Oil System Parts List

ITEM	PART NO	DESCRIPTION	QTY
1	445CDE	DOUGH HOPPER - EXTENDED	1
2	7220S	MALE CONNECTOR- HOSE	3
3	7240S	90 STREET ELBOW - BRASS	3
4	33942	HOPPER (EXTENDED) OILING SYSTEM SET-UP	1
5	EL-2002	FIXED DIA CABLE CLAMPS - HEAVY	1
6	7240S	90 STREET ELBOW - BRASS	2
7	7250S	STREET T 1/8" BRASS	3
8	7260S	MALE QUICK CONNECT	4
9	7270S	FEMALE QUICK CONNECT	5
10	7310S	1/8 BRASS COUPLING	1
11	7370S	NIPPLE 1/8 X CLOSE SCH 40 SST304	2
12	14393	OIL VALVE - NEEDLE	3
13	17664	1/8" NPT NIPPLE X 1-1/2" LG. SS	1
14	33940	OIL VALVE MOUNT BRACKET ASSY.	1

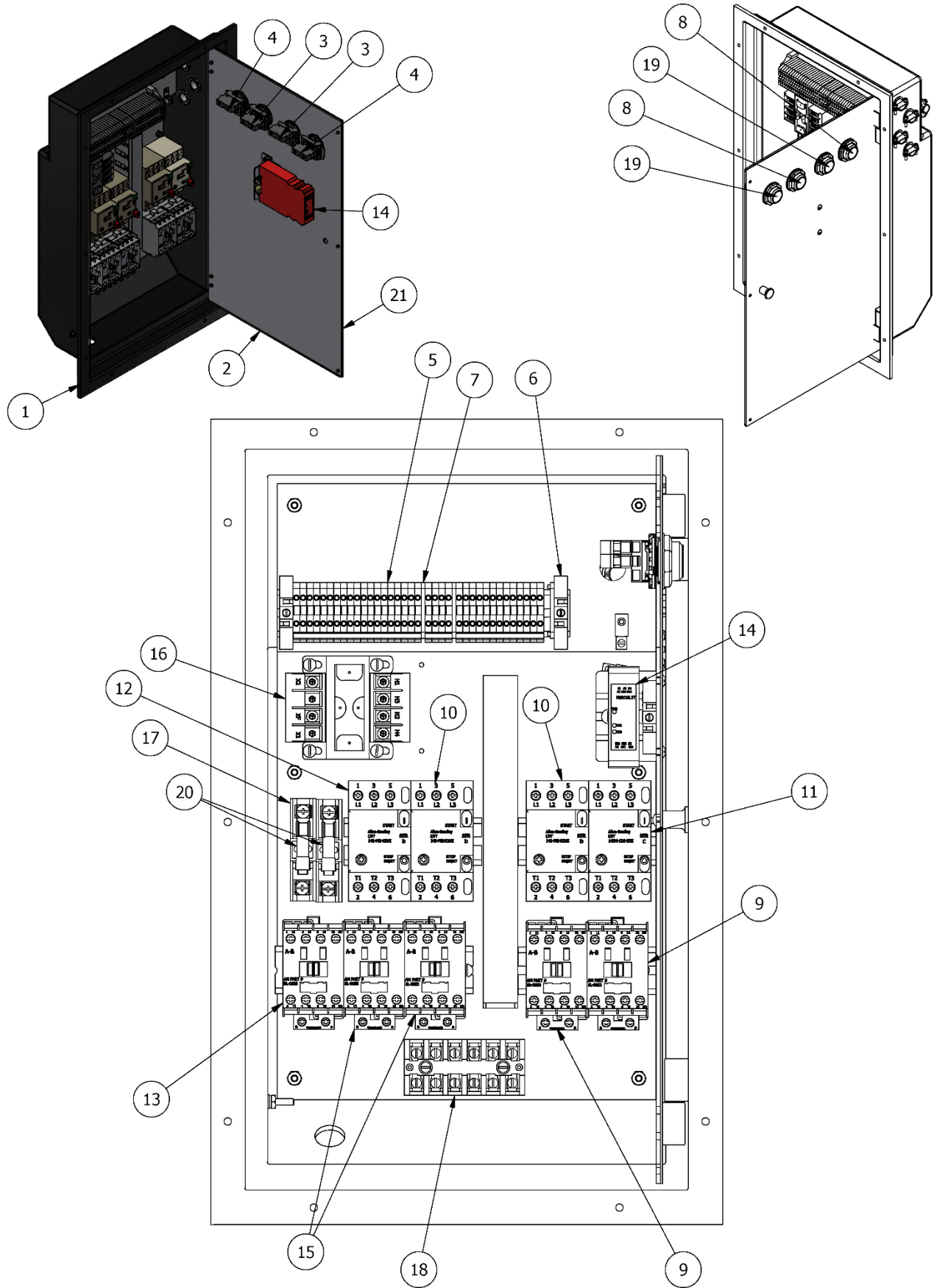
Electrical Box 208V-230V-3PH Breakdown



Electrical Box 208V-230V-3PH Parts List

ITEM	PART NO	DESCRIPTION	QTY
1	617CA6	ELECTRICAL ENCLOSURE, PLASTIC MOLD.	1
2	11423	S-300 ENCLOUSRE PANEL	1
3	400038	CONTACT BLOCKS, 1 N.C.	2
4	400039	CONTACT BLOCK 1 N.O.	2
5	EL-0395	TERMINAL BLOCK (TYPE MA2.5/5)	37
6	EL-0396	TERMINAL BLOCK END ANCHOR	3
7	EL-0397	END BARRIER (GRAY)	3
8	EL-0409	PUSH BUTTON, RED	2
9	EL-0853	IEC MOTOR CONTACTOR (9 AMP)	4
10	EL-0854	MANUAL MOTOR STARTER (2.5 - 4.0 AMP)	1
11	EL-0855	MANUAL MOTOR STARTER (4.0 - 6.3A)	1
12	EL-0856	MANUAL MOTOR STARTER (6.3 - 10 AMPS)	1
13	EL-0859	MANUAL MOTOR STARTER (0.63 - 1.0 AM)	1
14	EL-0935	IEC MOTOR CONTACTOR (16 AMP)	1
15	EL-1307	GUARDMASTER SAFETY RELAY	1
16	EL-1773	TRANSFORMER (50Va, 230/460Vac PRIMA)	1
17	SS142	FUSE HOLDER	2
18	SS143	6 POINT TERMINAL BLOCK	1
19	SS184	START BUTTON, GREEN	2
20	SS302	1 AMP FUSE (CLASS CC)	2
21	TAG #37	ELECTRICAL ENCLOSURE DOOR LABEL	1

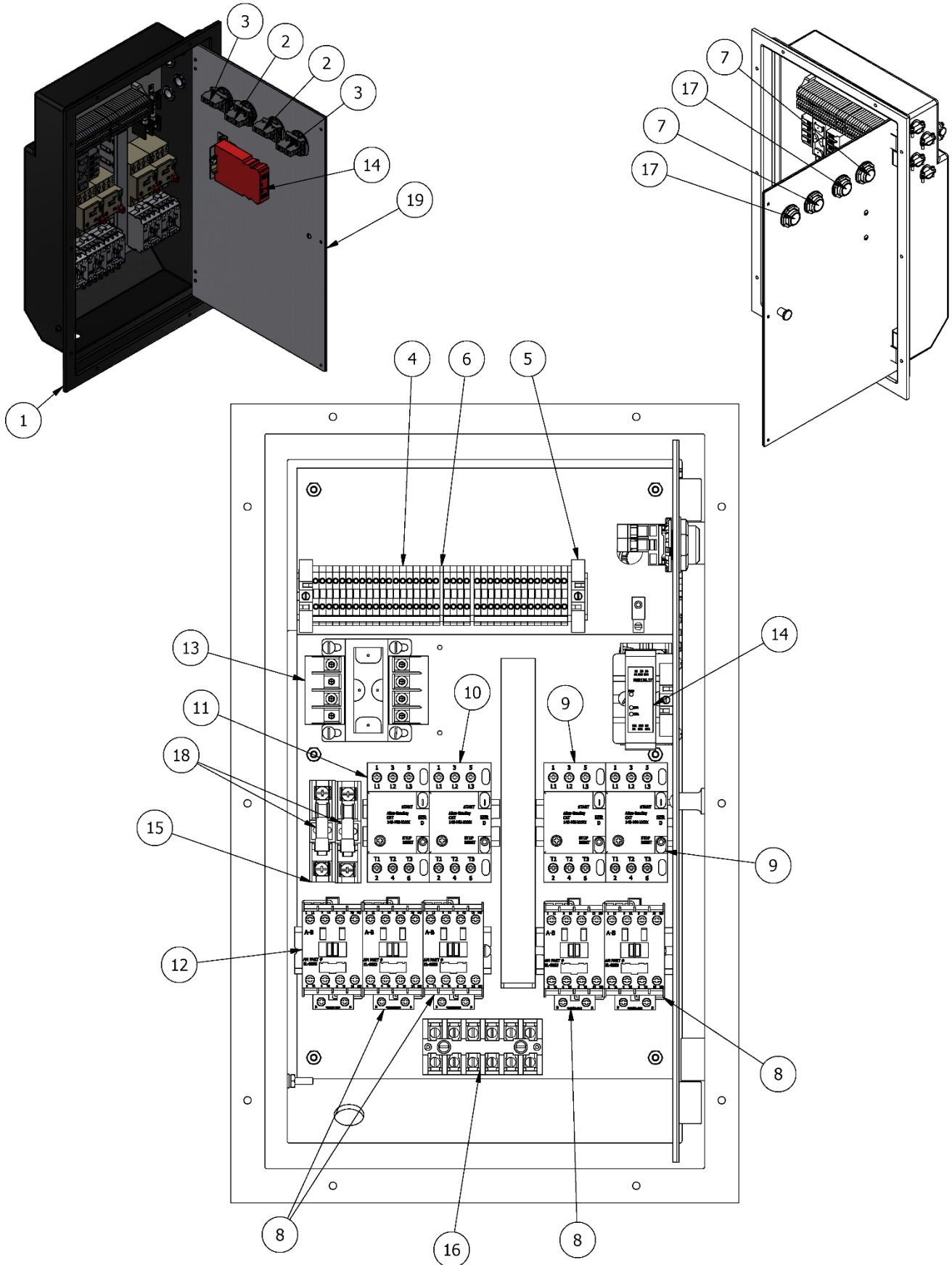
Electrical Box 208V-230V-1PH Breakdown



Electrical Box 208V-230V-1PH Parts List

ITEM	PART NO	DESCRIPTION	QTY
1	617CA6	ELECTRICAL ENCLOSURE, PLASTIC MOLD.	1
2	11423	S-300 ENCLOSURE PANEL	1
3	400038	CONTACT BLOCKS, 1 N.C.	2
4	400039	CONTACT BLOCK 1 N.O.	2
5	EL-0395	TERMINAL BLOCK (TYPE MA2.5/5)	36
6	EL-0396	TERMINAL BLOCK END ANCHOR	3
7	EL-0397	END BARRIER (GRAY)	3
8	EL-0409	PUSH BUTTON, RED	2
9	EL-0853	IEC MOTOR CONTACTOR (9 AMP)	3
10	EL-0855	MANUAL MOTOR STARTER (4.0 - 6.3A)	2
11	EL-0856	MANUAL MOTOR STARTER (6.3 - 10 AMPS)	1
12	EL-0859	MANUAL MOTOR STARTER (0.63 - 1.0 AM)	1
13	EL-0935	IEC MOTOR CONTACTOR (16 AMP)	1
14	EL-1307	GUARDMASTER SAFETY RELAY	1
15	EL-1430	IEC MOTOR CONTACTOR (16 AMP)	1
16	EL-1773	TRANSFORMER (50Va, 230/460Vac PRIMA)	1
17	SS142	FUSE HOLDER	2
18	SS143	6 POINT TERMINAL BLOCK	1
19	SS184	START BUTTON, GREEN	2
20	SS302	1 AMP FUSE (CLASS CC)	2
21	TAG #37	ELECTRICAL ENCLOSURE DOOR LABEL	1

Electrical Box 380V-3PH 50HZ Breakdown



Electrical Box 380V-3PH 50HZ Parts List

ITEM	PART NO	DESCRIPTION	QTY
1	617CA6	ELECTRICAL ENCLOSURE, PLASTIC MOLD.	1
2	11423	S-300 ENCLOUSRE PANEL	1
3	400038	CONTACT BLOCKS, 1 N.C.	2
4	400039	CONTACT BLOCK 1 N.O.	2
5	EL-0395	TERMINAL BLOCK (TYPE MA2.5/5)	37
6	EL-0396	TERMINAL BLOCK END ANCHOR	3
7	EL-0397	END BARRIER (GRAY)	3
8	EL-0409	PUSH BUTTON, RED	2
9	EL-0853	IEC MOTOR CONTACTOR (9 AMP)	4
10	EL-0854	MANUAL MOTOR STARTER (2.5 - 4.0 AMP)	1
11	EL-0855	MANUAL MOTOR STARTER (4.0 - 6.3A)	1
12	EL-0856	MANUAL MOTOR STARTER (6.3 - 10 AMPS)	1
13	EL-0859	MANUAL MOTOR STARTER (0.63 - 1.0 AM)	1
14	EL-0935	IEC MOTOR CONTACTOR (16 AMP)	1
15	EL-1307	GUARDMASTER SAFETY RELAY	1
16	EL-1773	TRANSFORMER (50Va, 230/460Vac PRIMA)	1
17	SS142	FUSE HOLDER	2
18	SS143	6 POINT TERMINAL BLOCK	1
19	SS184	START BUTTON, GREEN	2

Electrical Schematics

The following schematics include diagrams on a 208Vac-230Vac 3PH machine, and a 208Vac-230Vac 1ph 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)

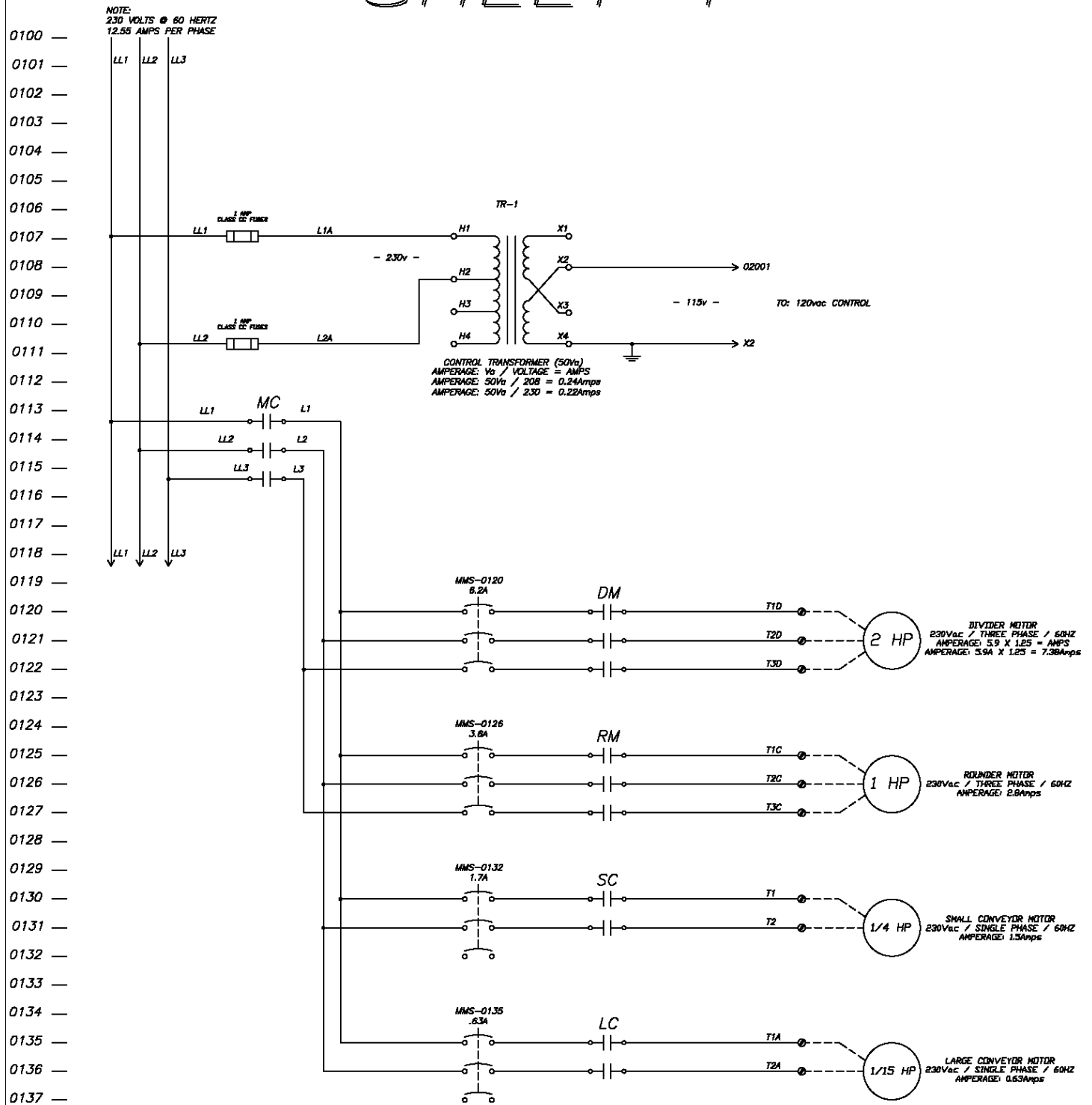
Monday through Friday, 3:30PM to 7AM (CST)
and Saturday or Sunday

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

support@ammfg.com

208Vac-230Vac 3PH Schematics

— SHEET 1 —

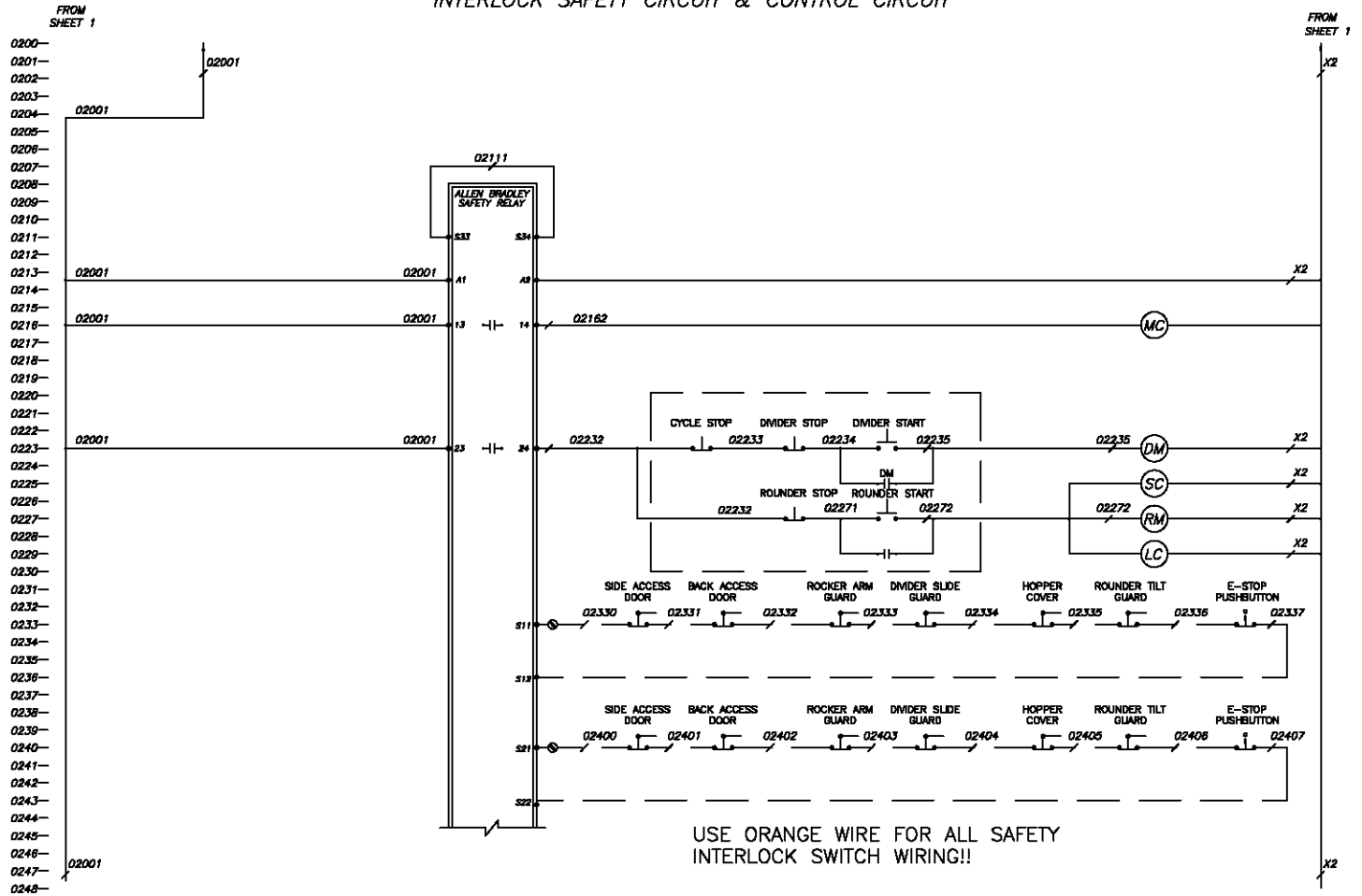


Control Circuit / Safety Schematics

— SHEET 2 —

AB SAFETY RELAY

"INTERLOCK SAFETY CIRCUIT & CONTROL CIRCUIT"



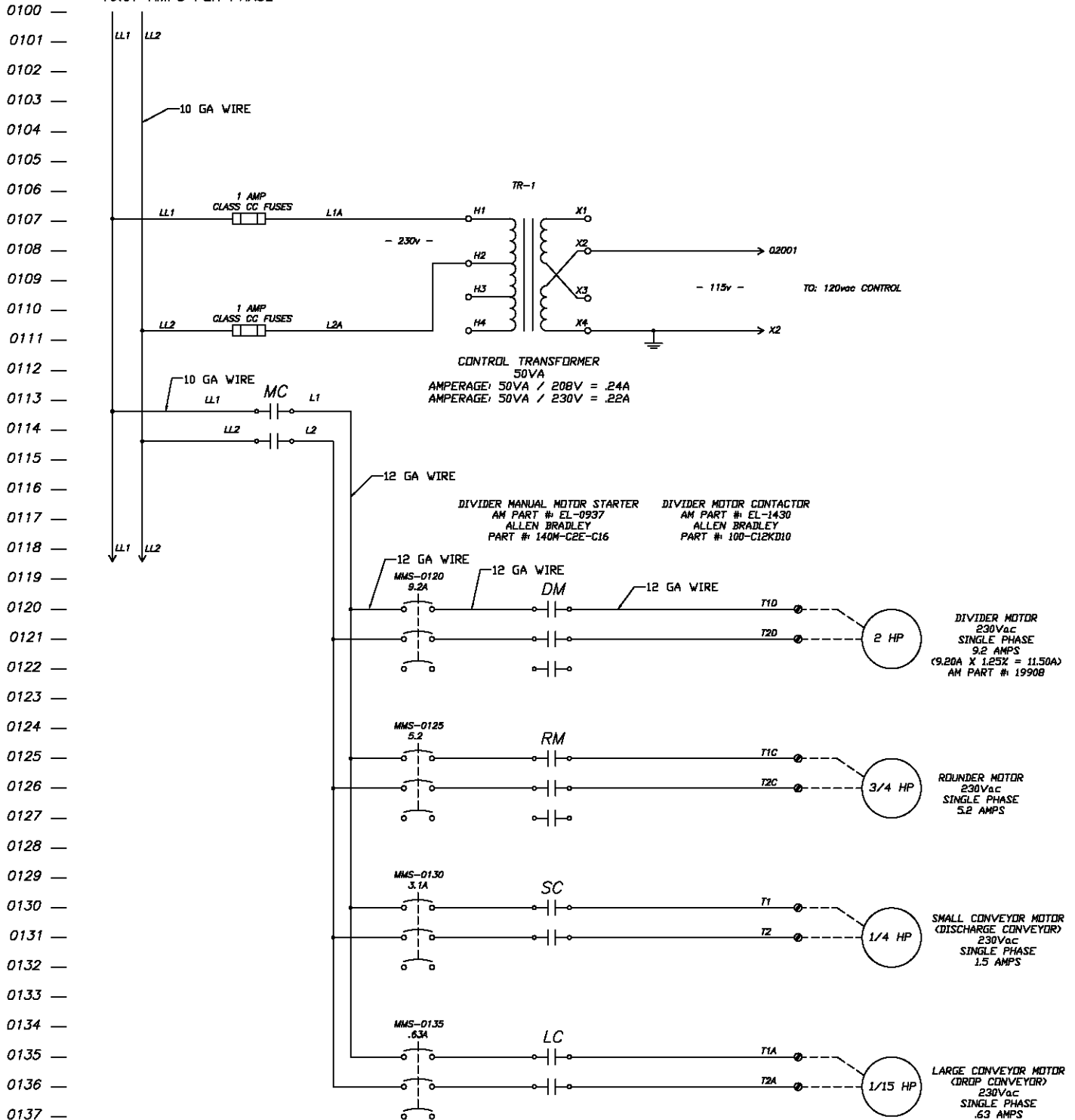
208Vac-230Vac 1PH Schematics

POWER CORD
 AM PART # EL-1151
 CAROL - 10/3 SD CORD

PLUG
 AM PART # EL-0602
 LEVITON - 2621 / 30 AMP PLUG

— SHEET 1 —

NOTE:
 230 VOLTS @ 60 HERTZ
 19.07 AMPS PER PHASE



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.

