



AUTOMAT MANUAL



Technical Data

Name: ERIKA Automat – fully automatic machine to divide and to round dough pieces of the same size

	Type	Divisions	Dough Portions (in ounces)	Plate Nos.
	3	30	1.0 – 3.5	#35
	4/40A	30	1.4 – 4.3	#45
	5/18 A	50	0.6 – 1.5	#50
	6/150A	15	5.4 – 9.5	#415
	7/70 A	20	2.5 – 7.1	#420
	9/20 A	36	0.7 – 2.5	#326
	10/25 A	36	0.9 – 3.3	#336
X	11/30A	36	1.0 – 3.5	#46
	Q1	30	0.7 – 3.0	#30Q1
	Q2	30	0.9 – 4.3	#30Q2
	Q3	36	1.0 – 3.5	#36Q3

Serial No.:

Weight: 1102 lb

Electrical Connections: 1.5KW

Year:

Measurement: standard

Diagram No.

	380 V	3 PH	50 Hz	3,8 A	No. 62
	200 V	3 PH	50 Hz	6,4 A	No. 30
	200 V	3 PH	60 Hz	6,4 A	No. 26
	220 V	3 PH	50 Hz	6,4 A	No. 26
X	220 V	3 PH	60 Hz	6,5 A	No. 29
	415 V	3 PH	50 Hz	3,0 A	No. 55.1
	380 V	3 PH	60 Hz	3,8 A	No. 28
	200 V	3 PH	50/60 Hz	7,0 A	No. 29

Noise Level: LwA = 76 dB Sound Level
LpAeq = 67 dB Emission Level

According to DIN 45635 part 1, sect. 7.2 and part 29, sect. 7.2.
and part 1, sect. 3.17,7.3 and part 29, sect. 5.4.4

To ensure proper use and to avoid accidents it is imperative to read the entire instruction manual prior to use of this machine.

Safety Tips

CAUTION: Do not reach inside the machine when it is in operation.

While in operation, ALL the covers have to be in place for safety reasons.

Before attempting any maintenance, repair work or cleaning, **TURN OFF** the main switch and disconnect the machine from the power supply (unplug from the receptacle).

In case of electrical malfunction, **NEVER** by-pass the start button in such a way that you could operate the machine with one button only.

The red plastic rounding plates shall be washed with lukewarm water, **DO NOT** clean them in pan washers or with hot water.

When first installing the machine, please make sure that the machine is running in the right direction; the rounding plate has to turn counterclockwise. (check the arrow on top of the control panel)

ATTENTION!!!

Notice:

- Plates should have no gaps in pinhole and rear bracket.
- If the plates are over-sized please scrape off slightly in the rear block area.

Manual

1. Setting-up and Installation of Machine

After unpacking set the machine level and make sure it stands firm and does not wobble. Unscrew the rear cover plates and ask a qualified electrician to connect the machine to the power supply.

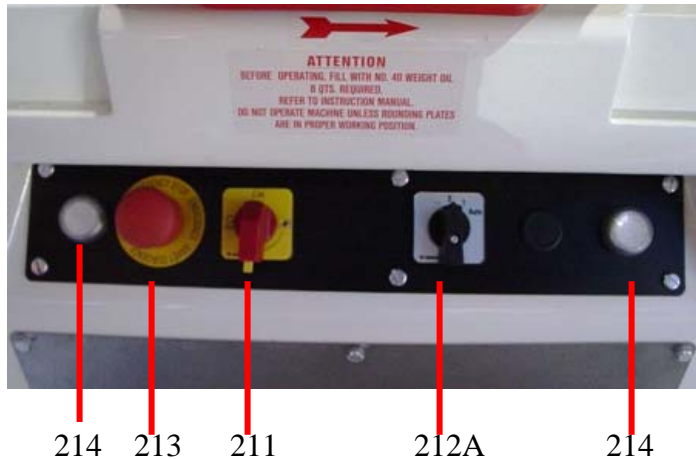


Fig. 1

Preselection

The machine is switched ON and OFF by the Main Switch (211) in the middle of the control panel. The main Selector Switch (212A) has 3 positions indicating the following:

- a) 1 - MANUAL – The machine operates only as long as the Start Buttons (214) are depressed
- b) AUTO – Normal operation i.e. press, divide, round
- c) 3 - REVERSE – When machine jams it can be returned to its starting position by first turning pressure adjusting screw 22 (Fig. IV) counterclockwise and then depressing start buttons. If the machine fails to operate, **first unplug it from the power supply**, then remove the external covers at the bottom of the machine and turn the V-belt pulley counter-clockwise until it is free to move. Reconnect the machine to the power supply and restart the motor. Turn the pressure adjustment screw clockwise until it is back to its previous position.

STOP = Emergency Stop Button: The machine stops when this button (213 Fig. I) is depressed. To restart the machine turn the emergency stop button counter-clockwise and depress jog buttons (214 Fig. I)

DO NOT Reach inside the machine when the machine is running

2. Electrical Connection

The machine is completely wired and ready for hook-up. The standard electrical 380 volts 3 phase and 50 cycles or 220 volts 3 phase and 60 cycles (USA), this is marked on the outside of the machine. When connecting the machine to the power supply make sure that the motor turns in the right direction. If the motor is properly connected, the rounding table rotates in the direction of the arrow (counterclockwise), during the rounding operation (see Fig. I above)

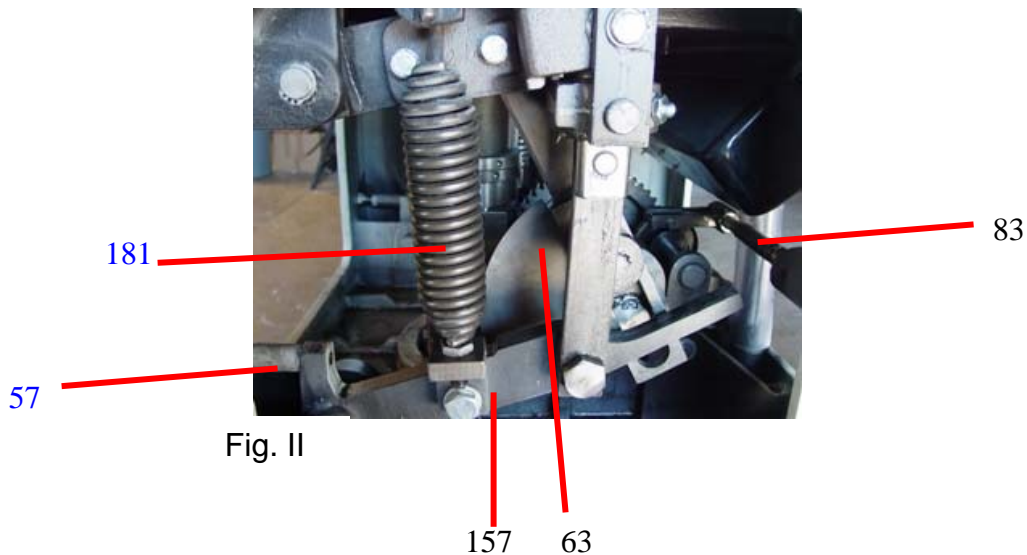


Fig. II

3. Lubrication

Fill the gearbox (Fig. II) above the motor compartment with approximately 7 quarts of SAE 46 (40 weight) engine oil, keeping the oil level approximately 1" above the bottom of the gearbox. After several work cycles the pump should deliver enough oil to the upper gearbox chamber to allow for the lubrication of all the bearings in the gearbox chamber. Check carefully to ensure that this happens.

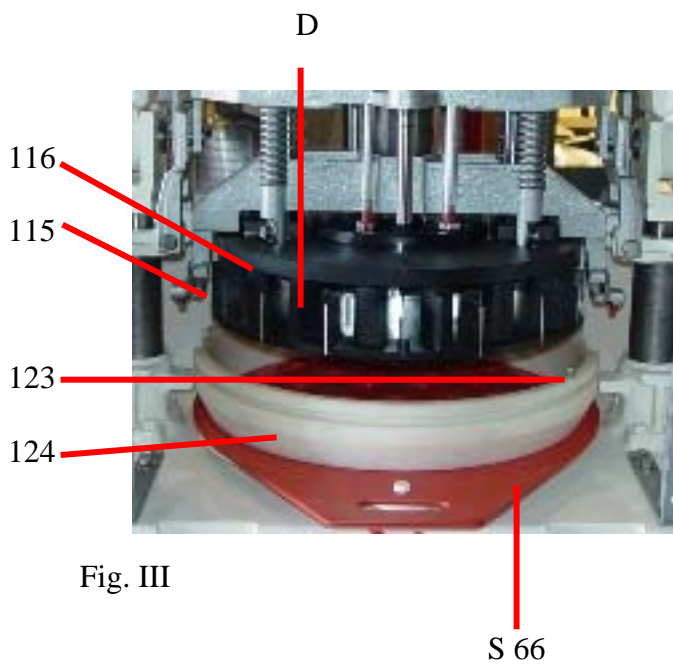


Fig. III

4. Cleaning of Machine Before First Use

Remove both head covers from the machine. By turning to the left remove the dough entrapment ring (124 Fig. III) from the machine. Clean all grease from the rounding table (5 Fig. IV), head and dough entrapment ring (124 Fig. III). Fit the dough entrapment ring back into the machine.

To do this proceed as follows:

First insert a rounding plate into the machine, then place the dough entrapment ring on top of it and push the ring towards the center and rear until it hits against the stop lugs (123 Fig. III)

While doing so, align smaller marking notch with its counterpart on the machine head. Set the switch to position 1 (Fig. I) and by pushing the START buttons slide the press piston carefully into the dough entrapment ring. When the two ring holders (115 Fig. III) reach the bottom position, release the push buttons and turn the dough entrapment ring to the right until it reaches the stop lug.

5. Rounding Plates (S-66 Fig. III)

Prior to the initial operation all rounding plates supplied with the machine should be checked to make sure that they do not jam. Prior to the machine start up it is advisable to leave the machine for at least 8 hours in the production area, so the machine could adapt to the area's ambient temperature. The rounding table (No. 5 Fig. IV) is protected against easy removal. This table should only be taken out by a service-technician, if there is a technical problem inside the machine.

6. Machine Operation

Spread the appropriate amount of dough face down onto the rounding plate. (S-66 Fig. III) Spread the dough to about $\frac{3}{4}$ " of the outside of the plate and insert the plate into the machine. Make sure that the plate is properly inserted and that the back of the plate as well as the top of the rounding table are free of any dough pieces or any other material. To prevent the plate from being damaged by the knife blades. Set the working pressure very low, i.e. turn the pressure adjustment screw (22 Fig. IV) down from its upper limit. The setting of the pressure adjustment:

set rounding handle No. 83 to number 0; then put the dough piece on the rounding plate and spread evenly. Go through the operating cycle then check whether the dough has spread all the way to the dough embracing ring.

Weigh individual dough pieces from the center as well as from the outside of the plate to make sure they weigh the same. If the outside pieces weigh less, you must turn the pressure adjustment screw clockwise to the next number and repeat the test until all dough pieces weigh the same. If you make larger dough pieces at a later time you may have to repeat this procedure. The rounding pressure is set by the weight adjustment screw (70 Fig. VII) in accordance with the weight of the individual dough piece. If they do not form into round dough balls, release the lock nut (71 Fig. VII) and turn the weight adjustment screw (70) clockwise or extend the rounding time by pushing in lever 83 (Fig. V). If the skin of the

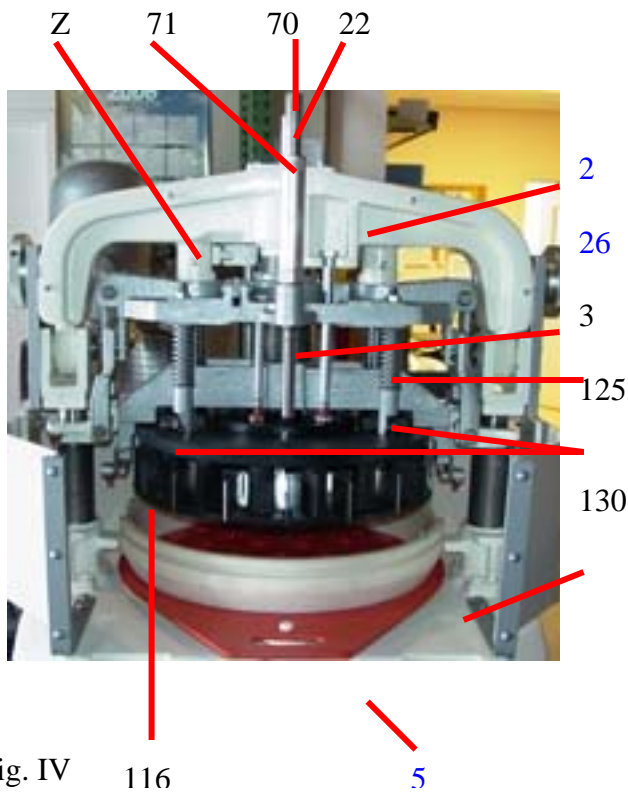


Fig. IV

rounded dough pieces becomes coarse or forms a nipple in the middle, turn the weight adjustment screw (70 Fig. VII) counterclockwise or reduce the rounding time. The first batch of dough pieces is used for set-up purpose and for the final cleaning of the machine head as well as of the cutter blades, these dough pieces should be thrown away.

7. Rounding Time Adjustment

Push Rod (83 Fig. V) Setting	Number or Rounding Revolutions
1	5
2	9
3	13
4	17
0	0

NOTE: Adjust rounding push rod only when machine is idling

8. Dividing Without Rounding

Turn weight adjustment screw 70 to its top position. Set the push rod (83 Fig. V) to Zero, turn rounding plate upside down and place dough on it. Slide the plate into the machine and start the machine.

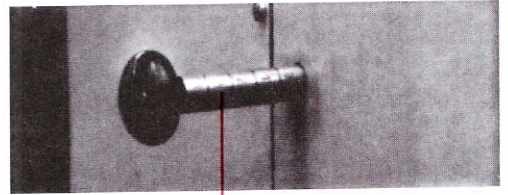


Fig. V

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9. Cutter Head Cleaning

Prior to cleaning set Main Switch to 'O'. Remove head covers and turn weight adjustment screw 70 to its top position. Remove the dough entrapment ring (124 Fig. III) from the machine and loosen both hand-wheels (68 Fig. VII) on each side of the machine head, thus allowing for the head to be tilted to the back. Apply flat iron lever 177, supplied with the machine, to both pins (4 Fig. VI) and push the knife blades out of the piston. After cleaning push the blades back into the piston by again using the flat lever. Next, tilt the head back into working position and secure it tightly by the two handwheels. After proper cleaning replace the dough entrapment ring, set the weight adjustment screw 70 to the required height of the rounding area and secure it by locknut 71.

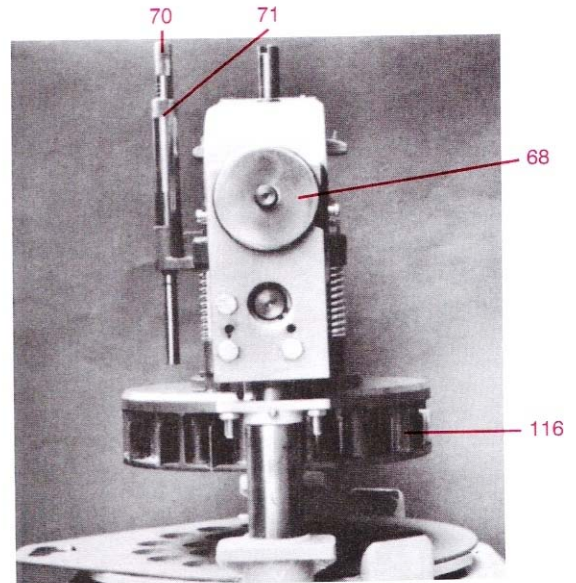


Fig. VII

10. Regular Cleaning

The dough entrapment ring (124 Fig. III) has to be cleaned daily. It is also recommended to grease the ring slightly after each cleaning. All dough deposits have to be cleaned from the grooves (D Fig. III) on the outside of the head and from the dough entrapment ring, along which the dough entrapment ring moves up and down. The machine **must not be washed or hosed down with water** this would cause the machine to rust and the machine eventually would seize up. The removal and mounting of the dough entrapment ring is described in item 4.

11. Manual Lubrication

All 5 grease nipples should be filled up at least once every 3 months, with surplus grease being wiped clean.



Fig. IX

182 a

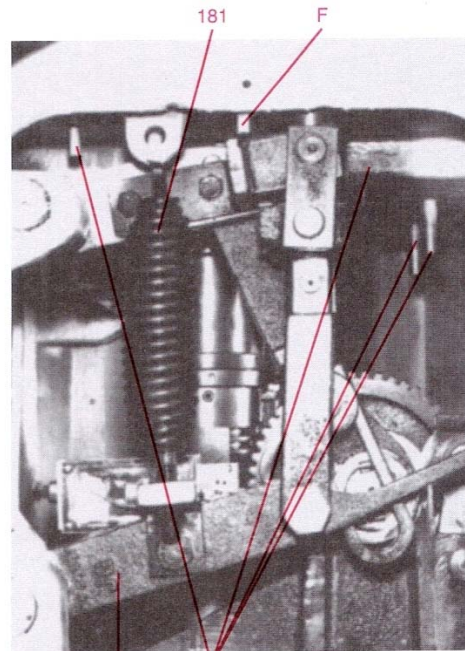


Fig. VIII

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E

12. Problems

- I. If the sequence of operations is not right;
The machine may have been plugged into a socket which changed its polarity. Check for such a mistake.
- II. In case of electrical failures, only a qualified electrician should be called in to check the machines.
- III. If slipping, the V-belts may be tensioned by adjusting the position of the motor.

I. Troubleshooting

- I. **Dough pieces do not have a smooth surface after rounding.**
Remove upper side base covers and check whether any of the two springs are broken (Part No. 181 – See Fig. VIII).
- II. **Machine divides unevenly (cutting knives protrude).**
Remove the upper rear base cover and check if any of the two springs (No. 182 a) are broken. (See Fig. IX part No. 182 a).
- III. **Machine does not stop and keeps on rounding.**
Remove the lower rear base cover and check whether any of the two springs (No. 182) are broken.
- IV. **Machine keeps on recycling and does not stop in the up position.**
DANGER: Do not touch the machine and simply push the emergency stop button: then disconnect machine cable from power source. Call an electrician to have the machine checked out.

V. Machine jams

Stop the machine by pushing the emergency stop button. Loosen spindles No. 22 and 70 (see Fig. IV) until they hit the end stop.

Put selector switch No. 212A to position 3 (reverse) (see Fig. I). Reconnect the machine and start the machine by pushing the two start buttons.

The machine should now go back to its original “up” position at which time you must stop the machine. You now must turn the selector switch to the standard operating position No. 2. If the motor did not start, disconnect the machine from the power supply again. Remove the lower rear base cover and turn the large V-belt pulley by hand in a clockwise motion until the machine is in the “up” position.

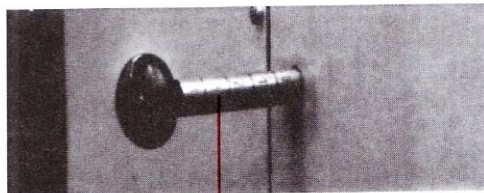


Fig. V

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Fig. I

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211

212A

214

VI. Machine stops during the dividing or rounding process.

The V-belts of the drive motor are not tight enough. Remove the lower base cover on the left side of the machine. Loosen the mounting bolts of the motor. Tighten the V-belts by moving the motor towards the front of the machine, then re-tighten motor mounting bolts.

Spare Part List

A66-0001	Housing
A66-0002	Arch
A66-0003	Knife Support
A66-0004	Ring Support
A66-0005	Pressure Plate
A66-0006	Sliding Piece
A66-0007	Flange Bearing
A66-0008	Bearing
A66-0009	Spring
A66-0010	Shaft
A66-0011	Roller
A66-0012	Bushing
A66-0012C	Bushing Cpl.
A66-0013	Pin
A66-0014	Roll Pin
A66-0015	Worm Gear
A66-0016	Spacer
A66-0017	Lock Nut
A66-0018	Oil Shield
A66-0019	V-Belt Sheave
A66-0020	Ring
A66-0021	Bushing
A66-0022	Pressure Spindle
A66-0023	Bearing Block
A66-0024	Flange
A66-0025	Guide Pin
A66-026L	Bracket Left
A66-026R	Bracket Right
A66-0027	Push Rod
A66-0028	Arm
A66-029L	Screw Left
A66-029R	Screw Right
A66-0030	Bolt
A66-0031	Bushing House
A66-0032	Snap Ring
A66-0035	Swivel Arm
A66-036L	Connection Rod Left
A66-036R	Connection Rod Right
A66-0037	Column
A66-0038	Column Housing
A66-0039	Screw
A66-0040	Pin F. Knife Support
A66-041L	Screw Left
A66-041R	Screw Right
A66-0042	Fork
A66-0043	Connection Rod
A66-0044	Shaft
A66-0045	Knife Locking
A66-046L	Arch Left
A66-046R	Arch Right
A66-0048	Fork
A66-0049	Bolt
A66-0050	Roller
A66-0051	Pick-up Lever
A66-0052	Main Shaft
A66-053L	Rock Arm Left
A66-053R	Rock Arm Right
A66-0055	Roller
A66-0057	Screw
A66-0059	Cutting Arm
A66-0061	Guide Bar
A66-0062	Rounding Cam
A66-0063	Pilot Disk
A66-0064	Bull Gear
A66-0065	Bushing

A66-0066	Pin
A66-0067	Pin
A66-0068	Knurled Lock Nut
A66-0069	Bearing Housing
A66-0070	Adjustment Screw
A66-0071	Lock Nut
A66-0072	Shaft
A66-0074	Washer
A66-0075	Shaft
A66-0077	Shaft with Retain Ring
A66-0078	Shaft
A66-0081	Switch Arm
A66-0083	Switch Rod
A66-0085	Knob for Push Rod
A66-0086	Push Rod
A66-0087	Set Screw
A66-0088	Latch
A66-0089	Pin F. Lever Rounder
A66-0090	Motor Support
A66-090A	Pump Support
A66-0091	Lever Rounder
A66-0092	Pin F. Bearing Housing
A66-0093	Pin F. Bearing Housing
A66-0094	Arm
A66-0095	Push Lever
A66-0096	Roller
A66-0097	Pin F. Bush Lever
A66-0098	Pin
A66-0101	Push Rod
A66-0102	Push Rod
A66-0103	Ex. Housing Cpl.
A66-0111	Spring Bracket
A66-0115	Hook Screw Type
A66-0116	Piston Knife Head Assy & Flange
A66-0124	Moulding Ring Type
A66-0125	Screw
A66-0126	Bearing Housing
A66-0127	Cover
A66-0128	Swivel Bear
A66-0129	Seal
A66-0137	Pulley F. Motor
A66-0138	Spring Bracket
A66-0143	V-Belt Pulley
A66-0152	Cover Front
A66-0153	Cover Rear
A66-157L	Pressure Arm Left
A66-157R	Pressure Arm Right
A66-0158	V-Belt
A66-0160	V-Belt Set
A66-0161	Motor
A66-0162	Cleaning Brush
A66-0167	Cable Guide
A66-0173	Screw
A66-0174	Screw
A66-0176	Bracket
A66-0177	Lever to Engage Knives
A66-0179	Spring F. Pressure Regulator
A66-0180	Spring F. Knives
A66-0181	Spring F. rounding Chamber
A66-0182	Spring
A66-182A	Spring F. Cutting Arm
A66-0185	Bracket F. Sensor
A66-0250	Safety Guard

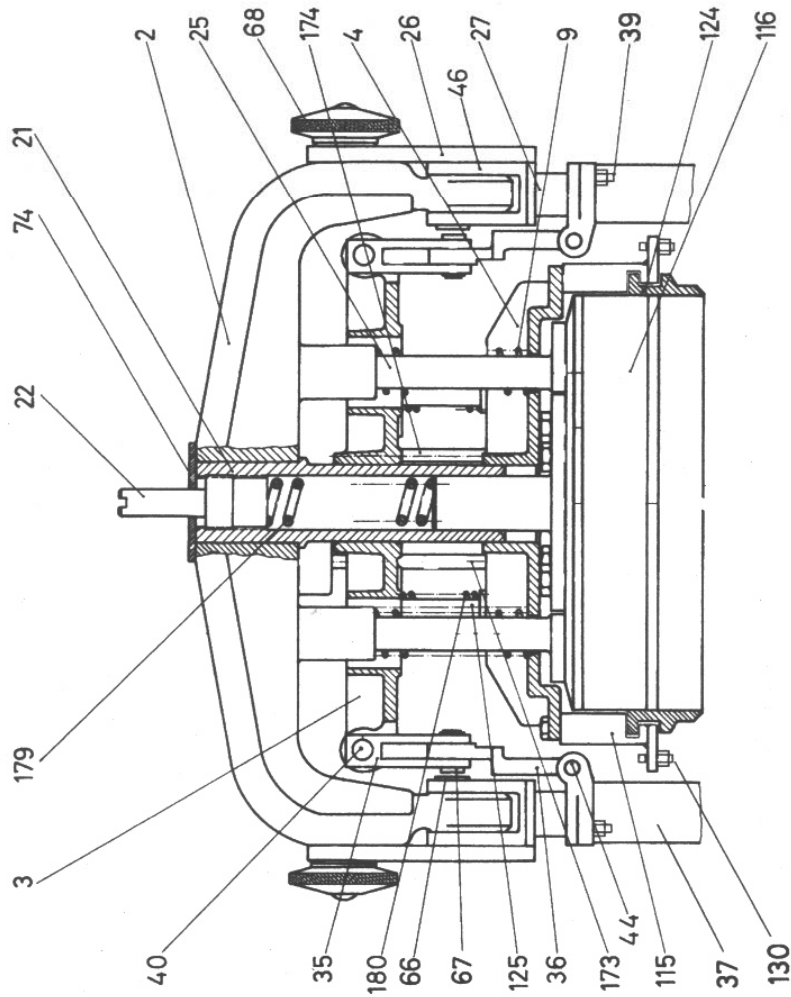
Please Find Electrical Parts at the End of this Manual with the Diagram

Type	Divisions	Dough Portions (ounces)	Plate No. Fully	Plate No. Semi/Easy
4/40 A	30	1.4 – 4.3	#45	#45
5/18 A	50	0.6 – 1.5	#50	#50
6/150 A	15	5.4 – 9.5	#415	#415
7/70 A	20	2.5 – 7.1	#420	#420
8/250 A	7	9.0 – 21.0	#47	#47
9/20 A	36	0.7 – 2.5	#326	#326
10/25 A	36	0.9 – 3.3	#336	#336
11/30 A	36	1.0 – 4.0	#46	#46
Q1	30	0.7 – 3.0	30Q1	30Q1
Q1	15	1.4 – 6.0	15Q1	15Q1
Q1	10	2.1 – 9.0	10Q1	10Q1
Q1	Cut		Q1S	Q1S
Q2	30	0.9 – 4.2	30Q2	30Q2
Q2	15	1.4 – 6.0	15Q2	15Q2
Q2	10	2.1 – 9.0	10Q2	10Q2
Q2	Cut		Q2S	Q2S
Q3	36	1.0 – 3.5	36Q3	36Q3
Q3	18	2.1 – 7.0	18Q3A	18Q3
Q3	12	3.2 – 10.6	12Q3A	12Q3
Q3	9	4.2 – 14.1		9Q3
Q3	6	6.4 – 21.6	6Q3	6Q3
Q3	3	12.7 – 42.3		3Q3
Q3	Cut		Q3S	Q3S
RH	Set up			RH
RH	Set up			RH-EASY

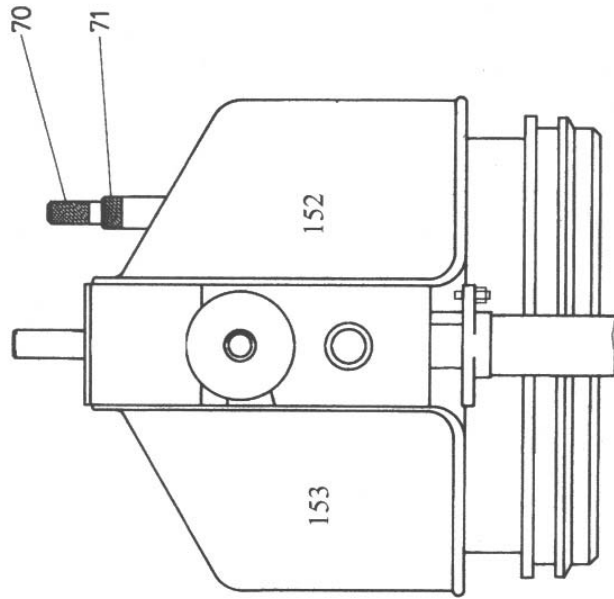
Specifications for Different Types of Fully Automatic Machines

A66-003A	Knife Support Type 11/30A
A66-003B	Knife Support Type 10/25A
A66-003C	Knife Support Type 9/20A
A66-004A	Ring Support Type 10/25A + 11/30A
A66-004B	Ring Support Type 9/20A
S-66/1	Moulding Plate Type 10/25A #336
S-66/2	Moulding Plate Type 11/30A #46
S-66/4	Moulding Plate Type 4/40A #45
S-66/5	Moulding Plate Type 5/18A 50 Parts
S-66/6	Moulding Plate Type 6/150A 15 Parts
S-66/7	Moulding Plate Type 7/70A 20 Parts
S-66/8	Moulding Plate Type 9/20A #326
A66-115A	Hook Screw Type 11/30A
A66-115C	Hook Screw Type 9/20A + 10/25A
A66-116A	Piston w/ Knife Head Assy Type 11/30A
A66-116B	Piston w/ Knife Head Assy Type 10/25A
A66-116C	Piston w/ Knife Head Assy Type 9/20A
A66-116D	Piston w/ Knife Head Assy Type 7/70A
A66-116E	Piston w/ Knife Head Assy Type 6/150A
A66-116F	Piston w/ Knife Head Assy Type 5/18A
A66-116G	Piston w/ Knife Head Assy Type 4/40A
A66-124A	Moulding Ring Type 11/30A
A66-124B	Moulding Ring Type 10/25A
A66-124C	Moulding Ring Type 9/20A
A66-124D	Moulding Ring Type 5/18A
A66-161A	Single Phase Motor 1,1 kw
A66-0200	Box CI-G UL
A66-207B	Timing RelayE57, 0x12F UL
A66-211B	On-Off Front Plate

Please check you Machine Type Label before Ordering!!!

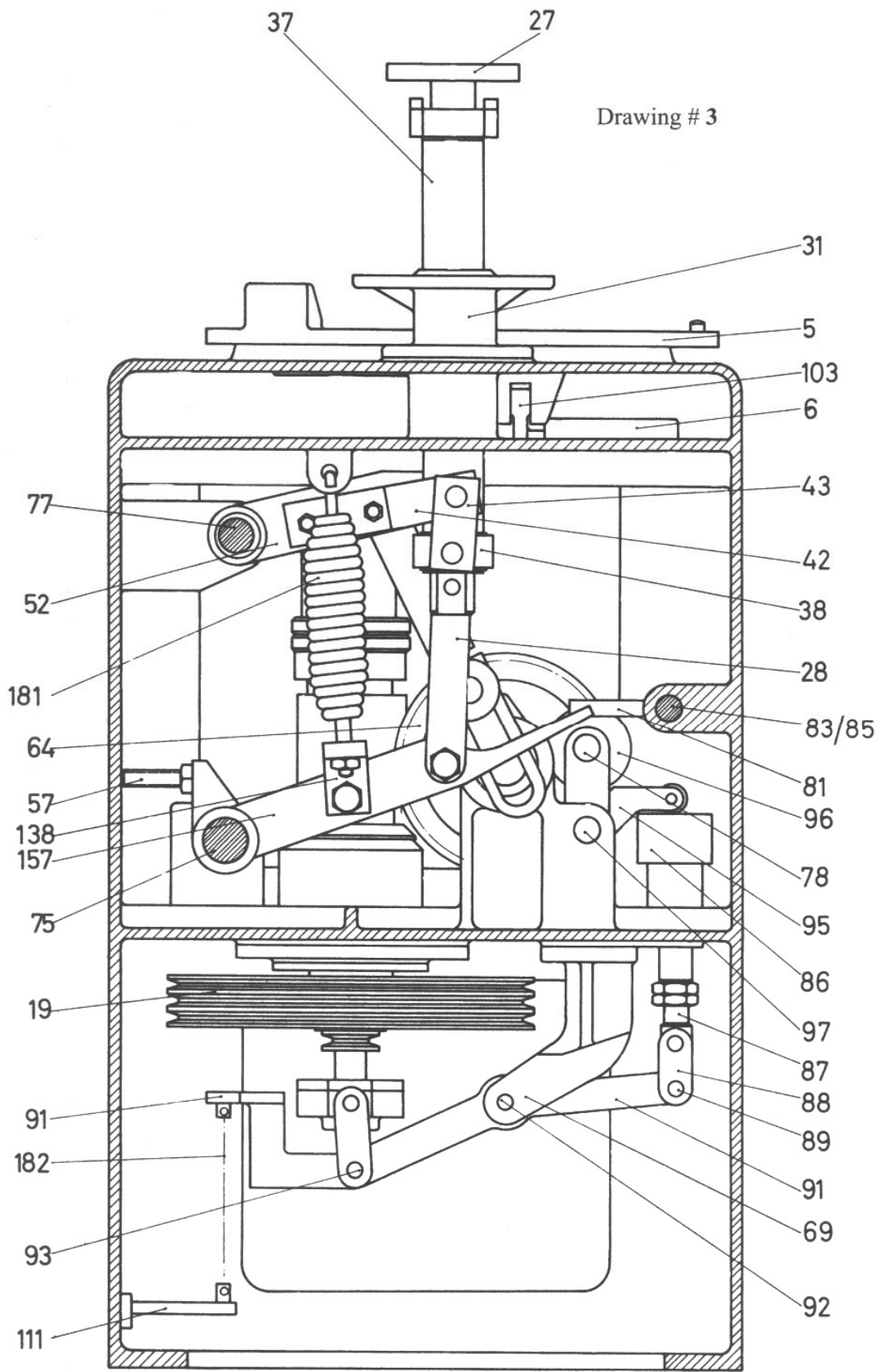


Drawing # 1

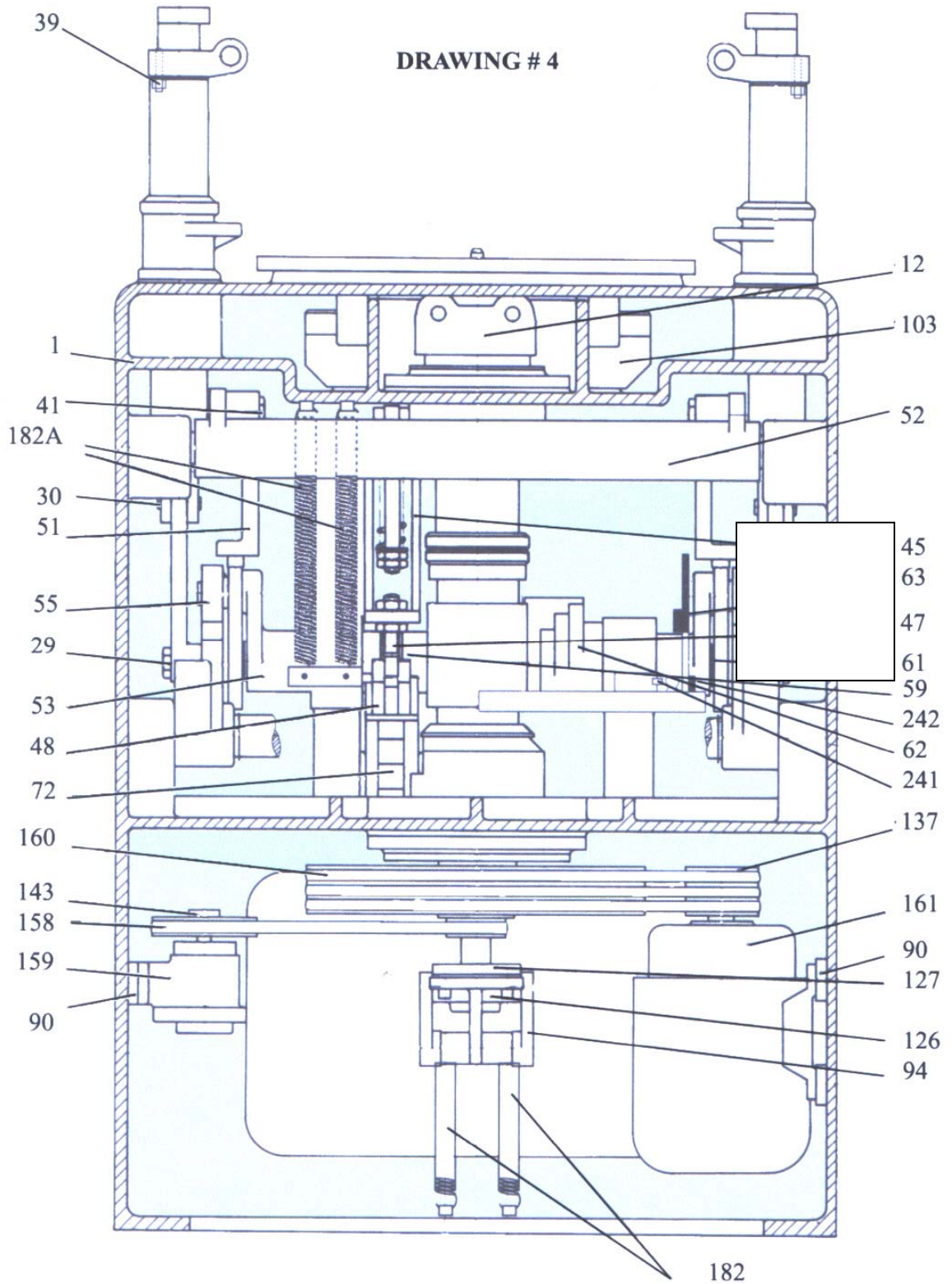


Drawing # 2

After unscrewing part no. 125a four times the knife can be taken out when head is turned. For mounting, line up the red markings on the piston knife



DRAWING # 4



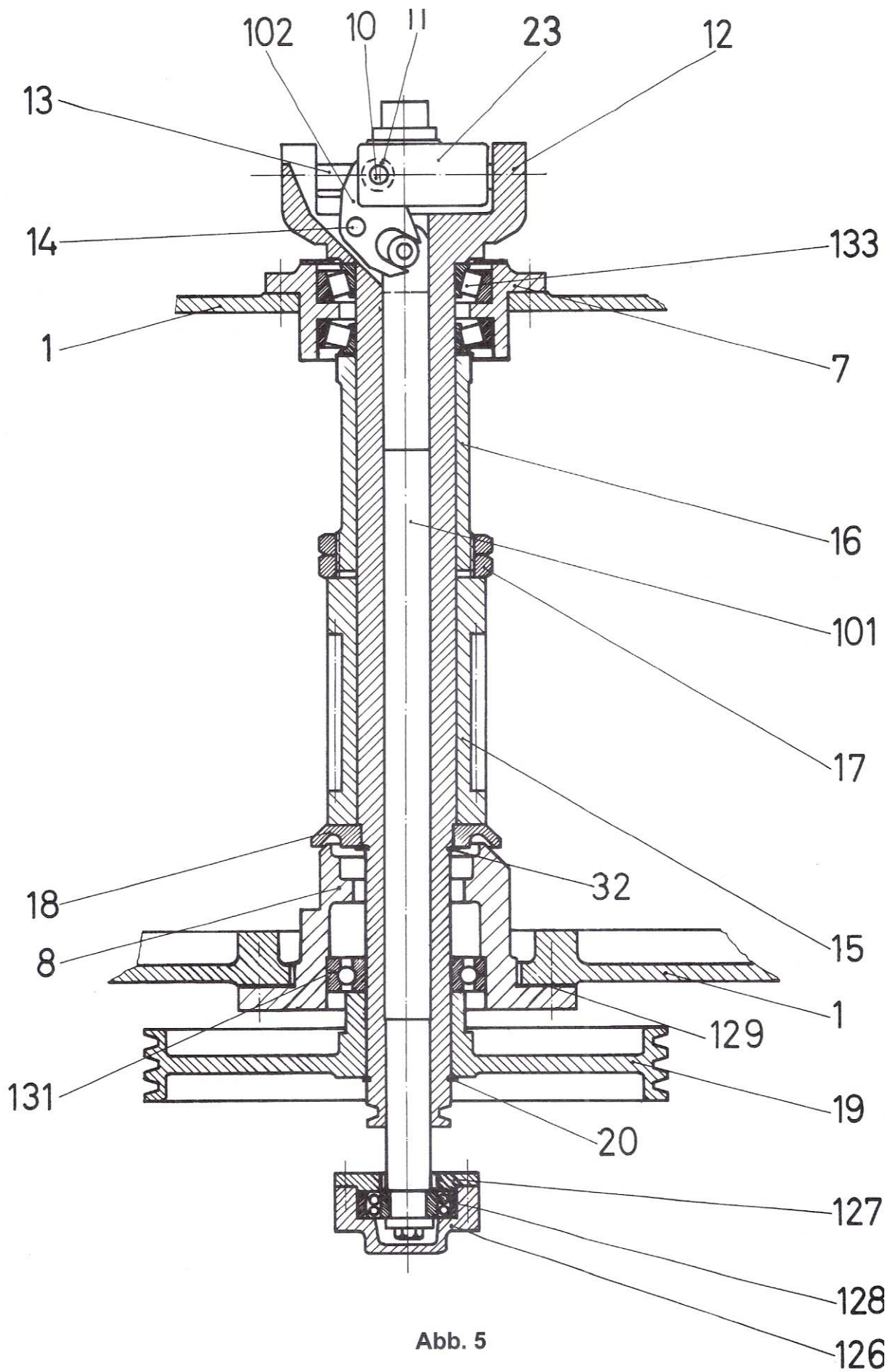
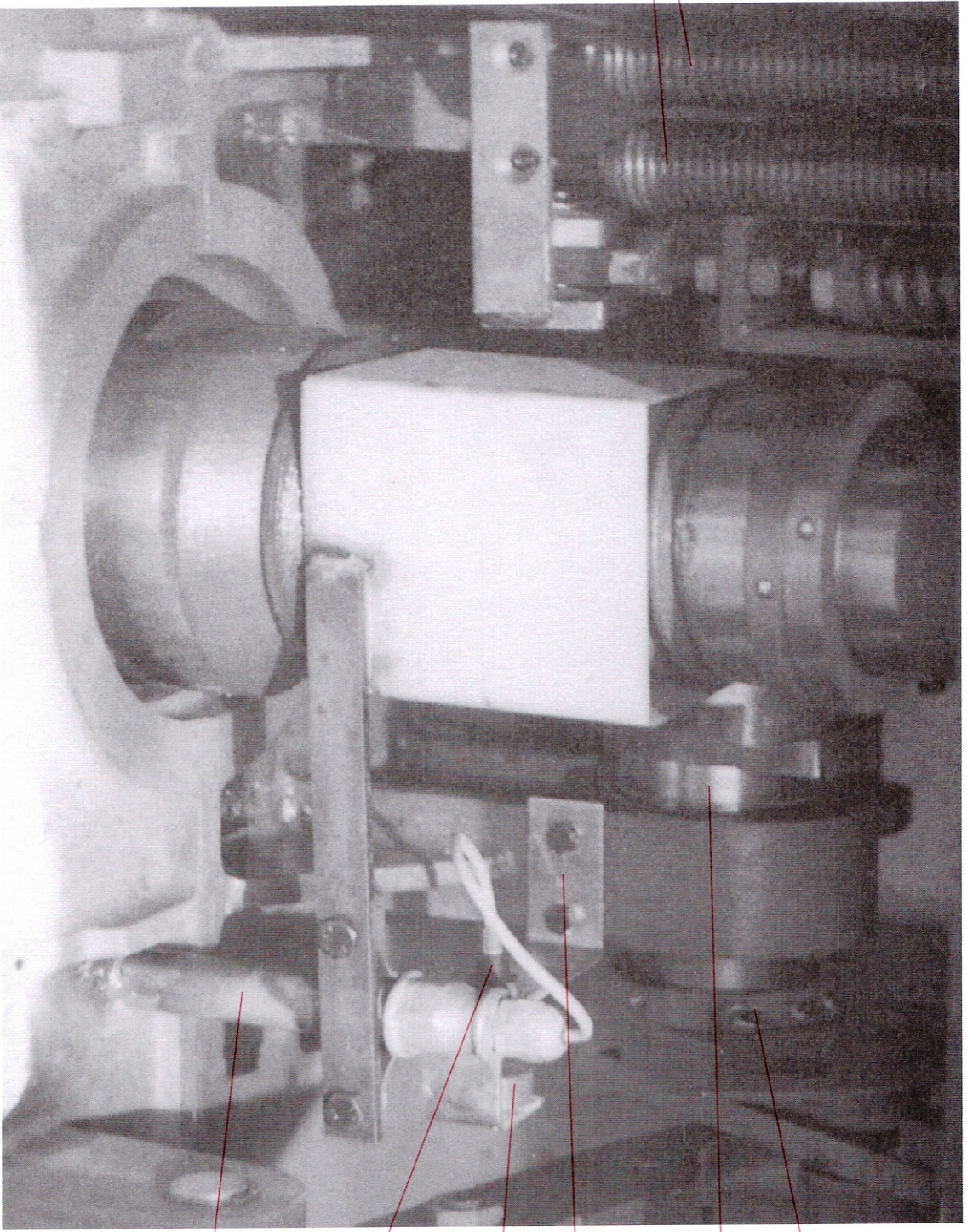


Abb. 5



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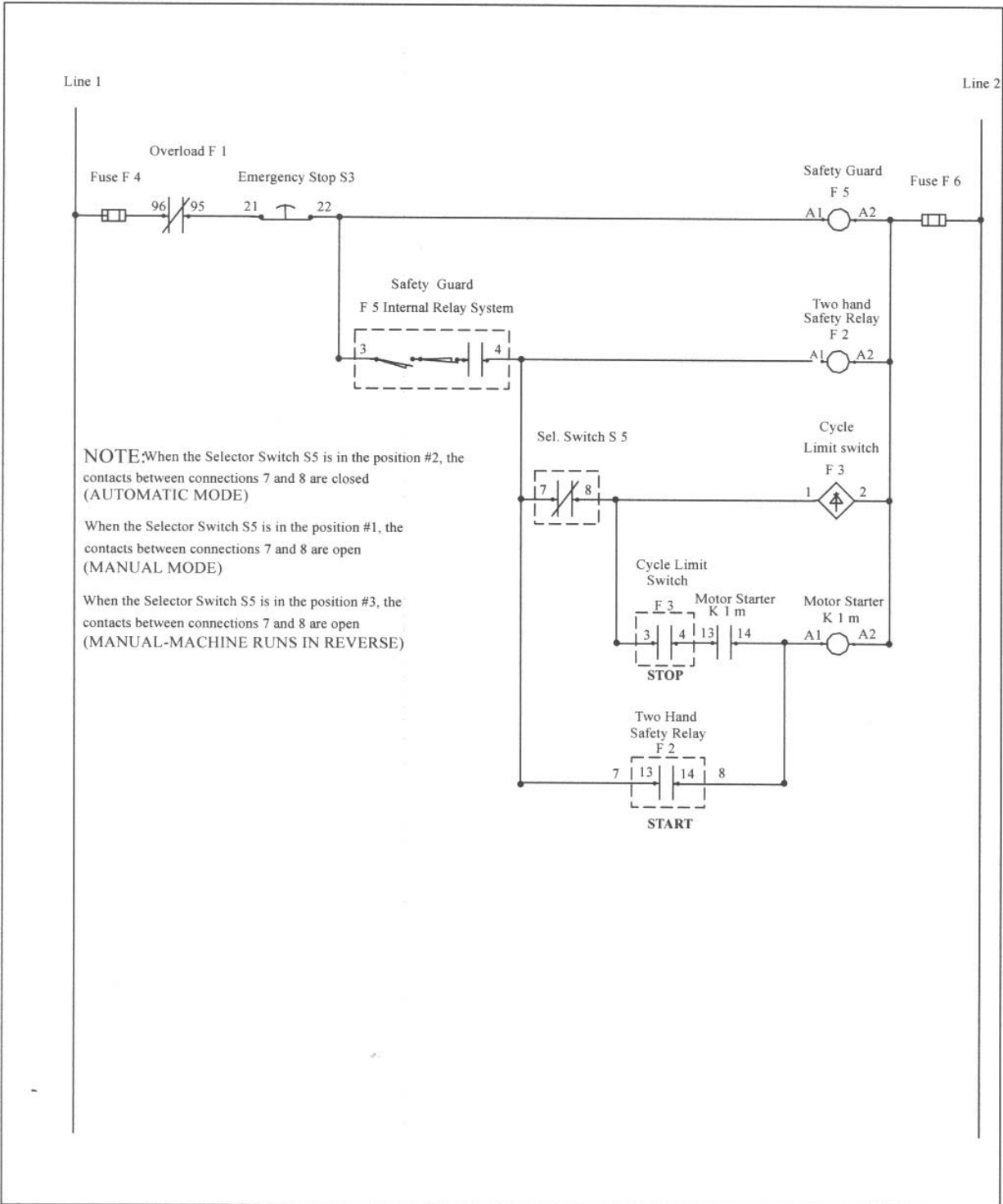
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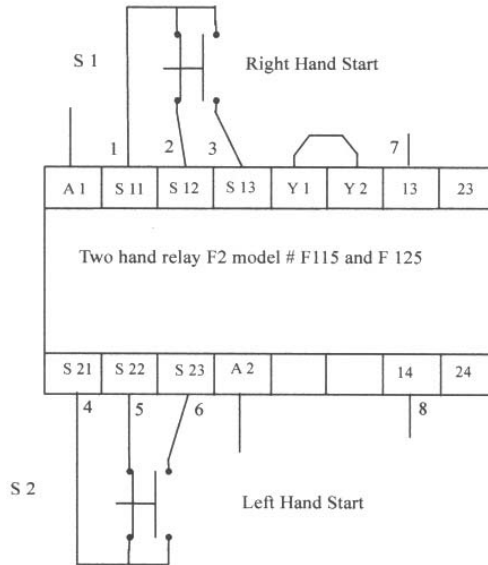
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Abb. 6



<p>ERIKA RECORD LLC 20 Vanderhoof Avenue Rockaway, New Jersey 07866</p>	<p>Date: July 7th. 2003 Drawing: H. Roerig Check: Moennecke</p>	<p>PAGE 1 OF 3</p>
<p>ELECTRICAL SCHEMATIC DIAGRAM Automatic Divider/Rounder Control wiring</p>	<p>U.S.A.: Rucker</p>	<p>ELA - 29</p>



The two hand relays, # F115 and # F125 are interchangeable, the only difference is the jumper
 In the # F115 the jumpers go between X 1 and X 2 , and in the # 125 the jumpers go between Y 1 and Y 2.

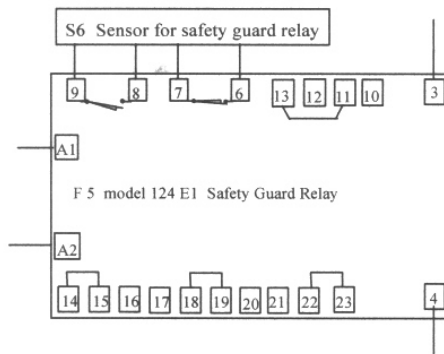
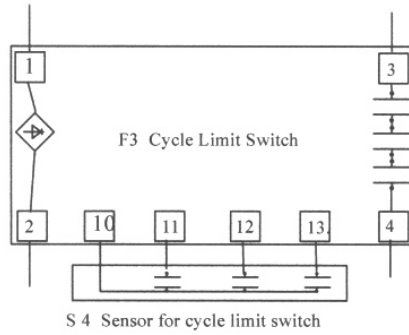


Diagram No. 29.1

	A66-300	Box
	A66-401	Panel (Standard)
X1	A66-210	Clam (1-4)
Q1	A66-402	Main Switch
K1m	A66-202	Contactor
F1	A66-205	Relay
F2	A66-207C	Timing Relay
S3	A66-408	Stop Button
S4	A66-241	Sensor
S1	A66-447	Start Button
S2	A66-447	Start Button
S5	A66-403	Selector Switch
F3	A66-240	Protection Switch
	A66-242	Magnet
	A66-217	Box
F4/F6	A66-307	Fuse Clamp
	A66-308	Fuse Holder
	A66-309	Fuse
	A66-310	Conductor Clamp
F5	A66-240A	Prot. Switch
S6	A66-241A	Sensor
	A66-242A	Magnet

Diagramm Nr. 29

