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Set-up & Operating Instructions For:

The John Hunt Little / Medium Champion Pie & Tart Machine.

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HANDBOOK FOR LITTLE & MEDIUM CHAMPION PIE & TARTS MACHINES

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CONTENTS

<u>TITLE:</u>	<u>PAGE:</u>
INSTALLATION	3
GENERAL	
HANDLING	
COMMISSIONING	
INITIAL SET-UP	
CURING TINS	5
REGULATING HEAT	6
DIGITAL THERMOSTAT	
SIMMERSTAT	
DIRECT SUPPLY TO ELEMENT (NO REGULATION)	
AIR RELEASE	8
WIZ-AIR SYSTEM	
AIR COMPRESSION FITTINGS	
BASE AIR EJECTION	
GENERAL OPERATION	10
3 PIECE DIE SET SYSTEM (FOR LIDDED PRODUCTS)	
ROTARY DIE SET SYSTEM (FOR OPEN PRODUCTS)	
NO SCRAP SYSTEM	
PRESSING ISSUES	
MAINTENANCE	13
CLEANING OF MACHINERY	
CLEANING OF DIE EQUIPMENT	
OILING & LUBRICATING	
HEALTH & SAFETY	
TROUBLESHOOTING	15
SPARE PARTS	16

INSTALLATION

GENERAL

YOUR PRESS WILL BE DELIVERED ON A WOODEN PALLET. IF YOU HAVE ORDERED ANY SUPPLEMENTARY ITEMS THESE WILL BE PACKED SEPERATELY ON THE SAME PALLET. DIE SETS ARE GENERALLY MOUNTED ON THE MACHINE, WHERE MORE THAN 1 DIE SET IS ORDERED THESE WILL BE PACKED SEPERATELY AS ABOVE.

OVERALL DIMENSIONS, WEIGHT, AND OTHER DETAILS ARE GIVEN IN FIGURE 1.

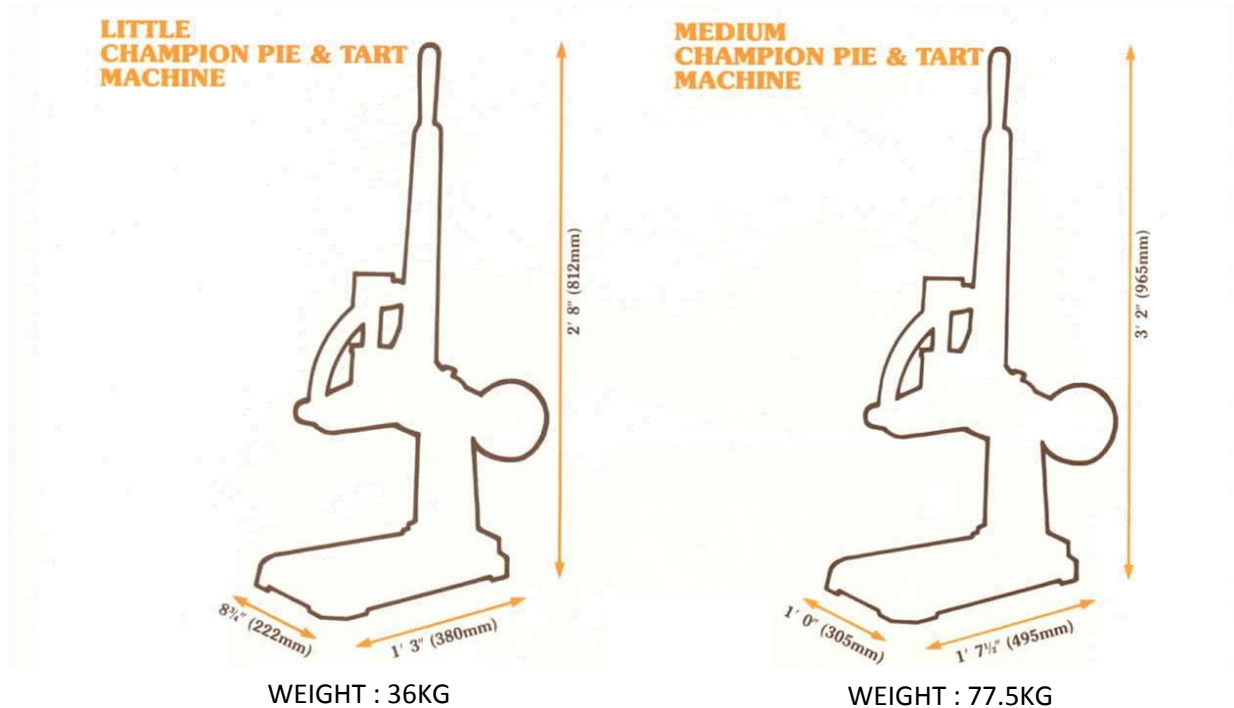


FIGURE .1

HANDLING

WE RECOMMEND THAT THE MACHINE IS HANDLED WITH A PALLET TRUCK OR TROLLEY AND IS MOVED AS LITTLE AS POSSIBLE ONCE POSITIONED. **WHEREVER POSSIBLE AVOID MANUAL HANDLING.** PLEASE ENSURE ENOUGH PEOPLE RELEVANT TO THE MACHINE WEIGHT, AND IN LINE WITH YOUR HEALTH & SAFETY POLICIES ARE INVOLVED IN LIFTING THE MACHINE WHERE NO ALTERNATIVE IS AVAILABLE.

COMMISSIONING

DIE SET COMPONENTS MAY BE GREASED BEFORE DISPATCH TO PREVENT RUSTING. IT IS RECOMMENDED THAT ANY EXCESS IS WIPED CLEAN.

MACHINES ARE GREASED AND OILED PRIOR TO DISPATCH. IN MOST CASES THIS WILL NOT CAUSE ANY ISSUES, HOWEVER UPON OCCASION EXCESS OIL MAY RUN DOWN THE MAIN DOWNSHAFT AND ON TO THE DISC. THIS IS NOT A LEAK AND NO CAUSE FOR CONCERN, SIMPLY WIPE AWAY ANY EXCESS AND AFTER A SHORT TIME THIS WILL STOP.

PLEASE NOTE : BEFORE OPERATING THE MACHINE. THE MACHINE SHOULD BE BOLTED IN POSITION USING THE BOLTS PROVIDED THROUGH THE 2 HOLES TOWARD THE REAR OF THE BEDPLATE.

WITH THE MACHINE SITED AND SECURED, EXCESS GREASE AND OIL WIPED CLEAN; PLEASE PROGRESS TO INITIAL SET-UP GUIDELINES.

INITIAL SET-UP

IN ORDER TO USE YOUR MACHINE YOU WILL NEED TO MOUNT THE DIE SET AS FOLLOWS;

- BASE DIE – THIS IS PLACED ON TO THE BASE OF THE MACHINE BY PLACING THE “PEG” ON THE UNDERSIDE OF THE BASE DIE INTO THE SITING HOLE IN THE CENTRE OF THE *BEDPLATE*.
- BLOCKING / LIDDING DIES – THESE DIES ARE ATTACHED TO THE DISC OF THE MACHINE UTILISING THE *HOOK SCREWS*. ONE OF THE *HOOK SCREWS* IS CHAMFERED AND HAS A FLAT EDGE, THIS SCREW SHOULD BE ON THE LEFT HAND SIDE AS YOU FACE THE MACHINE. PLACE THE SCREWS THROUGH THE GUIDE HOLES IN THE *DISC* AND TURN SLIGHTLY ANTI-CLOCKWISE TO SECURE IN POSITION. ON THE LEFT HAND SIDE OF THE *DISC* THERE IS A BRASS *DISC CATCH* THIS SHOULD BE ROTATED ANTI-CLOCKWISE AGAIN TO LOCK THE BLOCKING / LIDDING DIE IN POSITION.

YOU WILL NOW NEED TO CONNECT YOUR HEATING ELEMENT. AS STANDARD THESE ARE SUPPLIED WITH A 13 AMP STANDARD UK PLUG AND CAN BE PLUGGED DIRECTLY IN TO A WALL SOCKET WITH THE MOULDED 3 PIN CONNECTOR GOING DIRECTLY INTO THE ELEMENT. IF YOU HAVE PURCHASED A *SIMMERSTAT* OR *DIGITAL THERMOSTAT* PLEASE SEE **REGULATING HEAT** SECTION FOR MORE DETAILS.

CAUTION! ONCE THE HEATING ELEMENT IS CONNECTED TO AN ELECTRIC SUPPLY IT WILL BEGIN TO HEAT UP. DO NOT TOUCH THE DIE WITHOUT ADAQUETE PROTECTION.

FOR DETAILS ON CONNECTING YOUR AIR SUPPLY SHOULD YOU HAVE THE OPTION, PLEASE SEE **AIR RELEASE** SECTION.

CURING TINS

IT IS RECOMMENDED THAT ALL NEW TINS BE CURED BEFORE USE AS FOLLOWS:-

a) SLIGHTLY WARM AND WIPE CLEAN.

b) LIGHTLY GREASE WITH PURE LARD.

c) PLACE TIN(S) UPSIDE DOWN FOR TWO HOURS IN AN OVEN AT A TEMPERATURE NOT EXCEEDING 400 DEGREES FAHRENHEIT

d) REPEAT STEPS (b) AND (c) ONCE.

FOR THE FIRST FEW BAKES, THE TINS SHOULD BE HANDLED VERY CAREFULLY AND PREFERABLY GREASED WITH A SOFT BRUSH. CLOSE ATTENTION TO THESE INSTRUCTIONS WILL PRESERVE THE BAKED COAT AND WILL SUBSTANTIALLY INCREASE THE LIFE OF YOUR TINS.

REGULATING HEAT

HEAT IS REQUIRED IN THE MAJORITY OF CASES TO HELP IN PREVENTING THE PASTRY STICKING TO THE DIE ON RELEASE AND IN SOME CASES TO ASSIST IN THE PRESSING OUT OF BASES. THE HEAT REQUIRED TO ACHIEVE THIS WILL VARY DEPENDING ON THE FOLLOWING FACTORS:

- FRESHNESS OF DOUGH / PASTRY MIX
- TEMPERATURE OF DOUGH / PASTRY MIX
- AMBIENTE ROOM TEMPERATURE
- STICKINESS / TACKINESS OF THE DOUGH
- PATRICLE CONTENT OF THE MIX
- BASE INGREDIENTS
- HOW WET THE MIX IS
- QUANTITY OF DOUGH / PASTRY TO BE PRESSED
- SIZE OF PRODUCT TO BE PRESSED
- IS IT PRE-ROLLED

ALL THE ABOVE WILL HAVE AN EFFECT ON HOW MUCH HEAT IS REQUIRED.

DIGITAL THERMOSTAT

IF YOU HAVE PURCHASED A DIGITAL THERMOSTAT IT WILL HAVE A SINGLE PHASE PLUG FOR THE POWER SUPPLY. ON THE OTHER END IS THE BAYONET PROBE, THIS WILL NEED TO BE IN SITU ON THE DISC LOCKING IT INTO POSITION ON THE THERMOCOUPLE, THERE IS ALSO A 3 PIN MOULDED CONNECTOR BLOCK WHICH GOES DIRECTLY IN TO THE ELEMENT. THE BAYONET PROBE REGISTERS THE TEMPERATURE OF THE DIE AND RELAYS IT BACK TO THE THERMOSTAT WHICH WILL CUT POWER WHEN REQUIRED IN ORDER TO REGULATE THE TEMPERATURE WITHIN A SMALL TEMPERATURE RANGE.

ONCE THE THERMOSTAT IS SET-UP YOU SHOULD SELECT A TEMPERATURE. 40 DEGREES IS USUALLY A GOOD STARTING POINT, IF AFTER A SHORT PERIOD OF TIME EITHER THE DOUGH MIX IS STILL STICKING OR IT IS EXCESSIVELY DIFFICULT TO PRESS OUT THE BASE PASTRY, THE TEMPERATURE IS TO BE INCREASED GENTLY IN SMALL INCREMENTS UNTIL THE ISSUE IS RESOLVED. IF YOUR PASTRY MIX BEGINS TO "SHRINK BACK" THEN THE TEMPERATURE IS TOO HIGH AND THE HEAT SHOULD BE REDUCED. YOU ARE AIMING FOR A TEMPERATURE WHEREBY THE MIX DOES NOT STICK AND ALSO DOES NOT SHRINK BACK.

SIMMERSTAT

IF YOU HAVE PURCHASED A SIMMERSTAT IT WILL HAVE A SINGLE PHASE PLUG FOR THE POWER SUPPLY, ON THE OTHER END IS A 3 PIN CONNECTOR BLOCK WHICH FITS DIRECTLY IN TO THE END OF THE ELEMENT.

A SIMMERSTAT IS A HEAT CONTROL MECHANISM, IT IS NOT A THERMOSTAT. THAT IS TO SAY IT DOES NOT MAINTAIN THE DIE AT A SPECIFIC TEMPERATURE RANGE. THE NUMBERS ON THE OPERATING DIAL 1-5 GIVE AN IDICATION OF THE LENGTH OF TIME CURRENT IS SUPPLIED TO THE ELECTRIC ELEMENT, 1 BEING THE SHORTEST PULSE & 5 BEING CONSTANT .

PLEASE NOTE: SELECTING OPTION 5 WILL LEAVE A CONSTANT FLOW OF POWER TO THE ELEMENT.

THE SIMMERSTAT WILL ALLOW CURRENT TO THE ELEMENT AT INCREASING INTERVAL LENGTHS CORRESPONDING TO HOW HIGH A NUMBER IS SELECTED.

ON FIRST USE, IT IS RECOMMENDED YOU SELECT NUMBER 3 WITH THE DIAL. IF AFTER A SHORT PERIOD OF TIME EITHER THE DOUGH MIX IS STILL STICKING OR IT IS EXCESSIVELY DIFFICULT TO PRESS OUT THE BASE PASTRY, THE TEMPERATURE IS TO BE INCREASED GENTLY IN SMALL INCREMENTS (YOU CAN SELECT BETWEEN NUMBERS) UNTIL THE ISSUE IS RESOLVED.

THE LIGHT ON THE SIMMERSTAT WILL INDICATE WHEN TURNED ON AND OFF.

CAUTION: SHOULD YOU STOP PRODUCTION FOR ANY LENGTH OF TIME IT IS ESSENTIAL TO SWITCH THE SIMMERSTAT TO THE OFF POSITION. IF THIS IS NOT DONE THE DIE MAY WELL OVERHEAT CAUSING POSSIBLE DAMAGE.

DIRECT SUPPLY TO ELEMENT

WHEN USING THE DIE EQUIPMENT WITH AN ELECTRIC ELEMENT AND NOT USING A SIMMERSTAT OR THERMOSTAT, GREAT CARE MUST BE TAKEN TO ENSURE THAT THE DIE DOES NOT OVERHEAT. FIRST PLUG IN THE DIE TO THE SUPPLY AND SWITCH ON. HEAT THE DIE UNTIL IT IS HOT, THEN SWITCH OFF THE SUPPLY. ONCE THE DIE COOLS DOWN THROUGH USE – SWITCH IT ON AGAIN, AND REPEAT.

CAUTION! DIE SETS CAN BECOME VERY HOT AND SHOULD NOT BE HANDLED WITHOUT APPROPRIATE PROTECTIVE HAND WEAR. PLEASE ALLOW THE DIES SUFFICIENT TIME TO COOL BEFORE HANDLING.

AIR RELEASE

AIR RELEASE IS A SYSTEM THAT HELPS BOTH, LIFTING OF PRODUCTS AND WHERE APPLICABLE BASE EJECTION.

WHEN PASTRY IS PLACED IN TO A CONTAINER IT IS FULL OF SMALL POCKETS OF AIR, THESE ARE FORCED OUT OF THE CONTAINER DURING THE BLOCKING OUT OF A BASE. DUE TO THE AIR BEING REMOVED THIS EFFECTIVELY CAUSES A VACUUM WITHIN THE CONTAINER "SUCKING" IT TO THE DIE. IT WAS WIDELY BELIEVED THAT DEEP, STRAIGHT SIDED CONTAINERS WERE THE WORST AFFECTED, WHILST THIS IS TRUE MOST CONTAINERS WILL SEE AN IMPROVEMENT WITH THE USE OF AIR RELEASE. FOILS CAN BECOME DISTORTED SHOULD A VACUUM BE GENERATED AND TINS CAN SUFFER FROM LIFTING AND REQUIRE ADDITIONAL HELP TO BE FREED. *KNOCK OFF PINS* ARE PRESENT ON MOST DIES AND WILL AID IN PUSHING THE CONTAINER FREE AS WELL. THE AIR IS PASSED THROUGH A BRASS *AIR VALVE* IN THE CENTRE OF THE DIE.

WIZ-AIR SYSTEM

THE WIZ AIR SYSTEM IS A SILENT RUNNING TABLE TOP COMPRESSOR THAT PLUGS IN TO THE ELECTRIC SUPPLY VIA A SINGLE PHASE SOCKET. THE WIZ AIR CONNECTS TO THE BLOCKING DIE VIA THE *ELBOW* AIR FITTING BEING PUSHED ON TO THE BRASS *AIR INLET PIPE* OF THE DIE, A SMALL COLLAR AROUND THE END OF THE *ELBOW* CAN BE DRAWN BACK AND WILL ALLOW THE *ELBOW* TO BE REMOVED FROM THE *INLET PIPE* IF REQUIRED. ONCE CONNECTED AS ABOVE THE WIZ-AIR SHOULD BE TURNED ON VIA THE SWITCH ON THE UNIT. THIS WILL THEN BE FULLY FUNCTIONAL, THE UNIT CANNOT GENERATE MORE THAN 2.5BAR – 3BAR WHICH MEANS IT WILL NEVER GENERATE TOO MUCH AIR SUPPLY TO CAUSE PROBLEMS AND THEREFORE DOESN'T NEED REGULATING. ANY FORM OF AIR SUPPLY WILL BE SUFFICIENT, YOU ARE ONLY LOOKING TO REPLACE THE AIR FORCED OUT DURING THE PRESSING PROCESS.

THE WIZ-AIR IS NOT COMPATIBLE WITH BASE AIR EJECTION.

AIR COMPRESSION FITTINGS

IF YOU HAVE BEEN SUPPLIED THE MACHINE WITH AIR FITTINGS ATTACHED, YOU WILL NEED TO CONNECT YOUR OWN COMPRESSOR TO THE FITTINGS ON THE SIDE OF THE MACHINE AND AS WITH THE WIZ-AIR CONNECT THE AIR ELBOW TO THE DIE AIR INLET PIPE (SEE ABOVE FOR MORE INFORMATION). AIR FLOW FROM YOUR COMPRESSOR WILL NEED REGULATING TO ANYTHING BETWEEN 1.5BAR – 3BAR USING THE REGULATOR AND DIAL ON THE SIDE OF THE MACHINE.

BASE AIR EJECTION

IF YOU HAVE BASE AIR EJECTION TO AID IN THE REMOVING OF PRODUCTS ONCE PRESSED, YOUR BASE DIE WILL HAVE AN AIR CONNECTION SIMILAR TO THE ABOVE. THIS WILL BE THE AIRLINE LOCATED ON THE UNDERSIDE OF THOSE FITTINGS TO THE LEFT OF THE MACHINE AND IS ATTACHED IN THE SAME FASHION AS THE BLOCKING DIE.

YOU SHOULD PRESS YOUR PRODUCT AS NORMAL. YOUR PRODUCT, DUE TO THE AIR FLOW THROUGH THE BASE SHOULD BE LIFTED SLIGHTLY BEYOND THE TOP OF THE BASE. IF THIS IS NOT

THE CASE YOU CAN INCREASE THE AIR FLOW USING THE *AIR FLOW SWITCH* (NOT THE REGULATOR) ON THE FITTINGS TO THE LEFT OF THE MACHINE. ADJUST THIS SWITCH UNTIL YOUR PRODUCT IS AT AN APPROPRIATE HEIGHT FOR YOU TO WORK WITH.

GENERAL OPERATION

THE GENERAL OPERATION OF THE MACHINE IS AS FOLLOWS ENSURING DIES ARE APPROPRIATELY HEATED AND AIR RELEASE SYSTEMS TURNED ON (WHERE APPLICABLE):

3 PIECE DIE SET SYSTEM (FOR LIDDED PRODUCTS)

THE BLOCKING DIE SHOULD BE MOUNTED ON THE MACHINE AS DETAILED ABOVE AND THE BASE DIE LOCATED ON THE BED PLATE.

PLACE YOUR FIRST CONTAINER WITH AN AMOUNT OF PASTRY / DOUGH MIX INSIDE (THIS DOES NOT NEED TO BE WEIGHED), PULL THE *LEVER ARM HANDLE* UNTIL THE MACHINE “BOTTOMS” THIS IS INDICATED BY THE *HEAD* OF THE *DOWNSHAFT* TOUCHING THE *STAND*, THEN RETURN THE *LEVER ARM* BACK TO ITS STARTING POSITION. YOU SHOULD NOW HAVE A BASE PASTRY PRESSED IN TO YOUR CONTAINER WITH EXCESS PASTRY OVERHANGING THE EDGE. IF THE RESULT IS NOT SATISFACTORY YOU MAY NEED TO ADD MORE PASTRY MIX TO ENSURE COMPLETE COVERAGE OF THE CONTAINER.

REMOVE THE CONTAINER FROM THE BASE DIE AND PLACE TO ONE SIDE. REPEAT THE PROCESS FOR THE ENTIRE BATCH. PLACE YOUR FILLING IN TO EACH PRESSED OUT BASE AND PLACE A LID DISC ON TOP.

YOU SHOULD THEN CHANGE YOUR BLOCKING DIE TO YOUR LIDDING DIE, ENSURING THE *DISC CATCH* IS IN THE LOCKED POSITION AND PASS EACH PRODUCT BACK THROUGH THE MACHINE FOLLOWING THE SAME PROCESS. THE LIDDING DIE WILL CRIMP, SEAL AND TRIM OFF ANY EXCESS.

YOU SHOULD NOW HAVE YOUR COMPLETED PRODUCT.

ROTARY DIE SET SYSTEM (FOR OPEN PRODUCTS)

THE BLOCKING DIE SHOULD BE MOUNTED ON THE MACHINE AS DETAILED ABOVE AND THE BASE DIE LOCATED ON THE BED PLATE.

PLACE YOUR FIRST CONTAINER WITH AN AMOUNT OF PASTRY / DOUGH MIX INSIDE (THIS DOES NOT NEED TO BE WEIGHED), PULL THE *LEVER ARM HANDLE* UNTIL THE MACHINE “BOTTOMS” THIS IS INDICATED BY THE *HEAD* OF THE *DOWNSHAFT* TOUCHING THE *STAND*, WHILST HOLDING THE *LEVER ARM* IN POSITION WITH YOUR RIGHT HAND YOUR LEFT HAND SHOULD BE USED TO OPERATE THE CUTTING RING ON THE BLOCKING DIE VIA THE BLACK HANDLE ON THE SIDE OF IT. THIS WILL TRIM OFF EXCESS PASTRY AND ALSO LEAVE ANY CRIMP DESIGN BEHIND. YOU SHOULD CONTINUE DRAWING THE ROTARY DIE HANDLE TOWARD YOU AS YOU RETURN THE *LEVER ARM* BACK TO ITS STARTING POSITION, PUSH THE ROTARY DIE HANDLE AWAY FROM YOURSELF TO RELEASE ANY EXCESS PASTRY STUCK TO THE CUTTING RING. IF THE RESULT IS NOT SATISFACTORY YOU MAY NEED TO ADD MORE PASTRY MIX TO ENSURE COMPLETE COVERAGE OF THE CONTAINER.

PLACE YOUR INGREDIENTS IN TO THE PASTRY SHELL TO COMPLETE YOUR PRODUCT.

NO SCRAP SYSTEM

THE NO SCRAP SYSTEM HAS A CUTTING RING THAT IS FIXED IN PLACE AND EFFECTIVELY PREVENTS PASTRY FROM ESCAPING, THEREFORE PRODUCING “NO SCRAP”.

IN ORDER TO UTILIZE THIS SYSTEM YOU WILL NEED TO HAVE THE ABILITY TO ACCURATELY WEIGH OUT PASTRY.

TRIAL AND ERROR WILL ESTABLISH THE CORRECT WEIGHT OF PASTRY TO LINE THE CONTAINER. MAKE A NOTE OF THIS WEIGHT.

MOUNT THE CONTAINER IN THE BASE DIE, DRAW THE LEVER ARM HANDLE UNTIL THE MACHINE IS BOTTOMED AND THEN RELEASE THE LEVER ARM – THERE IS NO CUTTING RING HANDLE TO OPERATE ON THIS TYPE OF DIE. DO A TEST WITH THE WEIGHT AND ASSESS THE RESULTS. IF THE PRODUCT IS NOT COMPLETE ADD A LITTLE MORE PASTRY AND TEST AGAIN.

PLEASE NOTE : IF YOU ARE USING A NO SCRAP SYSTEM TO PRODUCE A LIDDED PRODUCT, THERE MUST BE ENOUGH PASTRY FOR THE LID TO SEAL TOO.

CAUTION! DIE SETS CAN BECOME VERY HOT AND SHOULD NOT BE HANDLED WITHOUT APPROPRIATE PROTECTIVE HAND WEAR. PLEASE ALLOW THE DIES SUFFICIENT TIME TO COOL BEFORE HANDLING.

PRESSING ISSUES

ISSUES CAN ARISE DURING PRESSING AND IT CAN APPEAR DIFFICULT OR EXCESSIVE TO PRESS YOUR PRODUCT. WITH THE MASSIVE VARIETY OF SHAPES, SIZES, AND DOUGH MIXES. THERE ARE A NUMBER OF THINGS TO CONSIDER THAT MAY HELP IMPROVE THE PROCESS.

INITIALLY, THE PASTRY. MOST TYPES OF PASTRY WORK WITH OUR MACHINES AND DIE SETS, HOWEVER YOU MAY NEED TO ALTER HOW YOU CURRENTLY WORK TO GET THE BEST RESULTS.

- THE IDEAL TEMPERATURE OF THE DIE HAS BEEN ADOPTED AND AIR RELEASE IS AVAILABLE AND TURNED ON.
- PASTRY IS AS FRESH AS IS REASONABLY PRACTICABLE.
- PASTRY IS AS NEAR TO ROOM TEMPERATURE AS POSSIBLE, IF THE PASTRY IS TOO COLD YOU WILL FIND IT DIFFICULT TO PRESS. ALLOWING THE PASTRY TO REST AT ROOM TEMPERATURE FOR AROUND AN HOUR BEFORE HAND WILL IMPROVE THE PRESSING PROCESS.
- FOR LARGER, DEEPER PRODUCTS YOU MAY BE BEST SERVED TO PRE-ROLL YOUR PASTRY OR AT THE LEAST ENCOURAGE IT OUT IN TO A THINNER MORE DISC LIKE SHAPE.
- HOT WATER PASTRY NEEDS TO BE DIVIDED AND HAVE TIME TO RELAX TO GET THE BEST RESULTS.
- PRE-ROLLED PASTRY IS EASIER TO FORM IN TO SHAPE THAN A BALL OF PASTRY.
- THE MACHINE IS WELL LUBRICATED (SEE MAINTENANCE)
- THE MACHINE IS FUCTIONING CORRECTLY.

NOTES

USE THIS AREA TO MAKE ANY NOTES ABOUT YOUR PRODUCT/MACHINE SPECIFICS, ETC...

MAINTENANCE

CLEANING OF MACHINERY

IT IS ESSENTIAL FOR HEALTH & SAFETY PURPOSES AND GENERAL MAINTENANCE OF THE MACHINERY THAT CLOSE ATTENTION BE PAID TO REGULAR AND SYSTEMATIC CLEANING.

PLEASE NOTE: ANY POWER SUPPLY SHOULD BE DISCONNECTED

AT THE END OF EACH DAY (OR SHIFT) THE MACHINE SHOULD BE CLEANED. LOW PRESSURE COMPRESSED AIR TOOLS CAN BE VERY USEFUL FOR REMOVING PASTRY, ETC FROM DIFFICULT TO REACH PLACES. WEAR PROTECTIVE GLASSES AND MAKE SURE THAT THE AREA IS CLEAR OF OTHER PERSONNEL.

WIPE THE MACHINE DOWN WITH PROPRIETARY CLEANING PRODUCTS. DO NOT POWER WASH OR IMMERSE THE MACHINERY IN WATER. THOROUGHLY DRY THE MACHINES.

SOME OF OUR MACHINES INCORPORATE HEATING ELEMENTS. EVEN THOUGH THE MACHINE IS NO LONGER IN OPERATION THE DIE EQUIPMENT MAY STILL BE HOT. BE AWARE OF THIS FACT BEFORE CARRYING OUT ANY CLEANING.

GREASING AND OILING THE MACHINE ON A MONTHLY TO QUARTERLY BASIS WITH FOODSAFE LUBRICANTS IS RECOMMENDED AND WILL SEVERELY IMPROVE THE ONGOING PERFORMANCE OF YOUR MACHINE.

ONLY USE FOOD SAFE LUBRICANTS SUCH AS FOODLUBE, ETC

PLEASE NOTE: NEVER LUBRICATE YOUR MACHINE WITH VEGETABLE OIL, THIS WILL CAUSE THE MACHINE TO CEASE UP AND BECOME UNUSABLE.

CLEANING OF DIE EQUIPMENT

CLEAN THE DIE AFTER EACH USE. CAUTION: THE DIE EQUIPMENT MAY BE HEAVIER THAN YOU IMAGINE! IT MAY ALSO BE HOT - SO WEAR PROTECTIVE GLOVES. REMOVE ANY BAKED ON PASTRY WITH A STIFF BRUSH. WIPE CLEAN. ALWAYS DRY THOROUGHLY AFTER CLEANING. DO NOT IMMERSE IN WATER. LUBRICATE WITH FOOD QUALITY GREASES WHERE APPROPRIATE. CHECK THE SPRINGS ARE FUNCTIONING CORRECTLY.

OILING & LUBRICATING

IT IS IMPORTANT TO OIL THE MACHINE ON A REGULAR BASIS COMPARIBLE TO THE AMOUNT OF USE. MONTHLY TO QUARTERLY SHOULD BE SUFFICIENT. OIL / GREASE THE *DOWNSHAFT* ABOVE THE *STAND* AND EACH OF THE FOUR OIL PORTS (1 EITHER SIDE OF THE *LEVER ARM* AND 1 ON THE TOP AND BOTTOM OF THE *LINK*). **PLEASE NOTE : DO NOT FILL THESE HOLES OR OTHERWISE BLOCK THEM, CLEAN THEM REGULARLY REMOVING ANY BUILT UP PASTRY DEPOSITS.**

ONLY USE APPROVED FOOD GRADE OILS & LUBRICANTS SUCH AS FOODLUBE, OR SHELL CASSIDA.

THE DIE MAY REQUIRE LUBRICATION TO MOVING PARTS ASWELL.

HEALTH & SAFETY

- ENSURE THE MACHINE IS SECURED TO A WORK BENCH BEFORE USE.
- AVOID MANUAL HANDLING WHEN MOVING THE MACHINE.
- TAKE GREAT CARE WHEN HANDLING DIE EQUIPMENT, IT MAY BE HOT! AND THEY ARE HEAVY. USE APPROPRIATE PROTECTIVE EQUIPMENT.
- MACHINES AND DIES SHOULD BE CLEANED AND DRIED AFTER EACH PRODUCTION CYCLE.
- ENSURE OPERATORS HANDS ARE FREE OF THE PRESSING AREA, DURING OPERATION.
- ONLY 1 PERSON SHOULD OPERATE THE MACHINE AT ANY GIVEN TIME.
- IF A COMPONENT FAILS, ELECTRICAL OR MECHANICAL: CEASE OPERATION, TURN OFF ANY POWER SUPPLY AND CONTACT JOHN HUNT ON 01204 532 798.
- ALWAYS WEAR PROTECTIVE GLASSES WHEN REMOVING DEBRIS FROM MACHINE AND DIES WITH COMPRESSED AIR TOOLS.

TROUBLESHOOTING

FAULT DIAGNOSIS AND REMEDIAL ACTION

Issue	Action to be taken	Still Faulting
Machine Operation Difficult	Apply oil to the 4 oiling wells and grease main spindle. Clean with WD40 first. <u>PLEASE NOTE: Do not use vegetable oil.</u> Use a food safe lubricant i.e. Foodlube	Link Arm/Link Pins could be worn or distorted & in need of replacement.
Die Equipment Difficult to Use	Disassemble die equipment. Clean all surfaces with stiff brush. Apply grease to metal to metal surfaces. Do NOT immerse die equipment in water. Always clean & dry after use.	Send to JH for diagnostic.
Die Equipment Not Heating	Element Fault/Element Power Cable	
Die Equipment Not Releasing Containers efficiently	AIR RELEASE: Check air valve and clean where appropriate. Increase air pressure where possible. Check pipe systems for leaks.	Send to JH for diagnostic.
	NON AIR RELEASE: Remove, clean & grease Knock off pins.	
Lever Casting does not return to upright position.	Check return spring. Lubricate main downshaft.	
Not Pressing to Full Depth.	Hold back rotary handle through full travel of lever.	Damaged Link Pins/Link.

IF YOUR ISSUE IS NOT OUTLINED ABOVE, OR IF THE REMEDIAL SOLUTION HAS NOT BEEN SUCCESSFUL PLEASE CONTACT JOHN HUNT ON 01204 532 798

SPARE PARTS

Product Code	Part No.	Description
PIEL23	1	BEDPLATE
PIEL26	2	STAND
PIEL28	3	LEVER
PIEL12	4	DOWNSHAFT WITH HEAD
PIEL06	5	DISC (CASTING ONLY)
PIEL15	6	LINK - STANDARD (5/8" BORE)
PIEL32	7	LEVER SIDE SHAFT
PIEL04	8	TOP LINK PIN
PIEL25	9	BOTTOM LINK PIN
	10	BEDPLATE BRACKET
	11	BEDPLATE B'KT SCREWS 6MM X 12MM CAP HEAD (PKT 2)
PIEL05B	12	DISC CATCH ONLY
PIEL05A	13	DISC CATCH STUD ONLY
PIEL05	14	DISC CATCH STUD (SPRING WASHER ONLY)
PIEL17	15	BACK BRACKET (FOR DISC)
PIEL03	16	TUBE SPRING
PIEL30	17	BLACK HANDLE ONLY
PIEL29A	18	BOLT ONLY FOR HANDLE
PIEL01	19	DISC SPRING
PIEL01A	20	DISC SPRING BRACKET - STAINLESS STEEL
	21	STAND BEDPLATE BOLTS 12MM X 50MM (PKT 4)
	22	STAND BEDPLATE BOLT SHAKE PROOF WASHER 20MM (PKT 4)
	23	15MM WASHERS FOR ABOVE (FOR BEDPLATE) (PKT 4))
	24	SIDE SHAFT COLLAR SCREW 10MM X 25MM
PIEL36	25	DISC SECURING SCREW
PIEL33	26	BEDPLATE CATCH
PIEL31	27	STOP COLLAR & SCREW
	28	12MM NUT (FOR STAND/BEDPLATE BOLT) PKT 4))
	29	8MM NUT (BEDPLATE BRACKET)
	30	8MM WASHER (BEDPLATE BRACKET)
	31	8MM X 16MM GRUB SCREWS (FOR PARTS 7,8,9)

Additional Parts		
PIEL11	5 & 15	L.C DISC COMPLETE WITH BRACKET
PIEL07		LC BACK CATCH
PIEL10		LC FRONT CATCH
PIEL35		DISC SPRING SCREW & BOLT
PIEL15A		NON-STANDARD HEAVY DUTY LINK - 3/4" BORE
PIEL29	17 & 18	BLACK HANDLE & BOLT COMPLETE
PIEL34	25A	BACK BRACKET SCREW & WASHER 8MM X 20MM (PKT 2)
PIEL31	27 & 24	STOP COLLAR & SCREW FOR SHAFT
PIEL39	39	M12 ZINC PLATED DOMED NUT
PIEL41		AIR RELEASE BRACKET

