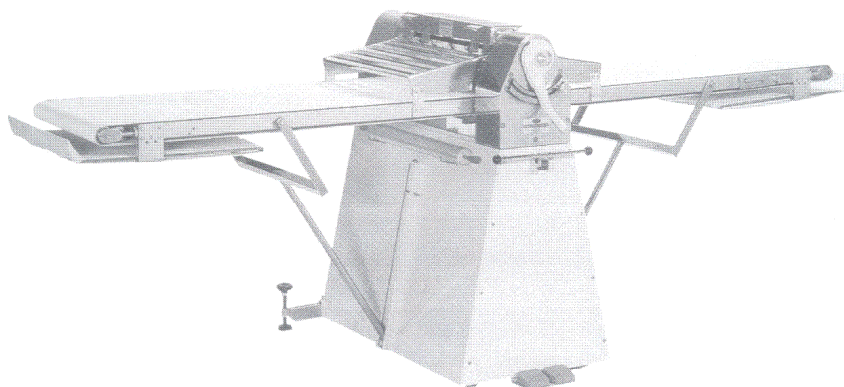


OPERATIONS & SAFETY MANUAL

REVERSIBLE DOUGH SHEETERS HEAVY DUTY SERIES

MODEL
ABSRDS 8.5/20
ABSRDS 8.5/24
ABSRDS 10/24



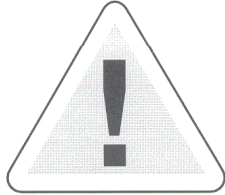
MODEL NO. _____ SERIAL NO. _____

AMERICAN BAKING SYSTEMS, INC.



3780 4th Avenue, Building A
Marion, Iowa 52302-3813
Phone: (319) 373-5006
Fax: (319) 373-5008

AN IMPORTANT NOTICE CONCERNING SAFETY



CAUTION

DO NOT OPERATE, CLEAN OR SERVICE THIS MACHINE BEFORE READING THIS MANUAL AND UNDERSTANDING COMPLETELY THE SAFETY INSTRUCTIONS FOUND IN THE MANUAL AND ON THE MACHINE LABELS.

Please follow these important safety rules...

IMPORTANT

All operators of this reversible dough sheeter must be of legal age to operate such equipment and must be familiar with and understand all caution labels!

IMPORTANT

Make certain that the person who is to operate this equipment carefully reads and understands these instructions before starting operations!

Disconnect from the power source when cleaning and/or servicing this machine.

Never attempt to clean this machine while it is in motion, serious injury could result.

Never operate this machine with safety covers or inspection plates removed or with safety switches inoperative.

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ILLUSTRATION 2. WIRING DIAGRAM

GENERAL INFORMATION

Introduction

The American Baking System's Reversible Dough Sheeter has been designed for years of trouble-free service in today's modern bakery operation. Every feature designed into this machine has been carefully tested. The machine has proven to gently handle a wide variety of doughs and produce a high quality product. It does this while maintaining the highest standards of safety.

Owners and operators should CAREFULLY READ this entire instruction manual before attempting to operate this machine. This will familiarize you with the proper operation and important features of your new dough sheeter. This will also ensure that you receive years of safe and trouble-free operation.

All information, illustrations, and specifications presented in this manual are based on the latest product information available at the time of printing. American Baking Systems, Inc. reserves the right to make changes without notice.

GENERAL INFORMATION AND INSTALLATION

Initial Inspection and Installation

After uncrating your Dough Sheeter, check for the following:

- a.) Two (2) conveyor tables
- b.) One (1) rolling pin
- c.) Two (2) conveyor table supports
- d.) Two (2) telescopic stabilizer feet rests

NOTE: Refer to Figure 1 for Reversible Sheeter Nomenclature.

Select a location for your reversible dough sheeter with sufficient room for operating, cleaning and servicing your machine. The floor **MUST** be solid and level. Follow the checklist below to set up your sheeter for operation.

1. Examine machine and conveyors for any damage caused in transit, report any damage to your dealer or factory representative.
2. Assemble the machine as follows:
 - A. Screw on outriggers and fasten screws firmly on under frame box.
 - B. Attach the conveyor tables (instructions on page 3).
 - C. Check whether the top and bottom scrapers are correctly attached (instructions on page 6).
 - D. Fit the plastic flour box.
 - E. Have the machine connected by an electrician. Please follow the instructions below and the wiring diagram (Illustration 1, 2).

IMPORTANT

It is very important to ensure that when the right foot pedal is depressed, the conveyor belts operate to the right and that they operate to the left when the left pedal is depressed. The phase sequence set-up must be strictly observed. If the machine is connected to a different power outlet, check immediately that the conveyor belts are operating in the proper direction.

- G. Safety check for the proper functioning of the protective grille. When the grille on the feed side is raised, the machine should stop immediately (instructions on page 5).

NOTE: Refer to Figure 1 for Reversible Sheeter Nomenclature.

GENERAL INFORMATION

Initial Inspection and Installation (cont'd)

3. LEVELING REVERSIBLE SHEETER

- a. Roll machine to the desired position.
- b. Fully extend outriggers.
- c. Lower adjustable mounting feet until they contact the ground and the sheeter is level front to back, left to right.

4. ATTACHING AND DETACHING OF THE CONVEYOR TABLES

NOTE: Before attaching or removing the conveyor tables, always disconnect the electrical power at the main breaker or unplug the machine.

4.1 Attaching machine tables:

- a. Press the table against the conical bolt on the roller mounting until the CONE on the opposite side of the machine engages.
- b. The DRIVING LUG must catch in the coupling bolt.
- c. Attach the two conveyor table support brackets and screw tightly.
- d. Push locking collar, located at the spring loaded conical bolt, tightly against machine head. Then tighten two set screws.

4.2 Detaching conveyor tables:

- a. Detach the telescopic rests or table support brackets.
- b. Loosen locking collar set screws. Press the table back against the spring loaded conical bolt (see figure 1).
- c. Tilt the table upwards at the front end and remove.

5. ELECTRICAL INSTALLATION

NOTE: Before making any electrical connections, be sure that your electrical supply system is compatible with the electrical specifications of your reversible dough sheeter. This data is shown on the nameplate on the right side of your machine. The standard specifications are:

220 Volt
3 Phase, 60 Hertz
8.0 Amps

The reversible dough sheeter is equipped with a factory installed six foot power cord. The sheeter is also equipped with a rotary ON/OFF switch located on the right side of the machine. This switch actuates a contactor with thermal and magnetic overload protection to disconnect the motor automatically in the event of an electrical overload or malfunction. To reset, turn the switch to the ON position.

OPERATING INSTRUCTIONS

Machine Checkout

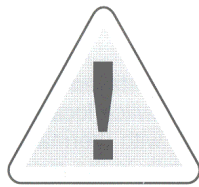
Each day, before beginning production with your dough sheeter, check the following:

- a.) Is the machine clean?
- b.) Are all guards securely in place?
- c.) Does the conveyor feed to the left when the left foot pedal or left hand lever are operated?
- d.) Does the conveyor feed to the right when the right foot pedal or right hand lever are operated?
- e.) Is safety guard grille operative?
- f.) Check to insure that top & bottom scrapers are installed properly.

General Operation

NOTE: Refer to Figure 1 for Reversible Sheeter Nomenclature.

- 1.) Properly check out machine as described above.
- 2.) Set initial roller spacing. (See Part 1, Page 5).
- 3.) Center 2-4 lb. dough piece on sheeter conveyor.
- 4.) Operate appropriate foot pedal or hand lever to feed dough through rollers.
- 5.) Feed dough back and forth through rollers several times, adjusting roller spacing until desired sheeting is obtained.
- 6.) Set knurled stop at final roller position.
- 7.) Roll dough onto rolling pin and remove for additional processing.



CAUTION

BEFORE STARTING PRODUCTION WITH YOUR NEW DOUGH SHEETER, AND EACH TIME BEFORE A NEW OPERATOR WILL USE THE MACHINE, BE SURE TO THOROUGHLY FAMILIARIZE EACH INDIVIDUAL WITH ALL THE FUNCTIONS AND ADJUSTMENTS OF THE MACHINE.

OPERATING INSTRUCTIONS

General Operation (cont'd)

1. SETTING ROLLER CLEARANCES

- a. Depress locking lever on handle of ROLLER ADJUSTMENT LEVER.
- b. Turn ROLLER ADJUSTMENT LEVER to alter position of top pressure roller.
- c. The SCALE DIAL indicates the value of the roller clearance setting.

2. DOUGH THICKNESS STOP CONTROL

- a. Set the ADJUSTMENT LEVER to the desired thickness.
- b. Undo the KNURLED KNOB and move the sliding block until it comes up against the lever.
- c. Tighten up the KNURLED KNOB.

3. PROTECTIVE SAFETY GUARD GRILLE

NOTE: Refer to Figure 2 for Guards and Scrapers.

- a. **RAISING:** Lift up the PROTECTIVE GRILLE and press against the FLOUR BOX until the BAR engages in the SPRING CATCH.
- b. **LOWERING:** Take hold of the PROTECTIVE GRILLE by the top bar and lower down.

4. HAND ROLLER

NOTE: Refer to Figure 2 for Guards and Scrapers.

The sheeted dough is wound up on the ROLLING PIN to remove dough for additional processing.

4.1 Winding sheeted dough

- a. Raise ROLLER MOUNTINGS into upright position.
- b. Place HAND ROLLER in the ROLLER MOUNTINGS (see figure 3).
- c. Operate machine in the direction of the arrow (Figure 3).
- d. Press the beginning of the dough strip onto the ROLLING PIN.
- e. Let the dough wind onto the roller.
- f. After winding, remove dough for further processing.

OPERATING INSTRUCTIONS

General Operation (cont'd)

5. ATTACHING AND DETACHING THE SCRAPERS

NOTE: Refer to Figure 2 for Guards and Scrapers.

5.1 Attaching top scrapers (angle scraper)

- a. Place SCRAPER on top pressure roller.
- b. Pullout the spring-mounted RETAINING LEVERS far enough to allow the angle scraper to slide underneath.
- c. Position RETAINING LEVERS to engage the SCRAPER.

5.2 Detaching top scraper

Lift up RETAINING LEVERS to allow SCRAPER to come away.

5.3 Attaching bottom scraper

- a. Place the T-SCRAPER with the hooks pointing downwards in the space between the pressure and conveyor rollers.
- b. Pushdown T-IRONS as far as they will go into the lateral guides.
- c. Affix spring-mounted rods under rolling table into the HOOKS.

5.4 Detaching bottom scraper Reverse procedure described in 5.3.

OPERATING INSTRUCTIONS

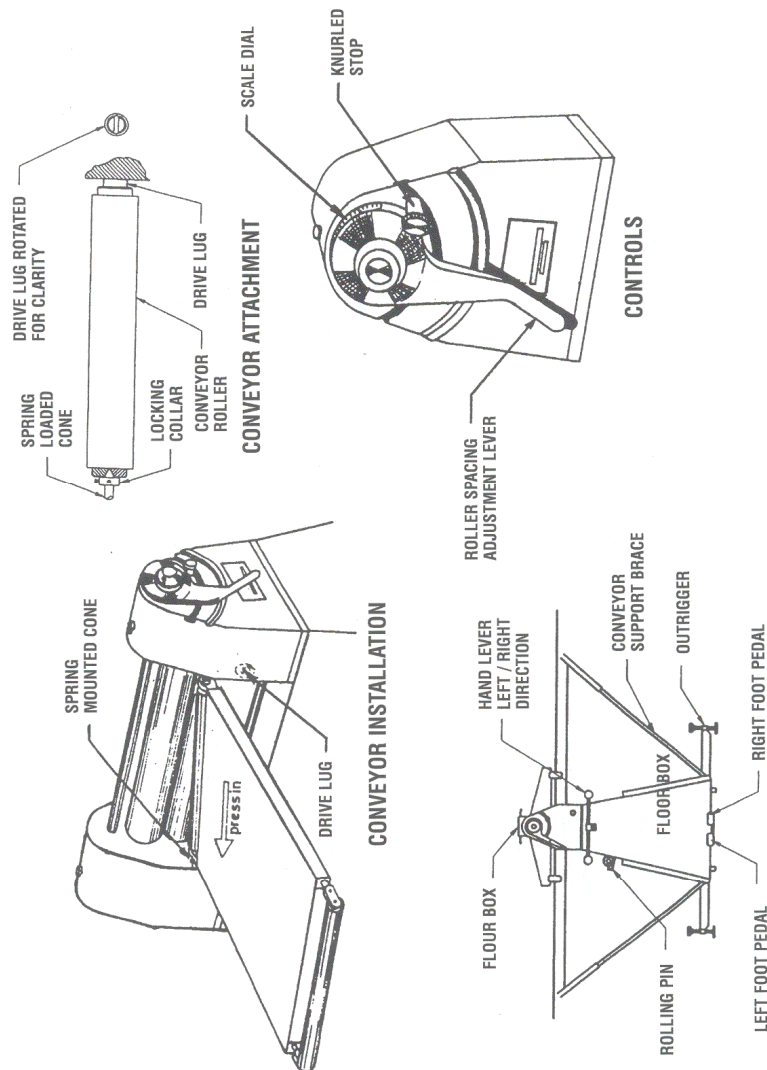


Figure 1. REVERSIBLE SHEETER NOMENCLATURE

OPERATING INSTRUCTIONS

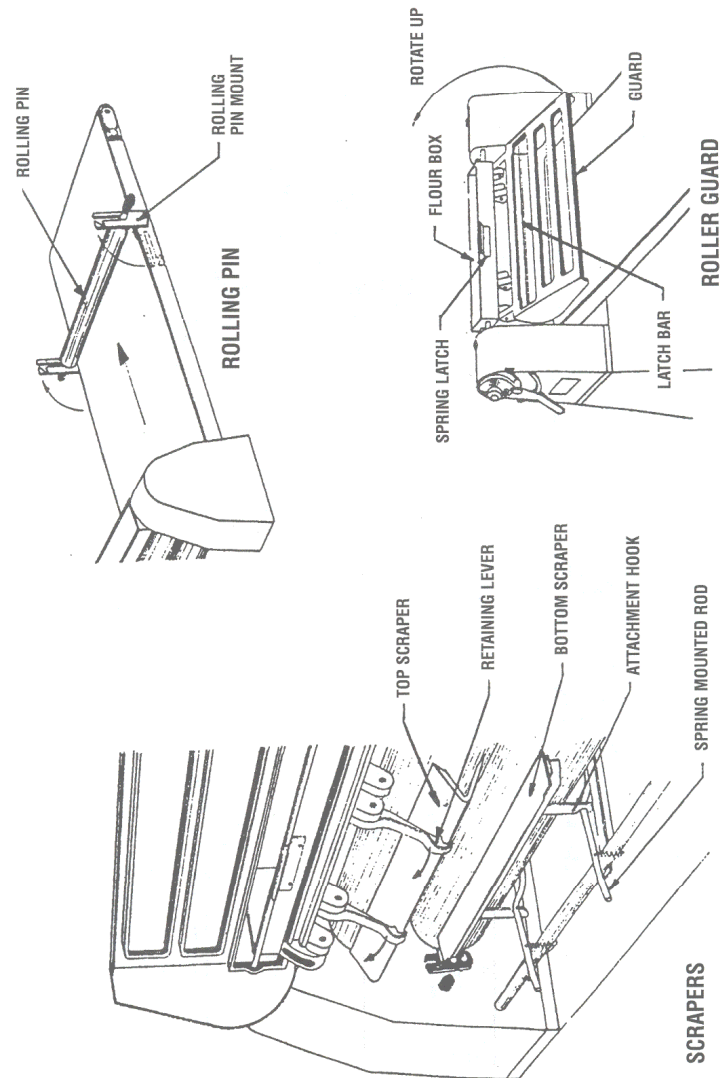


Figure 2. GUARDS AND SCRAPERS

CLEANING AND MAINTENANCE

CAUTION

ALWAYS SWITCH OFF AND DISCONNECT POWER TO THE MACHINE
BEFORE OPENING END COVERS!

This machine has been designed for simple cleaning and easy sanitation compliance.

If you regularly and properly service your machine, it will remain in good working order.

1. DISMANTLING CONVEYOR BELTS

- a. Take off the machine table.
- b. Turn the two hand nuts to de-tension belt using tool provided.
- c. Remove belt from table

2. CLEANING CONVEYOR BELTS

Belts must only be brushed clean when they are dry. NEVER clean belts when they are wet.

3. REGULATING TENSION OF CONVEYOR BELTS

Before operating the machine, always see that the belt tension is properly regulated by appropriate adjustment of the hand nuts.

- a. Run the machine from left to right.
- b. The belts must always track straight. If a belt tends to run to one side, the tension on that side must be increased, or the hand nuts on the opposite side slackened off. Use nut tensioning tool provided.
- c. Run machine from right to left and regulate the same way.
- d. Do not over tension conveyor belts.

NOTE: By setting and maintaining belts at the correct tension, you will greatly extend belt service life.

4. CLEANING THE SCRAPERS

Remove top and bottom scrapers for cleaning. Rub the scrapers over with a damp cloth and replace.

CLEANING AND MAINTENANCE

IMPORTANT: Do not use any sharp or pointed instrument to scrape off bits of dough that have hardened to the scraper.

5. LUBRICATION

NOTE: Refer to Figure 4 Lubrication Chart.

The machine head is filled with a high performance semi-fluid grease which needs to be changed every 5 years of operation, based on an 8 hour work day.

6. TENSIONING V-BELTS

- 6.1 Motor belt drive (see figure 3).
 - a. Unscrew back cover on stand base.
 - b. Loosen lock bolts.
 - c. Move down motor base plate and motor.
 - d. Tighten lock bolts.

7. TENSIONING DRIVING CHAIN

IMPORTANT: After every year of operation, the chain should be checked for correct tension.

To check chain tension, rotate top roller by hand. If the top roller turns more than a 3/8 inch with no rotation of the bottom roller, the driving chain needs to be retensioned.

Driving chain can be tensioned from the outside by doing the following:

- a. Loosen 2 CLAMPING BOLTS (one above the other Figure 3).
- b. Adjust the CHAIN TENSIONER with a screwdriver.
- c. Tighten CLAMPING BOLTS.

8. PARALLEL SETTING OF ROLLERS

After the driving chain has been tensioned, it must be verified whether the top roller is parallel with the bottom roller.

- a. Loosen CLAMPING SCREWS on front of housing.
- b. Turn eccentric bolt with a screwdriver until the top roller is parallel with the bottom one.
- c. Tighten CLAMPING SCREWS again.

CLEANING AND MAINTENANCE

9. PRESSURE ROLLERS

If both rollers stop rotating, the roll pin that connects the drive chain sprocket to the bottom roller has probably sheared off.

- a. Unscrew outer and inner COVERS.
- b. Drill out 4mm pinhole to 5mm diameter in both the sprocket and roller shaft.
- c. Insert 5mm x 37mm roll pin, insert a 3mm x 37mm roll pin into the 5mm pin.

NOTE: Do not drill 5mm diameter hole over size, or roll pin will shear again.

Troubleshooting

1. Sheeter will not run.
 - a.) Verify main switch is on.
 - b.) Verify conveyor and protective guards are in the proper positions.
 - c.) Check power plug for proper insertion.
 - d.) Have a certified electrician verify all power connections, and double check proper connection of the neutral wire.
 - e.) Check all fuses in the circuit.
 - f.) Check micro switches.
2. Sheeter runs intermittently.
 - a.) Check plug for poor contacts or loose wires.
 - b.) Check power cord for damage.
 - c.) Check power circuit for current fluctuations.
 - d.) Check protective guards for proper adjustment, adjust limit switches located under the back cover if necessary.
3. Rollers will not pull dough through.
 - a.) Re-tension V-belts from the motor to the machine.
4. Conveyor belts slip.
 - a.) Equalize conveyor belt tension.
5. Reverse conveyor belt does not operate.
 - a.) Check appropriate switches.
 - b.) Check V-belt tension.
6. Machine hums and does not operate or has low power.
 - a.) Have an electrician verify motor is operating on all 3 phases.
 - b.) Check all fuses in the circuit.

CLEANING AND MAINTENANCE

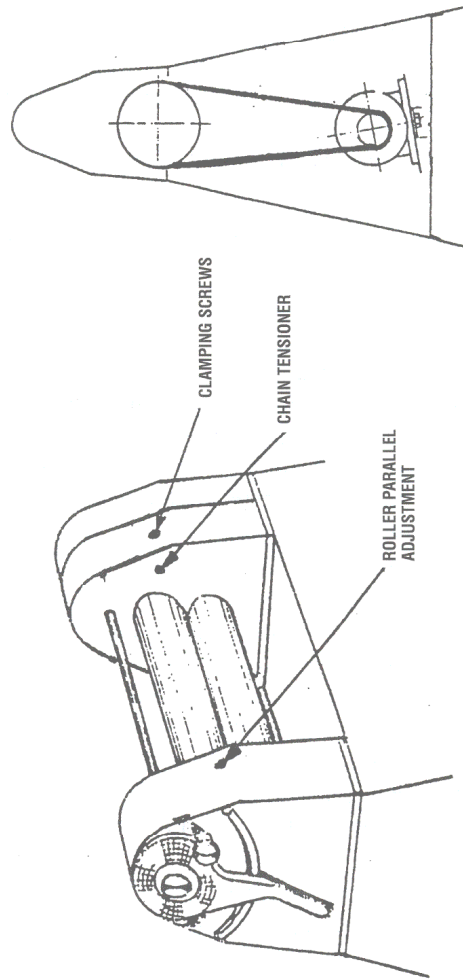
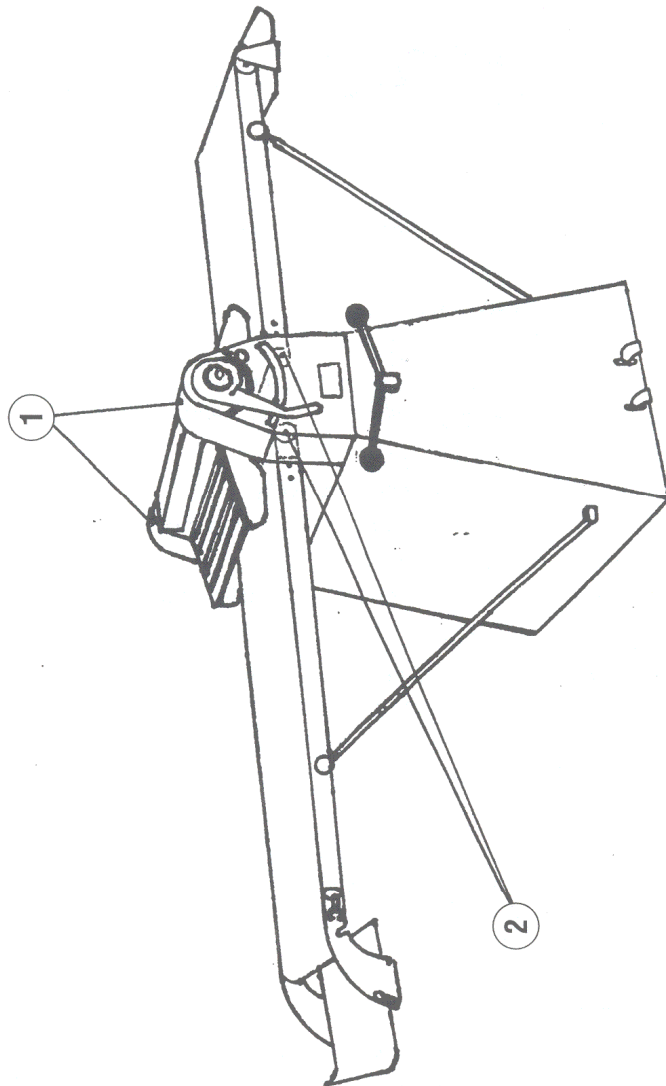


Figure 3. BELT AND CHAIN TENSION

CLEANING AND MAINTENANCE



- 1.) FILL WITH HEAVY DUTY GREASE EVERY YEAR OR WHEN SERVICED.
- 2.) TWO DROPS OF MINERAL OIL EVERY MONTH.

Figure 4. LUBRICATION CHART

AMERICAN BAKING SYSTEMS, INC.

Machine Warranty

American Baking Systems, Inc. certifies that all equipment of its manufacture is, to the best of their knowledge, free from defective materials and workmanship when it leaves the factory.

This warranty is intended as protection for our customers against failure due to defects in materials and workmanship in original manufactured items only. American Baking Systems will warranty its manufactured equipment as follows:

A. For a period of one year from date of original consumer purchase, American Baking Systems will exchange parts found to be defective due to faulty workmanship and/or materials.

B. For a period of six months from the date of original purchase, American Baking Systems will exchange electrical motors and components found to be defective except in the following cases:

1. Electricity was connected to machine incorrectly.
2. Machine was altered or repaired by an unauthorized mechanic.
3. Serial number has been changed.
4. Machine was misused or overloaded beyond published specifications.

C. For a period of 90 days from the date of original purchase, American Baking Systems will provide or reimburse the labor from item A and B at no charge to the customer providing American Baking Systems was notified in advance and had authorized the labor charges. A work service authorization number can and must be obtained by contacting the Factory Service Center prior to contracting repair work.

D. By executing this warranty, the buyer acknowledges that there are no other warranties, either expressed or implied, including (by example and not by limitation) warranties of merchantability and of fitness for particular purpose, in connection with the purchase of this machine.

Terms of Warranty

Terms of this Warranty begins with date of shipment from the factory, or with installation date if registered with American Baking Systems, Inc. within five days after installation, provided the installation date does not exceed the shipping date by more than two months.

AMERICAN BAKING SYSTEMS, INC.

Terms of Warranty (cont'd)

The enclosed warranty card should be completed in full and returned to American Baking Systems to ensure proper installation date and warranty registration. This warranty is intended as protection against failures due to defects in original manufacture only. It does not cover:

- A. Transportation and installation.
- B. Ordinary wear and tear from use.
- C. Abuse, misuse, misapplication, alteration, tampering, etc.
- D. Lost time due to site production schedules, rules and regulations.
- E. Accident, fire, flood, vandalism, and/or any act of God.

Merchandise becomes the property of the consignee when accepted by the carrier and thereafter travels at risk of purchaser. Notify the carrier in the event of damaged shipments, whether apparent at the time of delivery (or if any concealed damage is discovered after unpacking). Complaints should be filed directly with the carrier to expedite the claim and to ensure that proper attention is received from the carrier.

This warranty refers only to parts and materials supplied by American Baking Systems, Inc.

The obligation of American Baking Systems, Inc., under this warranty, is limited to the furnishing of parts and materials as described herein, and does not cover:

- A. Transportation
- B. Food costs or consequential damage costs
- C. Overnight travel costs
- D. Production material losses

After a part has been acknowledged by the factory to be defective within the scope of this warranty, American Baking Systems, Inc. shall comply with one of the following three methods:

- A. Furnish a free replacement part.
- B. Furnish a replacement part in even exchange for the return of defective part (customer will be invoiced/credited).
- C. Authorize and acknowledge replacement part to be obtained locally.

AMERICAN BAKING SYSTEMS, INC.

Terms of Warranty (cont'd)

American Baking Systems, Inc. agrees to pay any Authorized Service Organization for authorized certified labor required to repair or replace at our option any part which proves to be defective due to defects in material or workmanship during the warranty period. This warranty does not include travel time exceeding two hours and mileage exceeding 100 miles round trip.

Invoices for warranty labor will not be accepted for payment without a Work/Labor Authorization Number obtained from American Baking Systems prior to facilitating the repair. To obtain a Work Authorization Number, contact the dealer you purchased the equipment from or contact the factory direct.

Any obligations assumed by American Baking Systems, Inc. under this warranty are only to the person or organization to whom American Baking Systems, Inc. sold the equipment (except as authorized and acknowledged by American Baking Systems, Inc. and by authorized dealer selling equipment).

DRIVE NOMENCLATURE

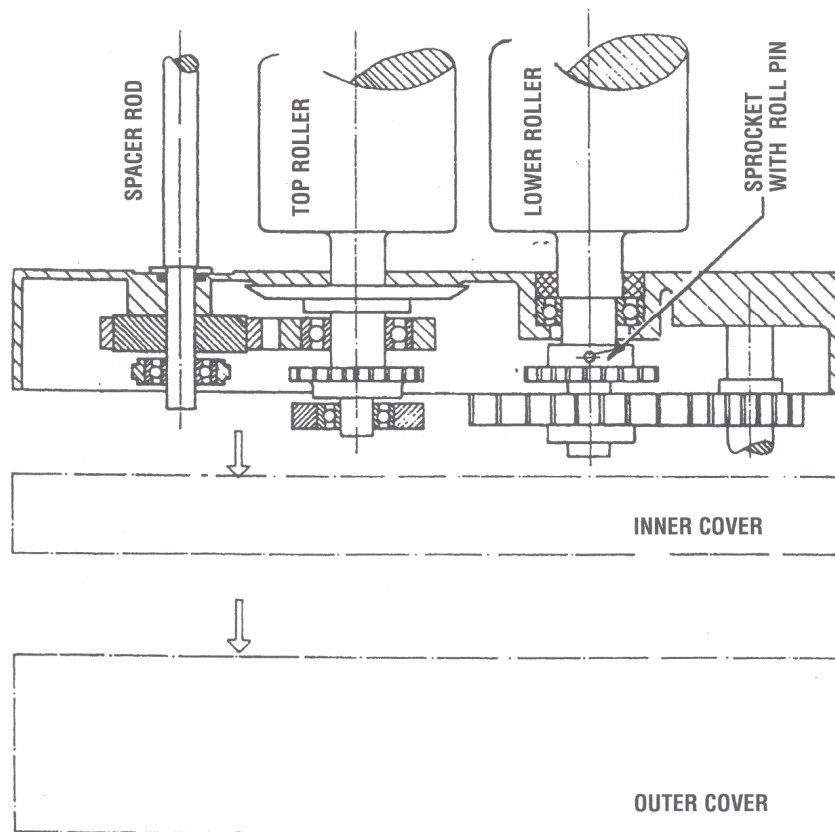


Figure 5. DRIVE NOMENCLATURE

SPARE PARTS

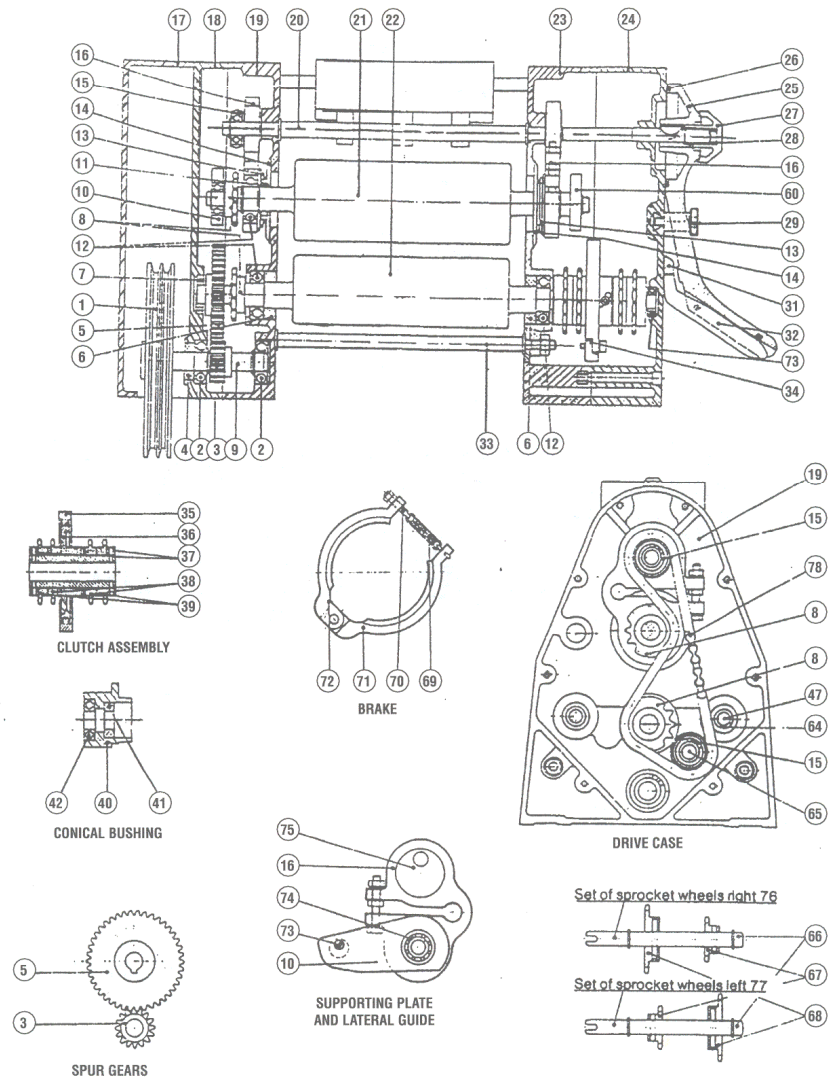


Figure 6. SPARE PARTS

SPARE PARTS FOR MACHINE HEAD AND CONVEYORS

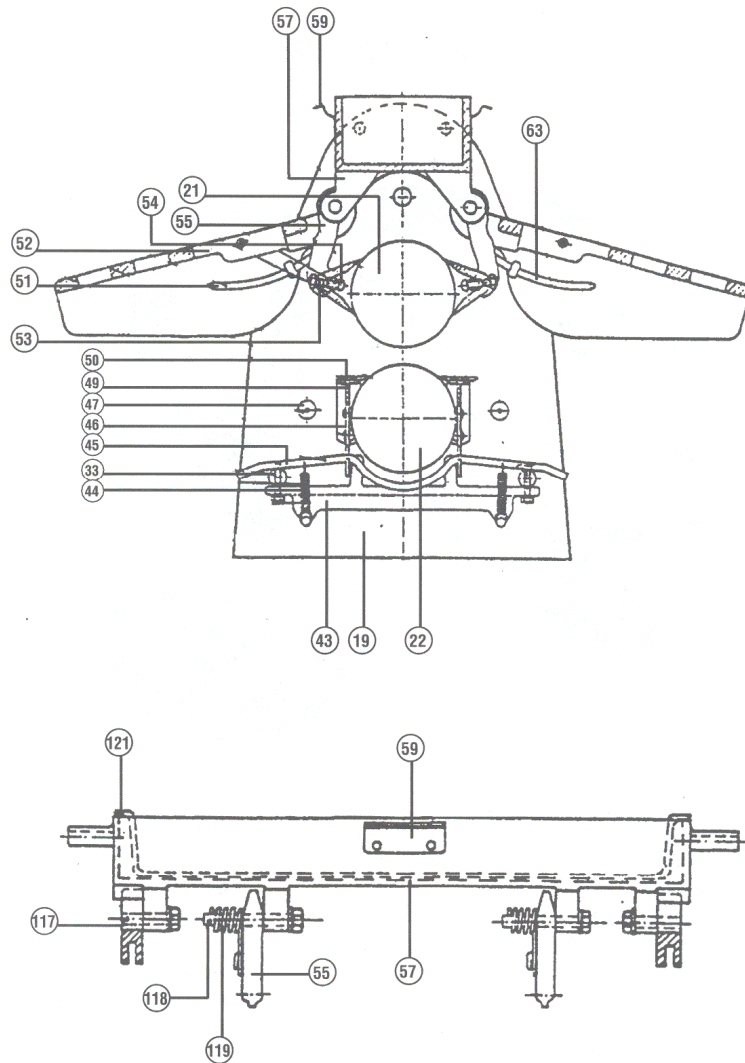
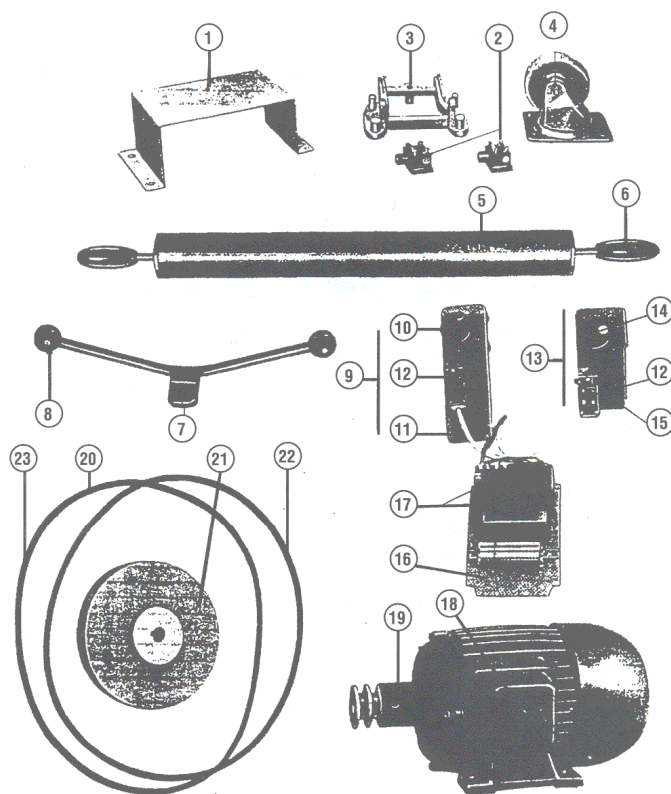


Figure 7. SPARE PARTS FOR MACHINE HEAD & CONVEYORS

PORTABLE STANDS AND SWITCHES



Spare Parts List

Accessories for portable stands and electric driving parts

POS.	PART	POS.	PART
1	Protective cover	11	Control panel
2	Limit Switch	12	Limit switch
3	Frame for foot-operated switch	14	Switch bolt with eccentric disc
4	Swivel caster with plastic wheel	15	Control panel
5	Hand roller, complete	16	Montage plate for sarel-case
6	Plastic handle	17	Contactor
7	Switch lever, complete	18	Motor 0.75 Kw
8	Ball handle, black Ø 40	19	V-belt pulley on motor
9	Control panel, compl.	20	V-belt DIN 2215
10	Switch bolt with eccentric disc		

PARTS LIST

No.	Designation	No.	Designation	No.	Designation
1	V-Belt Pulley	33	Spacer Rod	67	Sprocket, t = 10
2	Ball Bearing 6204	34	Clutch Assembly	68	Sprocket, t = 18
3	Small Gear, p = 16	35	Clutch Liner	69	Draw Spring
4	Oil Seal ID = 20 mm OD = 40 mm	36	Brake Disk	70	Adjustment Bolt
5	Large Gear, p = 42	37	Adjusting Ring	71	Right Brake Shoe
6	Oil Seal ID = 28 mm OD = 52 mm	38	Sprocket, Lateral	72	Left Brake Shoe
7	Ball Bearing 16004	39	Sprocket (No Spline)	73	Eccentric Bolt
8	Chain Sprocket, t = 13	40	Conical Bushing	74	Ball Bearing 6202
9	Drive Shaft	41	Oil Seal ID = 15 mm OD = 30 mm	75	Eccentric Disk
10	Lateral Guide, Right	42	Ball Bearing 6202	76	Sprocket Set, Right
11	Oil Seal ID = 25 mm OD = 35 mm	43	Retaining Strip	77	Sprocket Set, Left
12	Ball Bearing 6205	44	Spring, Bottom Scraper	78	Chain
13	Spring, Scraper Disk	45	Spring, Bottom Scraper Support Yoke		50 Link
14	Scraper Disk	46	Plastic Bracket Holder		30 Link
15	Reversing Roller	47	Pointed Bolt		26 Link
16	Support Plate	48	Reserved	79	Ball Bearing 6002
17	Cover	49	Lower Plastic Bracket	80-104	Reserved
18	AV Housing	50	Plastic Strip	No.	Designation
19	AR Housing	51	Left Hand Shift Lever	105	Conveyor Table
20	Eccentric Shaft	52	Protective Guard	106	Tension Screw, Conveyor Belt
21	Top Pressure Roller	53	Plastic Angle	107	Tapered Bracket, Table
22	Bottom Pressure Roller	54	Vibration Damper	108	Dividing Roller
23	KR Housing	55	Holding Lever	109	Idling Roller
24	KV Housing	56	Reserved	110	Reversing Roller Holder
25	Roller Adjust Lever	57	Flour Box		Idling Roller Holder
26	O-Ring	58	Reserved	112	Slide Pipe
27	Cap Nut	59	Spring, Protective Guard	113	Stroke Angle
28	Spring, Cap Nut	60	Reserved	114	Table Support
29	Strake Bolt	61	Reserved	115	Locking Screw
30	Lateral Guide, Left	62	Reserved	116	Conveyor Belt
31	Serrated Section	63	Right Hand Shift Lever	117	Screw Shank, Short
32	Locking Lever	64	Spring, Point Bolt	118	Screw Shank, Long
		65	Bolt, Reverse Roller	119	Spring
		66	Bolt, Clutch	120	Plastic Flour Box

WIRING SCHEMATIC

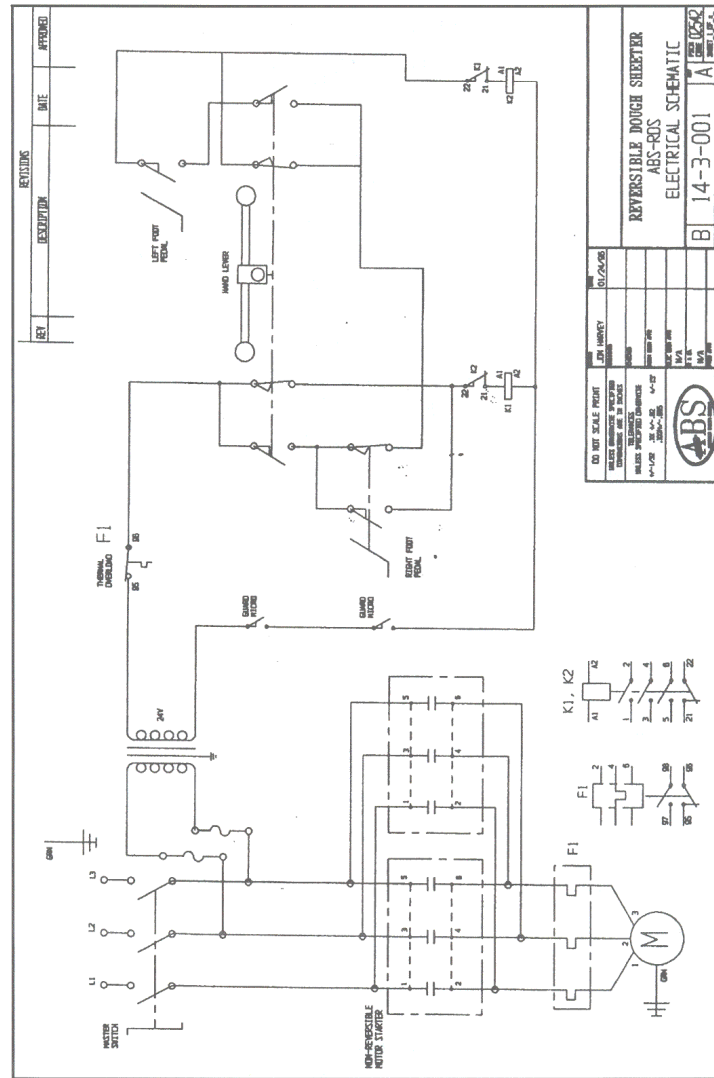


Illustration 1.

WIRING DIAGRAM

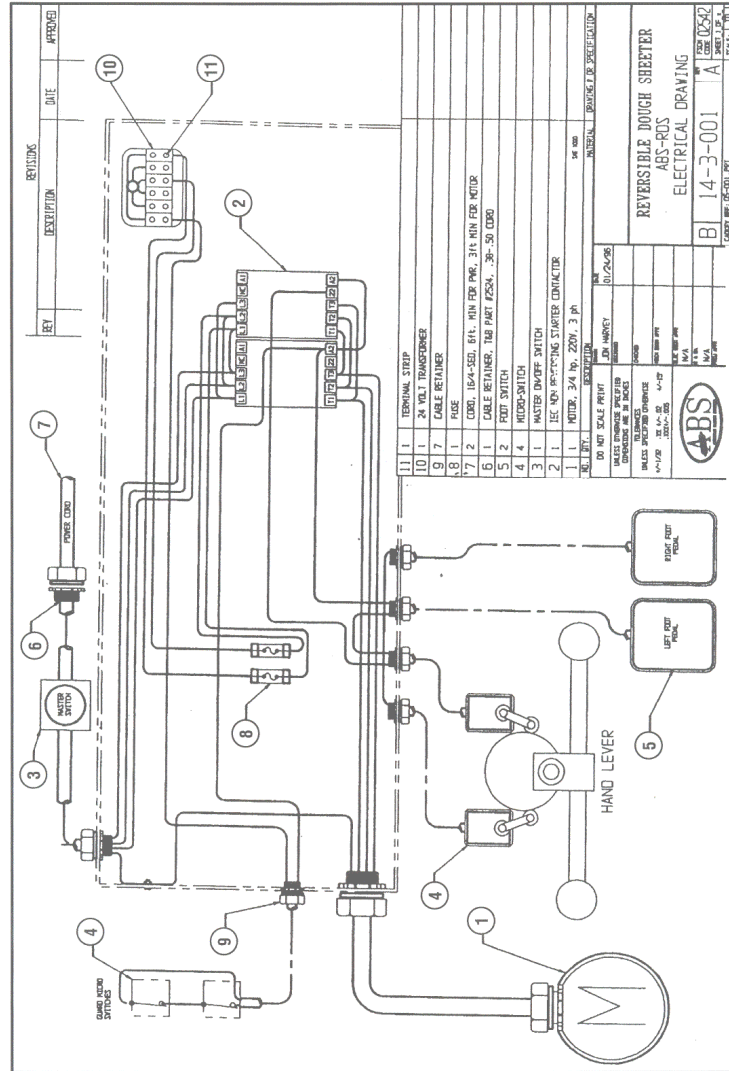


Illustration 2.