

**MANUALE d'USO e MANUTENZIONE**  
**MANUAL for USE and MAINTENANCE**  
**MODE d'EMPLOI et d'ENTRETIEN**  
**GEBRAUCHSANWEISUNG und WARTUNG**  
**MANUAL de USO y MANUTENCION**

Prodotto • Product • Produit • Produkt • Producto

**PIZZA ROLLER - Serie "GEMMA"**

Modelli • Models • Modèles • Modell • Modelo



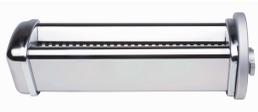
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Modelli • Models • Modèles • Modell • Modelo



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<b>LLKPR30</b>							
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**LLKPR30**

**LLKPR40**

Monofase • Monophase • Monophasé • Einphasig • Monofase

<b>1 N PE AC240V 50Hz</b>	<input type="checkbox"/>
<b>1 N PE AC240V 60Hz</b>	<input type="checkbox"/>
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<b>1 N PE AC 110V 60Hz</b>	<input type="checkbox"/>

# DECLARATION CE OF CONFORMITÀ

2006/42/CE

**The under signed, representative and builder:**

<i>Builder</i>	
<i>Address</i>	

**instructed by the person authorized to establish and maintain the technical file**

<i>Builder</i>	
<i>Address</i>	

**The undersigned manufacturer declares hereby that the machine**

<i>Generic name / trade</i>	<b>PIZZA ROLLER</b>
<i>Function</i>	<b>Forming of mixtures used in the food to flatten, flatten and stretch pieces of dough</b>
<i>Model</i>	LLKPR30
<i>Type</i>	LLKPR30/LLKPR40
<i>Registration number</i>	_____
<i>Year Of Manufacture</i>	20__

**Results in conformance with what foreseen from the following communitarian directives, (Included all applicable modifications):**

2006/42/CE - Machinery Directive

2006/95/CE - Low Voltage Directive

2004/108/CE - Electromagnetic Compatibility Directive

**The parts constituting the machine and destined to come into contact with the food product are in conformance with:**

Regulation CE n. 1935/2004

Regulation CE n. 2023/2006

.....(place) .....(date).

(signature)

\_\_\_\_\_  
Legal Representative

**1. SUPPLYING VALIDITY**

The Pizza Roller here follow called “machine”, is designed to flatten, roll out and extend cold dough pieces to prepare pizzas, bread, pasta for the first courses, pizzas, cakes and other, of different form obtaining thickness and diameters desired in the industry and in the food shops.

In accordance with the model and the commercial requests, the machine can be constituted with different configurations, optional and technical data, in accordance with the combinations individuated and identified in the chapter n. 2.

The supplied machine and object of the present instructions manual for the use is constituted with groups and parts included in the CE conformance declaration.

The machine is supplied with an identification plate on which the following data are showed:

*[fac simile]*

	<b>CE</b>
<b>DESIGNATION</b>	<b>PIZZA ROLLER</b>
<b>SERIES / MODEL</b>	_____
<b>REGISTRATION NUMBER</b>	_____
<b>MACHINE MASS</b>	_____ <b>kg</b>
<b>MANUFACTURING YEAR</b>	<b>20</b> _____
<b>NOMINAL VOLTAGE</b>	<b>... PE AC ... V ... Hz</b>
<b>FULL CHARGE CURRENT</b>	<b>... A</b>
<b>SHORT CIRCUIT CURRENT</b>	<b>... kA</b>
<b>ELECTRIC DIAGRAM NUMBER</b>	<b>...</b>

**For information on the machine correct use, consult the instructions manual**

## 2.1. MANUAL PURPOSE

### MANUAL IMPORTANCE

The present instructions manual for the use is to be considered as **integral parts of the machine**:

1. must be kept for all machine life.
2. must be coupled with the machine in case of its ceasing.
3. besides to show all useful notices for the operators, contains (collected in specific chapters) the electric diagrams that will be used for the possible maintenance interventions and reparation.

### SCOPE / MANUAL PURPOSE

The instructions manual for the use **has the purpose to** provide to the commitment all necessary information so that, except of an adequate supplied machine use, is able to manage the same in the more autonomous way and possible safe. Besides the present manual has been written with the purpose to supply **indications and warnings** to know the supplied machine, to understand its principles and functioning limits. For possible doubts you can call the **Authorized Assistance Centre**.



This instructions manual for the use has been produced exclusively for the machine user and contains informations of the manufacturer reserved property.

The texts, the drawings and the diagrams included in the present instructions manual for the use, are of reserved technical kind and of the machine manufacturer property and cannot be reproduced in any way or partially or integrally.

Without the advanced written authorization of the manufacturer, this manual or part of it cannot be reproduced in any form, modified, transcribed, translated in any language, put available to a third party or however used so that can prejudice the manufacturer interests.

**Every abuse will be pursued** in accordance with the law and with the author rights. © Copyright 2011

### RECEIVERS

The present instructions manual for the use, delivered in number of n. 1 copy together with the machine, is supplied as integral part of the machine, is turned both to the operators both to the skilled technicians qualified to the installation, use and maintenance.

**The prevention and protection service responsible** of the commitment and **the additional employees**, to whom is assigned the machine, must take vision of the present instructions manual for the use, with the aim to **adopt all technical and organizational measures**

Before to put in function the machine, and every time a doubt about its functioning appears, it is obligatory for the operator to read with attention the use instructions.

### PRESERVATION



- The present instructions manual for the use must be preserved in the immediate vicinities of the machine sheltered from liquids, from humidity, excessive heat and what else can compromise the readably condition.
- Consult the Manual so as to not damage all or in part the content.
- Don't remove pages from the Manual.
- Don't write on the Manual pages.

### UPDATINGS, INTEGRATIONS AND CHANGE



- If the present manual suffers damages or is lost, it is possible to request a copy to the Authorized Assistance Centre.
- The present manual reflects the technique condition during the machine manufacturing; the manufacturer reserves the right to update the production and of consequence other manual issues, without the obligation to update productions or previous manuals, if not in particular cases regarding the people health and safety.
- If the commitment desires to receive further informations, he is asked to contact directly the Authorized Assistance Centre.
- **The commitment is invited, in case of machine ceasing**, to signal to the Authorized Assistance Centre the identification data of the new receiver, to facilitate the transmission of possible integrations to the manual that, as yet remembered, must couple the removing container/distributor also in case of removal.

## LLKPR30



- If the present manual endures damages or is lost, it is possible to request a copy to the Authorized Assistance Centre.
  - The present manual reflects the technical state during the machine manufacturing; the manufacturer reserves the right to update the production and of consequence other manual issues, without the obligation to update productions or previous manuals, if not in particular cases regarding the people health and safety.
  - Pay particular attention to the residual risks content present on the machine and the prescriptions to which the operators must keep.
  - The manufacturer is the responsible for the machine in its original configuration.
  - The manufacturer isn't the responsible for damages caused from the improper use or not correct of the machine and documentation or for damages caused from the imperative standards violation, negligence, lack of experience, imprudence and the not respect of regulation standards on behalf of the employer, of the operator or the maintenance man and for every possible damage caused from an irrational, improper and/or wrong use
  - The manufacturer isn't the responsible for the consequences caused from the not original spare parts use or of equal characteristics.
  - The manufacturer is the responsible only for the information showed in the manual original version in Italian language.
  - The non-fulfillment prescriptions included in this manual will cause the guarantee immediate decay.
- The factory responsible, that supervision to the working activities, in the field of the foreseen respective attributions and competences must:
- Carry out the foreseen safety measures;
  - Make informed the operators about the specific risks whom are exposed and bring to their knowledge the prevention essential standards;
  - Prepare and require that the single operators observe the safety standards and use the protection means put at their disposal;
  - Get down working more operators, contemporary, on this product.

It explains besides that following the put in service of the machine, the same is subjected to what foreseen / prescribed from the directive 89/655/CEE and the successive modifications

### 2.3. SIMBOLOGY MEANING

Here follow it is clearly specified the symbols and definitions meaning, which will be used in the present document.



#### **DANGER**

It shows the danger presence for who works on the machine and for who is the vicinity, so the indicated activity must be performed in accordance with the actual accident prevention standards and with the indications showed in the present manual.



#### **PRECAUTION**

It shows a warning on useful information and/or further recommendations and/or shrewdness about the actual operation.



#### **ATTENTION**

It shows an operation to perform with attention to avoid damage to the machine.

### 3.1. TESTS PERFORMED BEFORE THE DELIVERY

Before the delivery, c/o manufacturer head office, the machine has been subjected to the safety tests foreseen from the actual and applicable legislation and to the functioning tests in accordance with the purpose defined in the present instructions manual for the use. Besides, all installed components are subjected to a detailed visual and instrumental check, with the aim to guarantee also the agreement to the contractual requirements.

### 3.2. PURPOSE AND MANUFACTURING PARTS

The Pizza Roller here follow called "machine", is designed to flatten, roll out and extend cold dough pieces to prepare pizzas, bread, pasta for the first courses, pizzas, cakes and other, of different form obtaining thickness and diameters desired in the industry and in the food shops.

In models of machine art. LLKPR30/LLKPR40, on the left side, you can attach the accessory CUTTING, intended to cut, depending on the type of accessory hook, the dough for the pasta.

The machine is generally constituted from the following elements (cfr. Annex):

1. n. 1 structure constituted from a carcass with reinforcement, that supports and contains the motor parts and the control devices. The front part of the carcass represents the chute on which the product run passing from the first rolls couplet o the second one (when present). In the back zone of the carcass a shelter is present that determines the complete closure of the motor parts.
2. n. 1 superior motorized rolls couple placed one in front of the other, that rotate in the same direction, where the product passes to roll out. The distance between two rolls is adjustable thanks to the possibility of millimetric setting of the external roll through a lever, to allow a different rolling thickness. In a machine model the superior rolls couple can be absent.
3. n. 1 fixed superior entrance system, for the superior motorized rolls couple placed one in front of the other, where the product is inserted manually.
4. n. 1 inferior motorized rolls couple placed one in front of the other that rotate in the same direction, where the rolling product passes. The distance between two rolls is adjustable thanks to the possibility of millimetric setting of the external roll through a lever, to allow a different rolling thickness.
5. n. 1 fixed inferior entrance system, for the inferior motorized rolls couple placed one in front of the other, where the product is inserted manually in the second passage. In the entrance system to facilitate the product introduction, an idle roll is present.
6. models of machine art. SPT30 2300 / SPT40 No A power takeoff for the manual docking of the accessory CUTTERS.
7. No 1 accessory sheet size, which according to the type of n. 2 rolls and carefully shaped counter, you can cut the dough for the pasta.

An only electric motor is present for the rolls control and it can be mono phase with different feeding voltages (cfr. Technical data).

All machine parts destined to come into contact with the food products, as the front face of the machine, the rolls, the entrance systems, etc... are in stainless steel materials or plastic material destined to come into contact with the food.

The automatic functions, the programming and the machine operative sequence, included the delay times for the tool stop, the speeds selection, etc..., are managed from electromechanical and electronic components, in wired logic, through the control and check panel placed in the machine front zone (cfr. annexed)

In accordance with the functioning and production requirements, the machine can be constituted with different optional parts (cfr. Technical data).



The possible further useable ingredients must not be dangerous for the operator and maintenance man health. Besides they must not determine explosive zones. Consult always the technical data and the safety cards about the dangers of every food product.

Eventually if dusty zone are generated, put on adequate protective mask, both during the manual loading, and both during the machine working.

DATA	LLKPR30/LLKPR40
Level of acoustic power continue equivalent weighted A	Minor of 70dBA
Current nature – Frequency	Cfr. machine plate
Current full charge value	Cfr. machine plate
Use nominal voltage	Cfr. machine plate
Allowable presumed current of nominal short circuit conditioned	6 kA symmetric
Mass and neutral	TT e TN
Protection degree	IP X3
Machine positioning	<b>Work bench used in the food field</b> of height included between <b>900/1100mm</b> from the trampling floor of adequate capacity, in which it is possible to circulate freely around the machine with a free space of at least <b>800mm</b>
Use place	Inside
Minimum and maximum temperature of use in the work environment	+10° / + 40°C
Requested minimum lighting	500 lux
Further use conditions	<p><b>Inadequate</b> machine for functioning in environments where there are contaminated agents: for example powders, acids, corrosive gas, salts and similar.</p> <p><b>Inadequate</b> machine for functioning in environments where there are potentially explosive atmospheres classified as zone 0 or zone 1 or zone 2.</p> <p><b>Inadequate</b> machine for functioning in environments where there are ionized and not ionized radiations: for example microwaves, ultraviolet rays, lasers, X rays and similar.</p> <p><b>Inadequate</b> electric equipment to be equipped with machines or to function in environments where there are vibrations and shocks: in contrary case assembly it far from the device and foresee antivibrating supports</p>
<b>PROTECTION DEVICE RECOMMENDED AGAINST THE OVERCURRENTS</b>	
Insulation nominal voltage	$U_i = > 690 \text{ V}$
Nominal current	$I_n = >$ see electric diagram
Magnetic relay setting	$I_m = <$ see electric diagram
Thermal relay setting	$I_r =$ see electric diagram
Maximum value of the damage ring impedance	0.1 $\Omega$

### 3.4. NORMAL USE, IMPROPER USE, NOT CORRECT USE OR FORBIDDEN

The machine described in the present instructions manual for the use is foreseen to be used **from an only operator** skilled and prepared on residual risks, but with the competence, in safety matter, of maintenance employees.



In its **NORMAL USE** and reasonably foreseeable, the machine can be used only to flatten, roll out and extend cold dough pieces to prepare pizzas, bread, pasta for the first courses, pizzas, cakes and other, of different form obtaining thickness and diameters desired in the industry and in the food shops.



The machine must not be used **IN IMPROPER USE**; in particular:

1. it must not be **used for domestic use**,
2. it must not functioned with parameters different from those showed in the technical characteristics table,
3. for every use of the machine with modalities different from those showed in the present manual, the manufacturer declines every responsibility,
4. the user is responsible of the damages resulting from the lacked exercise conditions observance in accordance with the agreed technical specifications and order confirmation,
5. **don't work with the vacuum machine**,
6. not tamper or damage intentionally nor remove or hide the labels.



The machine must not be used **IN NOT CORRECT WAY or FORBIDDEN**, so some damages or injuries could be caused for the operator; in particular:

1. it is forbidden **to move the machine** when it is connected to the electric feeding;
2. it is forbidden **to draw the electric feeding cable or the machine** to disconnect the feeding plug,
3. it is forbidden **to put weights** on the machine or on the electric feeding cable,
4. it is forbidden **to put the electric feeding cable** on sharp parts or with burn danger,
5. it is forbidden the machine use with the damaged and not integer **electric feeding cable or with the control devices**;
6. it is forbidden **to leave the machine off** with the electric feeding cable connected with the feeding plug,
7. it is forbidden **to leave the loaded machine unguarded**;
8. it is forbidden **to insert any type of object** inside the motor ventilation cap;
9. it is forbidden **to put the machine above different objects from the working bench** used in the food field of height included between 900 - 1100mm from the trampling level,
10. it is forbidden **to insert any type of object** under the machine base or place clothes or other between the machine support pressure feet and the working bench,
11. it is forbidden **the use of inflammable substances, corrosive or harmful for the cleaning**,
12. it is forbidden **to plunge the machine** in water or other liquids;
13. it is forbidden **the not authorized personnel use** and with clothes different from what showed for the use,
14. it is forbidden **to introduce products or objects having characteristics** different from those showed in the normal use, as for example bones, frozen meat, not food products, or other objects as scarves, etc...,
15. it is forbidden the functioning **with protection covers and fixed ones not blocked correctly or removed**;
16. it is forbidden the **partial or total neutralization, removal, modification or make however ineffective** the protections of the safety micro switches and danger signals.
17. it is forbidden the functioning without that all **precautions about the residual risks elimination** have been adopted on behalf of the user,
18. it is forbidden **to smoke or use free flame devices** and manipulate incandescent materials, unless some suitable safety measures aren't adopted,
19. it is forbidden to activate or **to set the control and blockage devices as knobs or similar** both during the machine functioning both if you aren't authorized,
20. it is forbidden to use **risky ingredients for the operator and maintenance man health**. Besides must not determine potentially explosive zones, so the machine isn't adequate for the use or treat products that determine potentially explosive zones.



**The user is however responsible** of the damages resulting from the lacked observance of the specified normal use conditions. For possible doubts contact the Authorized Assistance Centre.



**The lacked standards and safety procedures application** can be danger and damage sources.

**The machine means bound in the use** for the respect, on behalf of the final user, of:

1. all rules, of insertion in the environment and of people behavior, fixed from the laws and/or applicable standards; with particular reference to the fixed plant upstream of the supplied machine and for its connection/functioning;
2. all further instructions and use warnings making part of the technical/graphic documentation annexed to the same machine.

#### 4.1. OBLIGATIONS AND DUTIES

##### PERSONNEL GENERAL REQUIREMENTS

The personnel that work with the machine must:

- a. Have read and understood all safety prescriptions showed in the instructions manual for the use;
- b. Present normal psychophysical conditions;
- c. Be previously informed and trained about:
  - c.1. the wounds dangers or other damages that can derive from direct or indirect contacts;
  - c.2. the dangers caused from over temperatures, electric arcs or radiations produced and/or emitted from the device eventually present;
  - c.3. the not electric dangers that, as the experience teaches, can derive from the electric material eventually present;
  - c.4. the wounds dangers or other damages consequent on the residual risks showed in the instructions manual for the use;
- d. so have (or acquire through adequate training), the following requirements:
  - d.1. general and technical culture with sufficient level to understand the content of the actual instructions manual for the use and interpret correctly the electric diagram eventually annexed and all technical drawings;
  - d.2. knowledge of the main hygienic, accidents and technological standards;
  - d.3. total knowledge of the machine and of the electric device eventually present;
  - d.4. know how behave in emergency case;
  - d.5. know where find the individual protection devices and how use them correctly if the manufacturer indications prescribe it or if the collective protections are insufficient;
- e. must besides:
  - e.1. signal immediately to the employer the deficiencies of the devices, the safety and protection means, nor the other possible danger conditions, if they come to know, helping them directly, in urgency case and in the field of their competences and possibilities to eliminate or reduce these deficiencies or dangers;
  - e.2. not remove or modify the devices and the other safety and protection means without have obtained the authorization;
  - e.3. not perform, on one's own initiative, operations or works that aren't of their competence and that can compromise their or other people safety;
  - e.4. not wear rings, wrist-watches, jewels, torn clothes, scarves, ties, or any other clothes or hanging accessory that can be a risk source; tighten well the sleeves around the wrists, and keep well collected the hairs.



Except where differently specified, the **personnel that perform the interventions of installation, fastening, maintenance, reinstallation, and reusing, damages research or failures, demolition and dismantling** must be a **skilled personnel** trained in safety matter and informed on the residual risks, with the competences, in safety matter, of the maintenance men.

**All the specific competences, tasks and dangerous zones within which the operator and the maintenance man** must intervene to perform the functions of the present manual, are showed in the following chapters.

**This skilled personnel must be** able to evaluate his work and recognize the possible dangers on the basis of his preparation, knowledge and professional experience of the machine, of the relative equipment and of the relative standards; he must besides have an adequate professional qualification on the machine. He must be trained in safety matter and informed on the residual risks.

He must besides be **expert and not informed**, or must be a qualified and graduated technician with knowledges about the machine and the relative equipment and the relative standards and that he has a technical competence or training.

He besides **to perform all maintenance works**, in some cases is on support to the operator for fitting activities. The maintenance man can besides access to the electric panel with the equipment in voltage.



**For safety reasons**, during the working operations, in the zone around the machine, isn't allowed the presence of other people apart from the operator. Making an exception to this prescription the maintenance personnel presence is allowed expressly authorized from the production responsible.

**The personnel assigned to the setting/registration, to the use and to the maintenance** must immediately suspend the activities and inform the employer or the department responsible or the charged if they would find defects or anomalies in the functioning.

If **the user hasn't skilled or warned personnel** he must order the relative activities to a society competent to this purpose, as for example the supplier of the same.

#### **4.2. ENVIRONMENTS AND WORKING PLACES**

The work environment must answer to the directive 89/654/CEE requirements. In the working area extraneous objects must not be present.

**The employer**, in the respect of the directive 89/391/CEE, concerning the measures actuation turned to promote the workers safety and health improvement during the work, must provide to eliminate or reduce the residual risks showed as foreseen in the present manual.

#### **4.3. WARNINGS ABOUT THE RESIDUAL RISKS**



**The employer must** provide to train the personnel on the accident risks, on the safety devices and on the general rules about the accident prevention foreseen from the communitarian directives and from the State legislation where the machine is installed.

It is so necessary that the **use, the maintenances performed from the user and the cleaning** are entrusted to trained and competent personnel.

**The employer responsibility is** to check that the given instructions have been adequately received. When necessary, **is of user responsibility**:

1. to activate a training course, eventually in cooperation with the machine manufacturer, so that **the operators and the maintenance men** are adequately trained on **the risks in general and on the residual risks showed in the present manual**.
2. the **individual protection means supplying** in conformance with what showed in the directive 89/656/CEE and the successive amendments and updates and **the information on the allowed uses**.

#### **RESIDUAL RISKS DUE TO THE NOISE**



The machine produces, as from performed experimental tests, **an acoustic power level equivalent weighed A inferior to 70 dB**.

To avoid the injure dangers to the ears for tearing or persistent noises, the operator, besides to be adequately informed and trained, during the machine functioning **must always use appropriate ears protection devices, as for example caps or protective stoppers or similar personal auricular protections**.

#### **RESIDUAL RISK DUE TO THE INFLAMMABILITY**



To avoid the dangers consequent to a fire, the user besides to train and inform adequately the operator and the maintenance man, **near the machine work zone**, must prepare suitable **antifire systems** (for example the portable extinguishers of first intervention) adequate to the materials typology that can fire: as for example the electric and electronic devices of the electric equipment. The water must not be used for the fires extinction.

#### **RESIDUAL RISK DUE TO THE CONTROL/CHECK SYSTEMS CONNECTED TO THE SAFETY:**



It is signaled that the safety functions and the control/check systems connected to the safety are produced in **conformance with the safety category 1**; nevertheless for a break effect a malfunctioning can be present, or a residual risk due to the lacked stop, in accordance with what foreseen.

From the machine stop control activation or for the feeding electric energy absence, both the operator both the maintenance man, **before to access to the machine moving parts, must check their effective stop, checking visually from the machine superior zone**.

**RESIDUAL RISK DUE TO THE FIXED SHELTERS REMOVAL, INTERVENTION ON BROKEN/WORN PARTS**

For any eventuality **the operator must not ever try to open or remove a fixed shelter or tamper a safety device.**

In the phase of **tooling, maintenance, and cleaning**, and **during all further manual operations** that happen introducing the hands or other body parts in the dangerous areas of the machine, a residual risk remains due above all to:

1. **knocks with machine manufacturing parts,**
2. **grazing and/or abrasion with the machine rough parts,**
3. **cut with tools sharpened parts.**

The operator and the maintenance man besides to be adequately informed and trained, every time that they perform the above operations, **must use head protection devices, of the feet, clothes adequate to the work place and of the respiratory way, as for example the anti knock helmet, anti cutting gloves with metallic fibers, anti chute footwear, resistant and suitable to the risk particular nature, with the iron tip.**

Besides, the operator and the maintenance man **must be trained for the intervention connected to the manual operations with open shelters**, must be trained on the consequent connected risks and must be authorized from a responsible person.

**RESIDUAL RISK DUE TO THE LIFTING OPERATIONS AND TO THE INTERVENTIONS THAT REQUIRE MANUAL OPERATIONS**

The machine lifting and transportation operations or its parts are manual operations that involve a residual risk due **above all to knocks, crushing, dragging, grazing or abrasion**. The transportation/livening operations responsible must inform adequately the personnel on these residual risks.

A residual risk is present, of knock, abrasion, cut, injection and dragging, during **the maintenance, the cleaning and the further manual operations**, for the operator and the maintenance man due also to the necessity to disassembly and/or place the tools parts, etc...

**Both the personnel assigned to the livening both the operator and the maintenance man besides to be adequately informed and trained and to respect the foreseen use modalities, must use head protection devices, of the feet, clothes adequate to the work place and of the respiratory way, as for example the anti knock helmet, anti cutting gloves with metallic fibers, anti chute footwear, resistant and suitable to the risk particular nature, with the iron tip.**

**RISK DUE TO THE POSSIBLE CHUTTING AND/OR FALLING**

To avoid, **during the machine normal use and during the maintenance interventions**, the chutting and/or falling dangers on the reference level (trampling), the operator and the maintenance man, to be adequately informed and trained, **must always use appropriate feet protection devices, as for example anti chute footwear, resistant and suitable to the risk particular nature.**

The user must however maintain cleaned the trampling level on which the operator and the maintenance man move and to be free of substances that facilitate the sliding, as for example liquids or any type of granular or dusty substance.

**RISK DUE TO THE PRODUCTS NATURE USED IN THE MACHINE**

The machine is designed to flatten, roll out and extend cold dough pieces to prepare pizzas, bread, pasta for the first courses, pizzas, cakes and other, of different form obtaining thickness and diameters desired in the industry and in the food shops.

The eventual further useable ingredients must not be risky for the operator and maintenance man health. Besides they must not determine potentially explosive zones.

Consult always the technical data and the safety cards about the dangers of every food product.

LLKPR30

4.4. PLATES



The plates and the signs must always be well visible and must not be ever removed.  
The plates and the signs are safety instrumentation and must not be considered with superficiality.  
The user is kept to change immediately all safety plates and/or warnings that after the wear can become illegible

**LIST AND MEANING OF THE PRESENT PLATES**



Gloves with metallic fibers



Safety footwear



Body protection



Don't remove the safety devices



Machine for food use



RAEE



WITH THE REMOVED FIXED SHELTERS DANGEROUS MOVING ELEMENTS IN MOVEMENT ARE PRESENT.

**BEFORE TO ACCESS TO THE DANGEROUS MOVING ELEMENTS WAIT AT LEAST 10 SECONDS AFTER THE FEEDING ENERGY INTERRUPTION**



**400V 50Hz**

DEVICE IN VOLTAGE ALSO WITH OPENED DOOR

TO REMOVE VOLTAGE WORK ON THE SECTIONING DEVICE (disconnect the plug from the socket)

**LLKPR30 4.5. PROTECTION DEVICES ON THE MACHINE**



The machine protections and safety devices must not be removed. If they must be removed for extraordinary maintenance requirements **some measures will have to be immediately adopted ready to put in evidence and to reduce at the minimum possible limit the eventual danger.**

The replacement and the efficiency of the protection or of the safety device must happen when the reasons that have made necessary their temporary removal are finished.

**The machine is protected** from a fairing, produced also with fixed protections, that doesn't allow the access to any dangerous part of the machine, if not in the work front zone, protected from different fixed shelters that recover the superior, front and inferior parts of the motorized rolls (cfr. Annexed).

TYPE - POSITION	SAFEGUARDED DANGER TYPE
Fixed shelters  <b>Posterior, lateral front and inferior parts</b>	In the posterior, lateral front and inferior parts, to avoid the contact with the movement transmission devices, some <u>fixed shelters</u> are present in steel sheet metal suitable for the contact with the food, with thickness not inferior to 2mm (cfr. Annexed)
Fixed shelters  <b>Superior, front, and inferior parts</b>	In the posterior, lateral front and inferior parts, to avoid the reaching of the superior and inferior rolls, are present, respectively, n. 2 full <u>fixed shelters</u> in plastic material treated for food, with thickness not inferior to 2mm (cfr. annexed). The fixed shelters represent the superior and inferior entrance system.
Fixed shelters  <b>Lateral zone</b>	In the lateral zone, to avoid the superior and inferior rolls reaching, are present some <u>fixed shelters</u> steel sheet suitable for the contact with the food, with thickness not inferior to 2mm (cfr. annexed)
Fixed guards  <b>Area top, bottom, front, rear and side</b>	In the upper, lower, front, rear and side, managed to avoid the pasta roller accessory size, are of fixed guards in stainless steel AISI 314, with a thickness of not less than 2mm (see annex). The guards are the fixed system hub

For what concern the fixed shelters, is specified that:

1. the fixed shelters sizes are such as not leave openings in the protected dangerous working zone when are fastened in housing;
2. the fixed shelters not welded permanently to the machine are fastened with screws that request the use of special wrenches (allen spanner) and can be removed, with the suitable wrench, only from the maintenance responsables;
3. the access to the places protected from a fixed shelter is allowed only from the maintenance man. For any occasion, the operator must not ever try to open a fixed shelter;
4. it isn't possible to reassembly a shelter in wrong position so as to leave in the fairing dangerous openings;
5. if the shelters aren't fastened in their seats, with the appropriate special screws, cannot remain apparently closed and supported in that seat for lack of the fastening elements.

In the dimensioning and in the choice of the shelters and of safety devices, the people accessibility of equal age or oldest of 14 years is taken into consideration.

For all **safety functions** including the control and check systems parts connected to the safety, with reference to the safety category 1, components, safety principles and well-tested components have been used.

## LLKPR30 3. TRANSPORTATION, PUT IN SERVICE AND USE



**The machine management is allowed only** to an authorized and opportuently trained personnel equipped with a sufficient technical experience.

**The personnel involved in the machine driving** must be aware that the knowledge and the safety standards application is the integrating part of their work.

**The not qualified personnel must not** have the access in the operative area when the machine is used.

**Before to switch on the machine** perform the following operations:

- Read with attention the technical documentation,
- Know what protections and emergency devices are available on the machine, their localization and functioning.

**The not authorized use** of commercial parts and accessories making part of the protections and of the safety devices can provoke the confirmation of malfunctioning and the danger situation arising for the operator.

**The operator must besides** have received an adequate training.

### 5.1. WORK POSITIONS AND OPERATORS TASKS

The machine is designed to be driven from **an operator** trained and informed on the residual risks, but with the competences, in safety matter, of the maintenance employed, and having professionalism as previously showed.

**The operator** must be a competent person, or a designated man, opportuently trained and qualified for knowledge and practice experience and supplied with the necessary instructions to make so that the requested tasks are performed in safety.

Only during the living operations, the operator is **helped from a second operator** that has only the function to assist the operations of the first operator in the case there are some objects having mass superior to 25kg.

The work normal zone of the operator is the front zone of the machine (defined loading/unloading zone), in functioning normal conditions, for the operations of manual loading/unloading of the food product in the entrance systems, with the fixed shelters in closed position and blocked and with the moving shelter interblocked, lifted or lowered.

The operator has the task to:

1. load manually the product that must be rolled in the entrance system of the superior motorized rolls couple, with the fixed shelters closed and blocked;
2. take manually the product in exit from the superior motorized rolls and load manually in the entrance system the inferior motorized rolls couple, with the fixed shelters closed;
3. set manually with lever the distance between the rolls of the superior and inferior couple in accordance with the production requirements and with the product flattening.

The operator performs also the tooling tasks as the manual settino with lever of the distance between the rolls, with the fixed shelters in closed position and blocked. The tooling zone includes the front zone of the machine.

Besides the operator has the task to supersede the machine functioning and driving, circulating freely around the same in fixed shelters safety zones in closed position and blocked.

The operator is the working process responsible and has the task to control the machine, through the control actuators placed in the control panel.

Besides the machine normal driving, the operator has the task to start and stop the machine in normal conditions and stop it in emergency condition.

The verification operations belong to the operator; these tasks are easy, performed in safety conditions and clearly described in the following points.

Besides he has the task of general supervision on the machine driving; in case of necessity he must not make interventions but he must activate the maintenance service.

Besides he performs the machine external parts cleaning and of every other part that needs to be cleaned, with disconnected movements and fixed in safety, after having stopped the machine, at the end of every use and however before of a new use. The cleaning of the machine internal parts that have a disassembly of fixed shelters is entrusted to the maintenance man.

## LLK5230 TRANSPORTATION, LIVENING AND STORAGE

All transportation and livening operations must be performed from **personnel adequately informed and trained** and **must have read and understood** the safety prescriptions showed in the present instructions manual for the use.



Occur:

1. perform the machine livening and transportation always when it is unloaded,
2. verify that the lifting means are able to support the weight and the size of the loading in safety conditions and that they are approved and submitted to a regular maintenance,
3. adopt all measures necessary to assure the maximum stability of means and loads in relation to their masses and barycentres,
4. avoid to make suffer to the machine sudden shocks or accidental knocks during the livening and the unloading,
5. perform the livening with continue movements, without pulls or repeated impulses.

### STORAGE

The machine destined for the internal installation, in case of storage, must be stored in warehouse, in aired place, sheltered from the dust. The delivered machine must remain packaged up to the final installation in the use place.

In case of **long inactivity** the machine must be stored with the precautions relative to the place and to the storage times:

1. Store the machine in a closed place;
2. Protect the machine from knocks and stresses;
3. Protect the machine from the humidity and from excessive thermal ranges (make reference to the under table);
4. Avoid that the machine is on contact with corrosive substances.

The machine has been designed so as to support the temperatures, the humidity and the transportation and storage vibrations.

Environment temperature	-25 / +40 °C (if the electric material has a protection degree at least of IP54) 0 / +40 °C (if the electric material has a protection degree inferior to IP54)	Avoid places in which unexpected temperature jolts that can provoke condense or freezing
Storage temperature	-25 / +55 °C (if the electric material has a protection degree at least of IP54) 0 / +55 °C (if the electric material has a protection degree inferior to IP54)	
Relative humidity	100% to the temperature of +25°C (if the electric material has a protection degree at least of IP54) Inferior to 50% to the temperature of +40°C Inferior to 90% to the temperature of +20°C (if the electric material has a protection degree inferior to IP54)	
Vibrations	5.9 m/s <sup>2</sup> (0.6G) or bigger	
Atmospheric pressure	900 mbar or bigger	

The storage temperature is intended as a **short term values** as for example the transportation. The condense or the freezing happen normally in places where the temperature jolts are high. Also if the relative humidity in these cases can be included in the values showed in the table, it is necessary avoiding these places.

### CONTROLS DURING THE RECEIVING

It is very important to perform a **good control during the parcels incoming**, in the same moment of their receiving. The control performs in two phases for every parcel received with the aim to avoid possible errors of the carrier.

#### Administrative verification

1. Container and parcels number;
2. Weight and size;
3. Transportation document information correspondence with what delivered (description, registration number, etc. The technical data on the machine identification plate correspond with those ones included in the delivered technical documentation);
4. Transportation document data corresponding to the order.

#### Technical verification

1. Package condition and integrity.
2. The package has not suffered visible damages, in the transportation and livening operations.

In case of damages or incomplete or mistaken supplying, signal the fact directly to the manufacturer commercial department.



**For what above described, the manufacturer remembers to the user** that, for the current international and national standards, the goods travels always with risk and danger of this last one and, if not differently underwritten in the order confirmation phase, the goods travels not ensured.

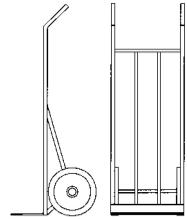
## TRANSPORTATION AND LIVENING

**The machine transportation** can happen on container or road haulage contractor. In the two cases the same packaging is foreseen. For what regard the sizes and weights, see previous technical data.

Taking into account of the sizes and the weights, the livening and transportation must happen **FROM THE BOTTOM**:

1. **manually** for packages of weight up to 25kg
2. through **two wheels trolley** or with an **elevator trolley** or **transpalett**, for packages of weight superior to 25kg. Assure that the appendices that will use the lifting mean, are placed in in the exact **correspondence of the pallet openings (if present) on which is placed the packaged machine, or in the centre of the package that the pallet is absent.**

During the livening, **keep the loading at the possible minimum height from the floor** to exceed the **possible obstacles present; this both for a better loading stability, both for a better visibility.**



In the case the loading doesn't allow a sufficient visibility of the ground, **request the presence of a second person on ground.**

For the stability, the machine independently from the form and morphology **must remain standing**.

The machine will have to be transported closest possible to the place foreseen for the use, that it will have been preliminarily verified for the sizes and for the necessary spaces.

**In case of successive livening, verify preventively that all possible particulars, or groups and under groups** that can suffer movements during the livening, are firmly fastened (through capacity systems), avoiding dangerous movements that can compromise the loading stability and weighing, parts accidental falls or possible reversal.

### 5.3. PACKING REMOVAL – OPENING MODALITY

#### PACKING DESCRIPTION – HOW GET RID OF THE PACKING MATERIAL

The machines are packaged so that the seepage/liquids insight, organic matters or alive beings is avoided: it is represented from a **covering in polyethylene around the machine**, and all inserted in a **cardboard box** of adequate size, placed on a wood pallet. The empty spaces within the box are occupied from the **fill material**.

Don't waste the packaging in the environment, but restore it for possible transportations or to address it to the recycling agencies.

The evaluation and the management with the aims of the biological compatibility of the products used in the packaging are of the user competence and responsibility.

It is an employer obligation **to be acquainted of the actual laws in own country and work so that to observe these legislations.**

**It is forbidden and besides liable to fines,** leave the machine and the electric equipment in the environment.

### 5.4. PRELIMINARY PREPARATION OPERATIONS

#### STABILITY

The machine stability is designed so that, in the foreseen functioning conditions, taking into consideration of the climatic conditions is such as to allow the use **without reversal risk, fall, or inopportune movement.**

Taking into consideration of the conformation and its position, **the machine results to be intrinsically steady without fastening needs to the working bench.**

#### USER ELECTRIC PLANT

**The user plant, upstream of the control and check equipment** of the machine, must be designed, installed and maintained in conformance with the applicable prescriptions of the safety rules for "low voltage users plants" in accordance with IEC3644 / HD384 / CEI 64-8 (last issues).

About the **energy distribution electric plant that feeds the control and check equipment** of the machine, is obligatory its regular/integral belonging to **one of the TT or TN normalized systems** in accordance with IEC364\_4\_41 / HD382\_4\_41 / CEI 64.8 (4\_41) (last issues).

About the above prescriptions / indications, **the correlative grounding system** must be in conformance with the applicable requirements for the coordination with the associated active devices, in accordance with IEC364-5-54 / HD382-5-54 / CEI 64.8 (5-54) (last issues).

## ELECTRIC FEEDING

The electric feeding connection must be in conformance with the **country legislation in which is used**.

**The electric feeding** so must be maintained in conformance with the following technical prescriptions:

1. **the electric feeding** must be always of type and have an intensity corresponding to the specifications indicated in the machine plate. If excessive voltages are applied, some components will be damaged irreparably,
2. **a differential device must be foreseen** coordinated with the protection circuit, respecting the legislation, the legislative and regulation disposals in force in the installation country;
3. **the electric feeding cable outside the machine cover** must be made pass in the spaces prepared from You and adequately protected;
4. if present **the neutral conductor (N)** before feeding the electric equipment, as for you its continuity must be guaranteed (connected and available).
5. before to feed the electric equipment, as for You must be guaranteed the continuity (connected and available) of the green yellow conductor of the protection equipotential circuit.

## PROTECTION DEVICE AGAINST THE OVERCURRENTS

The device is designed to resist to a **symmetrical short circuit current of short duration not superior to 6kA**. If the acceptable assumed current of conditioned nominal short circuit, in the installation point results to be major to the showed value, must be adequately limited.

Given that in the electric equipment supplied for the machine control and check, the electronic circuits aren't incorporated that function with continue current, it is recommended to take adequate precautions to assure the protection against the in direct contacts: in the protection field for the feeding automatic disconnection foresee **APPROPRIATE DIFFERENTIAL DEVICES**. The differential device must be strongly resistant to the impulsive over voltages of atmospheric and operation origin (cfr. EN 61008-1 last issues).

It is specified besides that:

1. in the electric feeding sectioning device, in the head of the electric panel **any nominal interruption power isn't adapted because it is a plug/socket combination**; besides it must be protected against the short circuits with a protection device having nominal current not superior to the technical data,
2. upstream the electric equipment feeding cable **the protection device against the over currents** must be installed and maintained in conformance with the technical rules prescriptions.

## ELECTRIC FEEDING SECTIONING DEVICE

The feeding sectioning device, as comparable from what described in the power circuits diagram delivered with the electric equipment, is supplied for the **machine feeding** unique source.

In case of incompatibility between the net socket and the device plug **change the socket with another type suitable from maintenance personnel**.

The feeding sectioning device allows **separating (insulate) the machine electric equipment** from the feeding, with the aim to make possible the interventions fulfillment without electric shocks risks.

The sectioning device presents two possible positions:



OFF or "disconnected", electric equipment **sectioned** from the electric feeding



ON or "connected", electric equipment **connected** to the electric feeding

## 5.5. LLKPR30 DEVICES AND CONTROL FUNCTIONS

Here follow the main **control devices** are showed (cfr. annexed):

CONTROL	PIZZA CONTROL LLKPR30/LLKPR40	
	ACTION	POSITION
BUTTON OF ON "I"	(ON) ACTIVE THE MACHINE ROLLS ROTATION	FRONT
BUTTON OF OFF "O"	(OFF) DISATTIVA THE MACHINE ROLLS ROTATION	FRONT
ELECTRIC PEDAL SOCKET	THE PLUG IS CONNECTED ON THE ELECTRIC PEDAL CONNECTION CABLE	SIDE
ELECTRIC PEDAL	SIMULATES THE FUNCTIONS OF THE BUTTONS. ACTIVATE AND DEACTIVATES THE ROLLS ROTATION, IS CONNECTED TO THE ELECTRIC PEDAL SOCKET. WHEN CONNECTED, EXCLUDE THE ON AND OFF BUTTONS FUNCTIONING.	GROUND

PIZZA ROLLER LLKPR30/LLKPR40		
CONTROL	ACTION	POSITION
ON/OFF BUTTON 	(ON/OFF) ACTIVATES THE MACHINE ROLLS ROATION WHEN IS PUSHED AND DEACTIVATES THE MACHINE ROLLS ROTATION WHEN IS PUSHED AGAIN	FRONT
ELECTRIC PEDAL SOCKET	THE PLUG IS CONNECTED PESENT ON THE ELECTRIC PEDAL CONNECTION CABLE	LATERAL
ELECTRIC PEDAL	SIMULATES THE FUNCTIONS OF THE BUTTONS. ACTIVATE AND DEACTIVATES THE ROLLS ROTATION, IS CONNECTED TO THE ELECTRIC PEDAL SOCKET. WHEN CONNECTED, EXCLUDE THE ON AND OFF BUTTONS FUNCTIONING.	GROUND

### STARTING

The machine starting is possible only **with a voluntary action on the control device foreseen for this aim.**

STARTING TYPE	MODEL	ACTION
Starting from switched off machine	LLKPR30/ LLKPR40	<ol style="list-style-type: none"> <li>connect the feeding socket/plug;</li> <li>drive the beginning button "P" (ON) or activate the electric pedal (when present and connected)</li> </ol>
	LLKPR30/ LLKPR40	<ol style="list-style-type: none"> <li>connect the feeding plug/socket;</li> <li>drive the beginning button  or activate the electric pedal (when present and connected)</li> </ol>
Start from under voltage machine situation	LLKPR30/ LLKPR40	For the working restarting, after a work suspension, it is necessary to activate the beginning button "I" (ON) or  activate the electric pedal (when present and connected)
Start from emergency machine situation (after emergency button pressure)	LLKPR30/ LLKPR40	For the working restarting, after a work suspension, it is necessary to activate the beginning button "I" (ON) or  activate the electric pedal (when present and connected)
Start from emergency machine situation (example thermal protection intervention)	LLKPR30/ LLKPR40	Switch off the Machine and after having perform to cool it, it is necessary: <ol style="list-style-type: none"> <li>connect the feeding plug/socket;</li> <li>activate the beginning button "I" (ON) or  activate the electric pedal (when present and connected)</li> </ol>

### STOP

For the stop control push the stop button "O" (OFF) or push the ON/OFF button  or release the electric pedal.

In case of **momentary or extended stop**, before to get in function the machine, all food products must be removed within the machine.

In case of **extended stop** sectionate the general plant of the electric energy feeding net, or disconnect the feeding plug/socket.

**SWITCHING OFF**

In succession, the switching off operations must perform what here follow showed:

1. before the switching off wait the machine functioning conclusion;



stop the machine pushing the stop button “O” (OFF) or push the ON/OFF button  or release the electric pedal.

2. disconnect the feeding plug/socket;
3. perform the cleaning interventions

**FUNCTIONING SAFETY**

If the machine is under stress or submitted to an overloading, the machine stops immediately for the thermal protection functioning. In this case **wait that it is completely cooled** before proceeding to the starting function.

**VOLTAGE LACKING**

In case of electric feeding breaking or if the machine is disconnected from the electric net, this last one will be able to be restarted only following the starting function, **after the electric feeding back or the reconnection to the electric net.**

**5.6. FUNCTIONING DESCRIPTION****CONTROLS AND VERIFICATIONS BEFORE THE SET IN FUNCTION**

VERIFICATION / CONTROL	MODALITY AND CHECKS
<u>Verify that:</u> ➤ Strange objects <b>among the rolls aren't on the machine</b>	Visual control of the showed parts, to check the absence of objects or strange bodies as for example various tools, clothes, etc.. and that there isn't however the food product. In case of presence provide to their removal.
<u>Verify the cleaning:</u> ➤ <b>Of the entrance systems and of the rolls surface,</b> ➤ <b>Of the machine external surface</b>	All the showed parts surfaces, before the machine use must be checked visually to check their cleaning. For the visual control of the rolls surfaces, provide to the machine control. In case of moulds or other type of dirt, provide the cleaning procedure in accordance with the indication of the chapter “CLEANING”
<u>Verify the integrity:</u> ➤ <b>Of the fixed protections,</b> ➤ <b>Of the machine body</b>	All devices must perform the function for which have been foreseen. Control directly the devices so that these ones determine the waited function. The actuators and all parts must be however changed to the first erosion signs or breaking.
<u>Verify the functionality:</u> ➤ <b>Of the control system parts / control about the safety;</b> ➤ <b>Of the control devices.</b>	All devices must perform the function for which have been foreseen. Control directly the devices so that these ones determine the waited function. The actuators and all parts must be however changed to the first erosion signs or breaking.
<u>Verify the absence:</u> ➤ <b>Of strange noises after the starting</b>	During the functionality check of the control devices, in the case there are strange noises, due for example to mechanical breaks, stop immediately the machine, and activate the maintenance service.

For any intervention or for the parts change that prove damaged, **activate the maintenance service.** The possible change must happen with original products of the manufacturer or at least of same quality, safety and characteristics. For investigations contact the Authorized Assistance Centre.

**SET IN FUNCTION R30**

The operator after positive result of the controls ready to check the respect of all safety conditions and all controls of the previous paragraph, can set in function the machine, following in order the indication under showed.

1. Make some little doughes (round) if possible of the same basis weight so that the discs formation for pizzas, breads and focaccia is easier.
2. Place one of the little doughes between the superior rolls and set the position, through the proper regulator relative to the superior rolls, so that the rolls are half opened.
3. It specifies that before to perform this operation it needs to place also the inferior rolls, with a proper regulator relative the inferior rolls: for example to obtain the final desired dough for the discs formation for pizzas, these ones will have to be half-closed.
4. the dough rolled in the superior rolls will be oval, and the proper precision balance placed in the centre of the slide will provide in automatic way to make slide and rotate for 90° degrees the dough within the inferior rolls yet placed.
5. the precision balance counterbalances must be set taking present the basis weight of the doughes.
6. If the precision balance isn't used, because disassembled from the user or in endowment, the hands must substitute it: once the portions are introduced in the superior rolls, insert these ones in the inferior rolls having care to place the oval dough borders in parallel with the same.

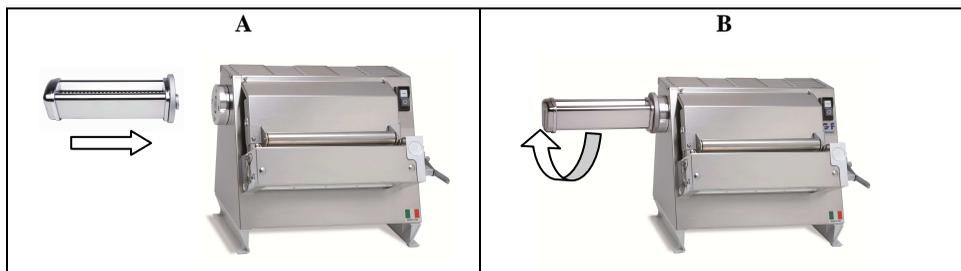


**It is recommended to make not function the vacuum machine, without the food product.**

**START ACCESSORY CUTTERS**

The operator following successful controls designed to ensure compliance with all conditions of security and all controls in the preceding paragraph, can operate the machine, in order following the instructions below.

1. place the accessory sheet size near the power take-off of the machine
2. keep it rotated slightly clockwise plugged into force (A)
3. rotate the accessory CUTTERS counterclockwise to allow complete attachment to the PTO (B)
4. turn on the machine by activating the START button
5. manually enter the threshold at the top of the accessory and fetch it from the bottom



## 6. MAINTENANCE, DAMAGES RESEARCH AND CLEANING

### 6.1. MAINTENANCE MAN REQUIREMENTS

With the term “**maintenance**” must not be intended only the periodical control of the machine normal functioning but also the analysis and the consequent remedy of all causes that for any reason put it out of service.

The personnel that perform the operations included in the present chapter, besides to present the characteristics showed in the chapter 4, **must have read and understood** the safety prescriptions showed in the same chapter about the residual risks.

It is absolutely necessary that for the activities of **maintenance, cleaning, parts change and damages research** performed from the user, **this task is entrusted to skilled personnel**, competent and authorized from the employer.

**These skilled personnel** must be able to evaluate the work and recognize the possible dangers on the basis of his preparation, knowledge and professional experience and his knowledge of the machine, of the equipments and of the relative standards; he must besides have an adequate professional qualification about the machine. He must be **trained** in safety matter and on the residual risks described in the chapter 4.

He must besides be **trained and not warned**, or he must be a qualified or graduated technician with knowledge concerning the machine and the relative equipments and the relative standards and that has a particular technical competence or training.



All operations of **maintenance, cleaning and parts change**, none excluded, must be peremptorily performed with the machine completely stopped and insulated from the external feeding sources.

Before of any intervention of **maintenance, cleaning, parts change and damages research**, pay much attention to the labels placed in the machine. During the activities the warning labels and the safety devices **must not be tampered or disconnected** for none reason, nor create by pass, nor use them for purposes different from those ones foreseen from the manufacturer.

In case of damaging or illegibility verification of the warning labels request immediately to the Authorized Assistance Centre.

**The maintenance man has the job to:**

1. perform the tooling, calibration and machine setting, also within the machine dangerous zones with the fixed shelters in closet position and blocked, with the dangerous moving elements disconnected and stopped in safety,
2. perform the cleaning of the machine internal parts (eventually performing disassemblies), the maintenance, the assistance interventions, damages research, worn or damaged parts or structural parts change, with the dangerous moving elements disconnected and stopped in safety,
3. perform the interventions of the previous points, removing also the fixed shelters.

### 6.2. MAINTENANCE PRESCRIPTIONS

#### SHELTERS REMOVAL AND/OR PROTECTION DEVICES

For any interventions of the present chapter, **it is necessary to remove from their position some fixed shelters**.

The removal can happen only with the maintenance man work.

At the end of the interventions, these shelters must be replaced and blocked in their original position, with the fastening systems that were foreseen before the intervention.

**The maintenance responsible must disconnect completely the machine**, as among other things here follow showed, before to proceed with the removal of a fixed shelter and/or with the element change.

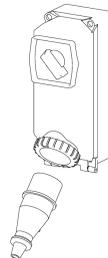
#### INSULATION FROM THE EXTERNAL FEEDING SOURCES

Before to perform any operation of **maintenance, cleaning and parts change**, the external feeding sources must be sectioned and insulated.

Position on “ZERO” the protection device placed upstream of the electric equipment feeding line



Disconnect the general sectioning device and provide to protect the plug with appropriate systems



### 6.3. ORDINARY MAINTENANCE



The personnel that perform the operations included in the present chapter, besides to present characteristics showed in the chapter 4 and **must have read and understood** the safety prescriptions showed in the same chapter 4.

**For the selling of the worn and changed materials,** make reference to the prescriptions of the chapter 7.

#### 6.3.1. ORDINARY MAINTENANCE PERFORMABLE FROM THE OPERATOR

FREQUENCY	VERIFICATION / CONTROL	MODALITIES AND CHECKS
Before of every shift	<b>Work area control:</b> <ul style="list-style-type: none"> <li>➤ Must be cleaned and without dust</li> </ul>	<p>The work place and the machine external parts must be cleaned and removing other parts that could prevent the correct functioning and that could compromise the safety conditions presented at the beginning in the machine.</p> <p>For any intervention or for the parts change, activate the maintenance service.</p>
At least once a week	<b>Verify the functionality:</b> <ul style="list-style-type: none"> <li>➤ Of the safety devices of the chapter 4</li> <li>➤ Of the stop functions</li> </ul>	<p>Perform a visual inspection and a functional test of the safety devices, of the foreseen interblocks and of the stop functions with the aim to check their correct functioning and stopping of the moving elements.</p> <p>For any intervention or for the parts change, activate the maintenance service.</p>
At least once a week	<b>Integrity visual verification</b> <ul style="list-style-type: none"> <li>➤ All instruction plates, signal and warning</li> </ul>	<p>In case of their illegibility, or are requested to the <u>Authorized Assistance Centre</u> or are however changed from the user with others showing the same information, in accordance with what showed in the chapter 4.</p>
At least once a month	<b>Integrity visual verification</b> <ul style="list-style-type: none"> <li>➤ Superior and inferior entrance system</li> <li>➤ Rolls</li> </ul>	<p>The use of the showed parts, determines their wear in the time. After the cleaning, check visually the absences of splintering, cracks or breaks. In case of negative result of at least a control, proceed with their change.</p> <p>The possible change must happen with <u>the manufacturer original products or at least of quality, safety and equivalent characteristics</u>. For investigations contact the <u>Authorized Assistance Centre</u>.</p>

#### 6.3.2. ORDINARY MAINTENANCE PERFORMABLE FROM THE OPERATOR

FREQUENCY	VERIFICATION / CONTROL	MODALITIES AND CHECKS
At least monthly	<b>Inside the covers – motor openings</b>	<p>All covers internal parts and the machine openings where the motors are installed must be <b>cleaned and dry</b>.</p> <p>Provide with adequate and common means (as for example vacuum cleaner and dry brush for the dust and absorbent clothes for possible water parts), to maintain adequate spaces.</p>
At least monthly	<b>Efficacy verification:</b> <ul style="list-style-type: none"> <li>➤ Mechanical connections</li> </ul>	<p>Perform, with the appropriate tools, a tightening control of clamps, screws, dies, bolts and connections in general.</p>
At least quarterly	<b>Verify the functionality:</b> <ul style="list-style-type: none"> <li>➤ Motors run contactors,</li> <li>➤ All control circuit relays</li> </ul>	<p>Perform a visual inspection to check the relays contacts condition, the contactors power contacts and the canalizations and internal and external pipes of the covers.</p> <p>If these ones included the unipolar and/or multi polar cables aren't in normal conditions, with the aim to guarantee a correct functionality, proceed to their change.</p>
At least quarterly	<b>General verifications</b> <ul style="list-style-type: none"> <li>➤ Electric equipment</li> </ul>	<p>Verify the whole electric equipment for requirements of service and functioning continuity.</p> <p>It must be checked that the electric equipment parts subjected to wear, as for example: cables and canalizations, all control actuators worked from the operators, etc..., are integral and functional.</p>

FREQUENCY	VERIFICATION / CONTROL	MODALITIES AND CHECKS
At least half-yearly	<b>Verify the efficacy:</b> <ul style="list-style-type: none"> <li>➤ Of the equipotential circuit and protection connections</li> </ul>	With adequate instrumentation the resistance must be measured and checked towards equipotential plant mass, protection and of every connection, so that the measured values are in the acceptability limits defined from the installation standards and in accordance with the actual disposals of the installation place. In the prescriptions ambit – above indications, the correlative grounding plant must be in conformance with the applicable requirements for the coordination with the associated active devices, in accordance with IEC364_5_54 / HD382_5_54 / CEI 64.8 (5_54) (last issues).
At least half-yearly	<b>Verify:</b> <ul style="list-style-type: none"> <li>➤ The motors electric insulation</li> </ul>	With adequate instrumentation the motors insulation resistance must be measured and checked, so the measured values are in the acceptability limits defined from the installation standards and in accordance with the actual disposals in the installation place.
At least half-yearly	<b>Verify:</b> <ul style="list-style-type: none"> <li>➤ the absorption in the single phases of the uses and motors</li> </ul>	With adequate instrumentation the absorptions must be measured on every feeding conductors of uses and motors. In the case in which the pointed out values during the normal functioning are not included in a range of 10% of the values showed in the electric diagrams of feeding and control/check, activate the maintenance service with the aim to verify all further use/motor characteristics, because this could in short time damage.
At least yearly	<b>Verify the efficacy:</b> <ul style="list-style-type: none"> <li>➤ of the connections and electric components within and outside the covers</li> </ul>	Verify the absence of possible releases. If present restore the connections in durable way tightening the connections with adequate torque and carried back directly on the electric components. The control must besides regard: <ul style="list-style-type: none"> <li>➤ the derivation boxes integrity, of the covers, of the push-button panels and the electric cables protection cases;</li> <li>➤ the functionality of all control and power actuators.</li> </ul>

The possible change must happen with original products of the manufacturer or at least of same quality, safety and characteristics. For information contact the Authorized Assistance Centre.

#### 6.4. EXTRAORDINARY MAINTENANCE

For the interventions of **extraordinary maintenance and parts change**, consequent to breaks or revisions or mechanical or electric damages, it is necessary an intervention request to the Authorized Assistance Centre.

**The instructions about the extraordinary maintenance are not present in the actual instructions manual for the use and so must be clearly requested to the Authorized Assistance Centre.**

**For the selling of worn and changed materials**, make reference to the prescriptions of the chapter 7.



**It specifies besides to:**

1. Not try any change and/or reparation of significant elements.
2. Not perform any welding of parts eventually damaged.
3. Not use ever the machine if it isn't in its full efficiency.



**After important reparation interventions or parts change**, before of the successive refunctioning, a positive result, the controls, recordings and verifications showed in the chapter 4, 5 and 6 must be performed and checked.

**For the worn and changed materials selling**, make reference to the prescriptions of the chapter 7.



**Before to proceed to any intervention or investigation:**

1. Signal, with a sign, that you are performing the maintenance.
2. Before to restart the machine, check always that there aren't personnel that are performing cleaning and/or maintenance operations.
3. For the controls and the little electric repairs make intervene exclusively qualified and regularly skilled professional electricians and/or electrotechnics.
4. For the mechanical reparations contact absolutely, always, the Authorized Assistance Centre.
5. Consult always and in every case the Authorized Assistance Centre in the ways showed in the first pages of the present manual.

Here follow the interventions for the **damages or breakdowns research and moving element unblock** are showed that can be performed from maintenance men, having professionalism, in accordance with what defined in the paragraph 6.1.

TYPE	POTENTIAL CAUSES	MODALITY ANDCHECKS
<b>Net voltage lacking</b>	General black out	Contact the electric energy distributor
	Fuses or magneto thermals placed upstream of the machine feeding line	After having eliminated the causes that have determined the protection device intervention, restore it. In case of problem persistency contact an electrician.
<b>Functioning breaking</b>	Protection device inside the machine	Contact an electrician technician: after having eliminated the causes that have determined the protection device intervention, restore it. <b><u>In case of fuses intervention</u></b> , change them with types of the same model, calibration and intervention curve.
	Cause/s not identifiable	Contact directly the <u>Authorized Assistance Centre</u>
<b>The machine doesn't function: the rolls don't rotate</b>	Feeding voltage lacking.	Check and restore the electric energy.
	Plug disconnected.	Insert the plug for the feeding in an adequate electric socket
	Intervened fuses or not functioning magneto thermals.	Make change the intervened fuses, check the magneto thermal switches condition.
	Lacked running button functioning or the electric pedal	Check the control devices efficiency and eventually contact directly the <u>Authorized Assistance Centre</u> .
	Thermal intervention due to the overheating	Wait the complete cooling before the machine restarting

## 6.6 CLEANING

LLKPR30



**It is forbidden to clean by hand the moving parts and elements.**

All cleaning interventions must be made only and exclusively **after having loaded the machine with the food product in working and having insulated from the electric feeding and external energy sources.**

For the machine, electric equipment and components cleaning **don't use ever fuel, solvents or inflammable and/or corrosive fluids.**

The machine, the electric equipment and the components **must not be ever washed using water, even less in jets form of any nature and quantity; so, without "bucket", "rubber" and "towelng"**. Don't put ever directly the machine in the sink or under the tap.

Use not inflammable and not toxic solvents, commercial and approved. **Respect the use modalities and adopt the possible individual protection devices** foreseen from the supplier of these substances.

**The hygiene level classification of the associated machine and tools, for the foreseen use, is 2 (two):** machine that, following an hygiene risk evaluation, is in conformance with the applicable international standards requirements, but requests a programmed disassembly for the cleaning.

FREQUENCY	PERSONNEL	MODALITY
<p><b>At the end of every shift and however before the daily use</b></p>	<p>Operator</p>	<p>All the surfaces and the machine parts destined to come in contact with the food product or with <b>the food zones</b> (<u>machine front surface, the rolls, the buttering systems and the relative structural parts, the internal scraper dough</u>) and <b>the jets zones</b> (machine external surface), must be cleaned and disinfected with the under showed modalities. For the tools disassembly activities see previous descriptions.</p> <ul style="list-style-type: none"> <li>➤ <b>Scrape the surfaces from the possible food product residuals</b> (for example with plastic scrapers);</li> <li>➤ <b>Suck the flour residuals or the food products</b> with an extractor fan having pressure between 2 - 3 atm, <u>with the stopped machine in guaranteed safety</u>.</li> <li>➤ <b>Clean the entire food zone surfaces and jets zone with a morbid dampened clothes</b> (<u>not draining</u>). Don't let soak them.</li> <li>➤ With a towel clean inside the tools. Use specific product for the steel, these must be liquids (not in cream or however abrasive pastes) and above all must not include chlorine. Against the fat substances it is possible to use denature alcohol.</li> <li>➤ <b>The tools reassembly</b> must happen only following of a working requirement, leave the pieces wrapped in a soft dry clothes that doesn't lose the coats</li> </ul> <p><b>PERIODS OF LONG INACTIVITY</b></p> <ul style="list-style-type: none"> <li>➤ During the machine <b>long inactivity periods</b> provide to pass vigorously on all steel surfaces (especially if stainless steel) a clothes soaked of Vaseline oil so that to spread a protective veil.</li> </ul> <p><b>THINGS NOT TO DO BEFORE OR DURING THE CLEANING:</b></p> <ul style="list-style-type: none"> <li>➤ Enter towards the moving elements without <u>to be previously checked of their stop</u>;</li> <li>➤ Enter towards the moving elements without have stopped it <u>in guaranteed safety stop</u> (blockage in zero position of the electric feeding sectioning devices)</li> </ul> <p><b>PRODUCTS NOT TO USE:</b></p> <ul style="list-style-type: none"> <li>➤ <u>Compressed air with jets towards the zones with flour warehouses</u> and in general towards the machine;</li> <li>➤ <u>Vapor equipment</u>;</li> <li>➤ <u>Detergents that contain chlorine (also if diluted)</u>, or its compounds as: the beach, the muriatic acid, products to clear the drain, products for the marble cleaning, in general decalcifying, etc ... can attack the steel composition, staining and oxidizing it unavoidable. The only above described products fumes can oxidize and in any case corrode the steel;</li> <li>➤ <u>Steel wool, brushes or abrasive discs</u> produced with other metals or alloys (ex, common steel, aluminum, brass, etc ...) or tools that have previously cleaned other metals or alloys, that except to scratch the surfaces.</li> <li>➤ <u>Detergents in abrasive dust</u>;</li> <li>➤ <u>Fuel, solvents or inflammable and/or corrosive fluids</u>;</li> <li>➤ Substances used <u>to clean the silver</u>.</li> </ul>

## 7. DEMOLITION AND SELLING

If it decides to not use more the machine because obsolete and/or obsolete damaged or worn about to bring anti economic the reparation, it is necessary to proceed to its out of service bringing inactive and without potential dangers. The out of service must be entrusted to **specialized and equipped personnel**.

Before beginning the **demolition**, signal that there are interventions in progress.

### 7.1. DEMOLITION



**The main sequential phases** for the disassembly and the dismantling include (not exhaustive indicative list):

1. the sectioning device of the feeding external energy must be blocked with a padlock in the zero "0" position. See for this aim the chapter 6;
2. disconnect the conductors from all components presented inside the electric panel and from all components installed on the machine and send them to corporations or waste separation societies in accordance with the actual standard;
3. disassembly all components included inside the electric panel and installed on the machine and send them to corporations or waste separation societies in accordance with the actual standard;
4. all metallic or plastic carcasses, the screws and any other part in steel or plastic must be sent to corporations or waste separation societies in accordance with the actual standard.

All disconnecting operations must be performed using **adequate equipment and tools of adequate sizes** (for example cutting or cross screwdriver, hexagonal wrench, allen spanner, etc...), in accordance with the screws to slacken.

**At the end of the dismantling activities** all identification labels and every other machine document must be destroyed.

### 7.2. SELLING



It is a user obligation **to know of the actual laws about to the management of the electric and electronic equipment refuses (RAEE), in its country and work so as to comply with these legislations.**

The evaluation and the management for the biologic compatibility of the products used in the machine are of user competence and responsibility

The machine **can be sold without need to reduce in tiny pieces**; it is sufficient to disconnect the main groups that made it and place them on the means of transportation used to the scrapping.

The main duties being up to the user are the following:

1. it is obligatory **not to sell the RAEE as urban refuses**, but occur to perform a separated harvest;
2. for the RAEE selling it is **possible to deliver to the distributor** the electric equipment during the new one purchasing;
3. **In option for the selling**, work in conformance with the actual standards, enquiring to the waste separation centers prepared from the local administrations and/or to the firms specialized in the industrial machines scrapping and/or in the refuses selling and/or rejob centers, treatment and recycling, in order that there is the separation between plastic material, metallic material and electric components **that must be sent to waste separations**;
4. in the machine **dangerous substances aren't present** that can have a potentially negative effect towards the environment and the human health;
5. **a machine improper use or of its parts** not determine a potentially negative effect towards the environment and the human health;



6. **the symbol that shows the separated harvest need** () is a rubbish crossed container on wheels as showed here under; the symbol is printed in visible way, readable and indelible on the product;
7. **the foreseen penalties**, in case of abusive selling of these refuses, are defined from the actual and applicable legislation where the product is eventually sold abusively; application of the administrative penalties in the article 50 and the next of the D.Lgs. n. 22/1997.

**8. MANUFACTURING MATERIALS**

In accordance with the functioning and production requirements, the machine can be constituted with different manufacturing materials typology.

GROUP	LLKPR30/LLKPR40		
	Steel painted	Steel painted	Steel painted
Machine body	■		
Machine front structure (slide)		■	
Precision balance		■	
Rolls couples			■
Entrance systems			■