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INSTRUCTION MANUAL

SM-330/ 430/ 936/ 1136

(Semi-Automatic Divider Rounder)



IMPORTANT INSTRUCTION

THE INFORMATION IN THIS MANUAL IS CRUCIAL, MAKE SURE THAT THIS MANUAL HAS BEEN MADE AVAILABLE TO ALL PERSONNEL WHO MAY OPERATE THE MACHINE. READ, UNDERSTAND AND FOLLOW THE WARNINGS AND INSTRUCTIONS CONTAINED IN THIS MANUAL.

**WARNING**

IMPROPER INSTALLATION, OPERATION, MAINTENANCE COULD RESULT IN DEATH, INJURY OR DAMAGE OF THE MACHINE.

**WARNING**

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

Model:	Serial Number:
Manufacture Date:	Installation Date:

Working Safety

The machine must be used only by personnel suitably trained for the purpose and who has been trained in the contents of this publication.

To ensure safe work, comply with the following instructions:

1. Install the machine in compliance with workplace safe requirement.
2. Use the machine with great care and never be distracted.
3. Do not wear loose fitting clothing or clothing with wide or open sleeves.
4. Do not remove, cover or modify the identification plates placed on the machine body.
5. Do not bypass the mechanical and electrical protection device.
6. Work on the products permitted and not on other types.
7. Do not use the machine as a working top and do not place any objects on it that are not required for normal working operations.
8. Do not use the machine with temporary electric connections or non-insulated cables.
9. Periodically check the state of the power cable and cable clamp on the machine body, replace it as soon as is necessary by qualified personnel.
10. Stop the machine immediately as soon as there is defective or abnormal operation, a breakage, incorrect movements, or unusual noise.
11. Before cleaning or carrying out maintenance, disconnect the machine from the power supply.
12. Use protective working gloves for cleaning and maintenance.

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Brief Introduction

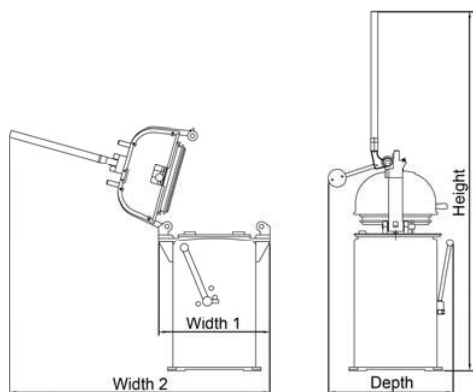
These machines are specially used for dough dividing and rounding, they can divide and round the dough for Bun evenly with very little difference in weight and structure. And with the semi-automatic system, it can save large labor working that only two persons are needed. The machine has proved to gently handle a wide variety of dough and produce a high quality product.

All of the information, illustration and specification contained in this manual are based on the latest product information available at the time of printing. SINMAG reserves the right to make changes at any time without notice. If questions arise during the operation or servicing, please contact us before proceeding.

Features

- 1). Can divide the dough evenly.
- 2). Can round the dough greatly.
- 3). The machines can keep in a good status with lubricating oil.
- 4). Can turn over the machine head and easy to clean the knives with loosen one side pin of the machine head.
- 5). Can save large working time and finish rounding just in 8 seconds.

Specification



Model	SM-330	SM-430	SM-936	SM-1136
Number of Division	30	30	36	36
Dough Weight Range(g)	30~100	40~120	20~70	30~100
Power(kw)	0.75	0.75	0.75	0.75
Dimension(mm)	Width 1	650	650	650
	Width 2	1720	1720	1720
	Depth	710	710	710
	Height	2050	2050	2050
Weight(kg)	340	340	340	340
Standard Attachment	Three plastic moulding plates			

**WARNING**

BEFORE INSTALLING THE DIVIDER, CHECK THAT THE AVAILABLE ELECTRICAL SUPPLY MATCHES THAT OF THE MACHINE AS STATED ON THE MACHINE'S NAME PLATE.

Installation

The machine is supplied factory lubricated and ready to run. After uncrating the machine, inspect it carefully to see whether there is any damage that might have occurred during shipment. Report any damage to us before proceeding. Never attempt to operate this machine with damaged or inoperable parts.

Check for the following in the package: three moulding plates, one pressing lever, one plastic bottle of transmission oil (check inside the base).

The divider rounder should be positioned on a level floor of appropriate strength and stability, also with a convenient location that allows for easy access to the units controls and working areas, as well as to the top, front and sides for maintenance.

Electric Connection

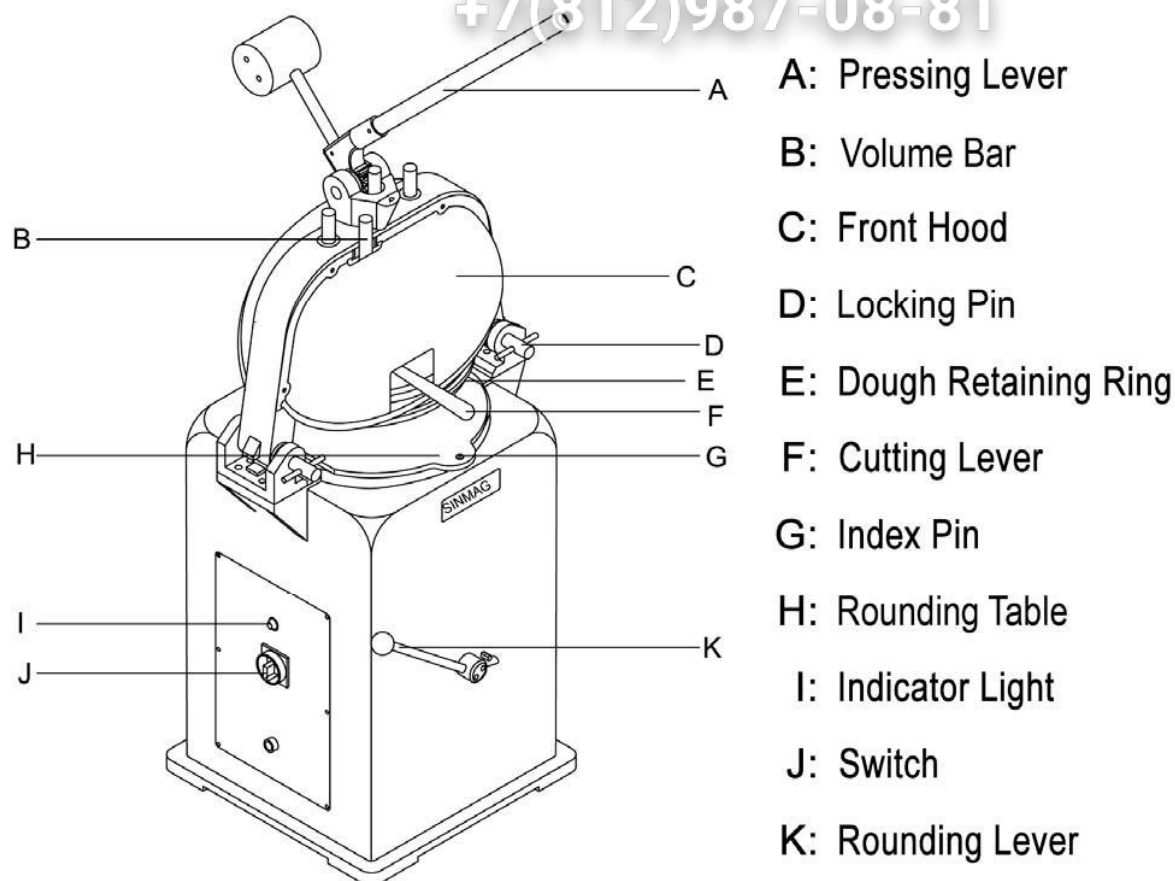
Before making any electric connection, read the specifications on the nameplate to ensure that they agree with your power supply. Electric connection should be made by a qualified service technician who will observe all applicable safety codes and the national electrical codes.

Appropriate electrical service should be available within the reach of the included electrical wires. Do not use any extensions to connect the machine electrical wires to the electrical outlet.

An air circuit breaker should be added to the main switch near the machine, and 1.5m high above the ground for the electric supply. The machine must be in ground protection.

Commissioning

After the machine is connected with the right power supply, use the rounding handle to see if the rounding plate is running in the direction of the arrow as indicated on the front side of the machine. If not, swap any two of the three phases, and restart the machine again until the plate runs in the right direction.

Set-up**Machine Check Out**

Without dough, insert and lock one rounding plate on the Index Pin. Be certain the rounding table and rounding plate are clean with no foreign trapped between them, and the rounding plate is completely flat on the rounding table.

Lower the dividing head by pulling down the pressing lever until it stops in the down position. This is the pressing operation, which evenly distributes the dough in the dividing head to assure uniform weight for each division.

While holding the pressing lever down, slowly push the rounding lever downward to actuate the rounding cycle (see figure 2). The moulding table and the moulding plate will shift sideways, and it will cause the moulding plate to move in a circular motion if the motor is turned on. After several

seconds, slowly return the rounding lever to the fully raised rest position. This is the rounding cycle, which rounds the dough pieces into dough balls. Slowly return the pressing lever to the fully raised rest position.

Remove the moulding plate by first pulling it up off the the locking pin and then straight out from the front of your Bun Divider Rounder.

Note: Check dividing plate for any unusual marks or scratches caused by the knives coming into contact with the dividing plate. If marks or scratches are detected, call your dealer for service advice.

Operation Steps

- 1). The dough is placed into a Moulding Plate within the marked circle. Flatten dough a little.
- 2). Place Moulding Plate with dough onto the Rounding Table of the machine. Do not flour the Moulding Plate.
- 3). Press dough by pulling down Pressing Lever.
- 4). Operate Cutting Lever (top part ball handle) and cut by pulling down Pressing Lever further. When operating the Cutting Lever, do not release Pressing Lever, press through immediately.
- 5). Keep Pressing Lever in bottom position and press Roulding Lever evenly sideways. Let Rounding table rotate for 3-5 seconds and return to zero position.
- 6). Lift Pressing Lever to stop position and remove Moulding Plate with the divided and rounded dough pieces.

Weight Adjustment

For the best rounding result, the rounding space must be adjusted according to the weight of the dough piece. This can be done by altering the position of the Volume Bar. Loosen the locking sleeve, set the Volume Bar and tighten the locking sleeve again.

The scale on the Volume Bar is for reference only. The position of the volume bar must be changed to suit the dough. If the Bar is setted too small, it may damage the surface of the dough. Also if the Bar is setted too high, it may result in the dough not rounding properly.

Before the dough is put into the machine, please ensure that it has had an adequate rest time.

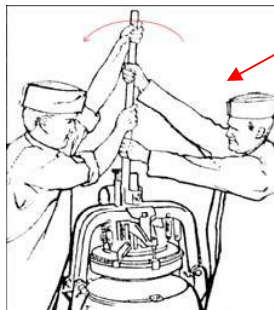
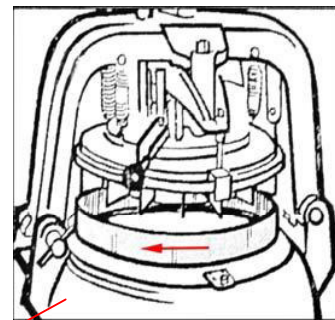
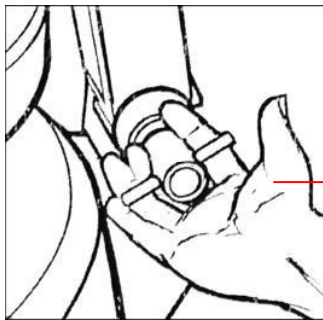
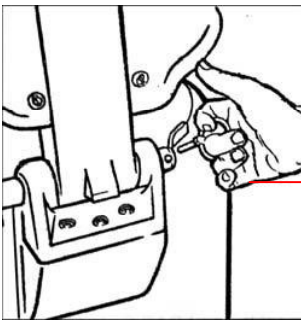
WARNING



ENSURE THAT DINDER COUNDER IS ISOLATED FROM THE ELECTRICAL SUPPLY BEFORE COMMENCING CLEANING OR MAINTENANCE.

Daily Cleaning Procedure

- 1). Brush off all external surfaces using a banister brush and work from top to bottom.
- 2). Wipe all surfaces with a damp cloth. Dry all external surfaces.
- 3). Remove the two Hoods.
- 4). Remove the pull pin from the end of Locking Pin on one side only.
- 5). Twist Dough Retaining Ring in an clockwise direction, low onto rounding Table and remove from the machine. Scrape Dough Retaining Ring only with a plastic scraper.
- 6). Using the Pressing Lever rotate the Pressing head assembly to allow the blades to be exposed.



7). Using a plastic scraper scrape and sweep old dough and build up deposits from the divider head and Rounding Table. Lightly oil divider head (use food grade oil only).

8). Engage dividing lever and pull on Pressing Lever to expose the dividing knife surfaces.

9). Scrape all the divider surfaces using a plastic scraper, then lightly oil (use food grade oil only).

10). Use two people to reposition the Pressing Head back to its upright working position.

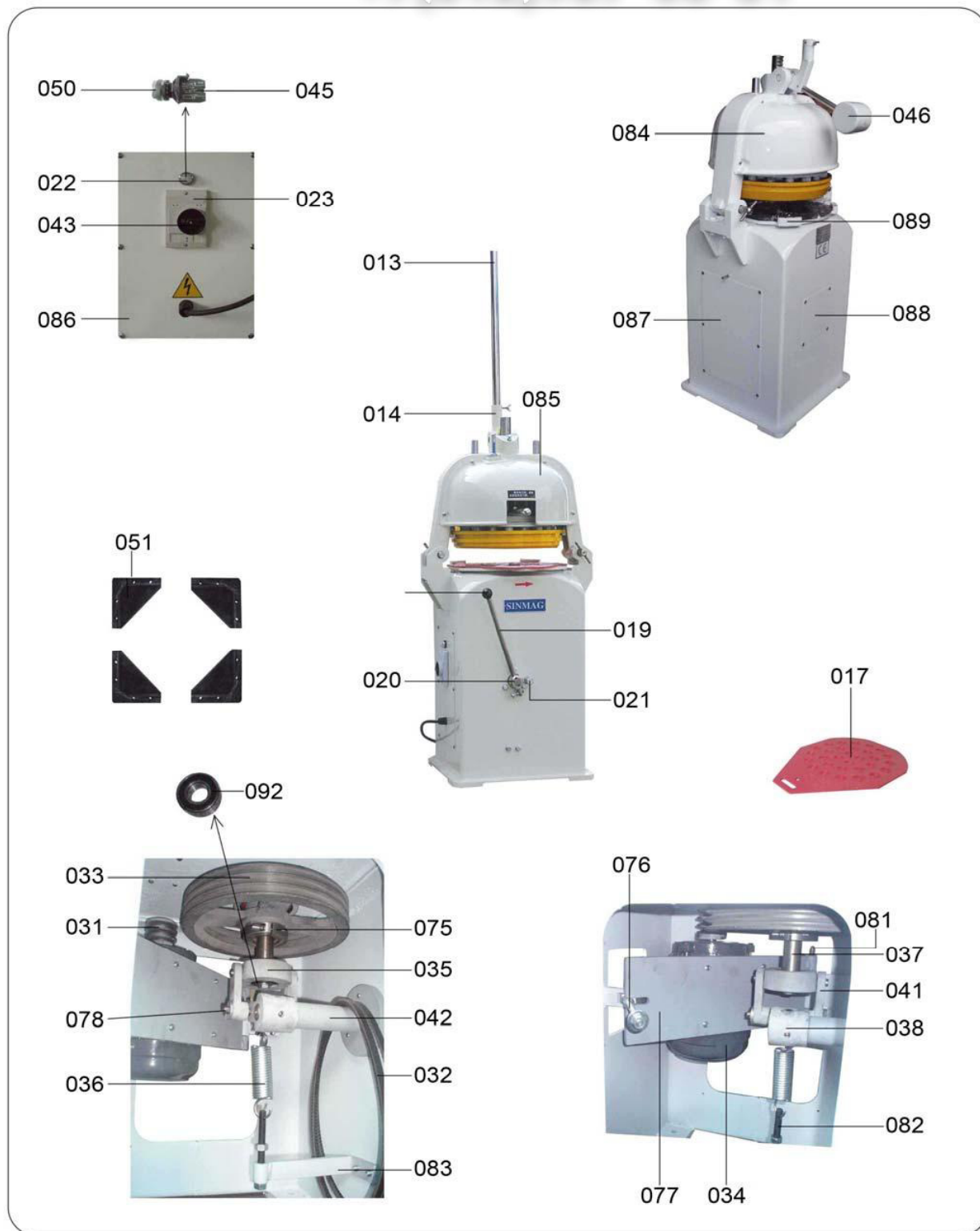
11). Locate and put back the Locking Pin.

Note: Do not hit into position with a hammer or metal object.

12). Put back the Pressing Ring and Hoods.

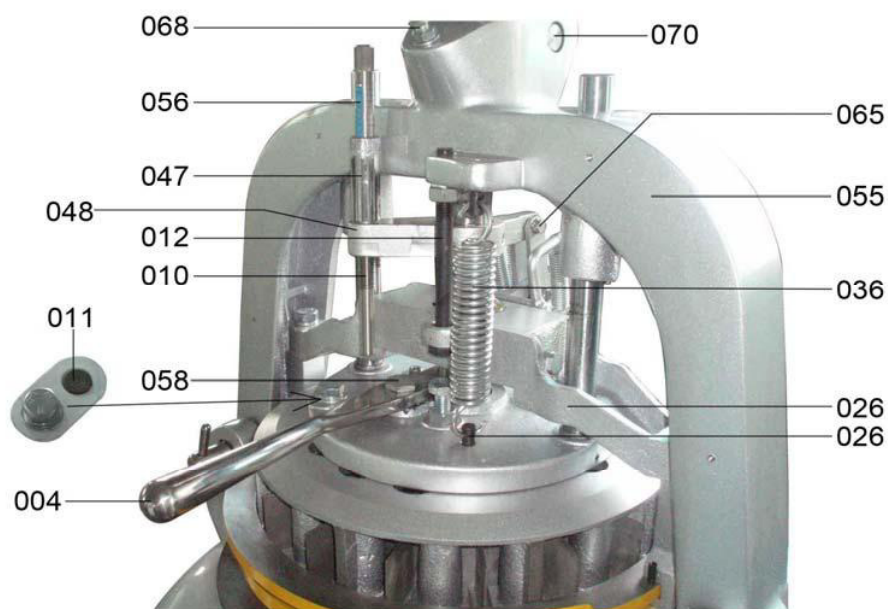
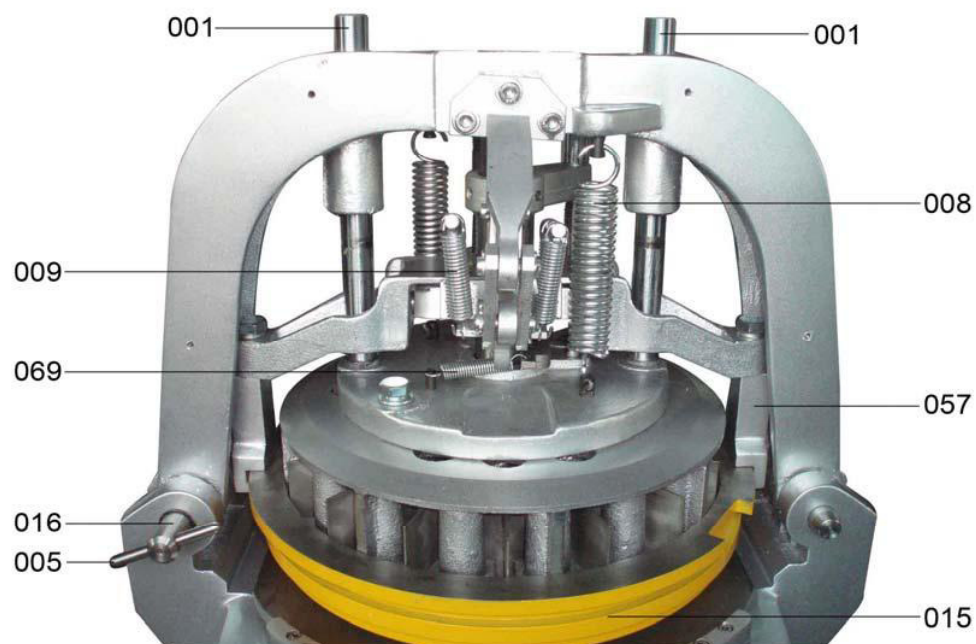
Maintenance

It is recommended that this machine should be lubricated and serviced by an authorised service person every three months.

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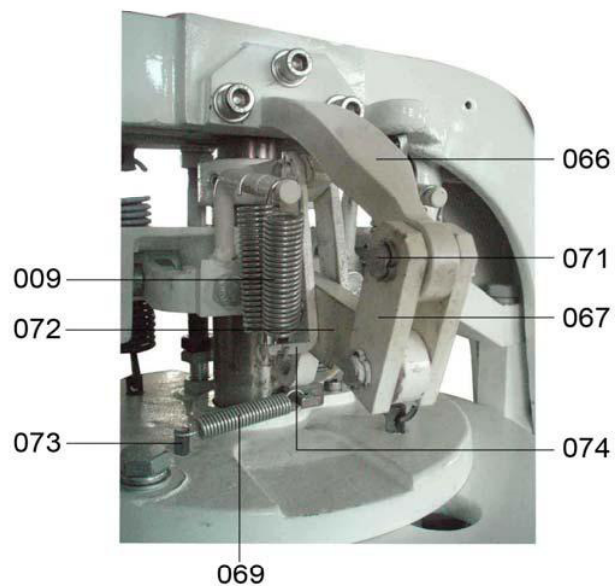
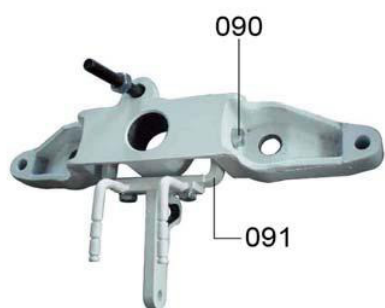
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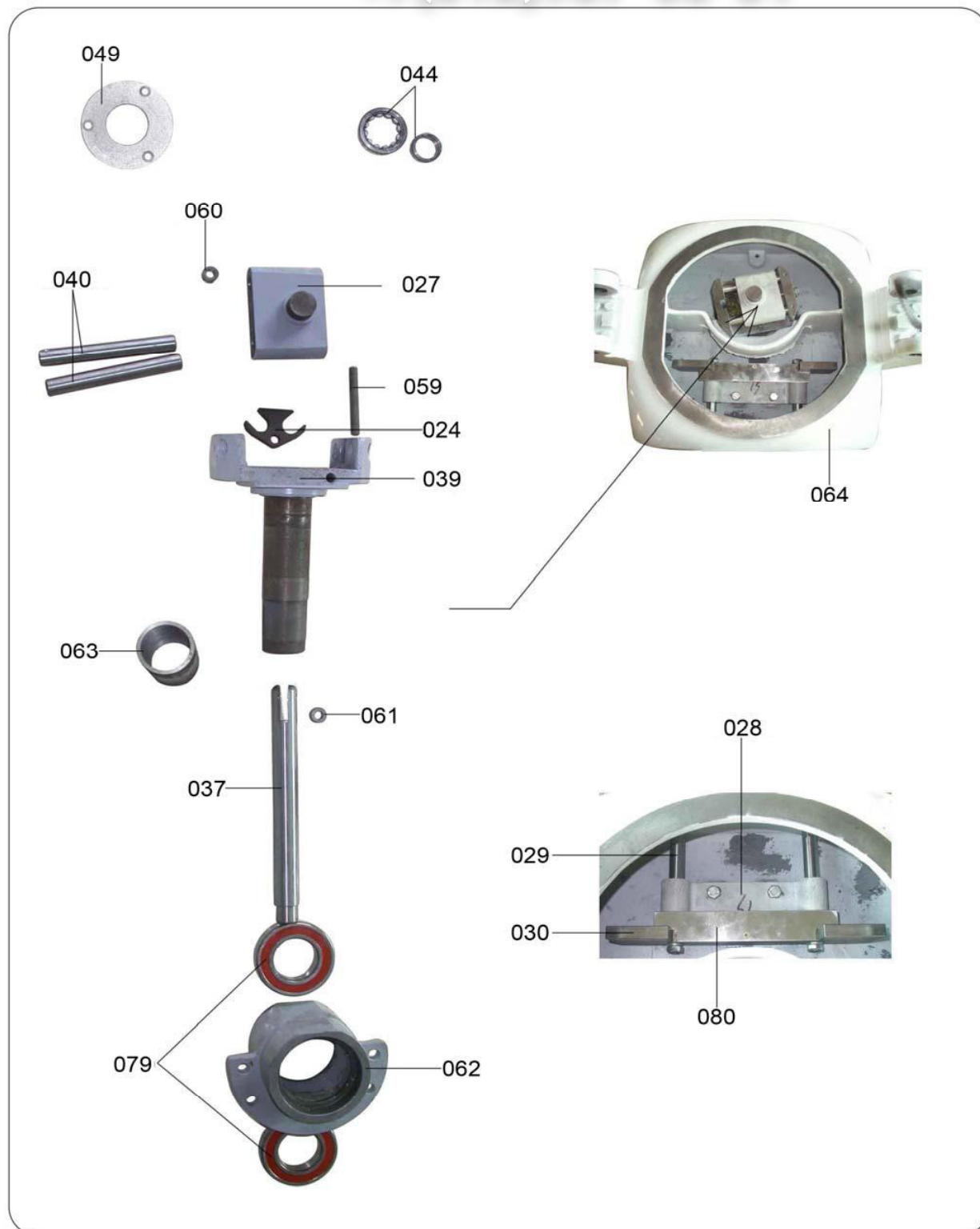
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Parts Number	Machine Model	Parts Code	Parts Name	Specification
001	SM330/430/1136	14D180-01	Fixed Mandrel	2PCS
	SM936	14D180-02		
002	SM330/430	14D129-01	Main Shaft	
	SM936	14D129-02		
	SM1136	14D129-03		
003	SM330/430	13D124-01	Cover Board Of Knife Seat	
	SM936	13D124-02		
	SM1136	13D124-03-Z1		
004	SM330/430/936/1136	13D110-01	Handle	
005	SM330/430/936/1136	11D136-01A	Pin of Handle	
006	SM330	13D125-01	Knife Seat	
	SM530	13D125-04		
	SM936	13D125-02		
	SM1136	13D125-03-Z1		
007	SM330/430	14D182-01	Cross Frame	
	SM936	14D182-02		
	SM1136	14D182-03		
008	SM330/1136	14D133-01	Tension Spring	1PCS
	SM430/936	14D133-02		
009	SM330/430/936/1136	14D106-02	Tension Spring	4PCS
010	SM330/430/1136	14D132-02	Screw With Scale	
	SM936	14D132-03		
011	SM330/430/936/1136	14D123-01	Plastic Orb	
012	SM330/430/1136	14D116-01	Adjusting Screw	
	SM936	14D116-02		
013	SM330/430/936/1136	14D130-01	Press-holder	
014	SM330/430/936/1136	13D128-01	Segment Gear	
015	SM330	14D107-01	Dough Frame	
	SM430	14D107-03		
	SM936/1136	14D107-02		
016	SM330/430/936/1136	11D136-01B	Handle Of Holder	
017	SM330	14D166-01R	Red Plastic Plate	RED (ABS)
	SM430	14D166-05R		
	SM936	14D166-02R		
	Sm1136	14D166-03W-Z1		
018	SM330/430/936/1136	15HQL38*1/2*12	Black Plastic Ball	φ38*1/2*12
019	SM330/430/936/1136	14D151-01	Control Staff	
020	SM330/430/936/1136	14D150-01	Mandrel Of Control Staff	
021	SM330/430/936/1136	14D191-01	Fixed Bolt	
022	SM330/430/936/1136	16DPL330	Lamp	
023	SM330/430/936/1136	16KGLHE-PKZO-G	Switch Box	
024	SM330/430/936/1136	14D137-01	Pisciform Block	

PARTS LIST

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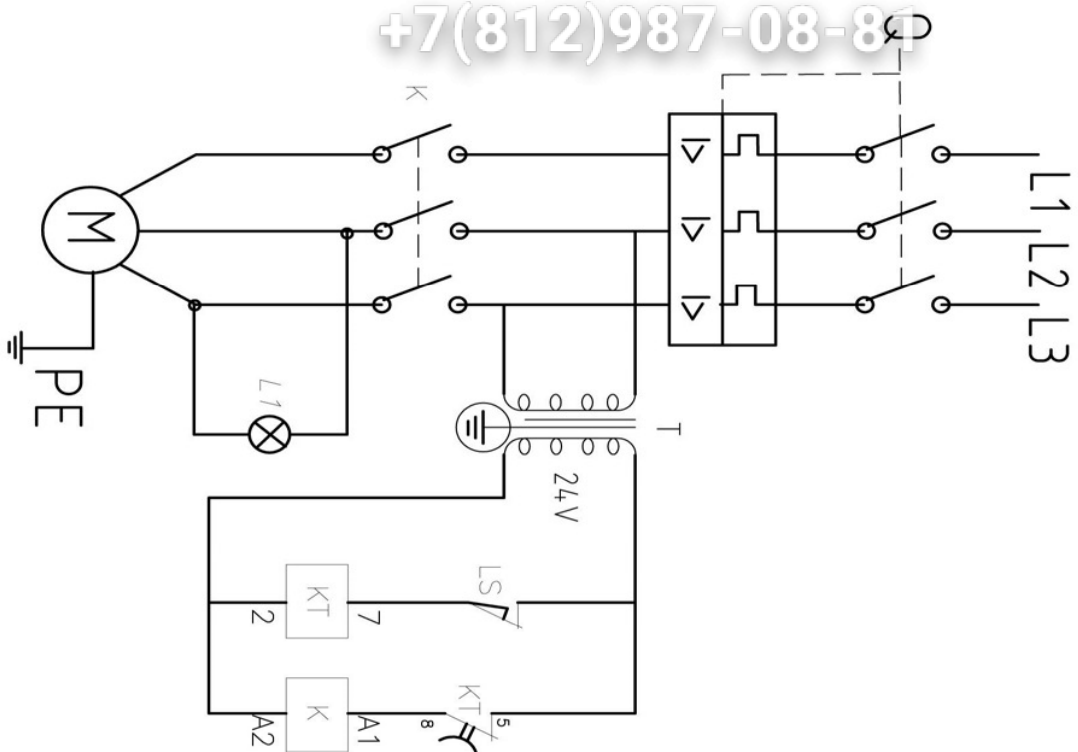
025	SM330/430/936/1136	14D175-01	Screw for Spring	5PCS
026	SM330/430/1136	13D105-01	Bridge Fixed Seat	
	SM936	13D105-02		
027	SM330/430/936/1136	13D184-01	Rotary Seat	
028	SM330/430/936/1136	13D149-02	Sliding Shaft Seat	
029	SM330/430/936/1136	14D153-01	Mandrel Of Sliding Piece	
030	SM330/430/936/1136	14D148-02	Sliding Piece	
031	SM330//936	14D146-02	Motor Pulley	FOR 50HZ
	SM430/1136	14D146-01		
032	SM330/430/936/1136	15PDL3V-375	Belt	3PCS
033	SM330/430/936/1136	14D145-01	Pulley	
034	SM330/430/936/1136	16MDL330-3PH-KDY	Motor	230/400V-50/60HZ-3PH
035	SM330/430/936/1136	14D155-02A	Pendulum Frame	
036	SM330/936/1136	14D133-02	Tension Spring	
	SM430	14D133-03		
037	SM330/430/936/1136	14D160-01	Shaft	
038	SM330/430/936/1136	14D158-01	Lever Seat	
039	SM330/430/936/1136	13D140-01	Seat	
040	SM330/430/936/1136	14D183-01	Guide Mandrel	
041	SM330/430/936/1136	14D157-01	Double Active Seat For Lever	2PCS
042	SM330/430/936/1136	14D152-01	Sleeve	
043	SM330/430/936/1136	16KGLPKZM0-4	Switch	3PH
044	SM330/430/936/1136	15ZCLNU206	Bearing	
045	SM330/430/936/1136	16DZL330	Lamp Seat	
046	SM330/430/936/1136	14D113-01	Counterweight	
047	SM330/430/936/1136	14D173-01	Screw Rod	
048	SM330/430/936/1136	13D101-01	Holder	
049	SM330/430/936/1136	14D190-01	Bearing Cover	
050	SM330/430/936/1136	16DZL01	Lamp Cover	
051	SM330/430	14D186-01H	Plastic Pad	
	SM936/1136	14D186-01J		
052	SM330	14D174-01	Knives	
	SM430	14D174-04		
	SM936	14D174-02		
	SM1136	14D174-03		
053	SM330/430/1136	13D142-01A	Rounding Plate	
	SM936	13D142-02A		
054	SM330/430/936/1136	14D167-01	Moulding Plate Index Pin	
055	SM330/430	13D127-01	Arch Seat	
	SM/936/1136	13D127-02		
056	SM330/936/1136	14D206-01	Scale Screw Plate	
	SM430	14D206-03		

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057	SM330/430	13D181-01	Fixed Hanger	
	SM936/1136	13D181-02		
058	SM330/430/936/1136	14D177-01	Baffle Fixed Screw	
059	SM330/430/936/1136	14D117-01	Rolling Mandrel	
060	SM330/430/936/1136	14D310-02	Bush	Thick
061	SM330/430/936/1136	14D310-03	Bush	Small
062	SM330/430/936/1136	14D185-01	Sliding Axle Housing	
063	SM330/430/936/1136	14D310-04	Bearing Housing Sleeve	
064	SM330/430	11SM330-00	Machine Body	
	SM936	11SM936-00		
	SM1136	11SM1136-01		
065	SM330/430/936/1136	14D103-01	Mandrel	
066	SM330/430/936/1136	14D114-01	Hanger Seat	
067	SM330/430/1136	14D119-01	Linker	SS41 8t*25*71
	SM936	14D119-02		
068	SM330/430/936/1136	14D170-01	Adjusting Screw	
069	SM330/430/936/1136	14D111-01	Tension Spring	1PCS
070	SM330/430/1136	14D131-01	Shaft	
	SM936	14D131-02		
071	SM330/430/936/1136	14D120-01	Link Stick	
072	SM330/430/936/1136	14D104-02	Support Seat	
073	SM330/430/936/1136	14D134-01	Screw Buckle	
074	SM330/430/936/1136	14D102-01	Spring Block	
075	SM330/430/936/1136	14D147-01	Screw	
076	SM330/430/936/1136	14D194-01	Adjusting Screw Rod	
077	SM330/430/936/1136	11D192-01	Motor Limited Board	
078	SM330/430/936/1136	14D159-01	Lever Mandrel	
079	SM330/430/936/1136	15ZCL6210VV	Bearing	2PCS
080	SM330/430/936/1136	12D205-02	Plate	
081	SM330/430/936/1136	14D196-01	Pin	
082	SM330/430/936/1136	14D187-01	Bolt For Tension Spring	
083	SM330/430/936/1136	11D189-01	Support Board	
084	SM330/430/936/1136	13D109-01	Protect Cover	
085	SM330/430/936/1136	13D109-02	Protect Cover	
086	SM330/430/936/1136	12D203-01	Machine Side Cover	SPCC 2.0T*290*430
087	SM330/430/936/1136	12D204-01	Side Cover Board	SPCC 2*290*430
088	SM330/430/936/1136	12D202-01	Frame Sheath	
089	SM330/430/1136	14D142-01B	Adjusting Block	
	SM936	14D142-02B		
090	SM330/430/936/1136	14D126-01	Screw	
091	SM330/430/936/1136	14D122-01	U-form Block	
092	SM330/430/936/1136	15ZCL5205VV	Bearing	1PCS



Q: Main Switch (ON/OFF)
M: Motor (1HP 3PH 4P)
SL1: Indiction Lamp

