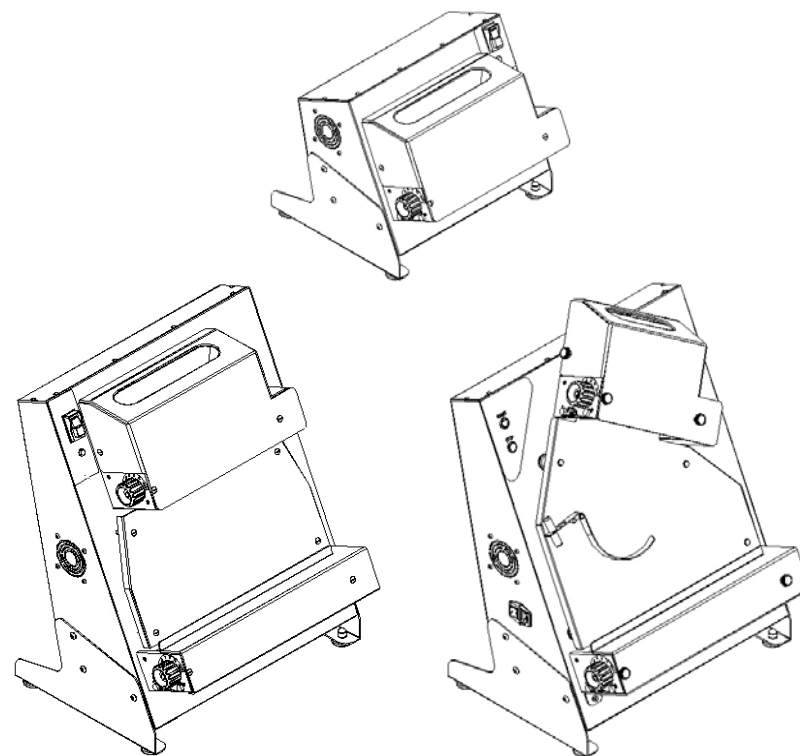


**SERVICE CENTRE  
AUTHORISED RETAILER**

## **USER AND MAINTENANCE MANUAL**



Ed. 02/2020

**Rolling machine**  
320/1 - 320/2  
420/2 - 420/2 RP

## **INTRODUCTION**

- This manual provides the client with information about the machine and applicable regulations, as well as the user and maintenance instructions required to use the machine properly and keep it in good working order.
- The manual must be made available to all users and maintenance technicians.

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## **CHAP. 8 - DISMANTLING AND DISPOSAL**

### **8.1 - Decommissioning**

If you decide to put the product out of service for any reason, make sure that it cannot be used by other persons: **disconnect and cut the electrical connections.**

### **8.2 - Disposal**

Once the machine has been decommissioned, it can be disposed of. This should be done by a waste management company, and its materials sorted for disposal.

### **8.3 - WEEE (Waste Electrical and Electronic Equipment) regulations**



***Pursuant to Art. 13 of Italian Legislative Decree n. 151 of 25 July 2005 "Implementation of Directives 2002/95/EC, 2002/96/EC and 2003/108/EC relating to the reduced use of hazardous substances in electrical and electronic devices, and to waste disposal".***

*The rubbish bin symbol on the machine or on its package indicates that the product must be disposed separately from other waste, at the end of its useful life.*

*The recycling waste collection of this machine is organised and managed by the manufacturer. If the user wishes to dispose of this machine, they must contact the manufacturer and follow the given procedure to make sure the recycling waste collection procedure is followed at the end of the machine's useful life.*

*The correct disposal of the machine for subsequent recycling, management and treatment of its parts in an environmentally-friendly way contributes towards avoiding any possible adverse effects on the environment and promotes the reuse and/or recycling of the machine materials.*

*Unlawful disposal of the product by the user will lead to the application of administrative penalties under current law.*

Extract the rollers and their couplings, then clean them carefully with a sponge with neutral foodsafe detergent and hand warm water.  
Rinse them off and dry them with paper towel. Now lubricate the shafts and the holes in the rollers with paraffin oil.

Restore and secure all parts in reverse order with respect to removal.

## **CHAP. 7 - MAINTENANCE**

### **7.1 - General information**

**CAUTION!** Before you service the machine, **disconnect its power plug from the mains to isolate it completely from the rest of the system.**

### **7.2 - Power cable**

Check the condition of the cable regularly and call the SERVICE CENTRE if it needs replacing.

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7.1 - General information

7.2 - Power cable

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8.1 - Decommissioning

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8.3 - WEEE (Waste Electrical and Electronic Equipment) regulations

## CHAP. 1 - INFORMATION ABOUT THE MACHINE

### 1.1 - General precautions

- The rolling machine may be used only by trained staff familiar with the safety information given in this manual.
- New staff must be trained in the use of the machine before using it.
- Do not use the rolling machine for any other purpose than rolling out soft pizza dough.
- **Before you clean or service the machine, disconnect it from its power supply.**
- The residual risks must be assessed when servicing or cleaning the machine with the guards removed.
- When servicing or cleaning the machine, concentrate on the job in hand.
- Periodically check the condition of the power cable; damaged or worn power cables pose a serious electrical hazard.
- If the machine is malfunctioning, do not use it; contact the Service Centre immediately.
- Do not attempt to make repairs yourself; always contact an authorised service centre.
- Never tamper with the machine in any way. Contact the manufacturer if you encounter any anomalies.
- Attempting to disassemble, modify or tamper with any part of the machine by the user or unauthorised personnel immediately voids its certification pursuant to Low Voltage Directive EEC 2006/42, voids the warranty and relieves the manufacturer of any liability for the consequences of such action.
- The manufacturer is also relieved of all liability for the consequences of:
  - ⇒ improper use or tampering with the machine by inadequately trained personnel;
  - ⇒ lack of or negligent maintenance;
  - ⇒ use of **non-original** spare parts which are not specified for the model;
  - ⇒ total or partial failure to follow the instructions given in this manual;
  - ⇒ use of unsuitable products to treat the machine's surfaces.

### 1.2 - Safety equipment

The mechanical and electrical safety equipment is conforming with Directives **UL 763** and **CSA 22.2**.

The rolling machine is equipped with an NVR device which prevents it from starting up automatically after a power failure. It is equipped with fixed roller

## CHAP. 6 - CLEANING THE MACHINE

**CAUTION!** Before cleaning the machine, pull its plug out of the power socket to isolate the machine completely from the rest of the system.

### 6.1 - General information

The machine must be cleaned with neutral detergents at room temperature, using a soft damp cloth.

The machine must be cleaned carefully in all its parts, especially those that come into contact with food.

- Do not use a jet of water or a pressure cleaner to clean the machine.
- Do not use tools, scrubbing brushes or anything that may damage the machine's surfaces.
- Do not wash the machine or any of its parts in a dishwasher.
- Never use non-foodsafe, abrasive or corrosive chemical products when cleaning the machine.

**Clean the machine after every use, as required by hygiene regulations in order to keep the machine in good working order.**

Use a brush to remove most of the dough and flour residues. Take the two guards and slides off, release the springs, extract the scrapers and turn the adjuster knob so that the rollers are fully open. Carefully clean the machine and all its parts, including those you have disassembled, using a sponge or cloth with water and detergent.

Now rinse off all traces of detergent.

Dry the machine and its parts with foodsafe paper towel, then wipe over all parts that come into contact with food and the machine as a whole with a clean cloth soaked with food processing machinery disinfectant.

**CAUTION!** The PLUS version has an AISI 430 ceramic coated slide which is held in place with magnets so that it is easy to remove for cleaning; it is easier to remove the scrapers once the slide has been taken off. The hand guards are equipped with handles for easy removal.

### 6.2 - Maintenance

Before you use the machine, always check that it is perfectly clean in all its parts, especially those that come in contact with dough. Clean it as described above, if necessary.

### 6.3 - Lubricating the shafts and rollers

The shafts and rollers must be lubricated once a year.

Remove the plexiglass guards, slides, springs and scrapers, then undo the screws holding the back panel and mounts in place.

the adjuster knob to set the gap between the top rollers (*Fig. 13*). The top rollers flatten the dough into an oval shape; the dough now slides into the rocker and rotates sideways at 90° so that it is ready to pass through the bottom rollers that were previously adjusted to the desired gap (*Fig. 2-3 letter B*); the disk which comes out of these rollers has a good shape, but must be finished by hand for better results.

The 42 RP version **does not have the rocker** (*ref. 5 - Fig. 3*); when using this machine, the dough must be moved by hand from the top rollers to the bottom rollers by rotating it at 90° and feeding it through the second set of rollers.

### **5.5 - Using the pedal control (PLUS version only)**

The pedal control is supplied on request as an accessory for the Plus version. This function must not be confused with the OFF control (*Fig. 16 and 17*); it is designed solely to limit power consumption to when it is needed. Hook the control pedal up by inserting the cable into the socket on the side of the machine (*ref. 7 - Fig. 3*).

### **CAUTION!**

**The machine works properly even without the use of the pedal control.**

guards which, in the PLUS version, can be removed and are fitted with interlock switches which stop the machine when the hand guards are removed.

There are nevertheless “**RESIDUAL RISKS**” which cannot be completely eliminated, which are highlighted in this manual by the wording “**CAUTION**”; they are related to the risks of electric shock and crushing when loading and handling the product, as well as when cleaning the machine or using it improperly.

## **1.3 - Description**

### **1.3.1 - General description**

The rolling machine is designed and fabricated specifically to guarantee that:

- all its parts are stable and robustly constructed;
- it is perfectly hygienic, thanks to the careful choice of materials in contact with food products;
- maximum safety during use, cleaning and maintenance operations;
- its operating temperature is in a range from 15 °C to 45 °C.

### **1.3.2 - Construction**

The rolling machine is made of AISI stainless steel throughout; this ensures that it is hygienic, unaffected by acid and salt, and very resistant to rusting. The pair of PE 300 foodsafe rollers are driven by a worm screw gearmotor. The PLUS version has an enamelled AISI 430 stainless steel slide, which is easy to remove when cleaning the machine.

A **start/stop** pedal can also be fitted to it through the provided socket. (PLUS version - optional equipment).

## 1.4 - Structure of the machine

### Model 32/1

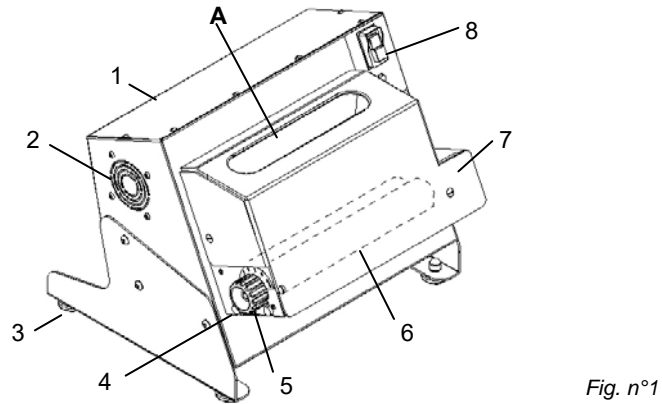


Fig. n°1

#### LEGEND

1	Frame	5	Adjuster knob
2	Cooling fan	6	Rollers
3	Foot	7	Roller housing
4	Scrapers	8	Controls/power led

### Model 42 RP

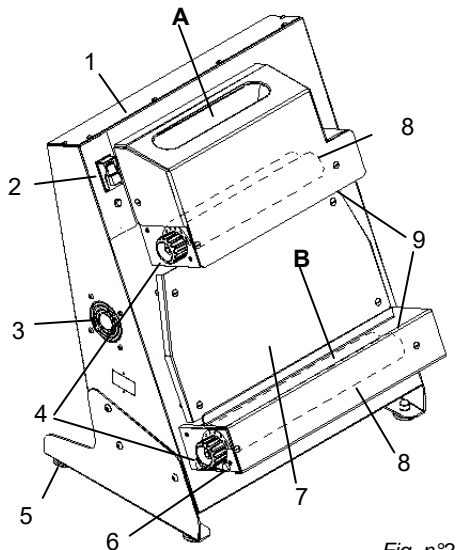


Fig. n°2

#### LEGEND

1	Frame
2	Controls/power led
3	Cooling fan
4	Adjuster knob
5	Foot
6	Scrapers
7	Slide
8	Rollers
9	Roller housing

## 5.2 - Standard version controls

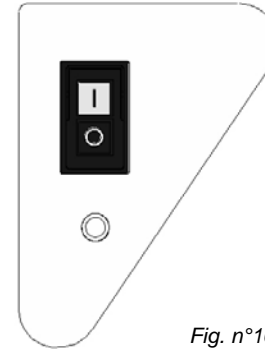




Fig. n°16

 **START** button: starts the cycle.

 **OFF** button: stops the cycle.

When the machine is running, the led under the controls turns on.

## 5.3 - Plus version controls

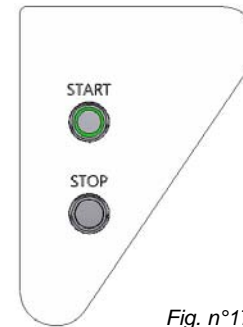




Fig. n°17

 **START** button: starts the cycle. When the machine is running, the green led turns on.

 **OFF** button: stops the cycle.

**Start the machine without dough to check that it is working properly.**

#### **CAUTION!**

**The rollers must rotate downwards when viewed from the front.**

The machine has been designed for food processing, to roll out flour products with a high water temperature (soft dough) without affecting the characteristics of the product.

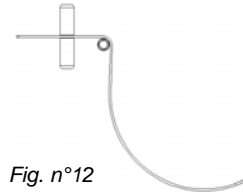
## 5.4 - Start up

Press the START button; the rollers start to rotate and the machine is ready to use.

Before you insert the ball of dough into the opening (the dough must be lightly dusted with flour and risen for at least 6-8 hours), squash the front edge of the ball into a wedge to help it run into the top rollers (Fig. 1-2-3 letter A). Use

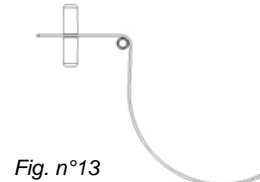
**Maximum sensitivity:**

- place the counterweight inside the slot;
- recommended for low weights (*Fig. 12*).



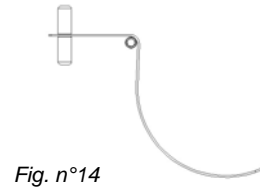
**Moderate sensitivity:**

- place the counterweight at the centre of the slot;
- recommended for medium weights (*Fig. 13*).



**Minimum sensitivity:**

- place the counterweight outside the slot;
- recommended for heavy weights (*Fig. 14*).

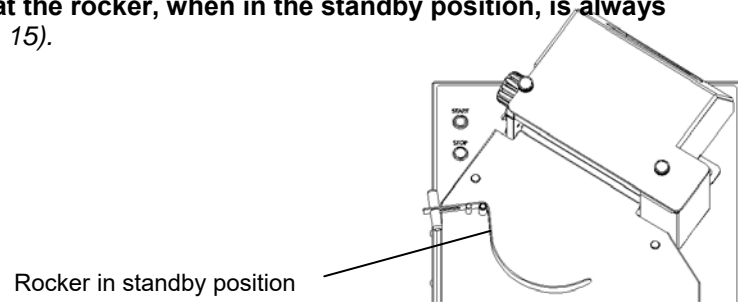


Once the adjustment is made, lock the counterweight in position with the lock screw.

In order to shape the disk properly, the sensitivity of the rocker must be set to suit the weight of the dough, so that the dough is perfectly horizontal before it passes through the bottom rollers.

**CAUTION!**

**Make sure that the rocker, when in the standby position, is always upwards (*Fig. 15*).**



**Model 32/2 - 42/2 PLUS**

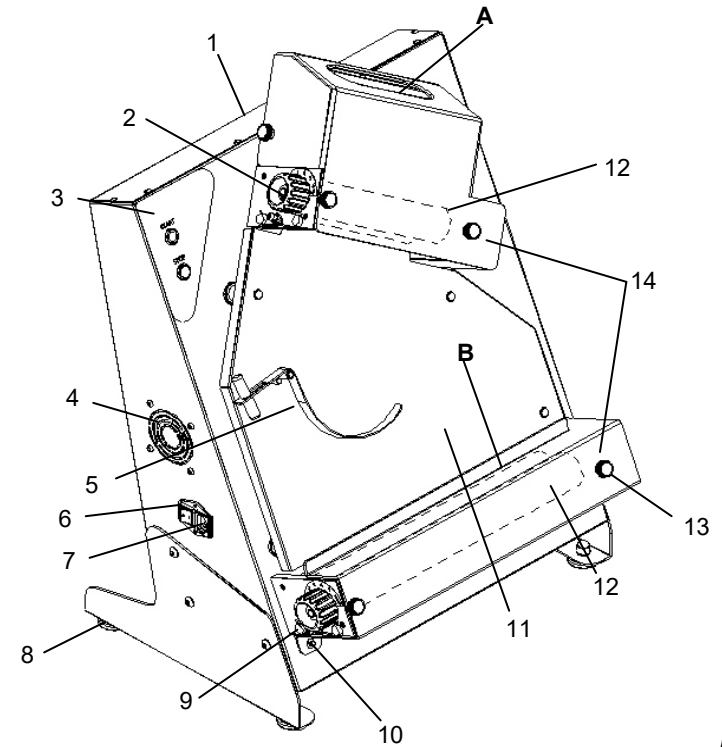


Fig. n°3

**LEGEND**

1	Frame	8	Foot
2	Adjuster knob	9	Scrapers
3	Controls	10	Interlock switch
4	Cooling fan	11	Slide
5	Rocker	12	Rollers
6	Pedal control	13	Housing lock knob
7	Pedal control socket	14	Roller housing

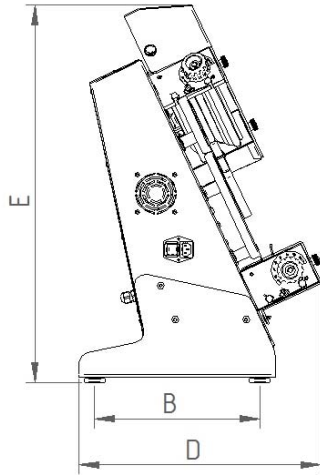
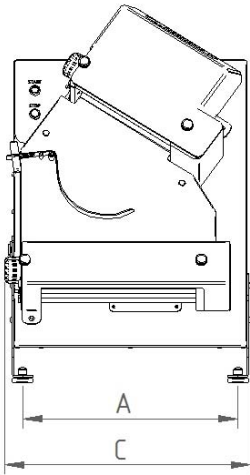
**A= Dough infeed top rollers**

**B= Dough infeed bottom rollers**

## CHAP. 2 - TECHNICAL DATA

### 2.1 - Overall dimensions, weight, specifications

Fig. 4 and 5 - Dimensions and clearances.



Model	320/1	320/2	420/2	420/2 RP
Power supply	250 watt/0,33 Hp			
Power supply	120 V-1Ph-60Hz F+N			
Motor speed	1400 r.p.m			
Roller speed	96 r.p.m			
A	mm 411	mm 411	mm 511	mm 511
B	mm 315	mm 315	mm 315	mm 315
C	mm 470	mm 470	mm 570	mm 570
D	mm 463	mm 463	mm 463	mm 463
E	mm 390	mm 720	mm 800	mm 700
Weight of dough	gr 80-210	gr 80-210	gr 210-700	gr 210-700
Pizza diameter	cm 14-29	cm 14-29	cm 26-40	cm 26-40
Noise level	db ≤ 70			
Net weight	Kg 29	Kg 40,5	Kg 47,5	Kg 48,5
Packaging dimension	750x400x510	750x580x1005		
Gross weight	Kg 32	Kg 52,5	Kg 59,5	Kg 60,5

## CHAP. 5 - USE

### 5.1 - Adjustments

#### **CAUTION!**

All adjustments (adjuster knob and rocker) must be done with the machine shut off.

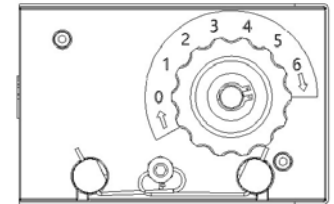
The following adjustments are for illustrative purposes only, since many different variables must be taken into account: the characteristics of the dough, its weight, thickness and form.

#### 5.1.1 - Setting the thickness of the dough

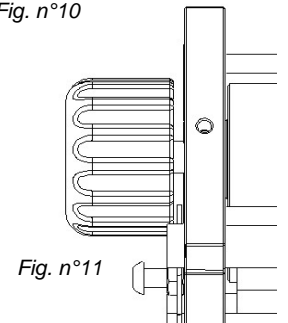
This adjustment is done with the plastic knob, by setting the gap between the rollers; once the adjustment is made, the knob can be locked with a pawl. For better results, we recommend adjusting the top and bottom rollers separately.

The thickness is set by rotating the knob (Fig. 10):

- **Minimum thickness** (0) turn counterclockwise.
- **Maximum thickness** (6) turn clockwise.



To make the adjustment, pull the knob out towards you (Fig. 11); this engages the spring, allowing you to make the adjustment.



#### **CAUTION!**

Only run the dough through the rollers once, otherwise it may break up and become sticky.

#### 5.1.2 - Setting the rocker

This varies the rotational speed of the dough. Undo the lock screw to change the position of the counterweight and hence the sensitivity by adjusting the position in the rocker's slot.





**CAUTION!**

The machine's electrical specifications are marked on its nameplate, mounted to the rear of the machine itself; before hooking the machine up electrically, refer to the section “**Electrical hookup.**”

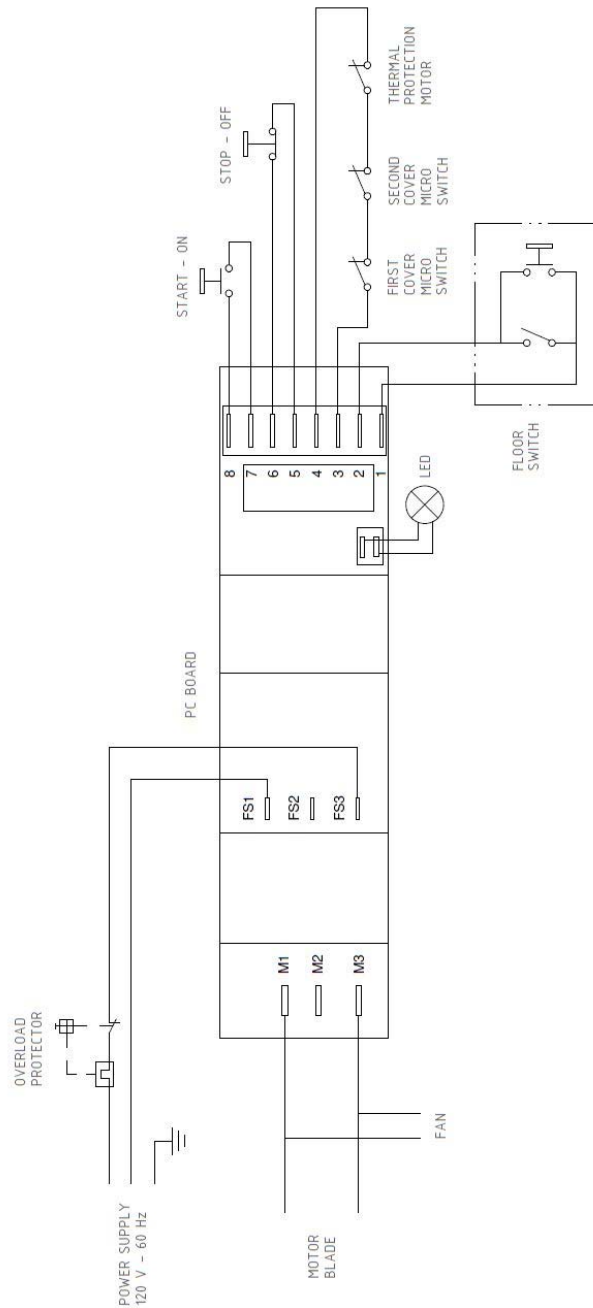


Fig. n°9

**CHAP. 3 - DELIVERY**

**3.1 - Shipping** (see Fig. 6)

The machines are carefully packed before shipping. The packaging is made of:  
 wood pallet;  
 robust cardboard external box with lateral supports, if needed;  
 the machine;  
 this manual.

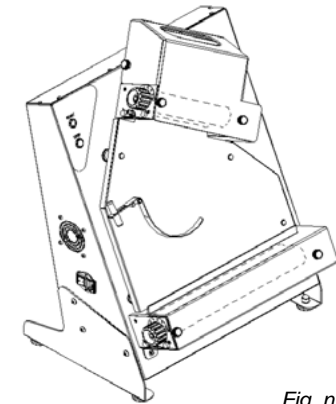
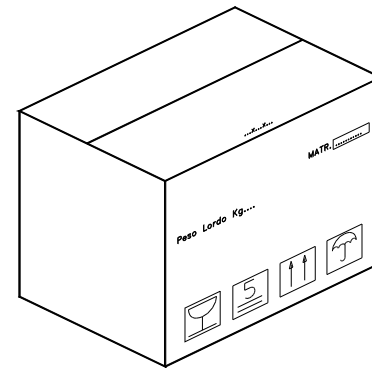


Fig. n°6



**3.2 - Checks on delivery**

When you receive the package containing the machine, carefully check the packaging for signs of damage during shipping. If the packaging shows signs of mishandling, impacts or dropping, report the damage to the shipping agent within three days of the date of delivery indicated on the documents and draw up a detailed report on any damage to the product.

### 3.3 - Disposing of packaging

The packaging materials (cardboard box, plastic strap and polyurethane foam) can be disposed of as normal domestic waste; there is no difficulty in disposing of them.

If the machine is installed in a country in which special regulations apply, dispose of the material in a regulatory manner.

## CHAP. 4 - INSTALLATION

### 4.1 - Positioning

Place the rolling machine on a solid table about 80 cm off the ground, with a smooth non-slip surface, keeping at least a 10 cm distance from walls or any other surfaces which may block its ventilation. Keep the machine away from sources of heat and humidity. Remove the protective film - do not use tools which may damage the machine's surfaces while doing so. Carefully remove all process waste from the machine before using it.

### 4.2 - Electrical hookup

The machine has a power cable with a cross section of 3x16AWG a length of 1.6 m and a NEMA 5-15P plug. Hook the machine up to the 120 Volt 60 Hz power supply with a differential circuit breaker rated 0.03A. Check that it is properly earthed.

Also check that the information on the machine's nameplate match the specifications given in the delivery and shipping documents, and that both the master switch and cable are easily accessible while the machine is in use (see Fig. 7).

Mod. _____
Matr. _____ Watt.
_____ H.p. _____ A. _____ Hz.
○ _____ ~ Volts. _____ Kg. ○
Anno _____

Fig. n°7

### 4.3 - Wiring diagrams

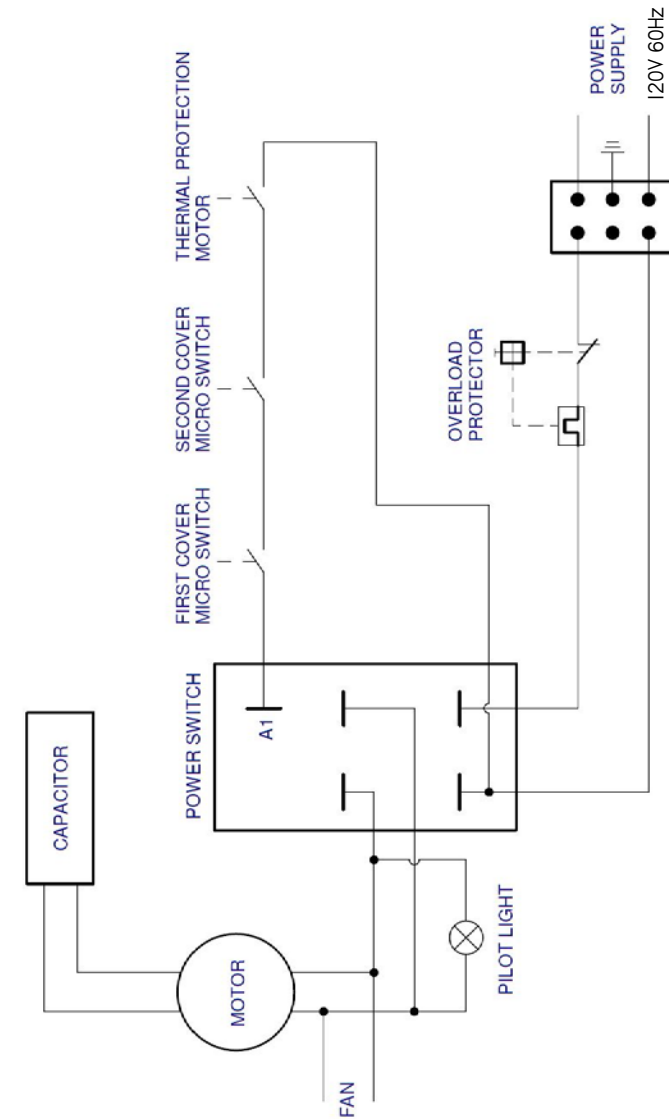


Fig. n°8