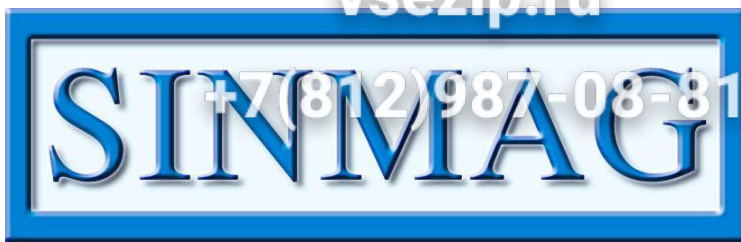


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## **INSTRUCTION MANUAL**

**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.*

|                          |                           |
|--------------------------|---------------------------|
| <b>Model:</b>            | <b>Serial Number:</b>     |
| <b>Manufacture Date:</b> | <b>Installation Date:</b> |

**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.

**Introduction.....(4)**

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**Set-up & Operation.....(7)**

**Cleaning & Maintenance.....(10)**

**Parts List.....(12)**

**Wiring Diagram.....(19)**

**Brief Introduction**

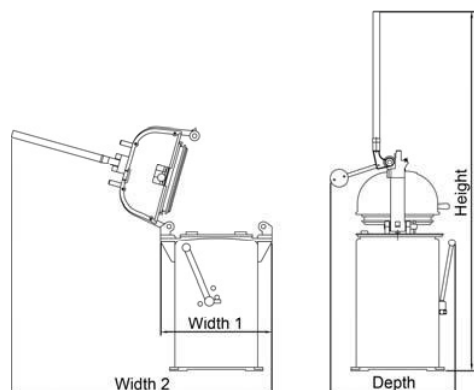
These machines are specially used for dough dividing and rounding, they can divide and round the dough for Bun evenly with very little difference in weight and structure. And with the semi-automatic system, it can save large labor working that only two persons are needed. The machine has proved to gently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

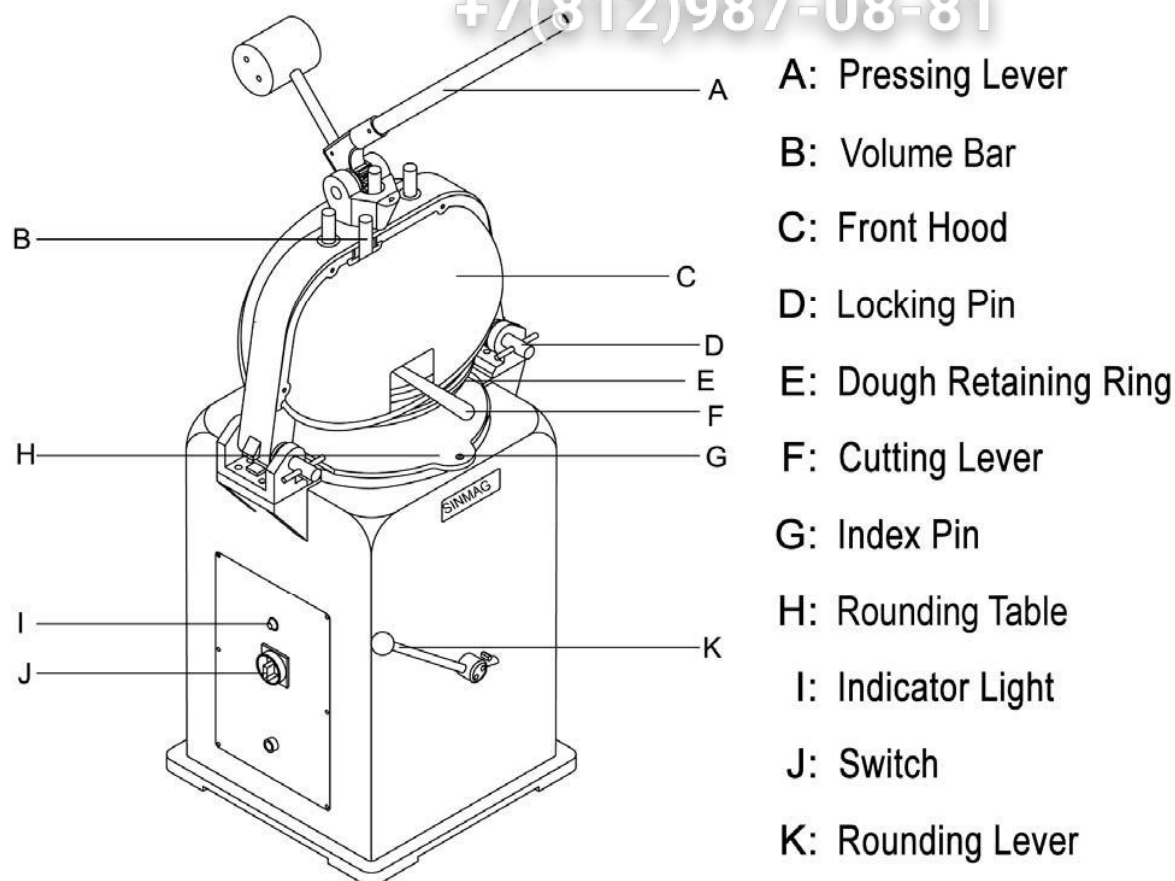
An air circuit breaker should be added to the main switch near the machine, and 1.5m high above the ground for the electric supply. The machine must be in ground protection.

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### **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.

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**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.

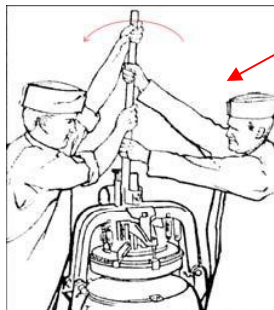
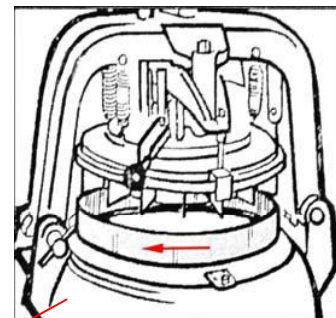
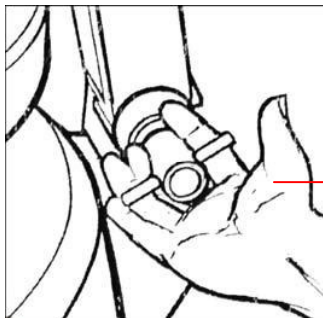
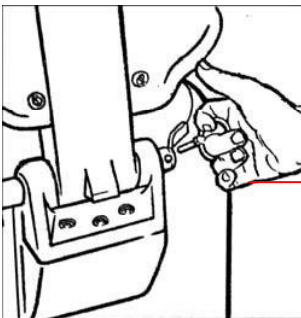
WARNING



ENSURE THAT DIVER BOUNDER 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.

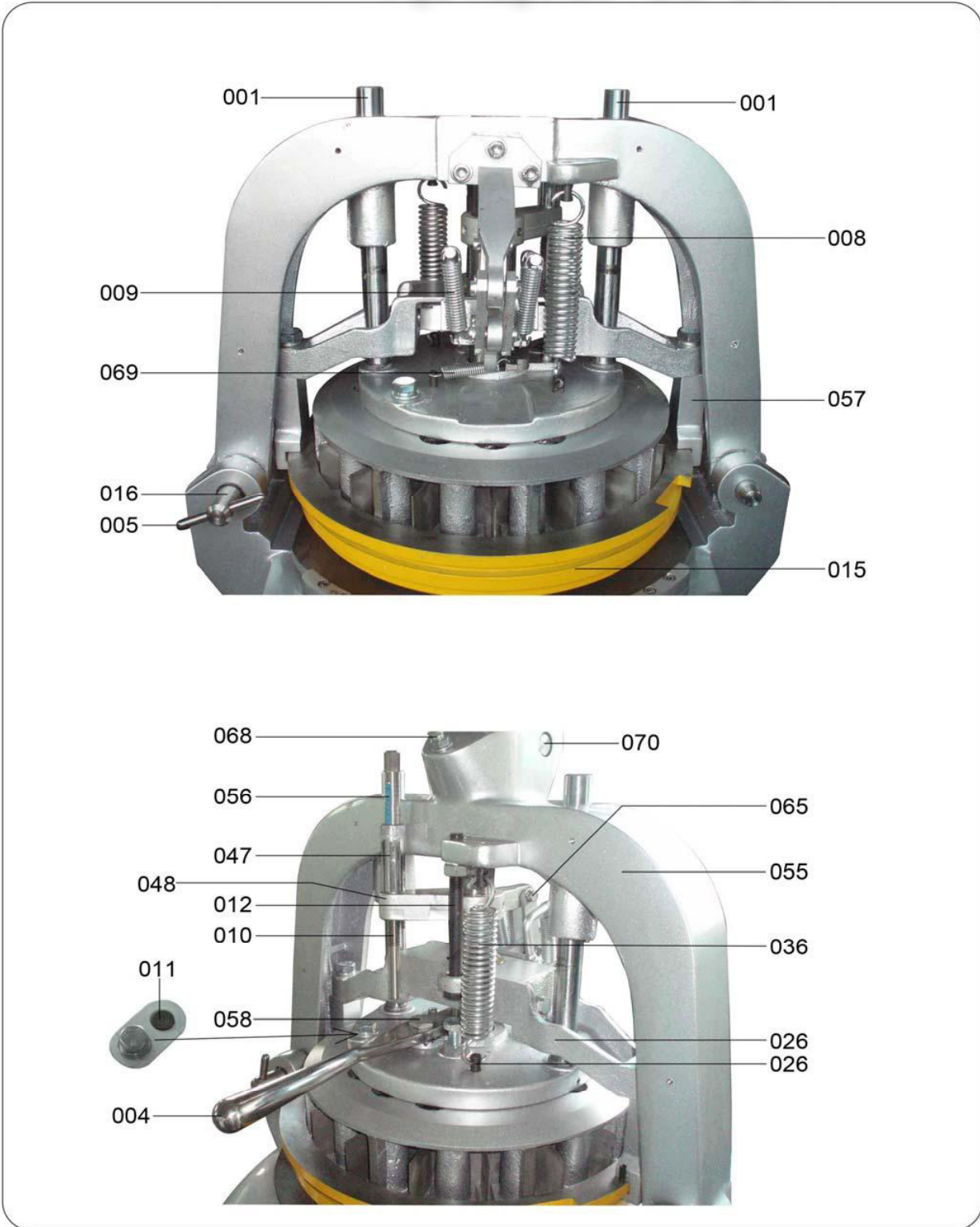
**SEMI-AUTOMATIC DIVIDER ROUNDER**

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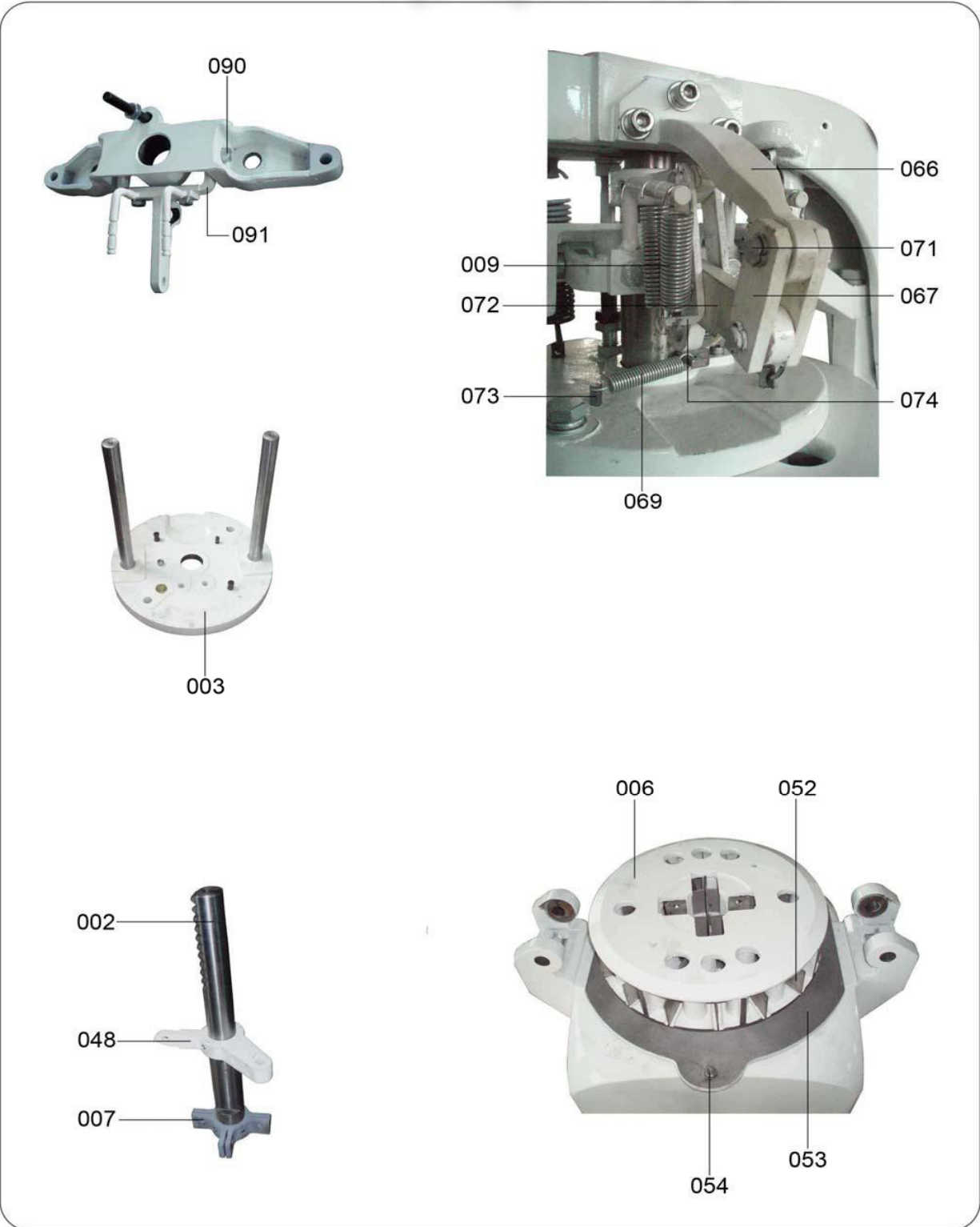
**SEMI-AUTOMATIC DIVIDER ROUNDER**

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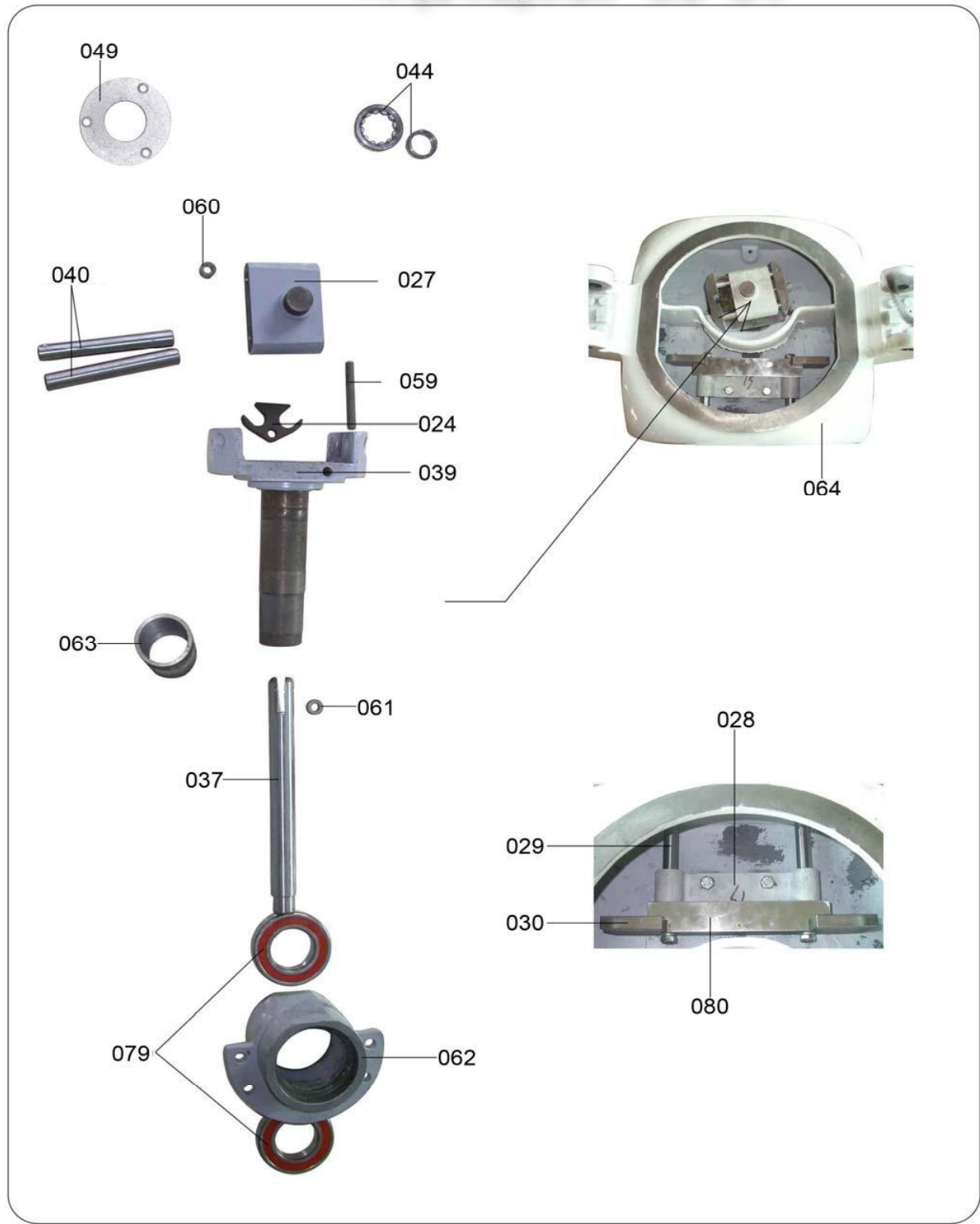
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## PARTS LIST

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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           |               |

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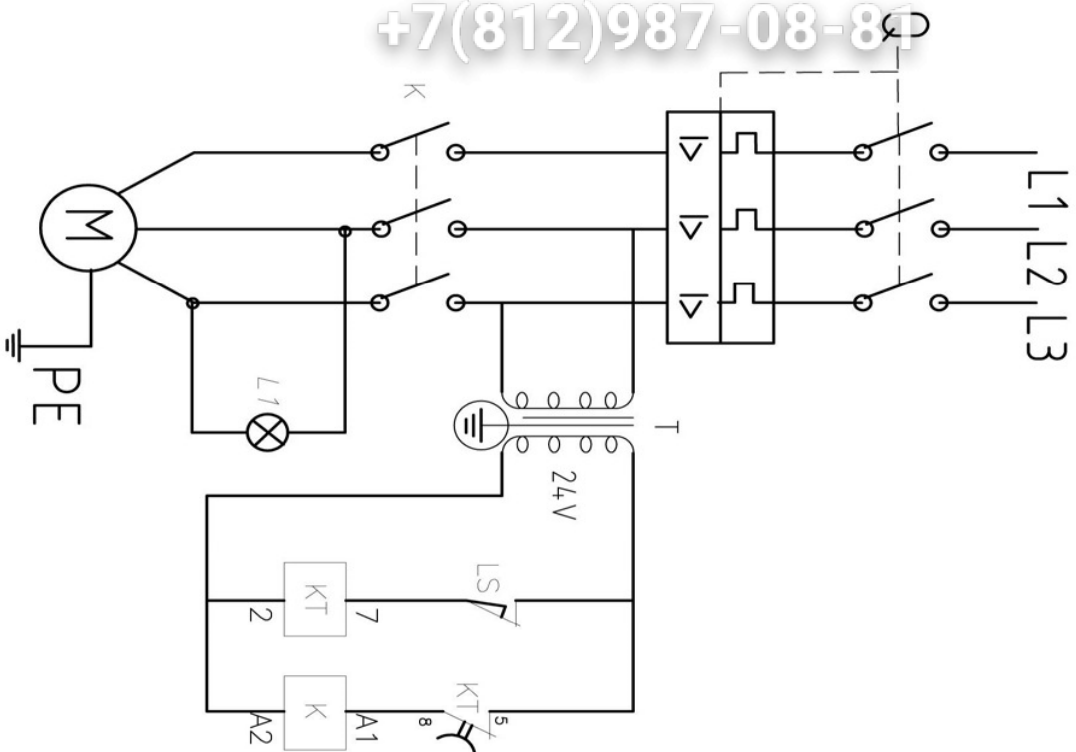
|     |                    |                  |                              |                      |
|-----|--------------------|------------------|------------------------------|----------------------|
| 025 | SM330/430/936/1136 | 14D175-01        | Screw for Spring             | 5PCS                 |
| 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<br>2.0T*290*430 |
| 087 | SM330/430/936/1136 | 12D204-01   | Side Cover Board        | SPCC<br>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 ЗРН 4P)  
 SL1: Indiction Lamp

