RONDO
Dough-how & more.

Operating manual

Econom 4000

STM5303
SSO5304

Edition BD404502
01.2014

Technical specifications subject to change without notice

www.rondo-online.com

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RONDO
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EC Declaration of conformity for machinery

(Machinery Directive 2006/42/EC, Annex II., sub. A)

Manufacturer: RONDO Burgdorf AG
Address: Heimiswilstrasse 42, 3400 Burgdorf, Switzerland

Name and address of the person authorised to compile the technical file:
RONDO Burgdorf AG, Heimiswilstrasse 42, 3400 Burgdorf, Switzerland

Herewith we declare that the dough processing machine:

Dough sheeter	Econom 4000
Table model	STM530x
„A" framed base model	SSO530x

- is in conformity with the relevant provisions of the Machinery Directive (2006/42/EC)
- is in conformity with the provisions of the following other EC-Directives:
  - Directive EMC 2004/108/EC.

And furthermore, we declare that

- the following (parts/clauses of) European harmonised standards have been used:
  - EN 1674: Food processing machines – Safety and Hygiene requirements
  - 1935/2004: Materials, intended to come into contact with food
  - EU 10/2011: Plastic materials and articles intended to come into contact with food
  - EN 60204-1: Safety of machinery – Electrical equipment – Part 1
  - EN 12100-1: Safety of machinery – General principles – Part 1

Burgdorf, 29.01.2016

Werner Mathis
Manager R&D

Hint for operating manual: The numbers of the illustrations (Ex. —— 1) are numbered chapterwise.

1 Safety information

1.1 Explanation of symbols

All the sections in this operating manual containing safety instructions which absolutely must be observed are marked with this symbol and with a number.

All the sections in this operating manual containing information which absolutely must be observed are marked with this symbol.

1.2 Explanation of warning signs

Sign indicating prohibited activity

Reaching under the closed safety guard is prohibited!

Instruction and information signs

Make sure to disconnect the plug before opening!

Danger warning sign

Danger warning

High-Voltage warning sign

Warning against electrical shock
Disconnect mains plug before opening.

1.3 Safety elements

1.3.1 Safety guards

Operation

The safety guards fulfill a dual purpose:

1. The safety guards protect the operator against inadvertent contact with the rollers.
2. The machine is stopped by lifting up the safety guard. Raising the safety guard even just slightly will cause the machine to discontinue operation.

- Lift the safety guard
  Machine stops
  (In order to restart the machine, see 4.2 Starting/stopping the machine)

1.4 Safety instructions and information which must be followed

Before putting the machine into operation the operating manual must be read!

The machine of RONDO is exclusively built for sheeting, booking and final sheeting of dough or marzipan sheets for the food industry.

However, the machine is not suitable for the processing of other products (e.g. modelling clay or other types of mouldable masses which are not dough products).

Any other use of these units is not in accordance with the purpose for which they are built. Therefore, the manufacturer will not be liable for any accidents or damage arising as a result of unauthorized use; the risk in any such instance will be borne solely by the user.

Authorized use also means that the user must follow all instructions prescribed by the manufacturer in respect of operation, maintenance and service.

Any work on the electrical components of the machine, in particular the correct professional electrical connection, may only be carried out by qualified personnel who are familiar with the prescribed safety instructions.

The maximum permitted fuse of the mains is specified in the enclosed electro circuit diagram or on the sign “Electrical connected loads”.

The machine may only be connected to the mains using the mains plug! No permanent electrical installation may be made using, for example, terminal screws. The mains plug is used as a disconnecting device, and must always be clearly visible and easily accessible.

Protective covers over the electrical controls and the mechanical moving parts may only be removed by professionally qualified personnel and must be remounted before the machine is put back into operation.

Any unauthorized changes made to the machine, and in particular, to the safety devices on the machine will automatically exclude any liability on the part of the manufacturer for accidents or damage sustained as a result of such changes.

Defective cables and mains plugs must be immediately replaced by qualified personnel.

The machine may only be connected to the mains using the plug once the machine has been fully assembled.

Before beginning any repairs, service or cleaning work on the machine, the electricity supply to the machine must be interrupted (pull out mains plug).

Safety devices on the machine may not be adjusted, shorted-out or expanded.

Operation of the machine when any of the safety devices is out of order is prohibited.

Defective safety devices must be replaced immediately with new original parts by RONDO.

Machine parts located in the area in which the dough is being processed, and whose surface coating becomes worn (e.g. chrome plate worn off) must be replaced.

The machine may not be lifted on the machine base (SSO5304), when being moved. The machine should be fastened and transported on a pallet without the table. The safety guard should be fastened in the upper position.

Reaching under the closed safety guard is prohibited!

The machine may only be operated with the machine tables mounted!

Observe the correct belt tension!

Do not deposit any loose objects such as knives, tools, articles of clothing, etc. in the area where the dough is located.

Table models (STM5303) must be placed so as to rest properly over the whole work table!

Check to ensure that there are no loose screws in the area where the dough is located.

The machine may not be operated without the use of a scraper.

Flour dust can cause respiratory tract difficulties and allergies. Limit the use of flour to a minimum.

Avoid draughts.

The use of a compressed air for cleaning the flour duster and the work surface is not permissible.

The use of a protective mask during the operations that generate dust, is recommended.

The use of a dust extraction system in the bakehouse is recommended.

Any disposal of the machine must be carried out in accordance with environmentally-accepted practices. The operators are fully responsible for ensuring that such practices are followed.

This machine is not designed to be used in explosive ambient.

Defective parts must be replaced with new original parts by RONDO.

After every use, the machine has to be cleaned thoroughly. Not thoroughly cleaned machines can be a health-hazard for the consumer.

The machine must never be cleaned using spray water, high-pressure cleaners or a steam-cleaning machine.

All still existing protective foils on the machine must be removed.

Prior to the first starting-up, the complete machine must be thoroughly cleaned.

Non-ionising radiation is not intentionally produced but only given off for technical reasons by electric equipment (e.g by electric motors). In addition the machine has no strong permanent magnets. By keeping a safe distance (the distance from the source field to the implant) of 30 cm, interference with active implants (e.g. pacemakers, defibrillators) can be excluded with a high degree of probability.

RONDO will not accept liability when any of the above safety instructions / notes have not been complied with!

2 Transporting, setting up, connecting, dismounting, storing

2.1 Machine delivery

The machine is delivered in its original packaging.

- Report any claims for damage caused as a result of transportation directly to the freight handlers (see the packaging: The delivery documentation is found here)

2.2 Transport

STM5303

When transporting the machine must be packed in the original packaging or in accordance with the instructions of the manufacturer to guarantee stability.

When being transported, the machine must be fastened onto a pallet.

The machine table (SSO5304) must be dismounted and the safety guards fastened in the upper position.

SSO5304

Machine may not be tipped over.
(For machine weight, see 9.1 Technical data)

2.3 Unpacking the machine

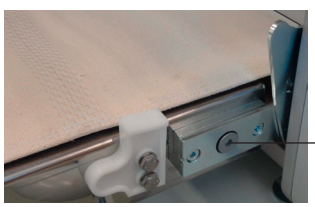
The machine must be set up on a level, even floor surface (SSO5304). For further information regarding the ambient conditions required for the machine, see 3.1 General information.

- Unpack tables and attachments
- Check all items received against the delivery slip to ensure completeness

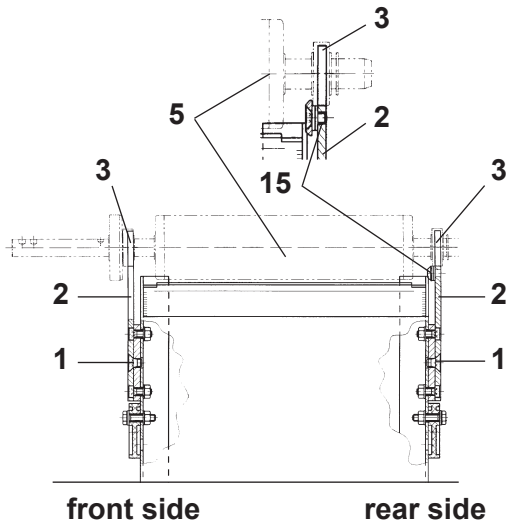
2.4 Setting up the machine

Two people are required to set up the machine!

2.4.1 Installation of the machine tables (SSO5304)



- Mount the lateral brackets (2), tighten the screws (1) using a hexagon wrench



- Place the lateral brackets (2) on the supports (3) of the roller drive (5)

Lateral bracket with lock nut (15) must absolutely be at the rear!

Lifting the machine tables

1. Bring the safety guard in the lower position.
2. Lift the machine table until the plastic material supports (16) (front and rear) lock on the safety guard.

Notice!

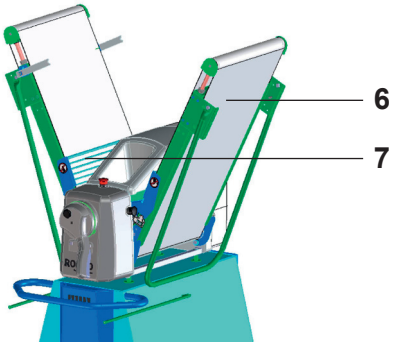
The plastic material supports must not be damaged!

Unhinging the machine tables

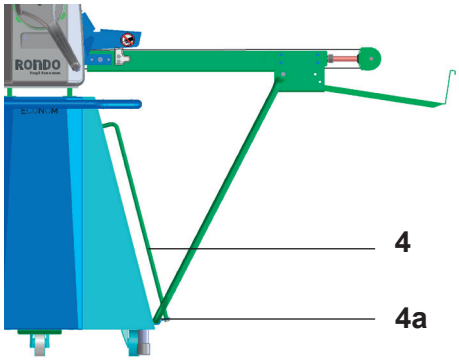
1. Push the machine table up, until the safety guard is locked.
2. Lower the machine table carefully.
3. Lower the safety guard by pushing the safety guard backwards.

Caution!

Against accidental unhinging of the machine tables!

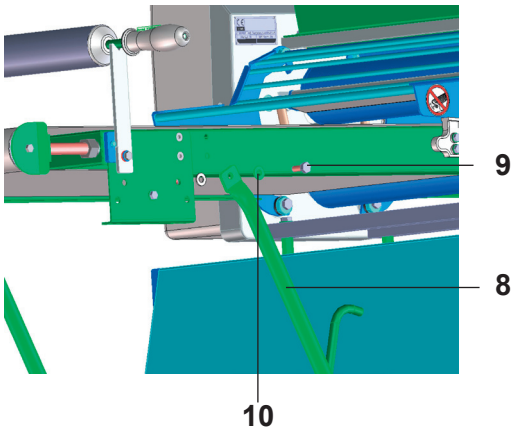


- Lift table (6) up until it is inserted into the safety guard (7)
- The machine table is now secured

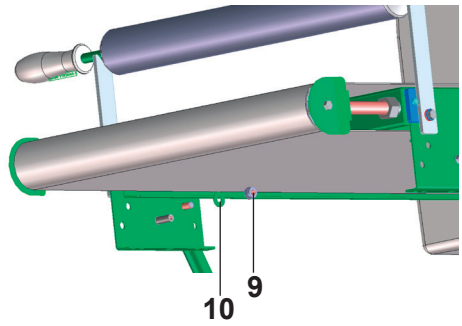


- Lower the tables and fix the guide bow (4) with the hexagon screw (4a)

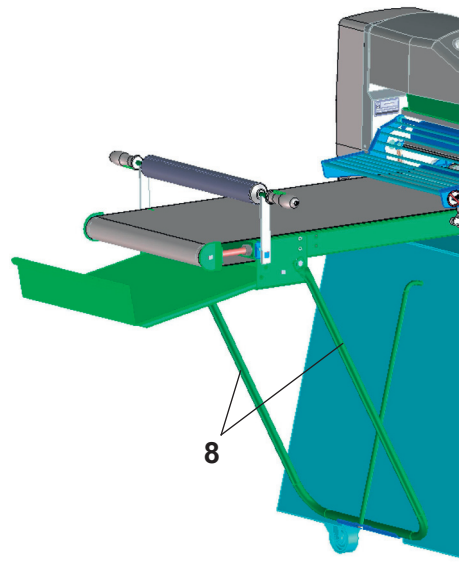
2.4.2 Mounting forked supports (SSO5304)



- Position forked support (8) and fix it by using nut (M8) (9)

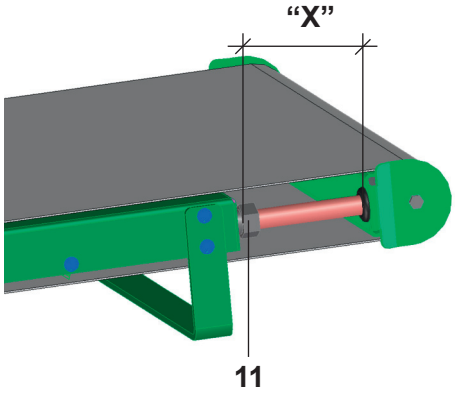


- Fix it on both sides by using two washers (10)



Position of the forked support (8) when the machine table is hinged down.

2.4.3 Tensioning the conveyor belts



Tense the conveyor belts only enough so that the heaviest pieces of dough (max. 4 kg) can still be moved along the belt without the conveyor belt dragging.

Proceed as follows:

- Retighten the left and right tension nuts (11) so that they are even and parallel
- Remeasure distance “X” on both sides using a millimeter measuring instrument
  Distance “X” must be identical on both sides.
- Switch on the machine (see 4 Putting into operation /3.5 Operating elements)
- Observe both the left and right running movement of the conveyor belt

If the belt runs off toward one side, proceed as follows:

- Retighten the side where it runs off using a tension nut

or

- Loosen on the opposite side using a tension nut
- Monitor the belt, and if necessary, correct it until it runs exactly in the middle of the table

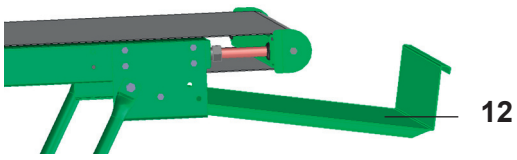
Repeat this procedure several times, if necessary. Routinely monitor the belt during the initial hours that the machine is operational, and if necessary, correct again.

Tensioning and adjusting the conveyor belts demands patience!

Prior to carrying out each further correction, allow the machine to run for at least 30 seconds.

Before putting the machine into operation, the conveyor belts must be rubbed lightly with flour in order to prevent the dough from sticking to the belt.

2.4.4 Mounting the dough catch pan (SSO5304)



- Remove the protective foil on the dough catch pan (12)
- Push in the dough catch pan on both sides

2.5 Conditions for initial operation of the machine

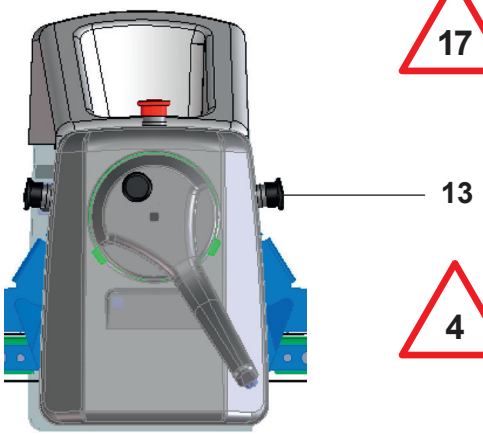
Power supply and frequency at the main circuit to which the machine is connected, must be in accordance with specifications contained on a identification plate affixed to the machine. (This plate is found on the cable lead-through on the machine base).

Direct connection without a plug is prohibited! Ensure that the connection is made professionally and in accordance with local regulations. (An electrical schematic is delivered with every machine. It is to be found next to the electrical control in the machine base).

The machine may only be operated with mounted machine tables!

All still existing protective foils on the machine must be removed.

2.6 Moving direction test



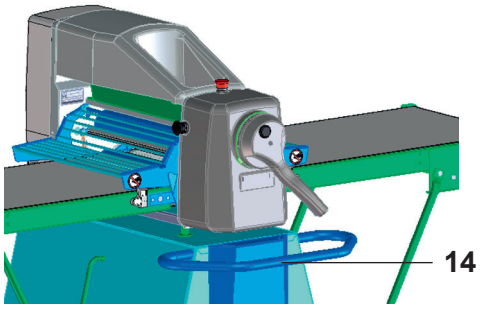
Observe to ensure that the belts are properly tensioned.

- Push the black push button (13) on the left (only impulse). The conveyor belts must move to the right.

If the conveyor belts move in the wrong direction:

- Exchange two phases in the power plug

2.7 Moving the machine (SSO5304)



- On the operator's side, lift up using the safety rail (14)

3 General data about the machine

3.1 General information

3.1.1 Authorized use of the machine

The machine of RONDO is exclusively built for sheeting, booking and final sheeting of dough or marzipan sheets for the food industry.

However, the machine is not suitable for the processing of other products (e.g. modelling clay or other types of mouldable masses which are not dough products).

This product is a technical working tool which is designated to be used exclusively for work.

Persons handling the product must be instructed accordingly and at least 16 years of age.

Booking

Booking in fat. Through sheeting to a thickness of approx. 6 - 11 mm and a subsequent folding of the dough there is a resulting formation of layers of fat and dough. A repetition of this process yields many thin layers.

Final sheeting

Includes sheeting the piece of dough to the necessary final thickness required for further processing.

3.1.2 Noise values

The emission value at place of operation is less than “70 dB(A)”.

The accuracy class of the acoustic emission measurement corresponds to class 2 (± 2.5 dB) according to:

DIN EN ISO 11201 / DIN EN ISO 11202 /
DIN EN ISO 11203 / DIN EN ISO 11204

3.1.3 Temperatures

The ambient temperatures permissible for the machine:
+ 5 ºC to + 40 ºC

Permissible temperatures for storage of the machine:
- 25 ºC to + 55 ºC, for brief periods of time up to + 70 ºC

3.1.4 Ambient humidity

The ambient humidity permissible for the machine lies inthe area of 30 % - 95 %, relative humidity, uncon-densed (for the dusting flour in the flour container, the relative humidity should not exceed 60 %).

3.1.5 Machine weight

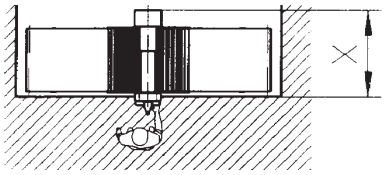
Total weight:

STM5303:	approx. 80 kg
SSO5304:	approx. 145 kg

(Compare 9.1 Technical data)

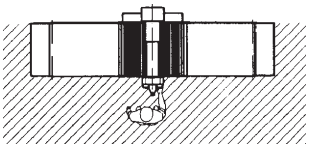
3.1.6 Working area for the operating personnel

STM5303



The hatched area shows the work area designated for the operating personnel.

SSO5304



On the STM5303 models, the machine must cover the whole width of “X” on the work table!

3.2 Machine models

3.2.1 STM5303

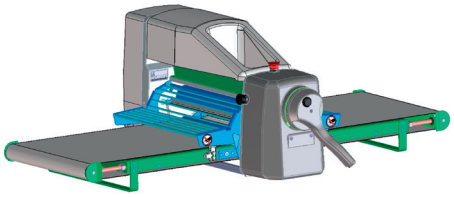
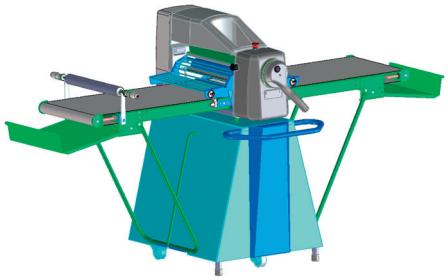


Table model
(see 9.1 Technical data)

3.2.2 SSO5304



Socle model
(see 9.1 Technical data)

3.3 Prerequisites

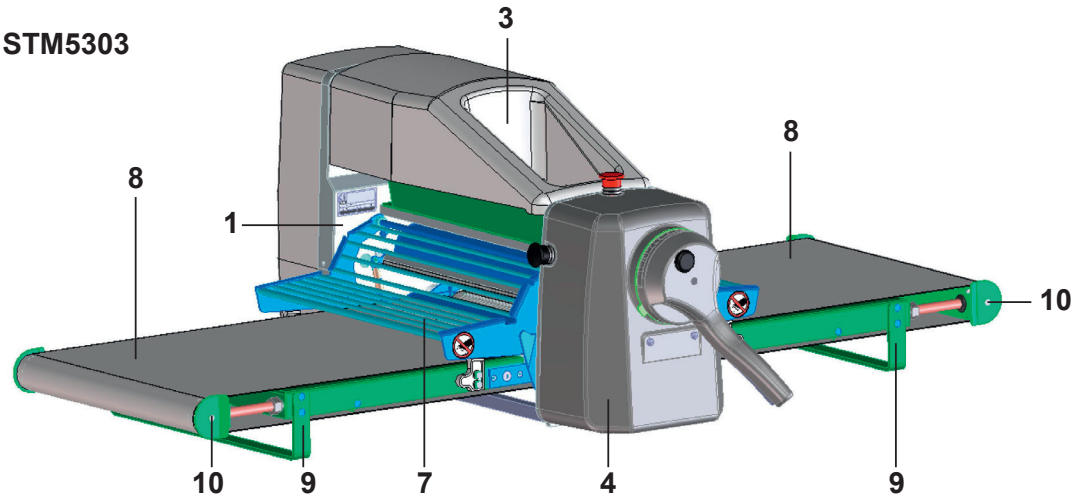
In order for the dough to be sheeted by the machine, the following pre-requisites must be fulfilled:

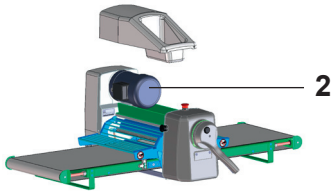
- Max. dough piece weight 4 kg
- Flour the dough pieces

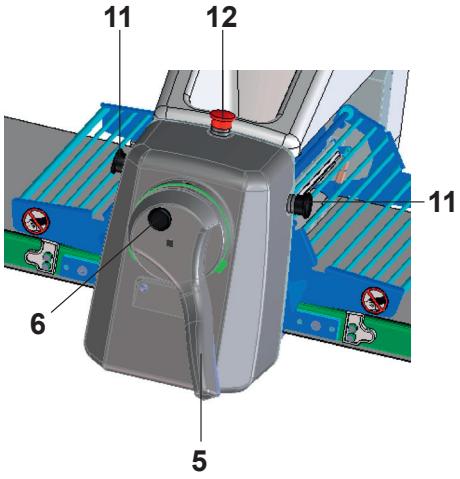
This will serve to prevent the dough from sticking to the rollers and scrapers.

3.4 Full view of the machine

STM5303

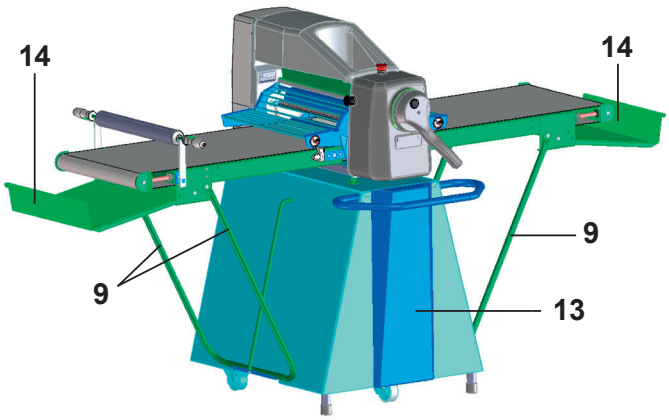






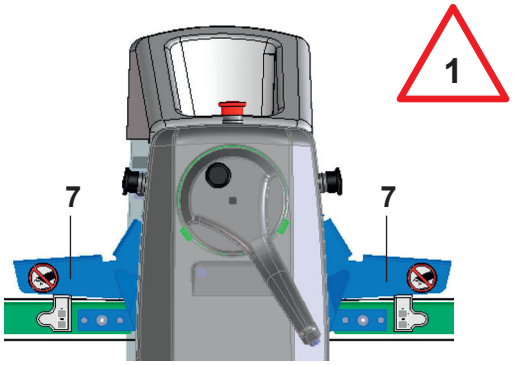
1 Rear housing
2 Motor
3 Flour container
4 Front housing
5 Roller gap adjusting mechanism
6 Push button for dough thickness control stop
7 Safety guard
8 Conveyor belt
9 Forked support
10 Idle roller
11 Black push button to switch on
12 Red push button to switch off
13 Machine base
14 Dough catch pan

SSO5304



3.5 Operating elements

3.5.1 Safety guards



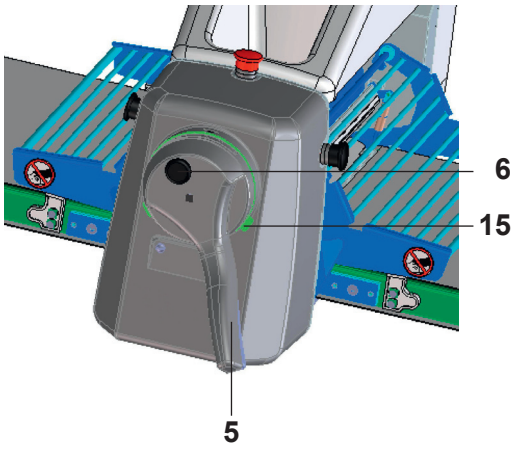
The safety guards (7) protect the operator against inadvertent contact with the rollers.

By raising the safety guards (7) the machine can also be stopped.

3.5.2 Roller gap adjusting mechanism

The desired roller gap is set by using the roller gap ad-justing mechanism (5) (see also 5.1.1 Sheeting).

3.5.3 Push button for dough thickness control stop

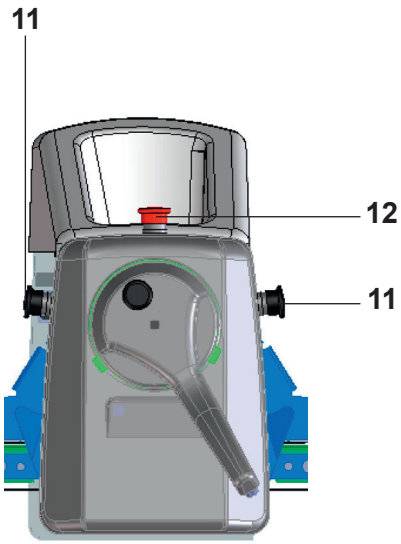


Using the roller gap adjusting mechanism, open the gap between the rollers to the maximum (30 mm).

Proceed as follows:

- Set the dough thickness control stop as follows:
- Set desired dough thickness by using the roller gap adjusting mechanism (5)
- Press the push button (6)
- Turn dough thickness control stop (15) to the limit stop with pressed down push button (e.g. final thickness 5)
- Release push button (6)

3.5.4 Black push buttons



Both black push buttons (11) (two push buttons on the side of front housing) serve to start the machine (see also 4.2 Starting/stopping the machine).

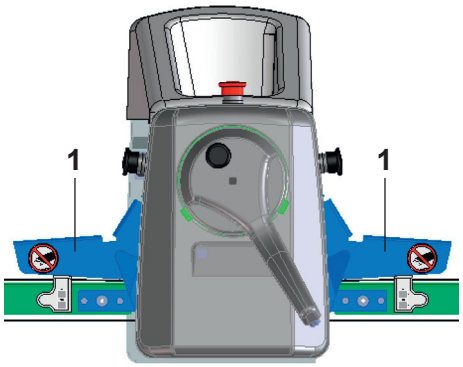
3.5.5 Red push button

The red push button (12) (push button at the top of front housing) serves to stop the machine (see also 4.2 Starting/stopping the machine).

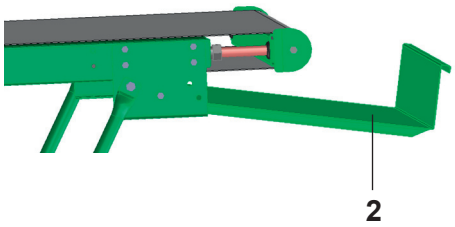
4 Putting into operation

Prior to the first starting-up, the complete machine must be thoroughly cleaned.

4.1 Preparing for operational readiness



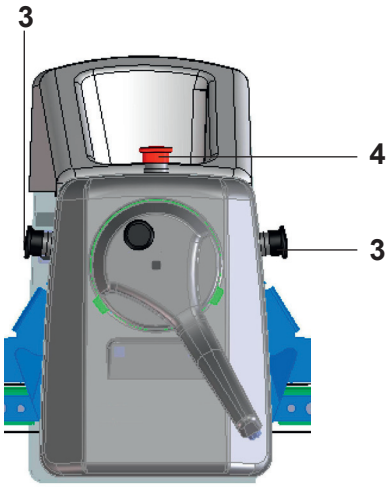
- Fold both safety guards (1) downwards
  (see 3.5.1 Safety guards)



By SSO5304:

- Pull out dough catch pan (2) on both sides

4.2 Starting/stopping the machine



In order to start up the machine:

- Briefly press the left start push button (3)
  The conveyor belts begin to move from left to right.

or

- Briefly press the right start push button (3)
  The conveyor belts begin to move from right to left.

In order to stop the machine:

- Press red push button (4)

5 Operation

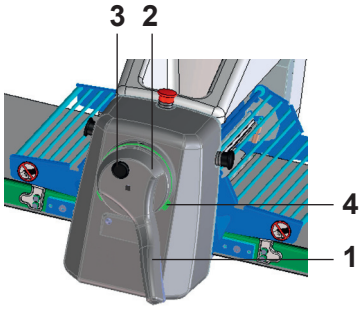
5.1 Operating instructions

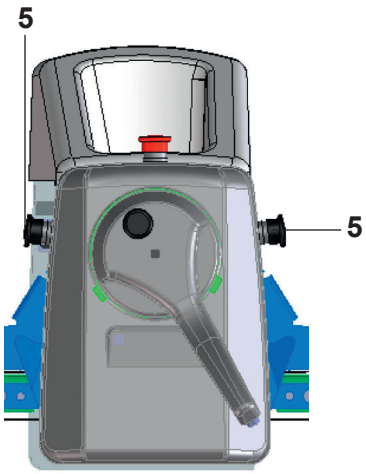
Reaching under the safety guard when it is closed is prohibited!

5.1.1 Sheeting

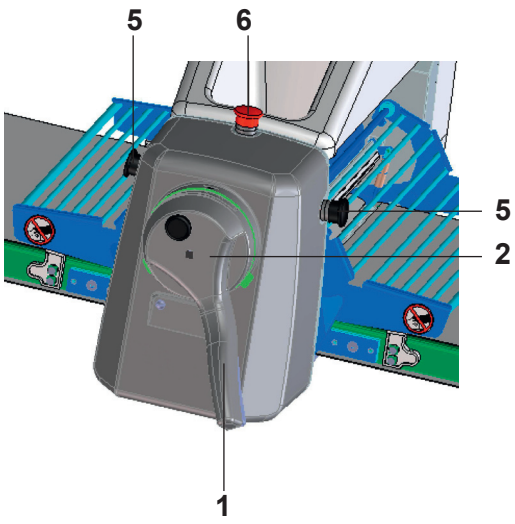
The machine is designed to accommodate dough pieces with a maximum weight of 4 kg!

Never leave loose objects such as knives, tools, articles of clothing, etc. lying in the area where the dough is located.





- Set desired roller gap (maximum 30 mm/minimum 0,3 mm) as follows:
- Push adjustment lever (1) towards the roller gap adjusting mechanism (2), do not release
- Set the desired roller gap, by using the roller gap adjustment mechanism (2) (scale)
- Release adjustment lever (1)
  Adjustment lever (1) must lock into place.
- Press the push button (3)
- Turn dough thickness control stop (4) to the limit stop
- Release push button (3)
- Place the dough piece (max. 4 kg) on the machine table (do not “throw” dough pieces on the table!)
- Start up the machine as follows:
- Briefly press the black push button (5) on the dough’s infeed side (see 4.2 Starting/stopping the machine)



Once the dough piece has fully cleared the rollers:

- Press red push button (6) (above on the housing)
  Machine stops.
- Manually set the next roller gap (depending on type of dough) (see Set desired roller gap, chapter 5.1)
- Release adjustment lever (1)
  Adjustment lever (1) must lock into place.
- Briefly press black push button (5) on the dough‘s infeed side (see Starting/stopping the machine, chapter 4.2)

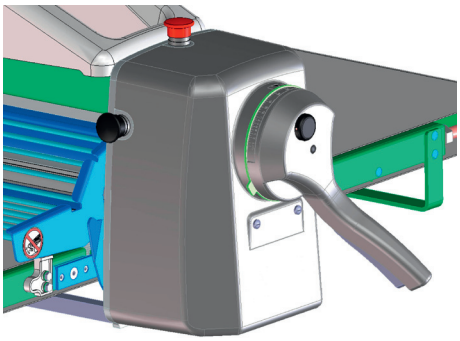
Once the dough piece has fully cleared the rollers:

- Briefly press red push button (6)
- Machine stops.
- Repeat this procedure until the desired final thickness of the dough has been obtained.

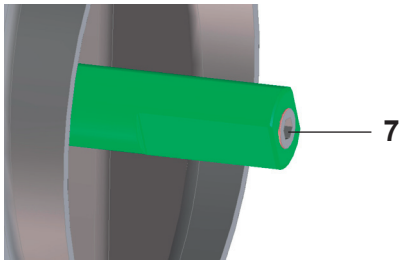
5.2 Sources of error in the sheeting process

Fault finding	Cause / defect	Remedy / to remove
1. Dough piece sticks, tears underneath.	Dough too moist Dough piece rubs against scraper bar.	Put more flour on the dough piece. Mount the scraper properly (see 6.1.1 General information).
2. Dough piece piles up (ripples).	Reduction steps too big.	Select smaller reduction steps: Let down the roller in smaller steps (see 5.1.1 Sheeting).
3. Dough sheet tapers.	Reduction steps too small.	Select bigger reduction steps: Let down the roller in bigger steps (see 5.1.1 Sheeting).

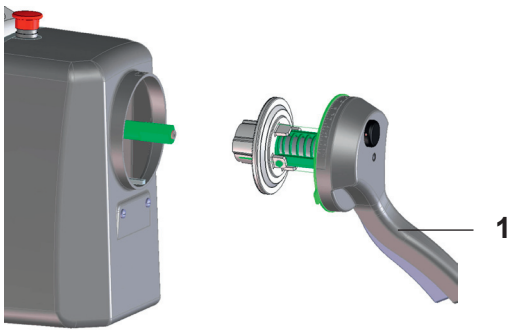
5.3 Adjustment lever



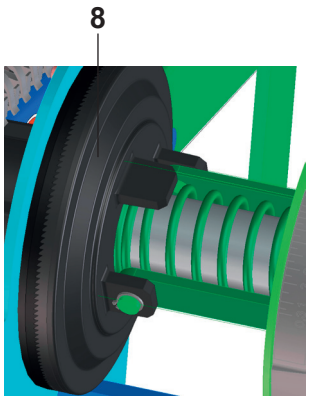
Starting point: machine body completely assembled and set screw (7) screwed home in the adjusting shaft



5.3.1 Assembly

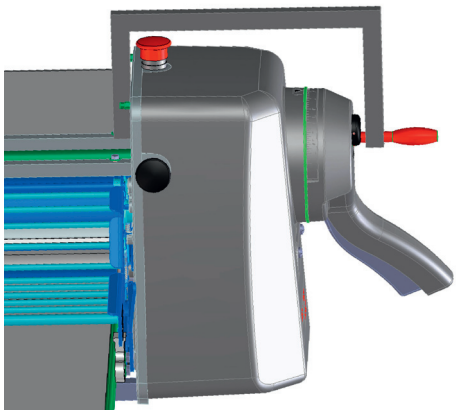


- Slide the pre-assembled adjustment lever (1) over the adjusting shaft up to the lid and press down



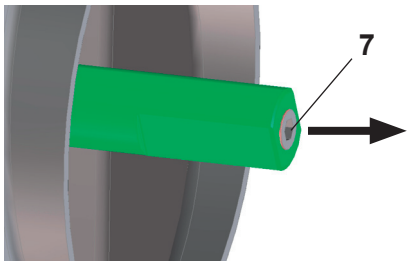
Check that the teeth are correctly engaged in the serrated segment (8)!

5.3.2 Adjustment

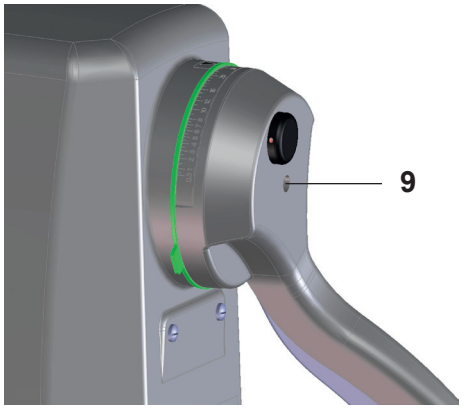


With screw clamp:

- Lightly tighten the screw clamp and unscrew the set screw (7) with the aid of an Allen key (through the drill hole (9)) until it projects
- Remove the screw clamp and unscrew the set screw (7) by a further approx. 1/8 turn



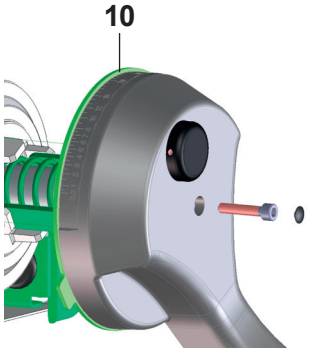
- Secure the set screw (7) with adhesive (Ergo 4401)!



If no screw clamp is available:

- Press down the adjustment lever (1) by hand and unscrew the set screw (7) until it projects
- Then take out the adjustment lever (1) by a further

5.3.3 Fixing



- Tighten the Allen screw and check that stop plate (10) runs smoothly
- If the stop plate (10) has too much play, screw the set screw (7) in or out until the optimum adjustment is abtained

6 Cleaning

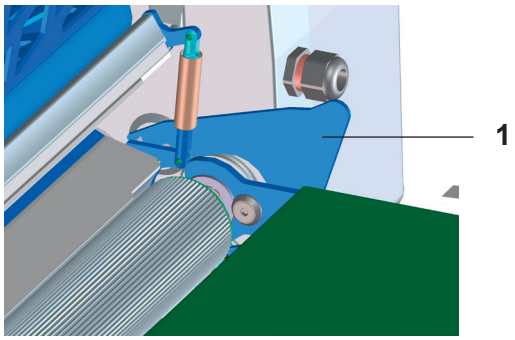
6.1 Cleaning

Before cleaning the machine, pull out the mains plug.

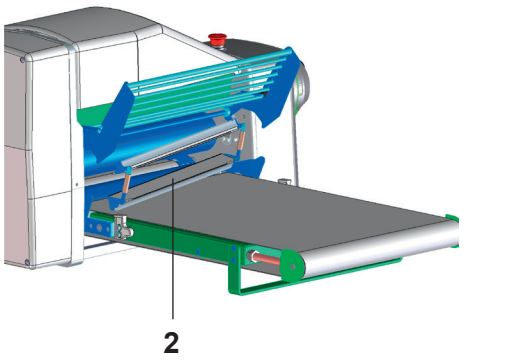
The machine must never be cleaned using spray water, high-pressure cleaners, steam cleaning machine or any similar cleaning methods.

6.1.1 General information

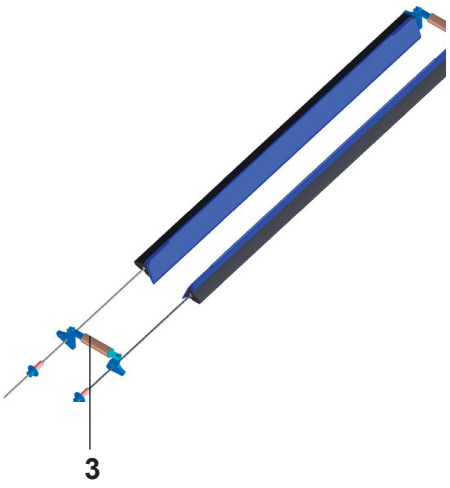
Dismounting the scraper



- Open rollers fully
- Lock the safety guard into the upper position
- Using the thumb, push the front and rear scraper lever (1) downwards

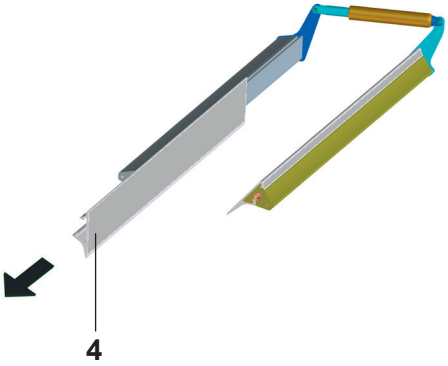


- Lift the scraper (2) out of the scraper mouting
- Pull out the scraper (2)
- Clean the scraper (see 6.1.2 Care)



Exchange of scraper blades

Required tool: Allen key No Nr. 4

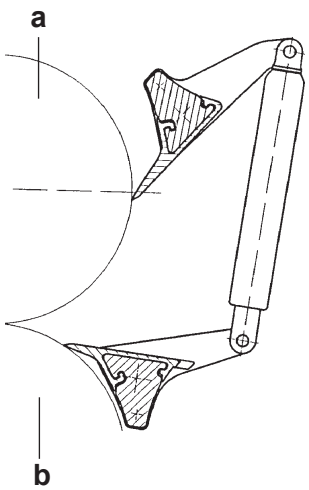


Exchange of scraper blades:

- Disassemble the spring clamp (3) on the left or the right side
- Slide the old scraper blade (4) off

Attention

For protection of the fingers, please use a cloth. The edges of the blades are sharp and there is danger of cutting oneself.

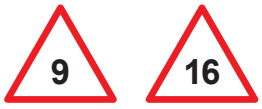


- Assemble the spring clamp in reverse order
- Assemble the new scraper blades in reverse order

Mounting the scraper

- To remount the scraper, carry out the dismounting instrutions in reverse order

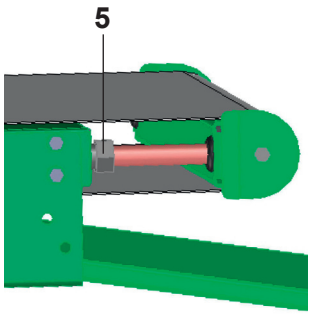
a upper roller
b lower roller



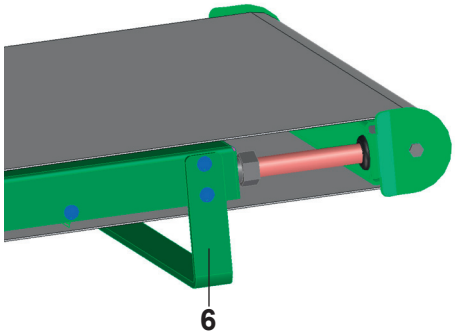
Dismounting machine tables/conveyor belts

In order to dismount the machine tables and conveyor belts, proceed as follows:

- Lift up the safety guards
- Pull out the mains plug

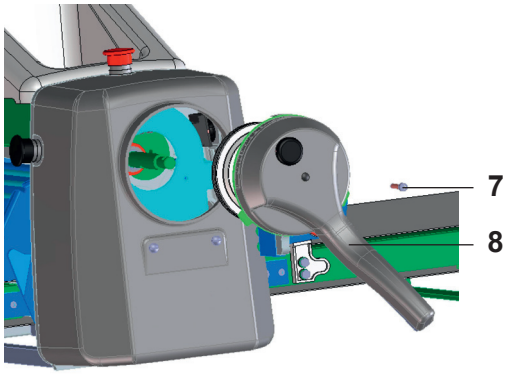


- Loosen the tension nuts (5) parallel, in order to retighten the conveyor belt
- Dismount forked supports (only for SSO5304 (in reverse order to Mounting the forked supports, see 2.4.2 Mounting forked supports (SSO5304))

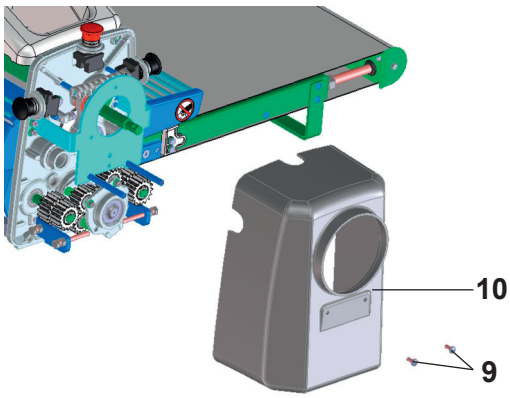


- Dismount forked supports (6) (STM5303)
- Dismount tables (in reverse order to Installation of the machine tables, see 2.4.1 Installation of the machine tables (SSO5304))

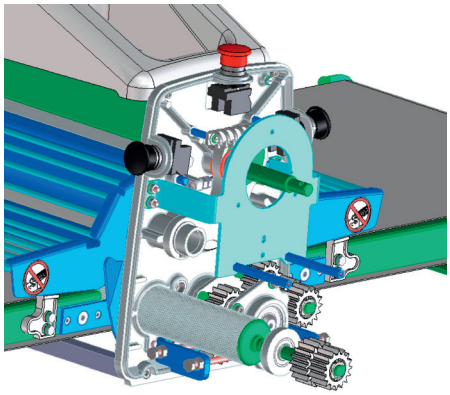
In order to dismount the conveyor belts, proceed as follows:



- Loose screw (7)
- Remove roller gap adjusting mechanism (8)



- Loose both screws (9) of the front housing (10)
- Remove front housing



- Pull the driving rollers (11) ahead out the machine base
- Remove conveyor belt
- The conveyor belt can now be cleaned or replaced (see 6.1.2 Care/7.3 Replacement parts list)

Mounting machine tables and conveyor belts

The right and left driving roller, as well as the machine tables must not be exchanged!

- Remount the machine tables and conveyor belts in reverse order of dismounting

6.1.2 Care

Part	see	daily see legend	weekly see legend
Machine head and machine base	3.4 Full view of the machine	B	A
Scraper	6.1.1 General information	A	
Cotton belt	6.1.1 General information	B	(E)
Synthetic belt	6.1.1 General information	B	C
Dough catch pan	2.4.4 Mounting the dough catch pan (SSO5304)	A	
Driving roller	2.4.1 Installation of the machine tables (SSO5304) 6.1.1 General information		D
Idle roller	2.4.3 Tensioning the conveyor belts		D
Flour container	3.4 Full view of the machine	B	

Only use cleaning agents with a ph-value of 6 to 8! Only cleaning materials approved for use in the food industry may be used.

Legend

A Wet clean using a cloth and soapy water

B Dry clean using a brush

C Wet clean using a brush

D Using a brush and plastic scraper, remove any remaining pieces of dough

E Wash cotton belt monthly as follows:

- Water temperature must not exceed 40 ºC
- Once belt has been washed, hang it over a rod and weight it down with a weight of approx. 10 kg

7 Maintenance

7.1 General information on the maintenance of the machine

Any defects on the machine must be repaired by an authorized customer service representative!

7.2 Maintenance list

What / Part	Activity	daily working time less than 4 h	daily working time 4 - 8 h	daily working time more than 8 h
Conveyer belts	check, if necessary: replace	M	W	W
Scraper blades (Dough sheeter)	check, if necessary: replace	M	W	W
Table drive and roller gap adjusting mechanism in the front housing	grease according to the Service manual	3J	2J	J
Roller drive and adjusting in the rear housing	grease according to the Service manual	3J	2J	J

Legend

W weekly

M monthly

J annually

2J every 2 years

3J every 3 years

7.3 Replacement parts list

The use of conveyor belts not supplied by RONDO can lead to premature wear or destruction on machine parts (coupling, drive rollers).

Item-No.	Description	Dimensions	Application
122773T02	Scraper complete	-	STM5303, SSO5304
122775T02	Scraper blade	-	STM5303, SSO5304
79302	Cotton belt	1490 x 475 mm	STM5303
120750T04	Cotton belt	1940 x 475 mm	SSO5304
121344T30	Synthetic belt	1470 x 475 mm	STM5303
121344T31	Synthetic belt	2020 x 475 mm	SSO5304
8934	Fuse 1,0 AT	1,0 AT slow Ø 5 x 20mm	STM5303, SSO5304

8 Trouble shooting

Fault finding	Cause/Defect	Remedy/To remove
1. Machine stands still after assembly.	Main switch not/not correctly plugged in.	Plug in the main switch.
	Safety guard not closed.	Close safety guard.
	Right or left Start push-button not pressed.	Press the desired Start push-button.
	Machine tables not level.	Put the machine tables in a even level position.
2. When pressing the right Start push-button, the conveyor belts move to the right.	Sense of rotation reverse (mains).	Moving direction test (see 2.6 Moving direction test).
3. Machine runs intermittently, stops, rattles.	Safety guard limit switch incorrect.	Readjusting by an expert.
	Support for safety guard incorrect.	Adjust supporting eccentric.
	Loose cables, wires.	Adjust loose wires, cables.
4. Main drive motor runs, rollers and conveyor belts stand still.	Belt drive defective.	Call after-sales service! Remove rear cover of machine base and roller head, replace belts or toothed belts if necessary.
5. Conveyor belts loops up, motor and rollers run.	Belt tension too weak.	Tension conveyor belt equally. (see 2.4.3 Tensioning the conveyor belts).
	Driving roller dirty.	Clean driving roller (see 6.1.2 Care).
6. Machine only runs to one side.	Defective motor contactor.	Call specialist (electrician). Replace motor contactor.

Fault finding	Cause/Defect	Remedy/To remove
7. Discharge conveyor belt stands still or jerks.	Table drive defective. Belt tension too weak.	Call after-sales service. Tension the belt equally (see 2.4.3 Tensioning the conveyor belts).
8. Dough piles up before the roller or passes under the roller between scraper and infeed conveyor belt.	Scrapers inserted incorrect. Scraper blades worn out.	Close the scraper levers properly (see 6.1.1 General information). Check and if necessary adjust scraper levers by means of eccentric (center of motion). If necessary replace scraper blades or the complete scraper.
9. Conveyor belts run to one side, tear at the edges.	Incorrect belt tension. Drive roller dirty.	Tension conveyor belt (see 2.4.3 Tensioning the conveyor belts). Clean drive roller (see 6.1.2 Care)
10. Cotton conveyor belts too short after washing.	Washing temperature too high.	Washing temperature max. 40 ºC. Hang washed conveyor belt over a rod and weigh it down below with approx. 10 kg.
11. All other errors/failures.		Inform nearest “RONDO” aftersales service giving as much information as possible.

9 Technical data

9.1 Technical data

Technical data	STM5303	SSO5304
Machine base	no (table model)	Socket
Belt width	475 mm	475 mm
Table width	487 mm	487 mm
Total table length	1550 mm	2060 mm
Req. floor-space: in working position in resting position	 1040 x 1550 mm 1040 x 815 mm	 1045 x 2500 mm (dough catch pan extended) 1045 x 1100 mm
Roller length	500 mm	500 mm
Roller gap	0,3 mm - 30 mm	0,3 mm - 30 mm
Sheeting speed of discharge conveyor	50 cm/sec	50 cm/sec
Rated power	0,5 kW	0,5 kW
Supply voltage	3 x 200 - 420 V, 50 / 60 Hz 1 x 200 - 230 V, 50 Hz 1 x 200 - 230 V, 60 Hz	3 x 200 - 420 V, 50 / 60 Hz
Machine weight:	approx. 80 kg	approx. 145 kg

Technical specifications subject to change without notice.

9.2 Additional information

All sheeters from RONDO have the following quality features:

- The conveyor belts made of plastic material:
  All plastic coated conveyor belts used on our machines are approved for coming into contact with food stuff and correspond with the requirements of the directives EU 10/2011 as well as the FDA (Food and Drug Administration, USA).
- The conveyor belts made of cotton:
  The fabric consists of 100 % cotton and has a non-toxic finish.
- The rollers are hard-chrome plated. This coating is approved for coming into contact with food stuff.
- The scraper blades are made of POM-C plastic material. This material is approved for coming into contact with food stuff and corresponds with the requirements of the directives EU 10/2011 as well as the FDA (Food and Drug Administration, USA).
- The dough catch pans are made of stainless steel (chromium nickel steel, DIN Mat. no. 1.4301, 1.4016) which is approved for coming into contact with food stuff.
- The rollers of the manual and the automatic dough reeler that are touching the dough are made of aluminium, anodised colourless and are approved for coming into contact with food stuff.
- Flour container:
  The flour container is made of plastic material (ABS). This material is approved for coming into contact with food stuff.