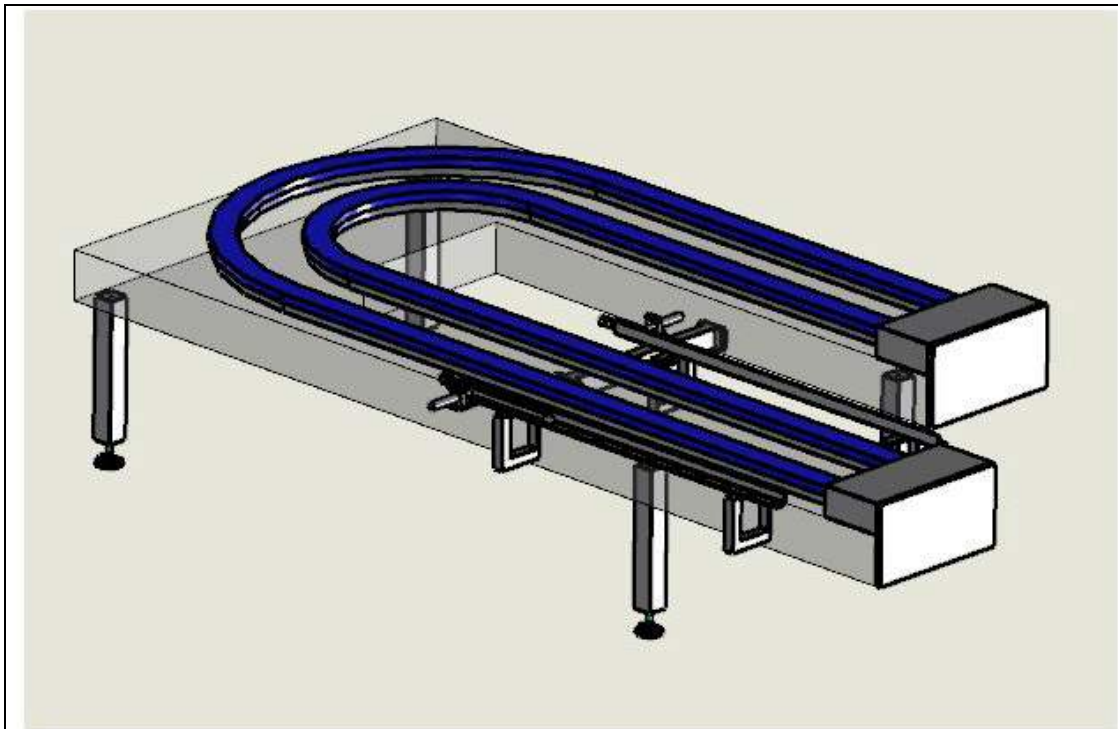


OPERATION, ADJUSTMENTS AND MAINTENANCE

U-SHAPED TRAYS SUPPLIER



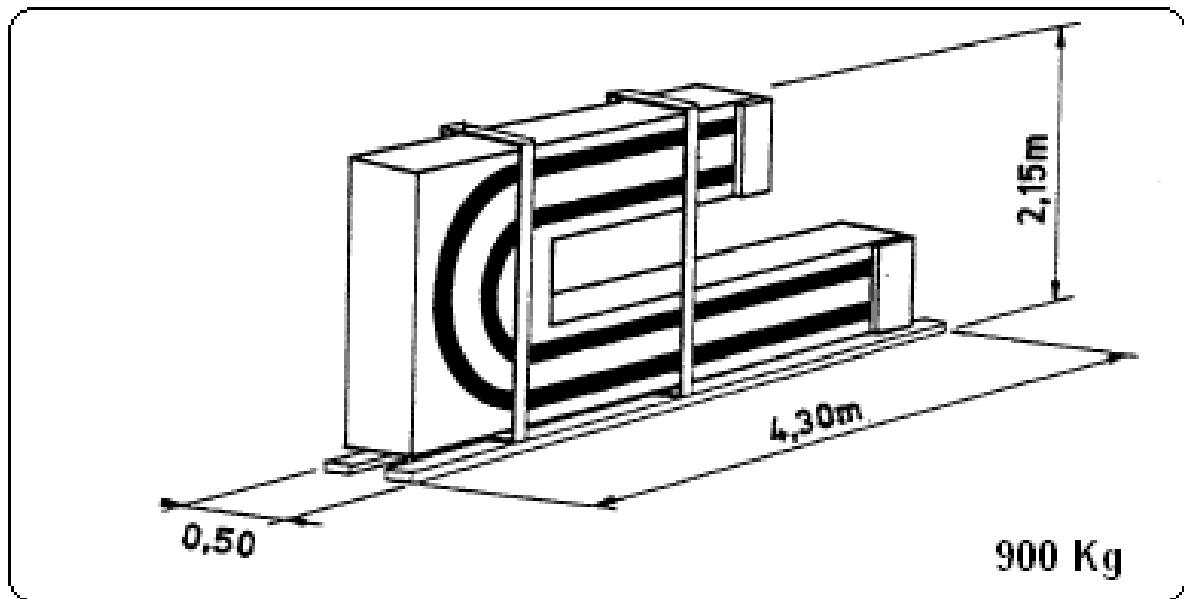
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1.HANDLING

To move a U-SHAPED TRAYS SUPPLIER use a forklift. Lift up this section by placing the forks directly under its flanks (see below).



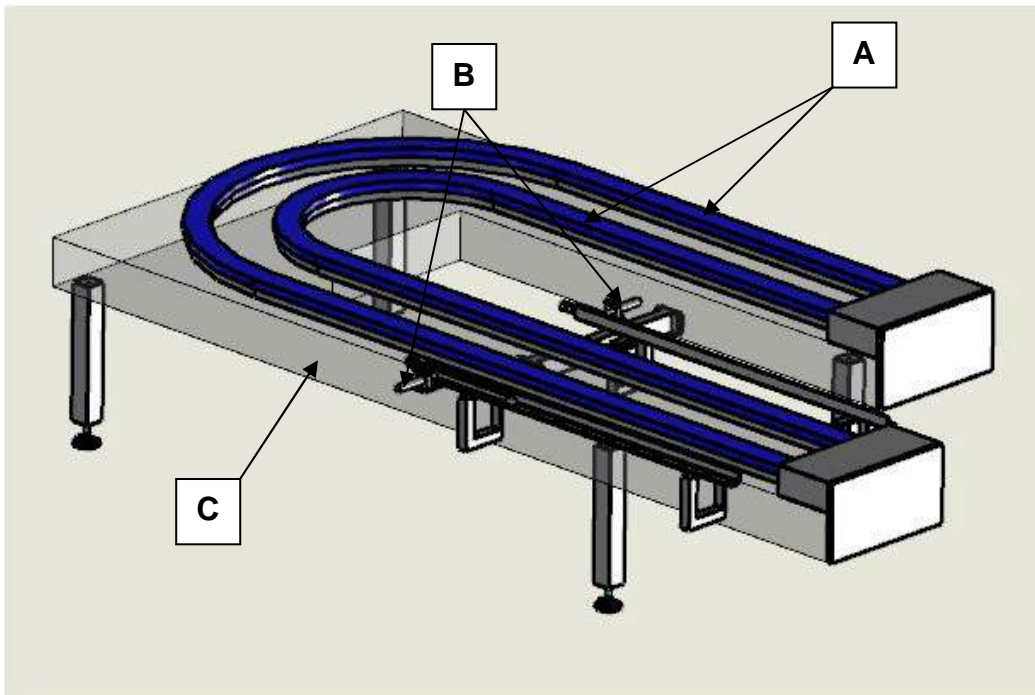
However, be careful not to damage the parts that could be mounted on the straight conveyor section (cables, cable channels, decentralized driving unit, etc.).

Weight: **900 kg**

2.DESCRPTION

The U-shaped trays supplier allows the depositing of dough pieces on trays step by step.

It is located under the depositing of the Bloc and consists of two pallet chains (**A**) and two lateral stoppers (**B**) mounted on a frame (**C**).



The loading of the empty trays and the unloading of the full trays is done manually.

A photocell detects the trays groove and permits to position the tray under the depositing point with the lateral stoppers.

A second photocell detects the arrival of a dough piece; after a temporization called "Fall time" the lateral stoppers release the tray and position the next groove under the depositing point.

3.RESIDUAL RISKS

(Risks which cannot be fully eliminated).

As per European directive 2006/42/CE:

"When risks continue to exist in spite of all the provisions that are implemented, or when they are non obvious potential risks, the manufacturer must include warnings. These warnings must preferably use pictograms which everyone can understand."

The U-SHAPED TRAYS SUPPLIER has been designed in conformity with the safety standards required by the EU (ISO standards) and by the United States and Canada (ANSI standards). Any use or intervention which differs from those planned by the manufacturer may create unexpected and severe risks. This also applies to failure to observe safety instructions.

Caution! Residual shearing risk: by inserting the hand towards moving plates.



SAFETY REMINDER

During maintenance or repair interventions, the line must be STOPPED, POWERED OFF AND COMPRESSED AIR SUPPLY OFF.

4.ADJUSTMENTS & MAINTENANCE

4.A.PALLET CHAINS

It is useless to tense the conveyor's pallet chains. The tension is ensured by rollers under each chain's loose strand.

The tension is made by the chain's own weight (see picture).

In case of excessive extending, remove one or more pallets on the chain.



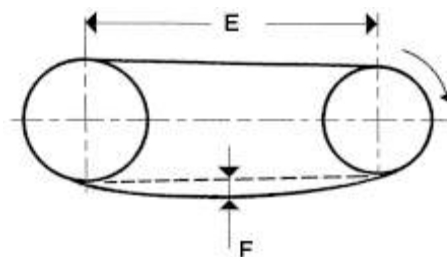
4.B.DRIVING CHAINS SETTINGS

Note: Concerns all the driving chains.

BASIC SETTING:

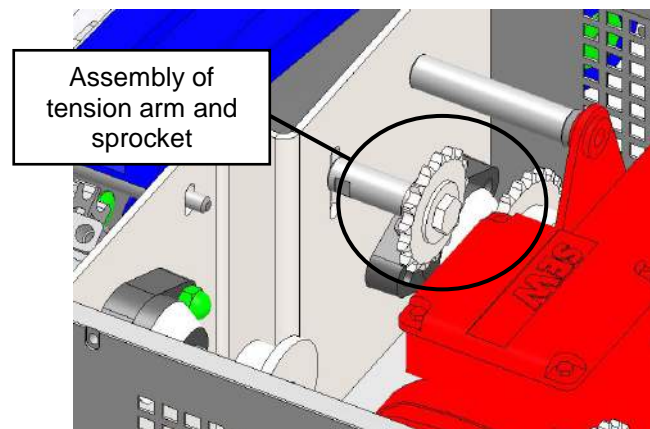
A drive line must never be "tightened"; only its functional extension must be corrected.

The arrow **F** on the slack end must be between 1% and 2% of the spacer **E**.



PROCEDURE:

Undo lightly the fixation screw of the tension arm, then push the assembly of the arm and sprocket against the chain. Once the correct tension is reached, tighten the fixation screw.



4.C.GEAR MOTOR MAINTENANCE

| GEAR MOTORS CHECK-LIST |
|--|
| 1. Check the oil level. Fill up if necessary |
| 2. Check the mechanism tightness |
| 3. Clean the fan to favor the cooling |
| 4. Check the fixations |
| RECOMMENDED OIL |
| Following the builder's recommendations |

Do not mix standard lubricants between them or with mineral lubricants.

Gear motors are delivered filled with oil.

Nota: For further information on the motors maintenance, see the builder's technical documentation.

4.D.BEARINGS MAINTENANCE

| BEARING CHECK-LIST |
|--|
| 1. Check the overall state of the bearings |
| 2. Check the fixations |
| 3. Grease with a pump. Fill with the right quantities following the builder's indications. |
| RECOMMENDED GREASE |
| SOGELUB MD Food BV or SKF LGFP2 |

To proceed to a cleaning of each part, use an "alimentary" degreaser responding to the FDA requirements.

When they aren't equipped with greasers, the bearings are lubricated for life. Otherwise, use a grease pump.

Attention: Remove the flour from the greasers before every greasing operation.

4.E.DRIVING CHAINS MAINTENANCE

| DRIVING CHAINS CHECK-LIST |
|---|
| 1. Check the overall state of the chains |
| 2. Check the links, fingers, quick fix and sliding paths. |
| 3. Lubricate the shafts and chains with a paintbrush |
| RECOMMENDED OIL |
| SOGELUB SOG Chain F |

5.CLEANING

5.A.GENERAL INDICATIONS

Cleaning the machine must be done after cutting off the power and compressed air. Cleaning operation must be carried out at least once a week or at every production end.

Always work from top to bottom.

In a general way, regardless the type of production or line speed, clean the environment regularly (floor and near the working zone). Use a broom or a vacuum cleaner.

Note: Do not use air blowing systems for the cleaning operation.

5.B.CLEANING SCHEDULE

| During production | At the end of production (or between 1 and 7 day) | Monthly | Biannual |
|---------------------------|---|----------------------------|----------------------------|
| Clean the environment | Remove dough accumulations | Clean the motors fins | Clean the electric cabinet |
| Empty the collecting bins | Wipe extra lubricant | Clean the exhaust silencer | |
| | Wipe the photocells / detectors | | |

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