

# SAFETY BULLETIN



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Product:	<b>Gemini Two-Pocket Roll Plant</b>
Models:	<b>Manufactured from January 2016 to September 2020</b>
Author:	Alex Davies
Date:	14 September 2020
Version:	1.0
Distribution:	All MONO Equipment Gemini Two-Pocket Roll Plant Customers, Service Partners & End-User Organisations

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## Operator Safety Concerns

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MONO Equipment has recently been made aware of a concerning safety issue arising with its Gemini Two-Pocket Roll Plant where the operator trapped their fingers in the dough pocket ejector and suffered a serious injury whilst trying to pick up dough prior to it being ejected on to the belt.

### 1. The Importance of Operator Training

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Operators should always be properly trained in the safe use and operation of all appliances, and read and understand the Operator Manual which sets out clear safety warnings to not place hands in the device when it is operating.

Do **NOT** attempt to pick dough pieces from the pockets. Operators should **ONLY** pick up dough pieces from the belts.

### 2. Always Ensure the Dough Lubrication System and Flour Duster Are Topped Up to Avoid Blockages

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Operators are reminded of the need to ensure the oil reservoir and flour duster are always topped up so as to provide lubricant to the dough moulding pockets. The lubrication assists the trouble-free ejection of dough pieces on to the conveyor belts.

### 3. Enhancing Safety Awareness – Additional Warning Labels & Guarding

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As a responsible manufacturer, MONO Equipment is committed to ensuring the best safety and operating standards are incorporated in to all our appliances.

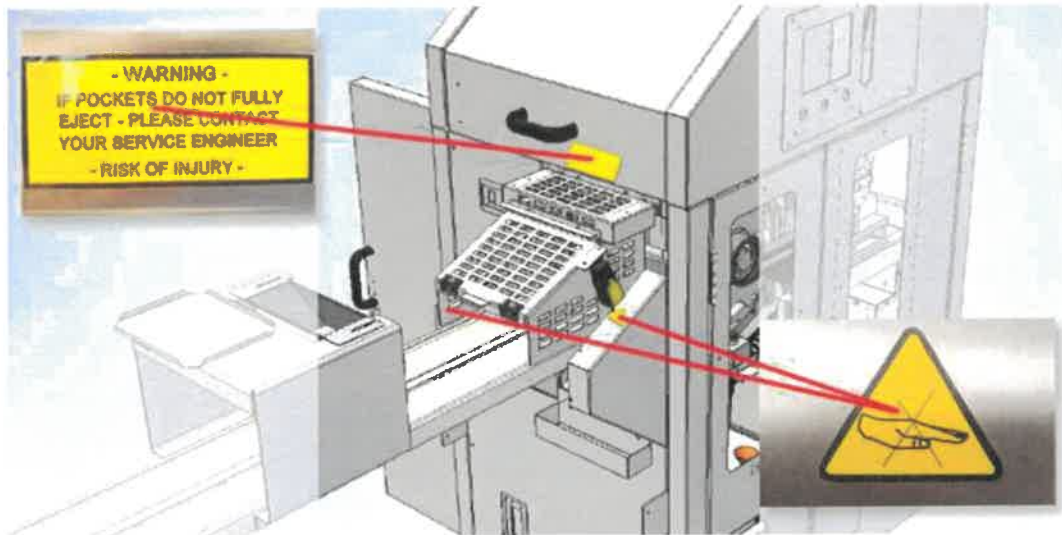
We have produced an enhanced Safety Warning Label Kit and extended, Fail-Safe Interlocked Guard that is available free-of-charge to all MONO Gemini Two-Pocket Roll Plant machine operators. MONO Equipment will contact all customers to arrange to supply these items. Customers can also contact MONO Equipment directly

**Tel: +44 (0)1792 561 234**

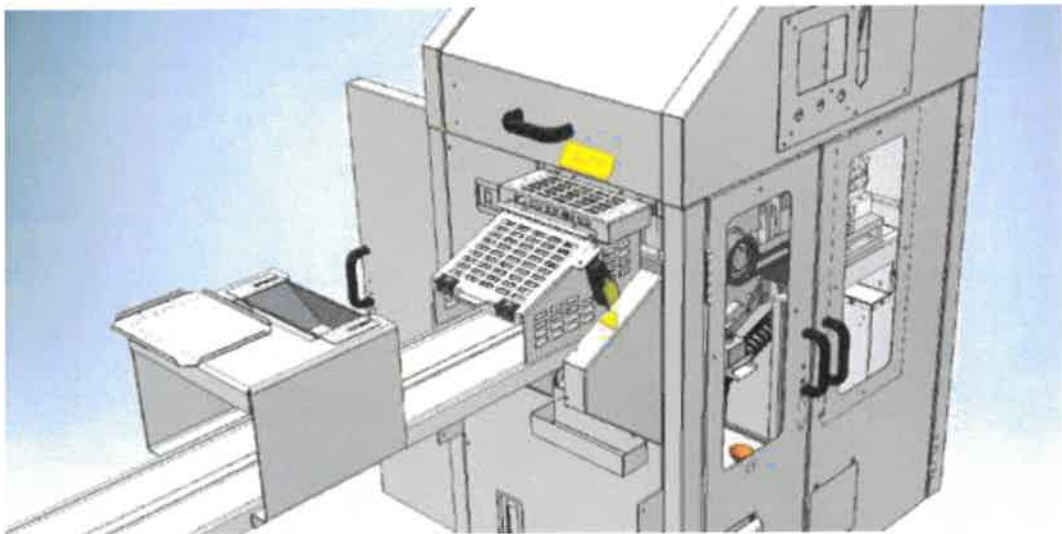
**or**

**Email: [spares@monoequip.com](mailto:spares@monoequip.com)**

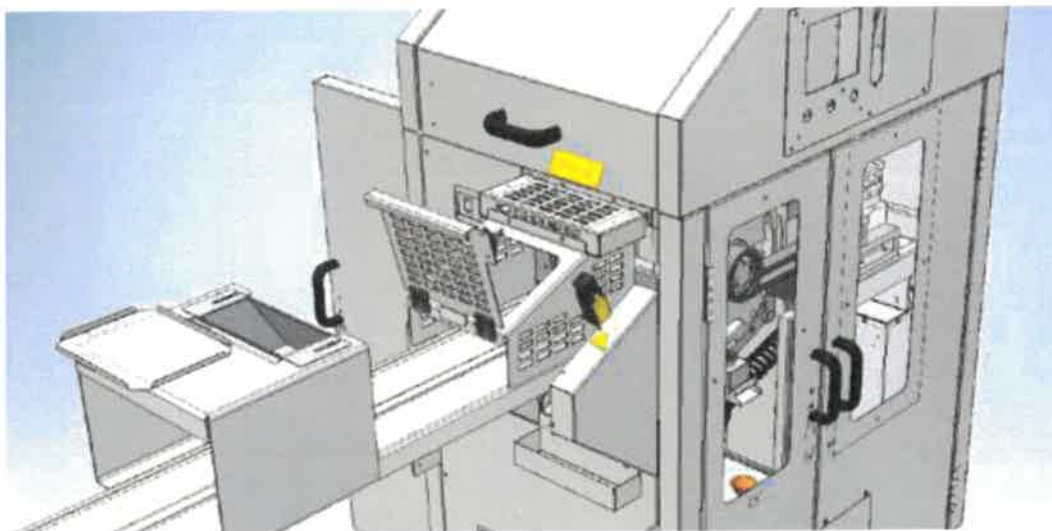
to register your appliance and to arrange an appointment for our engineer to attend.



*Fail-Safe Interlock Guard & New Safety Warning Label Retrofit Kit*



*Fail-Safe Interlocked Guard in Position*



*Fail-Safe Interlocked Guard with Interlocked Access Door Open*

## 4. Attending Service Engineer Advice – Roll Plant Linkage & Sequencing System

The Gemini Two-Pocket Roll Plant linkage and sequencing is carefully set at the factory to ensure trouble-free operation of the appliance.

An important aspect of the ongoing service and maintenance requirements for the Gemini Two-Pocket Roll Plant is to check the sequencing remains aligned and the ejector dough pockets are confirmed as fully extended in the machine's start / stop position.

If the ejector dough pockets are not correctly positioned then this could give rise to a shear point and an operating safety risk. The following details taken from the appliance service manual guide engineers to the correct positioning and timing that should be set for the cam, follower and pusher arm to ensure that the ejector pockets are correctly set.

### 4.1. Checking the Timing of the Ejector Arm

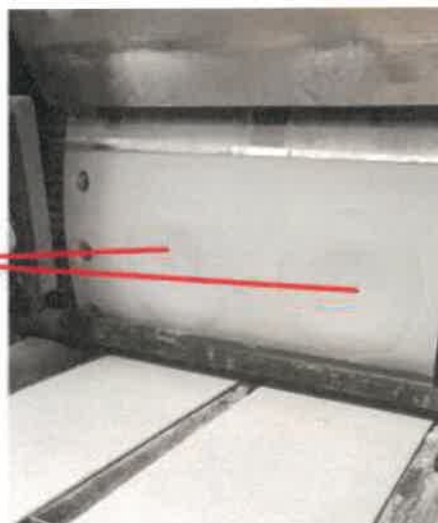
To ensure the safety of appliance operators, it is **ESSENTIAL** that any work carried out on the Gemini Two-Pocket Roll Plant is **ONLY** signed off once the positioning of the Ejector Dough Pockets has been checked and confirmed to be 'fully-out' in the Start / Stop position. Failure to do this can result in the possibility of a shear point between the drum and the green stripper bar.

- Always ensure the ejector cam is in the correct orientation ie. in the machine Stop indexing position
- Ensure that whilst in the Stop position, and also when the machine rotates between the ejecting position and the oiler position, that the pocket is fully ejected.

The Gemini Two-Pocket Roll Plant is not deemed to be safe if these requirements are not met; adjustments should be made accordingly to remedy the issue.

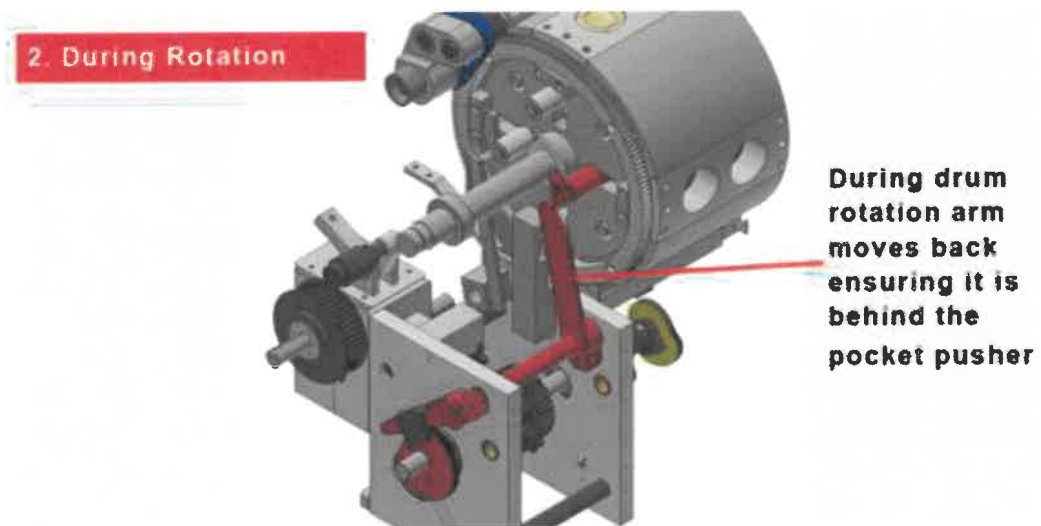
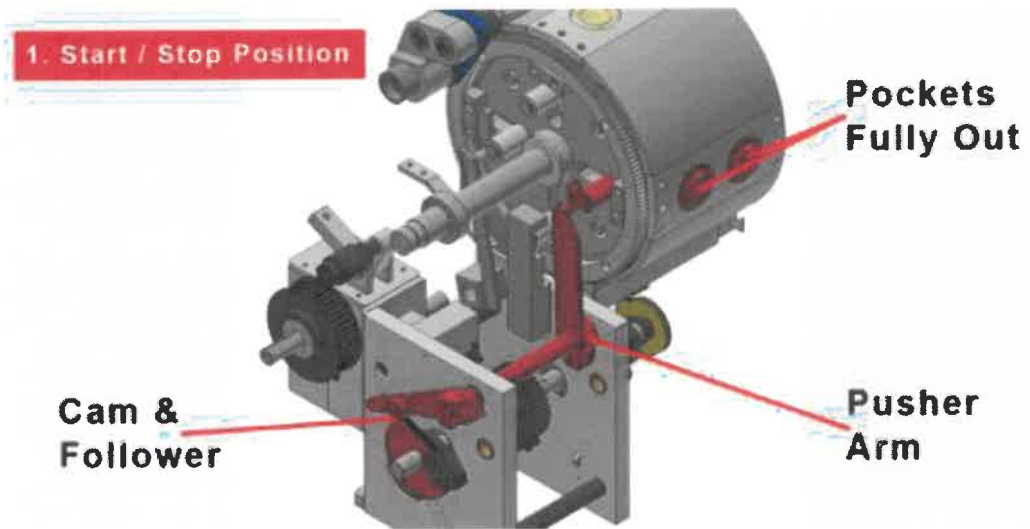
See below section 2.4 taken from the Gemini Two-Pocket Roll Plant Service Manual for details on the ejector and cam:

**Pockets  
Fully  
Ejected**

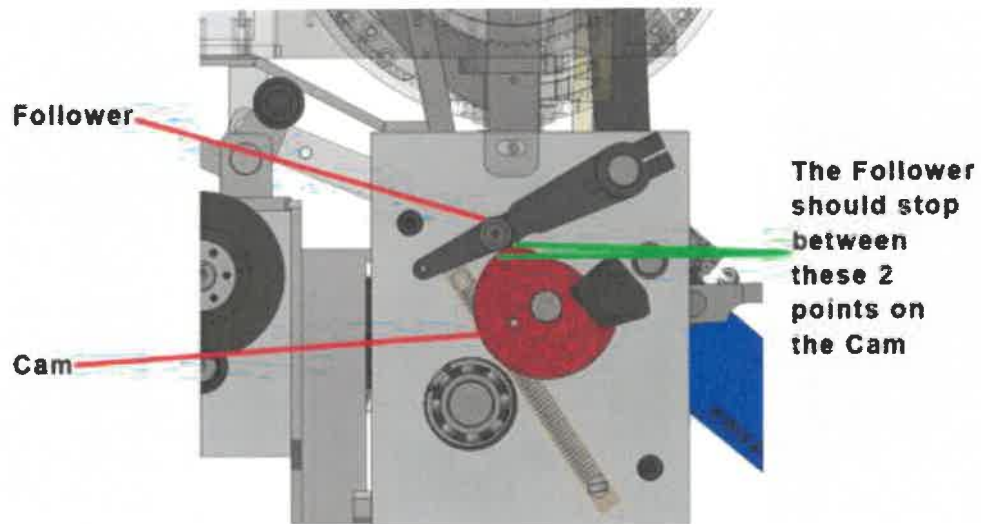


## '2.4. Ejector

The correct timing of the ejector ensures the dough pockets are fully ejected at the 3 o'clock position



The diagram below shows the correct cam rotation on the machine's Start / Stop points:



**Signed**

Name:	Alex Davies
Position:	Category Manager
Date:	14 September 2020
Signature:	