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Enter **Serial No.** here. _____

In the event of an enquiry please quote this serial number.



MONO TWIN MOULDER (UP TO 2017)

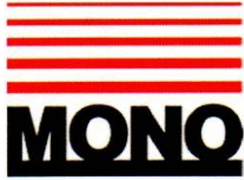
IMPORTANT INFORMATION and INSTALLATION INSTRUCTIONS

MONO EQUIPMENT
Queensway
Swansea West Industrial Estate
Swansea. SA5 4EB UK

Tel. +44(0)1792 561234
email: spares@monoequip.com
Spares Tel. +44(0)1792 564039
Fax. 01792 561016

**COMPLETE OPERATION AND MAINTENANCE INSTRUCTIONS
ARE AVAILABLE ON CD or www.monoequip.com**


FILE 16



DECLARATION OF CONFORMITY

We hereby declare that this machine complies with the essential health and safety requirements of :-

- The Machinery Directive 2006 / 42 / EC
- The Low voltage Directive 2014 / 35/ EC
- The requirements of the Electromagnetic Compatibility Directive 2004 / 108EC, 91 / 263 / EEC, 92 / 31 / EEC
Incorporating standards
EN55014-1:2006+A1:2009+A2:2011
EN55014-2:1997+A1:2001+A2:2008
- The General Safety of Machinery and food processing Standards applicable
- Materials and Articles intended to come into contact with food
Regulation (EC) No. 1935 / 2004

Signed	
G.A.Williams – Quality Manager	

Date	
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Machine FG Code.		Machine Serial No.	
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A technical construction file for this machine is retained at the following address:

MONO EQUIPMENT
Queensway,
Swansea West Industrial Park,
Swansea
SA5 4EB
UK

MONO EQUIPMENT is a business name of **AFE GROUP Ltd**
Registered in England No.3872673 VAT registration No.923428136

Registered office: Unit 9, Bryggen Road,
North Lynn Industrial Estate,
Kings Lynn,
Norfolk,
PE30 2HZ

**Thank you for purchasing the MONO TWIN MOULDER.
A combination of clean industrial design and the latest technology.
The following information should get your purchase running without any problems**

If you have a problem with your purchase please contact MONO EQUIPMENT at:

**MONO EQUIPMENT
Queensway
Swansea West Industrial Estate
Swansea. SA5 4EB UK
Tel. +44(0)1792 561234**

SAFETY

- 1** Never use a machine in a faulty condition and always report any damage.
- 2** No-one under the age of 16 may operate this machine.
- 3** No-one under the age of 18 may clean this machine under any circumstances.
- 4** Only trained personnel may remove any part from this machine that requires a tool to do so.
- 5** Always ensure hands are dry before touching any electrical appliance (including cable, switch and plug).
- 6** All operatives must be fully trained.
- 7** People undergoing training on the machine must be under direct supervision.
- 8** Do not operate the machine with any panels removed.
- 9** All guards must be fixed in place with bolts or screws unless protected by a safety switch.
- 10** No loose clothing or jewellery to be worn while operating the machine.
- 11** Switch off power at the mains isolator when machine is not in use and before carrying out any cleaning or maintenance.
- 12** The Bakery Manager or the Bakery Supervisor must carry out daily safety checks on the machine.

MODIFIED MONO MULTI MOULDER

Current MONO Multi Moulders are fitted with additional safety interlocks on the top cleaning cover and back guard. The moulder will not start unless these guards are properly located and the safety interlocks are correctly engaged.

An additional emergency stop button has been fitted at the front of the machine. If the emergency stop button is used the moulder will not restart until the stop button is released by pushing and turning.

**ALL CLEANING AND MAINTENANCE OPERATIONS MUST BE MADE WITH MACHINE
DISCONNECTED FROM THE POWER SUPPLY**

INSTALLATION

- 1 The Multi Moulder should be connected to a mains wall isolator.
- 2 When installing machines with 3 phase electrics check :-
At the discharge end of the machine the upper belt surface should travel back into the machine - see *direction of arrow in photograph*.
If belt direction is incorrect, change round any two of the three phase wires in the plug and check travel again.

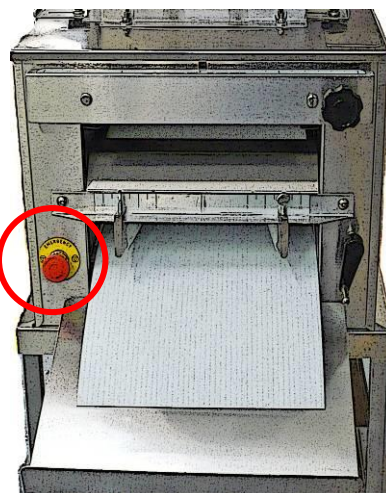


CHECK THE DIRECTION OF THE
MOULDING BELT TRAVEL
BEFORE COMMENCING
PRODUCTION

- 3 Ensure the moulder is standing on a solid level floor

ISOLATION

To stop the multi moulder in an emergency, switch off at the wall isolator or at the machine's emergency stop button.

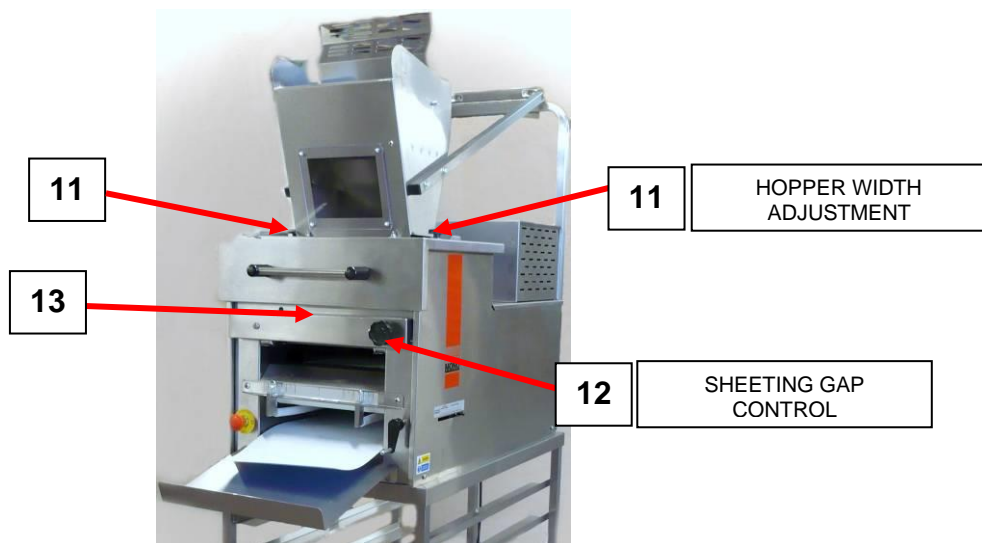


OPERATING INSTRUCTIONS

- A. Primary Adjustments
- B. Sheeting Gap
- C. Moulding pressure
- D. Starting

A. PRIMARY ADJUSTMENTS

1. Adjust the hopper width to the size of dough piece to be used by adjusting the hopper cheeks evenly around the machine's centre line, using wing bolts (11).



B. SHEETING GAP.

The sheeting roll gap can be set to the required width using the adjusting handle (12). The setting of the sheeting roll gap is shown on the indicator (13) across the front cover.



SHEETING ROLL GAP INDICATOR (13) ON FRONT OF MACHINE

If the sheeting gap is too small-- this will result in **torn edges** to the dough pieces.

If the sheeting gap is too large-- this will result in **poor curling** of the dough pieces.

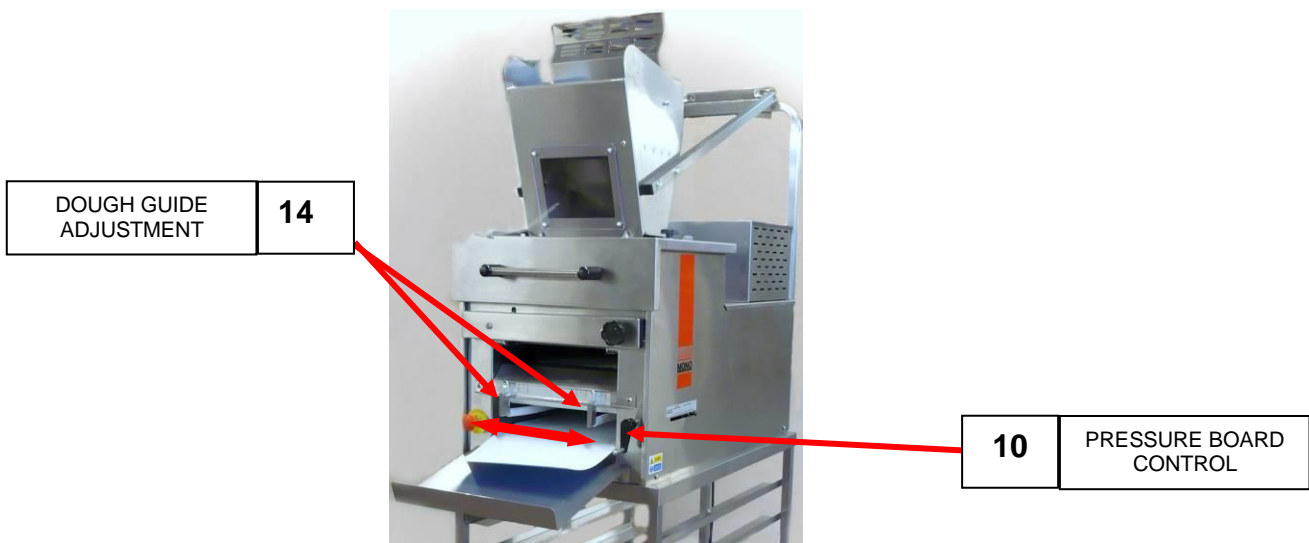
SUGGESTED SHEETING ROLL SETTINGS	
FINISHED LOAF	ROLL GAP SETTING
400 grms	No.5
800 grms	No.6

C. MOULDING PRESSURE.

The moulding pressure applied to the dough pieces is adjusted by raising the pressure board (to increase pressure) or lowering it (to decrease pressure). This is done by adjusting the pressure board adjusting handle (10).

If the ends of the moulded piece are torn it indicates too great a pressure. Adjust accordingly by lowering the pressure board - turning the adjusting handle (10) anti-clockwise.

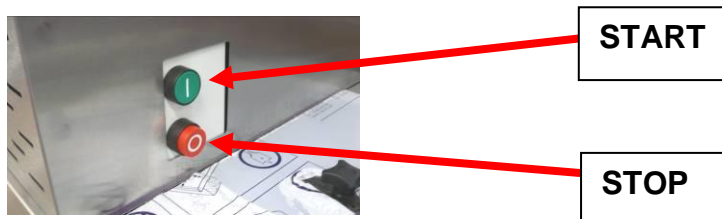
Insufficient pressure will result in a poor seal of the dough piece; rectify this by raising the pressure board by turning the adjusting handle (10) clockwise.



The pressure board dough guides (14) are adjusted by means of the guide clamps. The length of the dough piece required determines the width at which the dough guides are set. It should be noted that the dough guides and pressure board adjustments are relative to each other and should be adjusted accordingly.

D. STARTING

Ensure moulder is set up and adequate tins and trays are available before starting
Start the moulder by pressing the green button on the motor cover behind the hopper.



If the moulder does not start check:-

- 1 Check that the **power supply** is switched on.
- 2 Check that the **hopper door** is closed.
- 3 Check that all **safety interlocks** are properly engaged on the machine guards and covers.
- 4 Check that the **emergency stop** buttons are released. (Twist to release)

If machine still does not run call Mono Service Department.

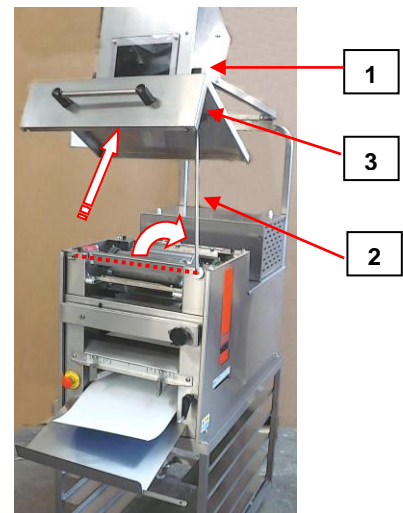
CLEANING INSTRUCTIONS

NOTE:- SWITCH OFF AND ISOLATE FROM THE MAINS SUPPLY BEFORE COMMENCING ANY CLEANING.

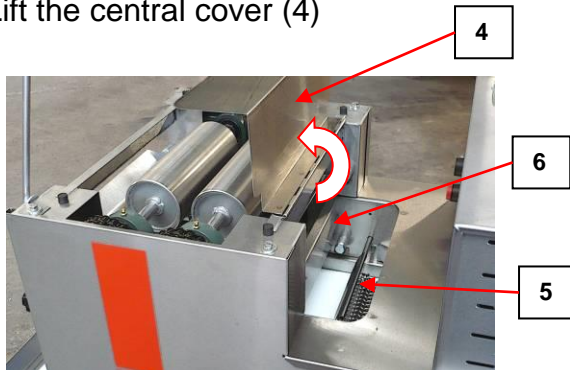
DAILY CLEANING

- 1 Scrape off any dough residue with a plastic scraper.
- 2 Wipe over clear window on hopper with cloth dampened in approved sterilising solution and hot water.

- 3 Lift hopper / top sheet assembly (1) and support with prop bar (2). Ensure that the bar is fully inserted in the holding tube (3).
BEWARE THAT THE TOP SHEET ASSEMBLY IS HEAVY.

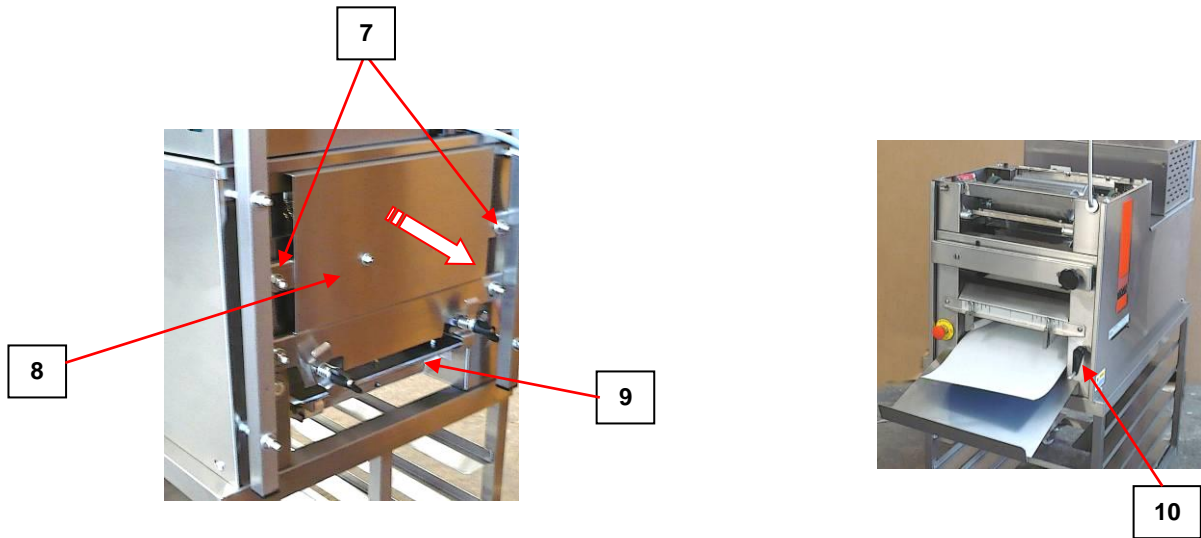


- 4 Lift the central cover (4)



- 5 Lift out curling chain (5) and shake off any dough residue, then brush with a stiff nylon brush. **DO NOT WASH.**
- 6 Replace chain.
- 7 Unclip and wipe scrapers (6) clean. **DO NOT WASH.** Smear edges with vegetable oil.
- 8 Scrape rollers with a **plastic scraper** and remove any debris around roller edges.
- 9 Replace scrapers.

- 10 Unscrew rear panel nuts (7) using a spanner and remove rear panel (8). Clean belting on panel and remove any debris from around belt edges on machine.
- 11 Replace rear panel ensuring belting is correctly positioned before tightening nuts (7).



- 12 Remove pressure board (9) by winding handle (10) to move the board to its lowest position. Lift it out of its slots and slide the board out from the front of machine. Wash board in solution of sterilising solution and hot water. Dry thoroughly and replace.
- 13 Close central cover and top assembly. BEWARE THIS IS HEAVY.
- 14 Scrape dough belt with a **plastic scraper**. **DO NOT USE A METAL SCRAPER.** The belt will have to be inched forward by turning the machine on and off to gain access to all parts of the surface.
- 15 Brush down external surfaces of machine and clean with sterilising solution and hot water. Pay particular attention to handles, levers and controls.