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Enter **Serial No.** here. \_\_\_\_\_

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

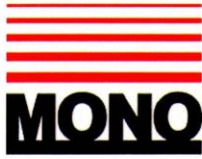


**SET UP AND OPERATION INSTRUCTIONS**

**METRO MOULDER**

**FILE 22**

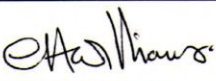
**Failure to adhere to the cleaning and maintenance instructions  
detailed in this booklet could affect the warranty of this  
machine**



## **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 2006 / 95 / EC
- The requirements of the Electromagnetic Compatibility Directive 2004 / 108EC, 91 / 263 / EEC, 92 / 31 / EEC
- 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
- Good manufacturing practice for Materials intended to come into contact with food - Regulation (EC) No. 2023 / 2006

<b>Signed</b>	
G.A.Williams – Quality Manager	

<b>Date</b>	
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<b>Machine FG Code.</b>		<b>Machine Serial No.</b>	
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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 35,  
Bryggen Road,  
North Lynn Industrial Estate,  
Kings Lynn Norfolk,  
PE30 2HZ

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# 1.0 INTRODUCTION

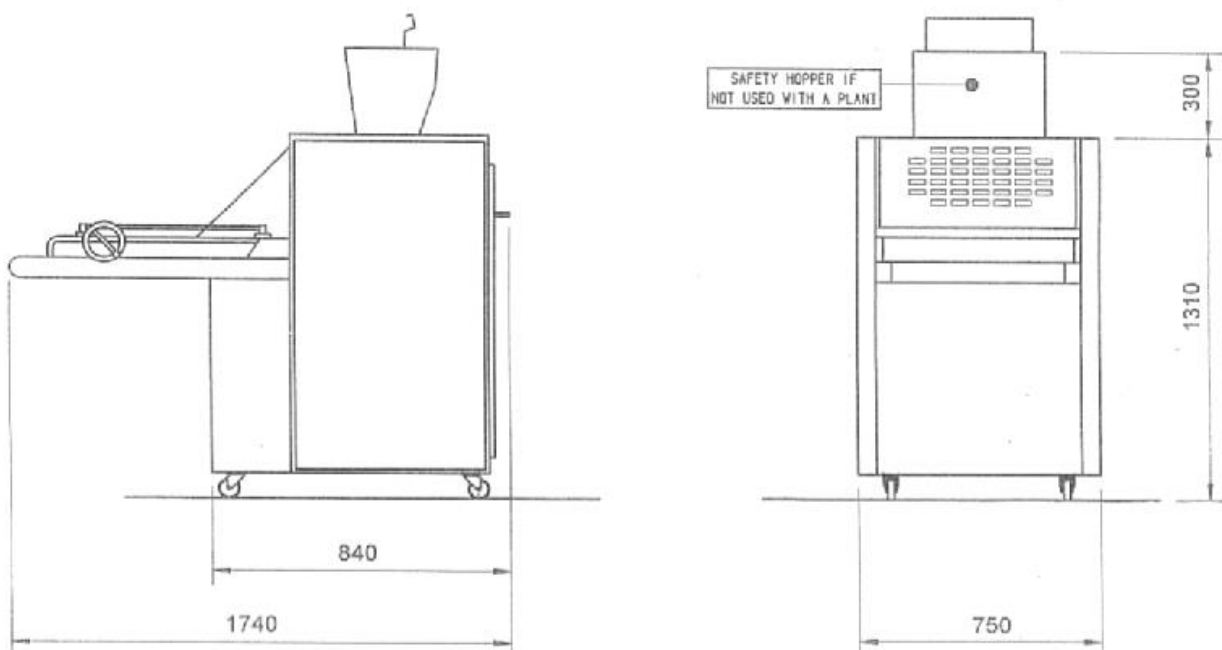
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The metro moulder has been designed with reliability and ease of operation in mind. Fully interlocked guards and covers ensure that semi skilled personnel can safely operate this versatile machine, which has a maximum output of 1200 dough pieces an hour.

The double sheeting rolls give a gentle two stage reduction of the dough and two curling chains give greatly improved consistency of shape and size to the moulded dough piece. Windows at the front and rear of the machine allow the operator to monitor the progress of the dough right through the moulder.

# 2.0 DIMENSIONS

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<b>HEIGHT</b>	<b>1310mm (WITHOUT HOPPER)</b>
<b>WIDTH</b>	<b>750mm</b>
<b>LENGTH</b>	<b>1740mm</b>

## 3.0 SPECIFICATIONS

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**CAPACITY:** Dough piece weight range – 56grms to 1.8Kg – (2oz to 4lbs)

**OUTPUT:** Up to 1200 pieces per hour

**POWER:** 0.75kW, 3 phase and neutral

**WEIGHT:** 230kg (507lbs)

**NOISE LEVEL:** Less than 85dB

## 4.0 SAFETY

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- 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 pressure board adjusting handle, side guide adjuster handle and dough sheet roller gap lever may be adjusted while the machine is running.

**ALL OTHER CLEANING AND MAINTENANCE OPERATIONS MUST BE MADE  
WITH MACHINE DISCONNECTED FROM THE POWER SUPPLY  
DO NOT ATTEMPT TO CLEAN THE MOULDING BELT  
WHEN THE MACHINE IS RUNNING**

- 13 The Bakery Manager or the Bakery Supervisor must carry out daily safety checks on the machine.

### **WARNING:**

Hand or bodily contact with moving belt surfaces may cause friction burns to skin.  
This situation need not occur to successfully operate the moulder

## 5.0 INSTALLATION

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- 1 The Metro moulder should be connected to a mains wall isolator or the correct socket on a breadplant.
- 2 Check the machine after installation to ensure the conveyor belt runs in the right direction (see direction of arrow below). This should be done by “inching” the motor.  
If the motor rotation is incorrect transpose any two wires of the three phase carrying wires.



- 3 Ensure the machine is standing on a solid level floor.

**Note**

The Metro will only work if connected to a breadplant or a safety hopper is fitted.



## 6.0 ISOLATION

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In an emergency, switch off the machine at the wall isolator or at the emergency stop button shown below.



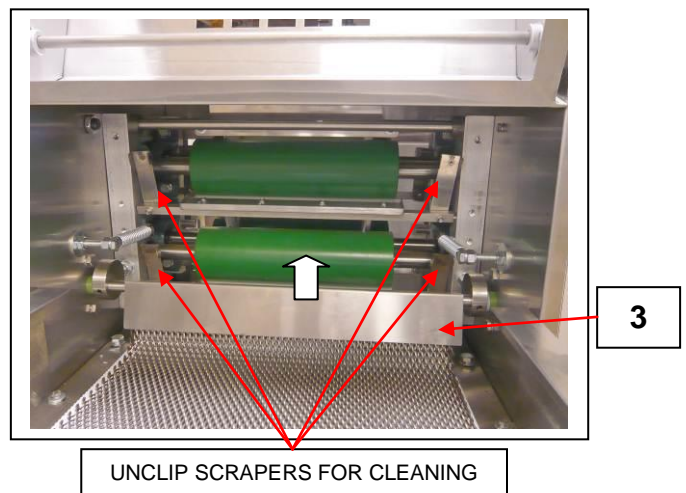
To release stop button after use, twist and release.

## 7.0 CLEANING

**SWITCH OFF AND ISOLATE MACHINE FROM MAINS SUPPLY BEFORE COMMENCING CLEANING**

### DAILY CLEANING (DO NOT USE A PRESSURE WASHER)

1. Remove hopper (if fitted) or pull machine away from prover.
2. Scrape off any dough residue.
3. If a hopper is fitted, wipe over the plastic window with a soft cloth dampened in a sterilising solution and hot water.
4. Replace hopper where applicable.

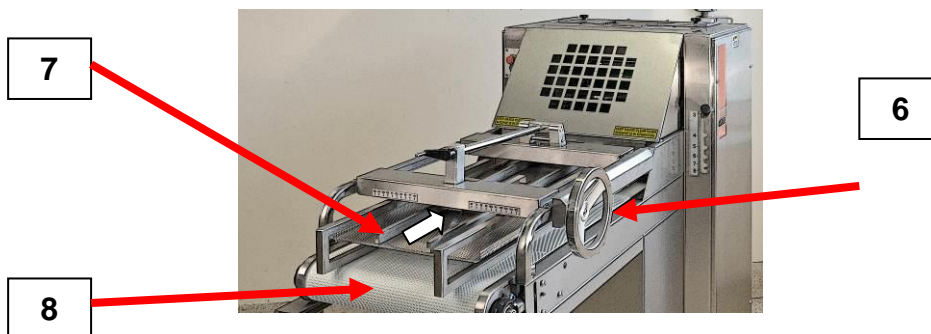


5. Raise front-hinged cover (2).
6. Lift out curling chain (3) and shake off any dough residue, then brush with a stiff nylon brush. **\*\*\*DO NOT WASH\*\*\***
7. Replace chain.
8. Unclip the scrapers and wipe clean (see photo above). **\*\*\*DO NOT WASH\*\*\***  
Smear edges with vegetable oil.
9. Scrape rollers with a **plastic** scraper and remove any debris from the roller edges.
10. Replace scrapers and close front cover.

11. Unclip and lower the rear window (5)



12. Unclip and wipe the rear scrapers  
\*\*\***DO NOT WASH**\*\*\*  
Smear edges with vegetable oil.
13. Scrape rollers with a **plastic** scraper and remove any debris from the roller edges.
14. Replace scrapers. Raise rear window. Wipe over plastic window, with soft cloth dampened in a sterilising solution and hot water.
15. Open dough guides to maximum width by turning wheel (6).  
Push pressure board (7) towards the main body, then withdraw.



16. Wash pressure board in sterilising solution and hot water, then dry and replace.
17. Scrape dough belt (8) with a **plastic scraper**.

**DO NOT USE METAL SCRAPER OR ATTEMPT TO CLEAN WITH WATER. BELT WILL NEED TO BE INCHED FORWARD TO GAIN ACCESS TO ALL PARTS OF SURFACE. SEE SAFETY INSTRUCTIONS.**

18. Brush down external surface of machine to loosen any dough remaining.
19. Spot clean with cloth and sterilising solution and hot water paying particular attention to handles, levers and controls.

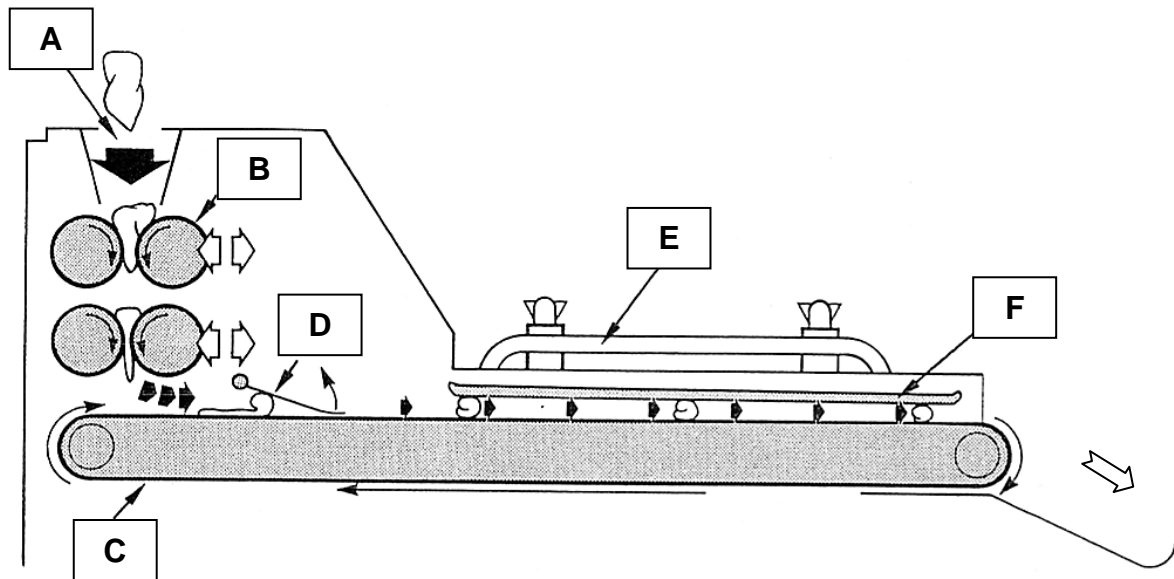
## **WEEKLY CLEANING**

### **SWITCH OFF AND ISOLATE MACHINE FROM MAINS SUPPLY BEFORE COMMENCING CLEANING**

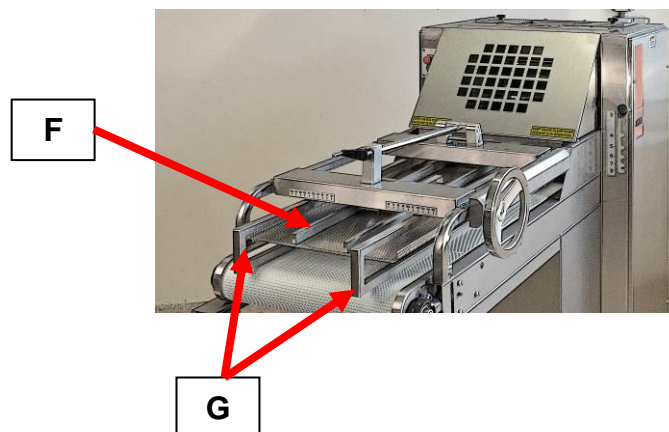
1. Follow the daily cleaning instructions 1 - 14 in previous section.
2. Remove side and back panels placing screws in a safe place.
3. Brush down framework where accessible to remove excess flour and dough.
4. Wipe down with a damp cloth and sterilising fluid and hot water.
5. Replace panels ensuring all screws are accounted for.
6. Follow the daily cleaning instructions 15 - 19 in previous section.
7. Scrape and scrub wheels clean as needed.

# 8.0 OPERATING INSTRUCTIONS

## HOW THE METRO MOULDS DOUGH PIECES



- ☐ Dough piece is feed into hopper (A) from intermediate prover or safety hopper.
- ☐ Twin sets of rollers (B) form a sheet of dough.
- ☐ This is carried along the off take conveyor (C) to the curling chain (D).
- ☐ The curling chain then picks up the leading edge of the dough sheet and forms a curled roll of dough.
- ☐ This is then carried to the pressure module (E) in which it is moulded. Its final shape and consistency are determined by the pressure board (F) and the side guides (G) positions.
- ☐ The finished dough pieces are conveyed to the collection tray.



# OPERATING THE METRO MOULDER

To ensure the best mould, make sure that the moulder is free of any previous dough used and set the following adjustments.

- a. Hopper width. (move cheeks(15) to required width).
- b. Sheeting gap. (move lever (16))
- c. Side guides position.(turn wheel (6) to adjust pressure board width)
- d. Moulding pressure.(turn handle (17) to adjust pressure board height)

MOULDER ADJUSTMENTS CHART				
DOUGH PIECE WEIGHT	HOPPER CHEEK SETTING	SHEETING ROLL GAP SETTING	PRESSURE BOARD WIDTH	PRESSURE BOARD HEIGHT SETTING
900g	1	4	10	10
450g	5	6	8	6
225g	6	6	10.5	6

## a. HOPPER WIDTH ADJUSTMENT.

1. Slacken wing bolts (14) and slid the hopper cheeks (15) to the required setting. *See chart above for suggested settings.*
2. Hand-tighten wing bolts and go on to the next adjustment.





**b. SHEETING GAP ADJUSTMENT.**

1. Move roller gap lever (16) to required setting.  
*See chart for suggested settings.*



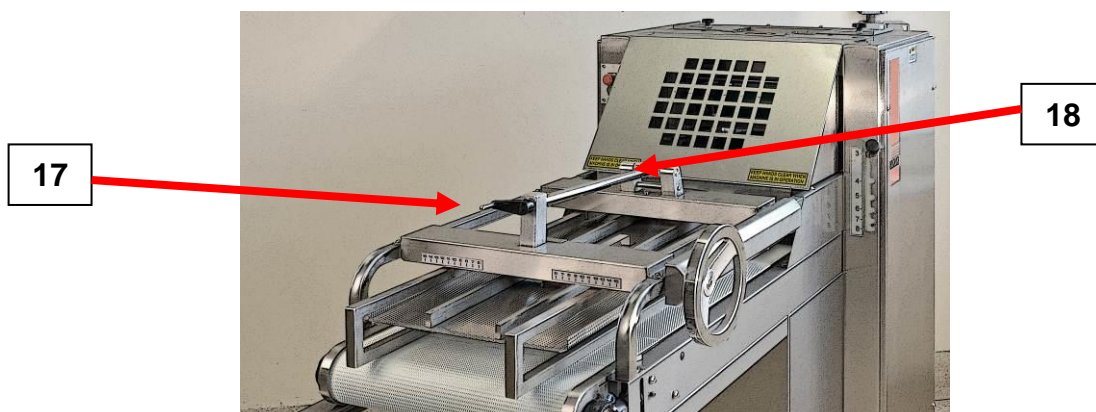
**c. SIDE GUIDES ADJUSTMENT.**

1. Turn wheel (6) to required setting.  
*See chart for suggested settings.*
- 

**d. MOULDING PRESSURE ADJUSTMENT.**

1. The pressure board height is adjusted by turning the adjusting handle (17).

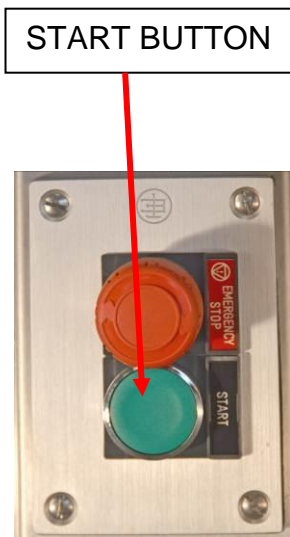
*To ensure the moulding pressure can be exactly reproduced at a later date, the adjusting handle shaft is graduated (18).*



## STARTING THE METRO

- Before starting ensure the metro has been adjusted for the product mould required. (See previous section.)
- If using in conjunction with a prover make sure that the eight minute pocket is open.
- Do not allow dough pieces to “skin” as this will result in the dough pieces catching each other up, “doubling”, and could cause a jam.

**To start the machine press the green button** found either on the main body next to the stop switch or, if used with a prover, on the front of the off take conveyor right hand side.



START BUTTON  
WHEN USED  
WITH A  
PROVER

If used with a prover always start the moulder before the prover or a build up of dough could clog the moulder hopper



## 9.0 TROUBLE SHOOTING ---

### **MOULDER WILL NOT START**

- ☐ Is power supply switched on?
  - ☐ Is stop button released?  
(twist to release)
  - ☐ Are all covers and doors closed?
  - ☐ When used with a prover, is machine in the correct position under the conveyor?
- 

### **DOUGH PIECES DOUBLE UP**

- ☐ Dough has been allowed to “skin” (left too long proving).
  - ☐ Hopper setting incorrect. (Increase gap)
- 

### **DOUGH PIECES TEARING**

- ☐ Pressure board (7) too low.
- ☐ Sheeting gap too small

## 10.0 SERVICE AND SPARES ---

If a fault arises, please do not hesitate to contact the  
Customer Service Department, quoting the **machine serial number**  
on the silver information plate of the machine and on the front cover of this manual

**MONO**

Queensway

Swansea West Industrial Estate

Swansea.

SA5 4EB

UK

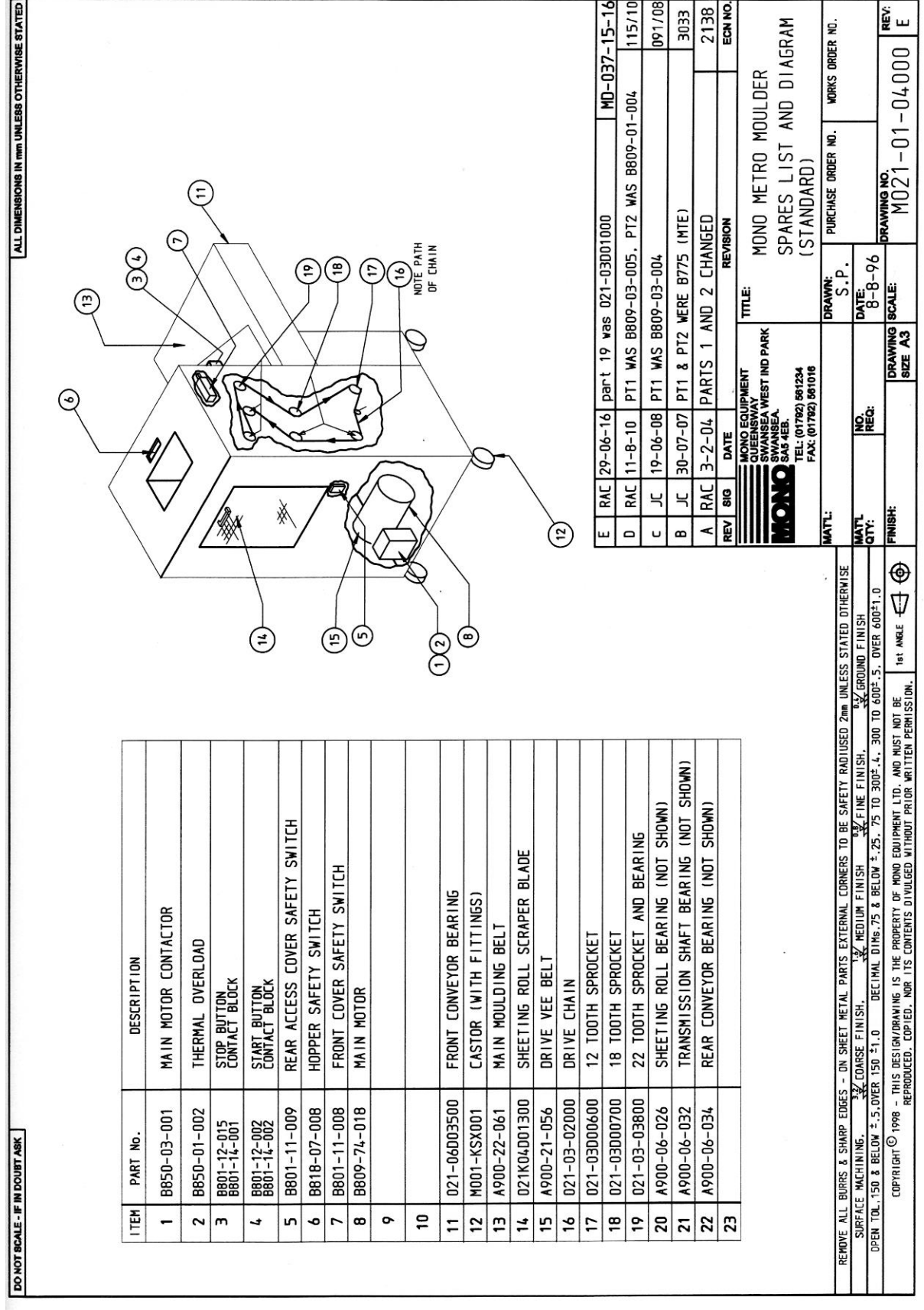
**email: [spares@monoequip.com](mailto:spares@monoequip.com)**

**Spares Tel. +44(0)1792 564039**

**Web site: [www.monoequip.com](http://www.monoequip.com)**

**Main Tel. 01792 561234**

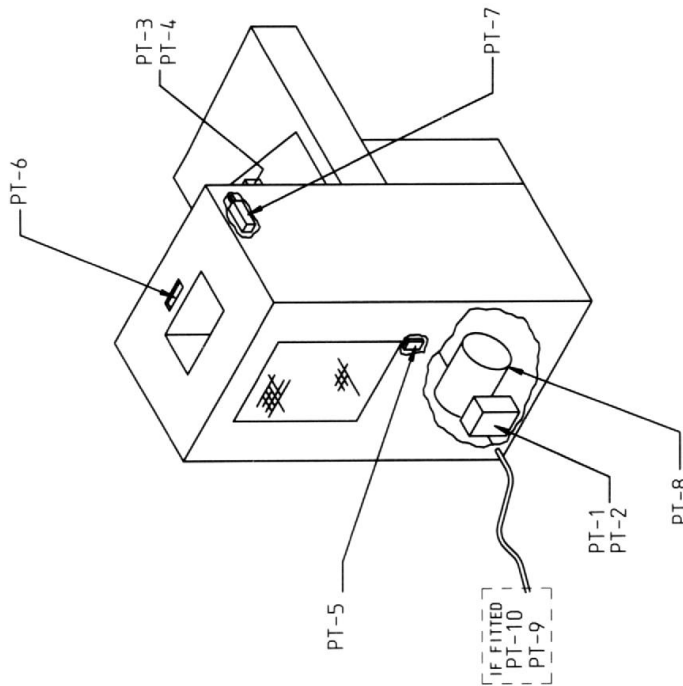
**Fax. +44(0)1792 561016**






## 11.0 ELECTRICAL INFORMATION

IF IN ANY DOUBT - ASK



DRAWING		DESCRIPTION		MONO	
PT-Ref				PART NUMBER	
PT-1	MAIN MOTOR CONTACTOR			8824-08-002	
PT-2	MAIN MOTOR THERMAL OVERLOAD		UP TO 01-04	8824-01-003	
PT-3	MAIN MOTOR CONTACTOR			8809-03-005	
PT-3a	MAIN MOTOR THERMAL OVERLOAD			8809-01-004	
PT-3b	REMOTE STOP BUTTON			8801-12-015	
PT-3c	REMOTE STOP BUTTON CONTACT BLOCK			8801-14-001	
PT-4	"STOP" LEGEND			8801-15-003	
PT-4a	REMOTE START BUTTON			8801-12-002	
PT-4b	REMOTE START BUTTON CONTACT BUTTON			8801-14-002	
PT-4c	"START" LEGEND			8801-15-002	
PT-5	REAR ACCESS COVER SAFETY SWITCH			8801-11-009	
PT-6	HOPPER SAFETY SWITCH			8818-07-008	
PT-7	FRONT COVER SAFETY SWITCH			8801-11-008	
PT-8	MAIN MOTOR			8809-74-018	
PT-9	MAINS PLUG (IF FITTED)			8814-25-001	
PT-10	MAINS PLUG FUSE (IF FITTED)			8883-85-001	

F	JC	19-06-08	PT1 WAS 8809-03-004		091/08
E	JC	30-07-07	PT1 & PT2 WERE 8775 (MTE)		3033
D	RAC	3-2-04	PARTS 1 AND 2 CHANGED		2138
C	JC	11-1-99	PARTS LIST REVISED		08/55
B	SP	13-3-96	NEW MTE STARTER. (PARTS LIST REVISED)		6097
A	SP	12-1-95	PICTORIAL CORRECTIONS		
REV	SIG	DATE	REVISION		ECN NO.
			TITLE:		
MONO EQUIPMENT CURRYWAY SWANSEA WEST IND PARK SWANSEA SA5 4EB. TEL: (01782) 881224 FAX: (01782) 881018			METRO MOULDER COMPONENTS LAYOUT		
ELECTRICAL SPECIFICATIONS:-			DRAWN:		
415V 3PH N 50HZ			SP/JC		
			ELECTRICALLY APPROVED BY:-		
			DATE:		
			24-5-96		
			DRAWING NO.		
			M021E25-00500		
			SHEET 1 OF 2		
			REV:		
			F		

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Queensway  
Swansea West Industrial Estate  
Swansea. SA5 4EB UK

Spares Tel. +44(0)1792 564039

Tel. +44(0)1792 561234

Fax. +44(0)1792 561016

Web site: [www.monoequip.com](http://www.monoequip.com)

**❑ DISPOSAL**

**CARE SHOULD BE TAKEN WHEN THE MACHINE COMES TO THE END OF ITS WORKING LIFE.  
ALL PARTS SHOULD BE DISPOSED OF IN THE APPROPRIATE PLACE, EITHER BY RECYCLING  
OR OTHER MEANS OF DISPOSAL THAT COMPLIES WITH LOCAL REGULATIONS.  
(IN UK, ENVIRONMENTAL PROTECTION ACT 1990 APPLIES)**