DRIVEN PNEUMATIC MINCE MEAT PORTIONING MACHINE

Mod. PNT

CM
Machine Services

GASER

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3. HYGIENE CERTIFICATE

We declare the machine:

Brand: GASER
Type: Portioning machine
Model: PNT
Serial no.
Year of construction:

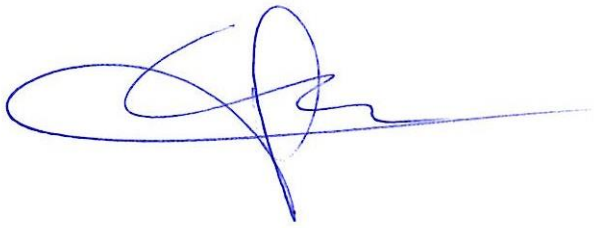
Is in conformity with the following regulations:

Regulation (EC) 1935/2004**,** materials and articles in contact with food, repealing Directives 80/590/EEC and 89/109/EEC.

This means that all of the types of steel and plastic from which the machine is constructed and which are in contact with the meat comply with the hygiene rules and regulations in force.

* Plastic material: polyethylene terephthalate (PETP), white, density 1.37 g/cm^3,
Manufactured in accordance with DIN 50014.
* Stainless steel: AISI 304, manufactured in accordance with European regulations EN-10088,
Chemical composition: C≤0.07% Si≤0.75% Mn≤2% Cr=18-19% Ni = 8-10 %

Salt,



CARLOS GARGANTA SERRAMITJA
TECHNICAL DIRECTOR INDUSTRIAS GASER S.L.

4. INTRODUCTION

Before using or handling the machine, you must read this manual carefully.
The instructions in this document are, whenever possible, accompanied by illustrations to help with understanding of how to start, use and clean the machine.

This manual is subject to amendment.

4.1 Safety

The machine has been designed for use with food products and must be used in the way described in this manual. Any use other than the specified one will involve risk for the user and for the machine. INDUSTRIAS GASER S.L. accepts no liability either for damage to the machine or personal injury or injury to third parties that this use might cause.

This machine includes moving parts and mechanisms that could be a risk to the user's health. To ensure users are protected, the machine includes safety features that must be appropriately used and maintained, in accordance with the instructions in this manual.

Making any change or modification to the machine without the prior written permission of our technical department is forbidden. Use of the machine in these conditions could cause accidents, in the event of which INDUSTRIAS GASER S.L. will accept no liability for improper use of the machine.

4.2 Hygiene

All of the materials used in the manufacture of the machine, which come into contact with food comply with Regulation 1935/2004. Consequently, the machine has the CE mark.

Use of detergents containing chlorine, its derivatives or any other product that might damage the construction materials of the machine is not recommended.

5. TECHNICAL SPECIFICATIONS

1. It connects to any filler or mincer up to an outlet diameter of Ø120mm.
2. Produces up to 300 kg/h, depending on the device supplying the portioning machine and the type of mixture.
3. Uses paper on spools
4. Portion weight up to 900 grams
5. Automatic paper cutting and positioning
6. Adjustable portion length and shape
7. Pneumatic operation at 6 bar (kg/cm^2)
8. Air consumption: 100 litres/minute
9. Electrical power: 200W
10. Electric current 230V, 50/60Hz
11. Dimensions: 1,050 × 580 × 950* mm (adjustable height)
12. Weight: 70kg
13. Made from Stainless Steel
14. Noise: acoustic pressure under 70dB (A)

6. RECEIPT AND START-UP

6.1 Receipt

When you receive the machine, you must first check that it is in perfect conditions, without any damage, dents or knocks.
If there is any problem, we advise you to notify the distributor or INDUSTRIAS GASER S.L. directly.

6.2 Transport and maintenance

The machine can be moved using lifting devices suitable for its weight (70 kg) such as a pallet truck or a forklift truck to place it on the corresponding support.

To move the machine, follow these steps:
1. Check the power supply is disconnected.
2. Ensure passageways and the unloading location are clear.
3. Keep the machine in its horizontal operational position at all times when making the necessary movements.

6.3 Installation

6.3.1. Environmental conditions

The environmental conditions for the correct operation of the machine are determined by its electronic equipment.

Temperature: 5 to 50 °C
Humidity: 30 to 90% without condensation

6.3.2. Location and levelling

The space needed to locate the machine must include enough space to do its work and to view the machine's indicators, as well as for carrying out maintenance work and foreseeable repairs.

Locate the machine on a completely flat surface and at a height that makes it possible to work with the machine in an appropriate way, using the height adjustment in its feet if necessary.

6.3.3. Connections

The user is solely responsible for protection against insulation flaws, short circuits and overloading of connections that might happen upstream of the machine's terminal block.

Before making the machine's external connection, it is necessary to check the characteristics of the installation's protection features (differential protection) and the cross section of the power supply cables to the machine's terminal block, depending on the maximum intensity of use corresponding to the maximum power absorbed stated in this manual, to ensure people and property are protected.

The connection to make simply involves connecting the plug to the supply (230V, 50Hz).

The DPPM model must be connected to a compressed air supply. Its working pressure is 6 bar (kg/cm^2). This pressure must be constant.

6.4 Start-up

WARNING: DO NOT ADJUST THE MACHINE WHEN IT IS RUNNING. THE MACHINE MUST BE DISCONNECTED FROM THE ELECTRICITY SUPPLY AND COMPRESSED AIR NETWORK BEFORE MAKING ADJUSTMENTS TO IT.

1. The portioning machine can be supplied by a piston filler, continuous filler or mincer. In each case, a different support is used so it can work, depending on the height of the device supplying the portioning machine.

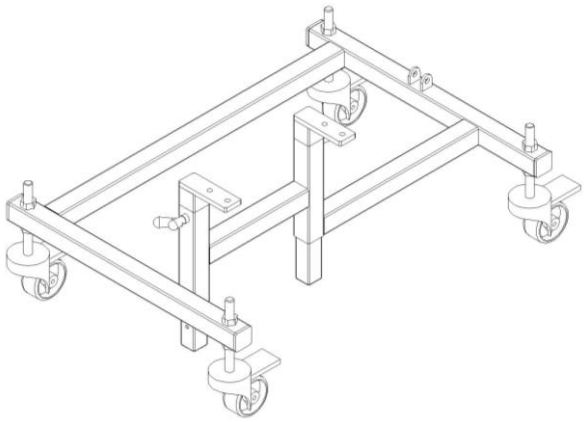


Image 1, Mincer support

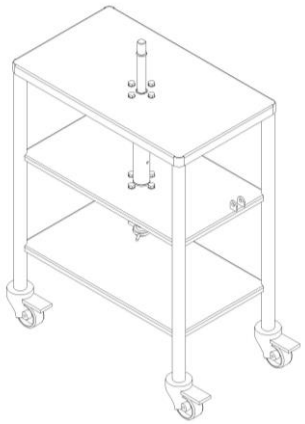


Image 2, Filler support

Each support is height adjustable.

The support for working with mincers allows heights (to the centre of the nozzle) of between 527 and 764 mm. It is adjusted using the shafts that support the wheels (Pos. 3, Adjustable mincer base overview) and the telescopic structure (Pos. 6 and 7, Adjustable mincer base overview) attached to the chassis base.

The filler support allows heights (to the centre of the nozzle) of between 1060 and 1260 mm and is adjusted using the nut (Pos. 8, Adjustable filler base overview) which is below the second level of the table.

2. If working with a piston filler, load it with the mixture to be used (packing it down slightly, to ensure that there are no large air pockets in the mixture if it is a piston filler).

   The filler lever is fixed almost mechanically; there should never be anyone pulling on this lever. The mixture exit velocity is controlled using the control included on all fillers.

3. If working with a continuous filler, connect it to the portioning machine using the continuous filler connector (Pos. 11, Installation overview)

4. If using a mincer to supply the portioning machine, you must make sure it has a constant and uniform mixture outflow at any speed.

5. Before starting operation, fit the nozzle or ramp you want to use.
   - 5.1 Fit the nozzle to the machine that supplies the portioning machine.
   - 5.2 Lift the cover (Pos. 2, general overview)
   - 5.3 Bring the portioning machine up to the outlet from the nozzle so that the nozzle points at the inlet belt (Pos. 35, Blade overview).
     - 5.3.1 If you want “Free-flow” production, do not attach a nozzle. Just attach the ramp intended for this purpose.
   - 5.4 Fit the safety detector (Pos. 47, Overview) so that the white plastic part is touching the chassis.
   - 5.5 Fit the knob (Pos. 45, Overview) so that the safety detector is well attached and does not move.
   - 5.6 Close the cover

WARNING: ALL OF THE PROCESS DESCRIBED IN POINT 5 MUST BE DONE WITH THE MACHINE DISCONNECTED FROM THE ELECTRICAL POWER SUPPLY AND FROM THE COMPRESSED AIR NETWORK.

6. Put the paper spool on its support (Pos. 27, Blade overview). It must be located so that the greased part of the paper is on contact with the product.

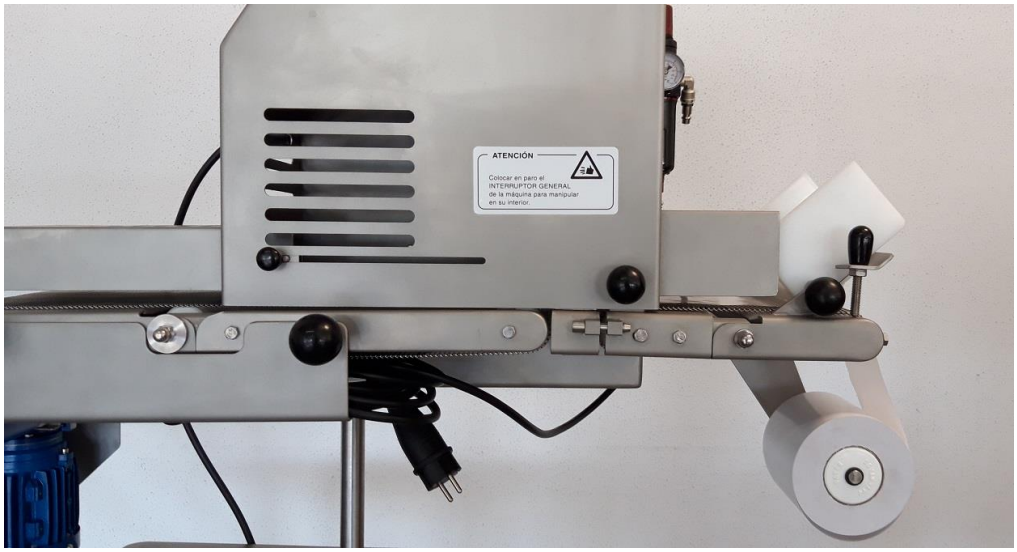


Image 3, Positioning the paper

7. The machine is ready to start production.

6.5 Operation

1. Put the ON-OFF switch (Pos. 6, Installation overview) in the ON position.

2. The blue illuminated reset button will light up (Pos. 1, Installation overview). Pressing this button resets the machine.

3. Using the manual-automatic switch (Pos. 4, Installation overview), select automatic or manual mode according to how you want to work.

   In manual mode, the belts work constantly. To make portion cuts, press the green button (Pos. 3, Installation overview) every time you want to cut a portion.

   In automatic mode, the belts operate the same as in manual mode. Before starting work, ensure the machine is disconnected from all of its supplies and adjust the light sensor units (Pos, Overview) and light sensor mirror (Pos, Overview) as these set the final length of the portion.
   When the emitter and receiver units of the light sensor are correctly adjusted, press the green button (Pos. 3, Installation overview) to start up the machine.

4. Depending on the amount of product the filler or mincer supplies, the speed of the machine's belts (Pos. 7 and 16, Overview) and the piston cutting speed can be adjusted using the control on the electronic panel (Pos. 9, Installation overview).

5. The machine has a stop button (Pos. 3, Installation overview) and an emergency stop button (Pos. 2, Installation overview). If the emergency stop is pressed, the machine must be reset using the blue button for it to work again. This will also happen if you lift the cover (Pos. 2, Overview) or if the safety detector unit is removed (Pos. 47, Blade overview).

WARNING: DO NOT OPEN THE DOOR WHEN THE MACHINE IS RUNNING THE MACHINE MUST BE DISCONNECTED FROM THE ELECTRICITY SUPPLY AND COMPRESSED AIR NETWORK IF YOU WISH TO CARRY OUT WORK ON ITS INTERIOR.

6.6 Notes

1. It is important that when the machine starts production, it is completely clean to ensure it operates properly.

2. The most appropriate mixtures are usually ones kept in the conservation chamber at temperatures between 0 and 4 ºC after being prepared and mixed or ones minced with a cutter if using frozen meat.

3. It is important that the fillers and mincers feeding GASER machines have a steady and uniform mixture outflow at any speed.

4. The mesh bands must be kept tensioned, otherwise they could break. They are tensioned using the tensioning rollers (Pos. 38, Blade overview and Pos. 21, Belt overview).

7. CLEANING

You must clean the machine when you have finished production. To do so, follow the steps below.

1. When all of the mixture has been used, separate the portioning machine from the filler/mincer. Disconnect the portioning machine from the electricity supply and the compressed air supply and separate both machines to clean them separately.

   To separate the machines, first remove the nozzle/ramp from the inlet belt (Pos. 35, Blade overview). Next, remove the nozzle from the machine that supplies the portioning machine.

Image 4, Removing knob

Image 5, Removing safety sensor

2. Remove the paper or cellophane spool and store it in a dry place, ideally somewhere airtight.

3. Lift the cover (Pos. 2, general overview).

Image 6, Opening the cover

WARNING: BEFORE OPENING THE LID, YOU MUST CHECK THE MACHINE IS DISCONNECTED FROM THE ELECTRICAL SUPPLY AND FROM THE COMPRESSED AIR SUPPLY.

4. Remove the conveyor belt (Pos. 16, Overview) using the knobs that hold it (Pos. 12, Belt overview and pos. 9, Conveyor belt overview). The portioning machine must be disconnected before removing the belt.

Image 7, Removing the belt

Image 8, Removing lower knob

Image 9, Removing upper knob

5. Remove the tray support (Pos. 8, Belt overview) using the two remaining knobs (Pos. 12, Belt overview).

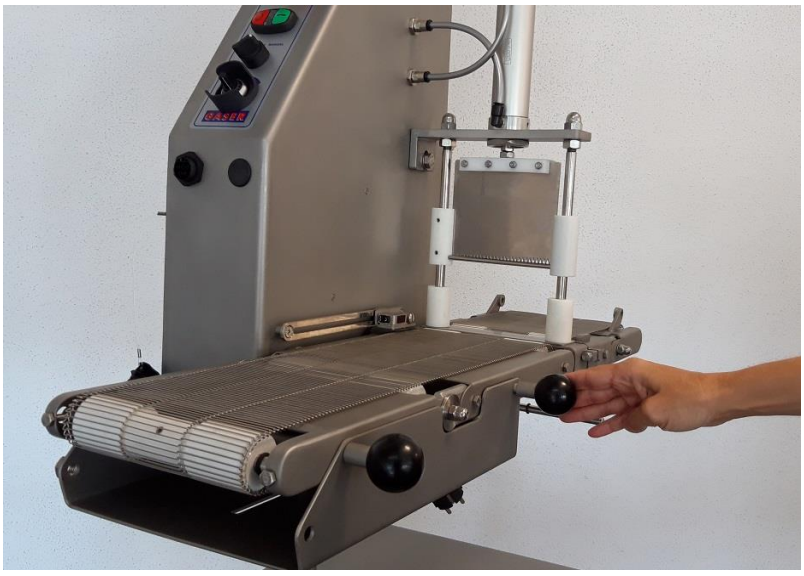


Image 10, Removing knobs

6.Remove the fork pin attachment (Pos. 31, Blade overview) from the blade chassis.

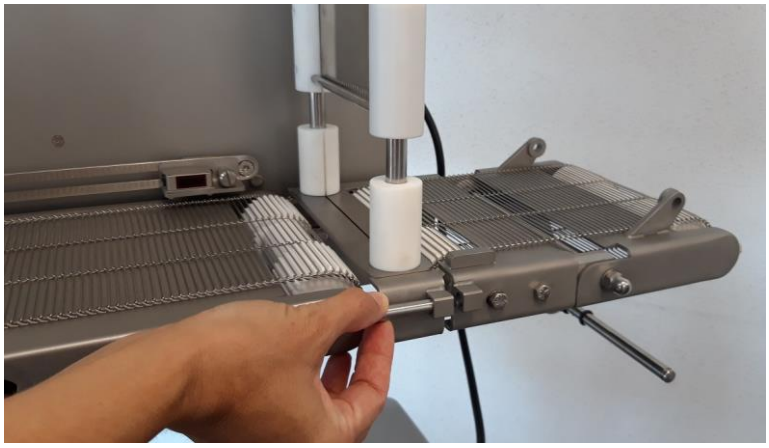


Image 11, Remove fixing shaft

7.Loosen the two metal bands with the folding belts (Pos. 24 Belt overview and Pos. 48, Blade overview) so they can be removed and cleaned separately.

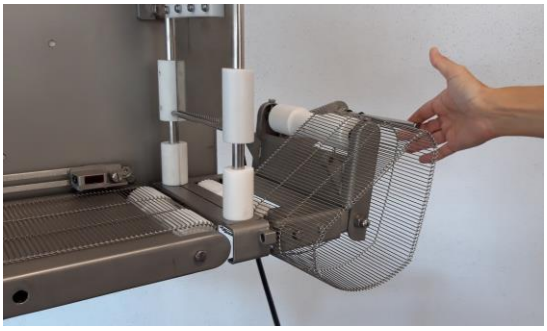


Image 12, Loosening inlet belt

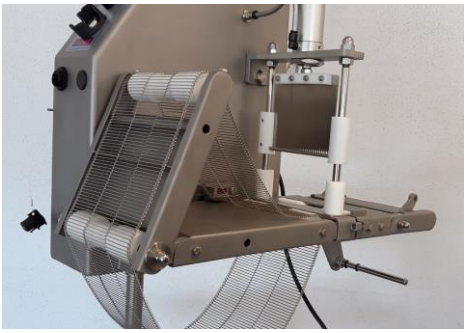


Image 13. Removing outlet belt

8.Remove the nozzle or meat entry ramp and remove all components that do not require the use of tools.

9.The machine is now ready for cleaning. We recommend cleaning it with a damp cloth, otherwise the machine's internal elements could be damaged.

10. Clean the remaining elements separately. Clean plastic parts with water at a temperature not exceeding 40 °C.

8. MAINTENANCE

1. Periodically check the condition of all moving parts: mesh belt, chains, rollers, gears, bearings, and bushes.

2. Periodically check the condition of the geared motor.

3. Periodically check the general condition of the belts.

4. If one of the bars on the mesh belt breaks, replace the broken bar with a new one.

5. Lubricate the gears, drive train, and bearing housings after every 300 hours of work.

6. Lubricate the cylinder rods with food-grade oil after every 100 hours of work.

9. TROUBLESHOOTING

The table below lists problems that might occur with the machine, their potential causes, and how to solve them.

Problem	**Cause**	**Solution**
The machine does not start	Machine unplugged	See section “6.3.3 Connections”
	Blue pilot light on but machine does not reset	Guard open or not properly closed.
		Emergency stop activated
		Safety sensor wrongly positioned or not in place
Machine running, but not making the cut or too slow	No air pressure	See section “6.3.3 Connections”
	Cutting speed badly adjusted	See point 4 in section “6.5 Start-up”
The machine does not reset	Door not closed properly	Close the door properly
	Safety sensor wrongly positioned	Correctly position the sensor
The portions break when they come out of the nozzle.	Insufficient protein in the product	Add protein
	Difference between belt speed and product outlet speed	Correctly adjust the speed of the belt and the device supplying the portioning machine.
	(MICCI) Nozzle incorrectly adjusted	Each outlet hole must be adjusted so that the product comes out of all holes equally.