

**ROLLMATIC S.R.L.**

**BREAD SLICER**

**MR52**

**USE AND MAINTENANCE  
MANUAL**

**ORIGINAL INSTRUCTIONS**



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## 1 INTRODUCTION

### 1.1 INTRODUCTION

This manual contains operating instructions for consultation by anyone who is charged and authorized to use and/or run the machine. It is also intended for employers, for managers and for the people in charge of the work site, who must read it and must understand every part of it, to use it as a valid support to fulfil a part of the obligations which the laws in force attribute to them in matters of safety and health in the workplace. The employer at the work site, the managers, and the people in charge must provide workers, assigned to the specific functions, adequate information, instruction, and training (which must be easy and comprehensible in relation to the reasonably expected aptitude level) with regard to its correct and safe use and to the general and specific risks of the workplace and/or task; comprehension must be verified with specific theoretical and practical testing; this manual may to be a valid support to fulfil such a delicate task, even though, for obvious reasons, it may not be deemed comprehensive for matters not strictly pertinent to the machine itself.

The manual is composed of a number of sections, in particular:

#### **Instructions for moving and installing**

These subjects, for the most part concentrated in Chapter 3, are intended for personnel charged with moving, transporting, installing and first starting up the machine in the operation site. Their purpose is to provide the most important information - excluding any that should already be part of the technical background of an expert and/or professionally-qualified and/or specialized technician - for the purpose of carrying out these operations correctly.

#### **Instructions for use and routine maintenance in compliance with safety requirements**

These subjects, covered mostly in Chapters 2, 3, 5 and part of Chapter 4, are intended for the Employer of the personnel with responsibility for the machine, managers and supervisors of the User Company as well as the machine operators themselves. Apart from instructions on how to use the machine, indications on how to carry out operations related to maintenance, cleaning and routine checks are also provided. Due to their relative simplicity and low risk level, these operations do not require particular experience or professional skills, and can therefore be carried out by the operator normally responsible for running the machine for production purposes.

#### **Instructions for machine extraordinary maintenance**

This subject, covered mostly in the remaining part of Chapter 4, is intended for the Employer of the personnel with responsibility for the machine, managers and supervisors of the User Company, machine operators, and persons charged with carrying out routine and/or extraordinary maintenance on the machine. It includes important safety instructions that must be followed when carrying out maintenance, adjustment and checking operations that, due to their complexity and/or related danger, must be performed by specialized, expert personnel with a professional preparation, who possess all the technical and legal knowledge necessary for carrying out the works properly and safely. Given the prior experience required of the personnel chosen for this type of intervention, all technical instructions are omitted apart from those specifically related to carrying out the tasks safely, given that a person with the required professional profile must be already fully prepared in the other subjects.

**Instructions for disposal and/or dismantling** This subject is dealt with in Chapter 6.

By **use of the machine** is intended the range of activities related to the machine, or reasonably expected to be required for the machine, during its lifetime, connected with its intended use as explicitly stated in this manual.

The term **machine** is used in the following to refer to the product that is the subject of this manual, and for which this manual has been written and consigned to the purchaser to ensure its correct, safe use.

Before carrying out any operation relating to the machine (transportation, installation, connections, technical adjustments, use, repairs, part replacements, dismantling etc.) **read with attention** the general and detailed instructions contained in this manual, in order to understand completely their motivations and meanings, and acquire the knowledge necessary for operating the machine properly, maintaining correctly its parts, and becoming familiar with its safety devices and the residual risks present so that the machine can be run correctly and in safety.

**Preserve** this manual and any other documentation supplied with it (drawings, diagrams, etc.) in a safe place, known to the personnel responsible for use of the machine and/or its maintenance. Store the documentation in a dry place (e.g. in a transparent plastic bag), so that it is safe from atmospheric agents that could, over time, cause it to deteriorate. It is recommended to leave a copy near the machine so that it is available for quick reference by personnel.

**In the case of loss or deterioration, request another copy immediately** from the Manufacturer, specifying the identification data for the machine (year of manufacture, model, serial number etc.).

This manual reflects the state of the technology (i.e. state of the art) that exists at the time the machine enters the market. It therefore cannot be held to be inadequate solely because the machine subsequently undergoes upgrading as a result of innovations, or the availability of new technical solutions.

The Manufacturer cannot be held responsible in any way for the suitability of the site chosen for installation of the machine, and for its support services, although some important indications for correct installation are given in the dedicated section of this manual. The Company reserves the right to update both machines and manuals, without this in any way creating a duty for the Company to update the machines and/or manuals of earlier productions.

#### **WARNING**

**After placing and/or installing the machine in the site intended for operation, and before authorizing or proceeding to put it into operation, make sure that the machine corresponds with that indicated on the purchase order, and that all the devices are present, in particular the safety devices described in this manual and in any promotional material.**

**This manual is an integral part of the machine and must accompany it** in the case of transfer or cession under any terms, even when given away free.

#### **WARNING**

**The machine described in this manual is intended to be used for cutting oven-baked bread in slices of a pre-defined, constant thickness, that does not exceed the dimensions indicated in Section 2.3, and that has properties that allow a clean cut by the stainless steel, serrated blades with alternating motor without any humid residues remaining attached.**

**Only a professional use of the machine is permitted and by personnel who are expert in breadmaking and with adequate training and instruction on how to use the machine safely.**

**Use of the machine is permitted exclusively in closed, protected areas;** under no circumstances must the machine be used outside or in areas where it is exposed to the action of atmospheric agents.

**Use of the machine is not permitted in places open to the public, except for demonstration purposes, and provided that precautions are taken to guarantee the safety of persons involved.**

**Under no circumstances, and for no reason, can the machine be used by private individuals** (shop customers, shopping mall visitors, canteen customers etc.).

**Use of the machine** is not permitted for other purposes and/or products and/or using different methods from those described in this manual.

**Use of the machine is not permitted** unless, beforehand, all connections have been made to the systems serving the installation site as indicated in this manual.

**Use of the machine is not permitted** in environments where there is risk of fire and/or explosion and/or any type of incident considered of importance by current legislation, or that presents high levels of humidity or wetness, where there is excess water vapor and/or oily vapor and/or dust, or the presence of corrosive substances and/or gases.

**Use of the machine is not permitted** in environments subject to vibrations or abnormal jolts.

**For safety, hygiene, health, and warranty reasons, it is absolutely forbidden to use the machine in any way other than described here. Any different use of the machine from that indicated here - even if it could not reasonably be foreseen - is considered improper and non-compliant and is therefore not covered by the Manufacturer, and for this reason constitutes a potential danger to the health and safety of persons exposed, as well as animals and/or things.**

**IMPORTANT!** Before putting the machine into service or using it, the user must read and understand all the instructions and indications given in this manual. Subsequently, when the machine is put into service or used, the Employer at the site of use declares implicitly that they accept all civil and criminal liability resulting from damage to persons, animals and things as a consequence of non-observance, even partial, of these instructions and indications.

## 1.2 GENERAL INSTRUCTIONS AND WARNINGS

The Manufacturer accepts no liability for damage to persons, animals or things caused by failure to observe the instructions contained in this manual and, in particular, the following:

- **Do not tamper** with the machine's guards and safety devices
- **Do not remove** the machine's guards **or deactivate** the safety devices unless actually necessary for certain activities, and given that suitable measures are taken to make the danger evident and reduced to a minimum, as well as the risks resulting from it
- **Put the guards** back into position **and reactivate** the safety devices as soon as the reasons for their temporary removal/deactivation no longer exist
- **Do not use** the machine in ways and/or for loads different from those indicated by the Manufacturer;
- Each day **check** the safety devices, levels, condition of the technological fluids (where used) as well as the general condition of the machine;
- **Perform** cleaning operations on a daily basis, that must be scrupulous and efficient
- **Adopt** suitable measures and caution when performing registration, cleaning and maintenance activities etc. to ensure that the machine and any of its parts are not put into motion by anyone else, even accidentally;
- **In the work place, observe the European Directives and legislation and standards that apply in the country where the machine is installed and operational, with regard to:**
  - safety signs and warnings (in particular, should the signs originally fixed onto the machine become deteriorated, the user must see to their immediate replacement with new, equivalent signs);
  - health and safety in the work place;
  - individual protection devices

- environmental protection and preservation (normal and/or special and/or harmful toxic waste disposal, used oil disposal, emission of smoke into atmosphere, waste water discharging etc.).
- **Respect the limits imposed by climatic conditions** (see Table 1, page 13) and permitted uses
- **The employer** at the work site, the managers, and the people in charge must provide assigned workers adequate information, and training, and for the machine which is the subject matter of the training, relative to the specific duties (they must be easy and comprehensible in relation to the reasonably expected aptitude level and language comprehension) as regards correct and safe use and the general and specific risks of the workplace and/or task; this manual may be a valid support to fulfill such a delicate task, even though, for obvious reasons, it may not be deemed comprehensive for matters not strictly pertinent to the machine itself.
- **Clothing worn by operator** must be adherent and without any volatile parts. Overalls, jackets, loose shirts etc., nor jewellery (such as bracelets, necklaces etc.) must not be worn that could risk getting caught up and dragged by the moving bodies.
- Should replacement of one or more parts be necessary, **use only original spare parts** by sending the request to Rollmatic s.r.l. If non-original spare parts are used, the Manufacturer of the machine considers itself relieved from any liability for damage to persons, things and/or animals that may result as a consequence.
- **Any single, ad hoc modification made to the machine relieves the Manufacturer from all liability that might result from damage to persons, animals and/or things.**

### 1.3 MAIN SITUATIONS WHEN COMPANY DOES NOT ACCEPT LIABILITY

Rollmatic s.r.l. accepts no responsibility for damage to persons, animals and things, or loss of production, under the following circumstances:

- **machine used in a way that does not** comply with its intended use, or for products different from those specifically indicated in this manual
- **installation not carried out in compliance** with the procedures described in this manual
- **use of the machine by personnel with insufficient instruction, knowledge** and, where foreseen, practical training, on how to use it correctly and safely
- **use of energy supplies** that are different from or incompatible with those foreseen by the data specifications in this manual
- **lack of or scarce maintenance**, or performed without observing the methods indicated here
- **non-observance, or partial observance**, of the instructions provided in this manual
- **ad hoc modification** of the features and original equipment provided with the machine, without receiving formal authorization from the Manufacturer in advance
- **damage caused by** tools, equipment etc., whether used or **not on the machine, which are not supplied or, in any case, not foreseen or authorized by Rollmatic s.r.l.**
- **non-observance of legislation and standards** applying in the country where the machine is in operation
- **exceptional circumstances and reasons of force majeure** outside the Manufacturer's control.

### 1.4 TERMINOLOGY

To improve understanding of this manual, we provide below definitions of the terms used:

**MANUFACTURER, PRODUCER:** Rollmatic s.r.l. Via Piemonte, 9 Schio (VICENZA)

**CUSTOMER, PURCHASER:** natural person or juridical entity that has purchased a new machine, or one in a condition that can be considered new (that is intact, and including these original instructions and the original EC Declaration of Compliance).

**USER:** who is legally responsible for use of the machine. In most cases, the purchaser and the user are one and the same.

**OPERATOR:** person responsible for using the machine, where by use is intended any phase related to the normal life cycle of the machine.

**MACHINE, SLICER:** the subject of this manual - written to explain how to operate it safely and correctly - and duly consigned to the purchaser.

**USE OF MACHINE:** the set of operations that must be carried out on the machine during its lifetime or that may be necessary, within the context of its intended use as explicitly stated in this manual.

**BREAD:** bread products, already cooked, having dimensions that must not exceed those indicated in Section 2.3 and characteristics that allow it to be cut cleanly by the stainless steel, serrated blades with alternating motor, without humid remnants from the product being left attached to the blade (loaves, baguettes, sandwich bread etc.)

**ROUTINE MAINTENANCE:** operations necessary for good operation of the machine and its correct duration. Due to the simplicity of these operations and their low associated risk factor, no particular preparation or professional qualifications are required to perform them, and they can therefore be delegated to the machine operator.

**EXTRAORDINARY MAINTENANCE:** operations necessary for the good operation of the machine and its correct duration. Due to their complexity and/or associated dangers, these interventions must be performed by expert, specialized personnel, professionally prepared and possessing the necessary technical and legal knowledge to carry out the work properly, and in complete safety.

**DANGER AREA,** any area inside and/or in the vicinity of the machine, where the presence of a person exposes them to danger, and constitutes a risk to their health and safety.

**EXPOSED PERSON:** any person who is completely or partially within a danger area.

**WARNING:** information of primary importance for the operator's health and safety.

**IMPORTANT:** important information to avoid damage to the machine and/or its parts.

## 2 MACHINE FEATURES

### 2.1 INTENDED USE AND DESCRIPTION

**The machine described in this manual is intended to be used for cutting oven-baked bread in slices of a pre-defined, constant thickness, that does not exceed the dimensions indicated in Section 2.3, and that has properties that allow a clean cut by the stainless steel, serrated blades with alternating motor without any humid residues remaining attached.**

- **Only a professional use of the machine is permitted and by personnel who are expert in breadmaking and with adequate training and instruction on how to use the machine safely.** Instruction and training must regard all the arguments dealt with in this manual; the employer must verify comprehension through specific theoretical and practical testing.
- **Use of the machine is permitted exclusively in closed, protected areas;** under no circumstances must the machine be used outside or in areas where it is exposed to the action of atmospheric agents.

- **Use of the machine is not permitted in places accessible to the public except for demonstration purposes, and provided that precautions are taken to guarantee the safety of the persons involved.**
- **Under no circumstances, and for no reason, can the machine be used by private individuals** (shop customers, shopping mall visitors, canteen customers etc.).
- **Use of the machine** is not permitted for other purposes and/or products and/or using different methods from those described in this manual.
- **Use of the machine is not permitted** unless, beforehand, all connections have been made to the systems serving the installation site as indicated in this manual.
- **Use of the machine is not permitted** in environments where there is risk of fire and/or explosion and/or any type of incident considered of importance by current legislation, or that presents high levels of humidity or wetness, where there is excess water vapor and/or oily vapor and/or dust, or the presence of corrosive substances and/or gases.
- **Use of the machine is not permitted** in environments subject to vibrations or abnormal jolts.

## VERSIONS

- **STANDARD:** with simple unloading surface
- **WITH BLOWER:** with unloading surface equipped with device to inflate the slice packaging bags

Both versions can be equipped (only if requested at the time of the order) with a **BLADE LUBRICATION** system

## OPTIONS

- bread loading slide

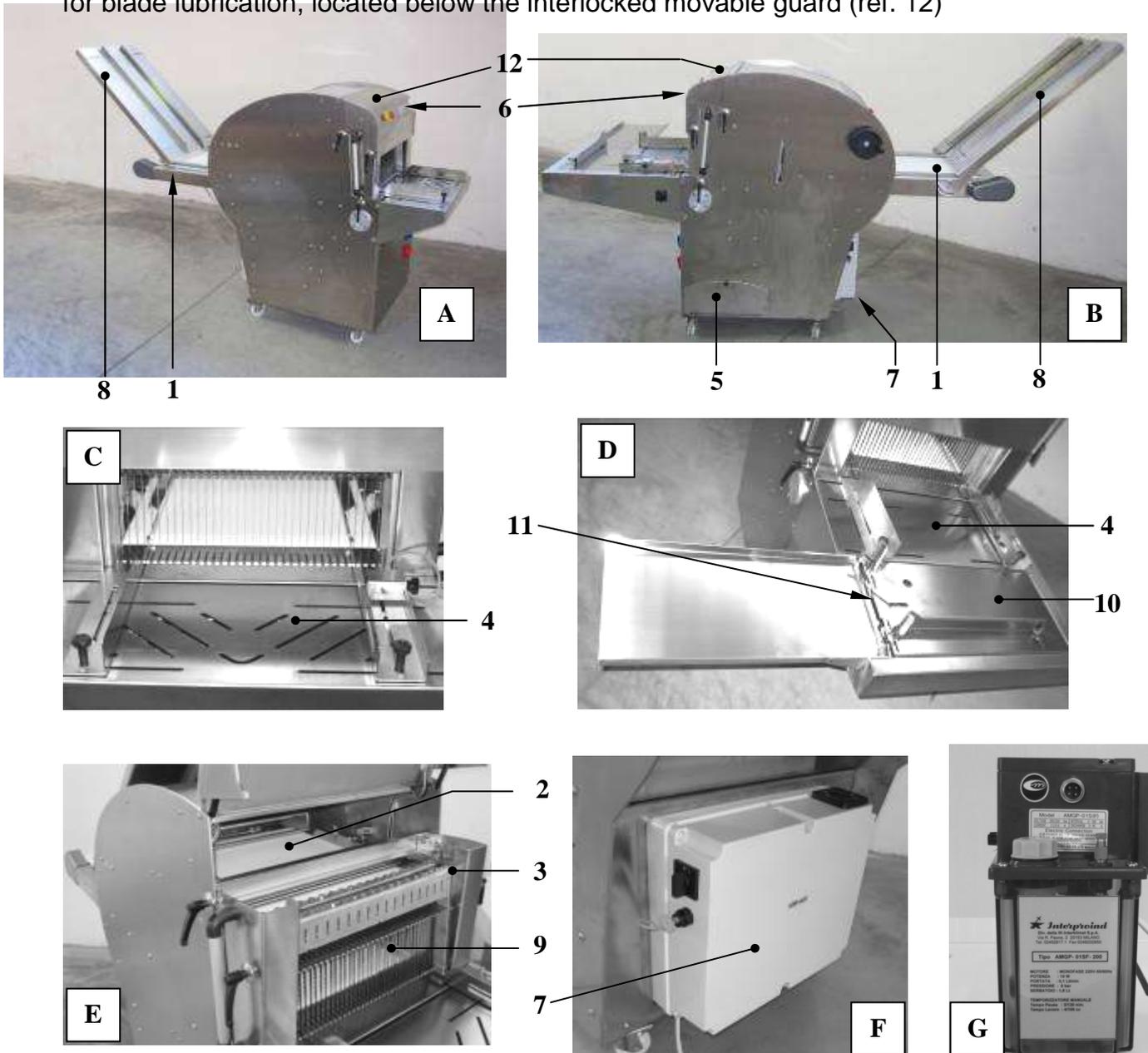
Apart from the support structure, each machine is composed of (Figure 1):

- ref. 1 bread loading belt; this has two guide and containment barriers; the distance between them may be adjusted manually by a handwheel
- ref. 2 top belt, the distance between this belt and the belt of ref. 1 can be adjusted to compress the bread just enough to push it against the cutting blades; it has the same speed as belt of ref. 1
- ref. 3 detachable unit (photo E) with two series of blades (ref. 9) and the corresponding frames furnished with alternating motion
- ref. 4 **STANDARD** version (photos A - C): unloading platform with adjustable containment barriers,  
version **WITH BLOWER** (photos B - D): platform as described above, with an additional bag inflation system (ref. 10) from air blowing through the slot (ref. 11)
- ref. 5 bread-crumbs drawer held closed by steel hatch
- ref. 6 control pad

ref. 7 electric control panel box (photo F); located below the belt (ref. 1)

ref. 8 (optional) loading slide with adjustable barriers (photo A - B) to move loaves that will then be drawn one by one from the belt (ref. 1); it can be folded back rest against the machine when not in use to reduce encumbrance

The version WITH LUBRICATION is also equipped with an oil-pump power unit (photo G) for blade lubrication, located below the interlocked movable guard (ref. 12)



**Figure 1 – Main Machine Parts**

## 2.2 ELECTRIC /ELECTRONIC CONTROL AND COMMAND DEVICES

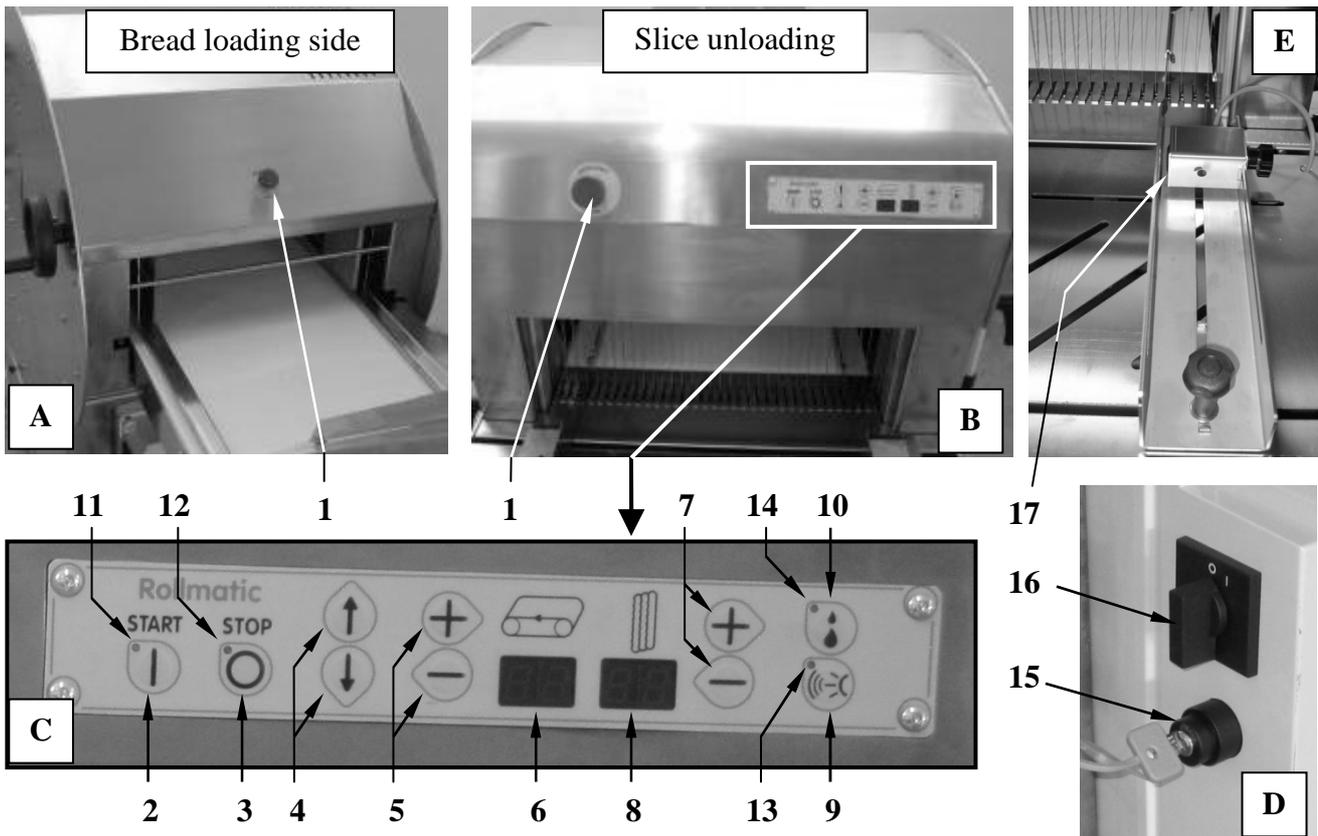
With reference to Figure 2, the STANDARD version machine is equipped with the following command and control devices:

ref. 1 **EMERGENCY STOP BUTTONS** (photos A-B); there are a total of two (red mushroom-head button on yellow background) located above the openings where the bread enters and the slices leave the machine

ref. 2 **START key** (photo C), LED ref. 11, off = machine waiting for the start command pressing the button for less than 2 seconds gives the normal start command; the led (ref. 11) blinks

when the button is pressed and kept pressed for 2 seconds or more, this gives the backward drive command to the feed belts; the led (ref. 11) blinks quickly; upon

- releasing the button, the belts stop
- ref. **3** STOP key (photo C): LED ref. 12 on = the stop key has been pressed  
LED ref. 12 off = the start command has been given (work cycle in progress)
- ref. **4** buttons (photo C) to raise **↑** or lower **↓** the top feed belt (ref. 2) Figure 1
- ref. **5** buttons (photo C) to increase **+** or decrease **-** the speed of the feed belts
- ref. **6** two-digit display (photo C); gives an indication of the feed belt speed on a scale from 20 to 90, regulated by single steps with buttons (ref. 5)
- ref. **7** buttons (photo C) to increase **+** or decrease **-** the speed of the cutting blades
- ref. **8** two-digit display (photo C); gives an indication of the cutting blade speed on a scale from 20 to 60, regulated by single steps with buttons (ref. 7)
- ref. **9** (photo C) photocell activation button ref. 17 (photo E) to detect exiting slices;  
led ref. 13 lit up = on, blinking = busy, not-lit up = off
- ref. **10** button (photo C) to enable blade-lubrication power unit operation (if present)  
led ref. 14 lit up = enabled, blinking = pump in operation, not-lit up = power unit not enabled
- ref. **15** three-position operation selector switch (photo D):  
pos. **0**: the pad commands of photo C are enabled  
pos. **1**: the top belt goes to the upper end stop; the pad of photo C is disabled  
pos. **2**: the shaft that moves the blades is brought to the correct position to disassemble the blade unit ref. 3 Figure 1; the pad of photo C is disabled
- ref. **16** main power switch (photo D); **O = OFF, I = ON**



**Figure 2 - Electric /electronic control and command devices of the STANDARD version**

The WITH BLOWER version of the machine, in addition to the standard-version devices listed above, is equipped with an I (ON)/ O (OFF) switch to turn the air fan (Figure 3) on or off

Blower switch



**Figure 3 - Blower on/off switch**

## 2.3 TECHNICAL SPECIFICATIONS

STANDARD machine overall dimensions (WxDxH)	mm	.....x803x1369
Machine overall dimensions WITH BLOWER (WxDxH)	mm	2307x1331x1369
Greater machine length with loading slide open	mm	
Greater machine height with loading slide open	mm	
Greater machine length with loading slide folded back	mm	
Greater machine height with loading slide folded back	mm	
Min-max bread length (dimension perpendicular to cut)	mm	
Min-max bread width (dimension parallel to cut)	mm	

Bread max height	mm	
Blade pitch	mm	see note
Minimum maximum speed of the feed belts	m/s	
Machine weight STANDARD version	kg	
Greater machine mass WITH BLOWER version	kg	
Greater machine mass WITH BLADE LUBRICATION version	kg	
Greater machine mass with loading slide (optional)	kg	
Maximum installed power (the difference between the versions is minimal)	kW	1.5
No. of electrical phases	-	3 ~ + PE
Nominal voltage / Frequency	V/Hz	400 / 50
Intervention threshold of protection devices in case of overloading	A	
Ambient temperature, min/max	°C	-5 / +40
Maximum ambient temperature - average over 24 h	°C	35
Maximum ambient relative humidity (with T < 40 °C)	%	50
Maximum height over sea level	m	2000

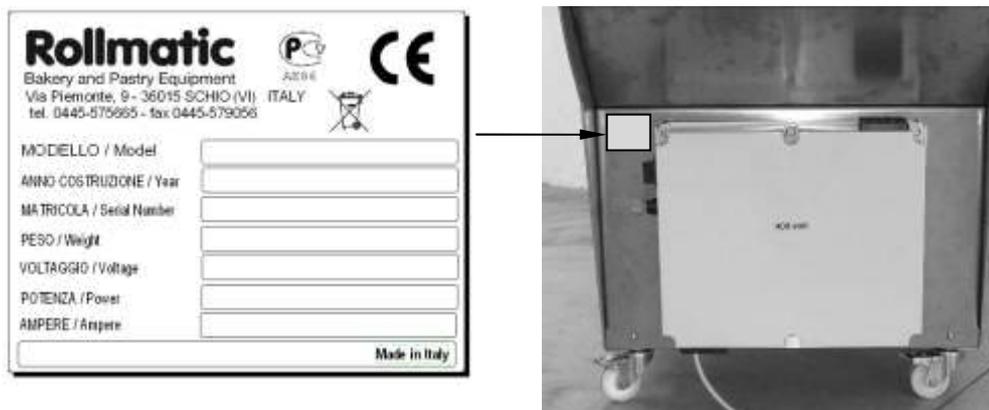
**Table 1 - Technical specifications**

**Note.** The blade pitch in mm (thicknesses of slices cut) can be 7 - 9 - 10 - 12 - 14 - 15 - 16 - 18.

The pitch for each cutting unit is specified by the customer when making the purchase order and cannot be modified. For safety reasons the pitch cannot exceed 25 mm under any circumstances, even if specifically requested by the customer.

## 2.4 IDENTIFICATION PLATE

The identifier plate, indelibly bearing the EC marking, general information regarding the manufacturer, the machine model, serial number, the year of construction, weight, essential electrical data, is fastened onto the machine on the side of the electrical box (approximately in the position shown in Figure 4).


**Figure 4 – Identification Plate**

## 3 INSTALLATION AND USE

### 3.1 WARNINGS RELATED TO INSTALLATION SITE

The room where the machine is to be installed and used must comply with current legislation and standards, in particular on account of its intended use. The room must have walls and floors that can be easily cleaned and washed, and be in an excellent state of

maintenance and hygiene (no moulds, organic/poisonous substances etc). The floor must be flat and compact, without holes or irregularities.

The entrance to the room must be at least big enough to allow passage of the machine. The floor and support structures must comply with current legislation and standards, in particular taking into account the total load to be carried and the related safety coefficients. The electrical and earthing systems of the production site must comply with current legislation and standards. The earthing system in particular must be maintained in perfect working condition, with periodic controls. Appropriate protection devices must be mounted correctly on the main power panel supplying the machine with electricity, and offering protection against current overloads, short-circuits and phase-phase, phase-neutral and phase-earth failures. Every aspect of the electrical system of the site in use must be in designed, maintained and periodically checked by specially-chosen, professionally-qualified personnel who, on completing the intervention, are able to issue a Declaration of Compliance as required by current legal requirements and standards.

**Use of the machine** is not allowed in environments where there is a risk of fire and/or explosion, and/or any type of incident considered of importance by current legal requirements.

### **3.2 LIFTING, TRANSPORTATION AND POSITIONING INSTRUCTIONS**

The area in which the machine is to be located, tended and/or operated must guarantee adequate protection from potential damage and from atmospheric agents, ensure maximum stability of the machine, be forbidden to underage persons and outsiders, be accessible only to persons qualified for the type of use for which the machine is intended.

If the machine is not going to be used for any length of time or longer than the normal non-use time where it is installed, it must be put in a closed, dry place off limits to unauthorised people where it cannot be damaged; it must be covered with a waterproof, opaque cloth.

The machine is shipped in a single package with any additional cutting units in a separate package. When shipped from the manufacturer's premises, the machine is packed and fixed on a pallet (Figure 5, photos A - B - C - D) and, if necessary or agreed in the contract, in a thick cardboard box (carton) or wood (crate).

The pallet is placed on the floor of the transport vehicle and fixed at the bottom by means of crossbars and/or blocks of wood appropriately positioned. The load is tied with an adequate number of ropes to parts of the vehicle's structure strong enough to prevent unexpected, undesirable movements during transit.

The weight and the method to follow for lifting and moving the pack correctly are indicated on the pack, or directly on the machine itself.

**When moving and transporting the machine, you must adopt every precaution possible to avoid, or to limit, risks to persons, animals and things.**

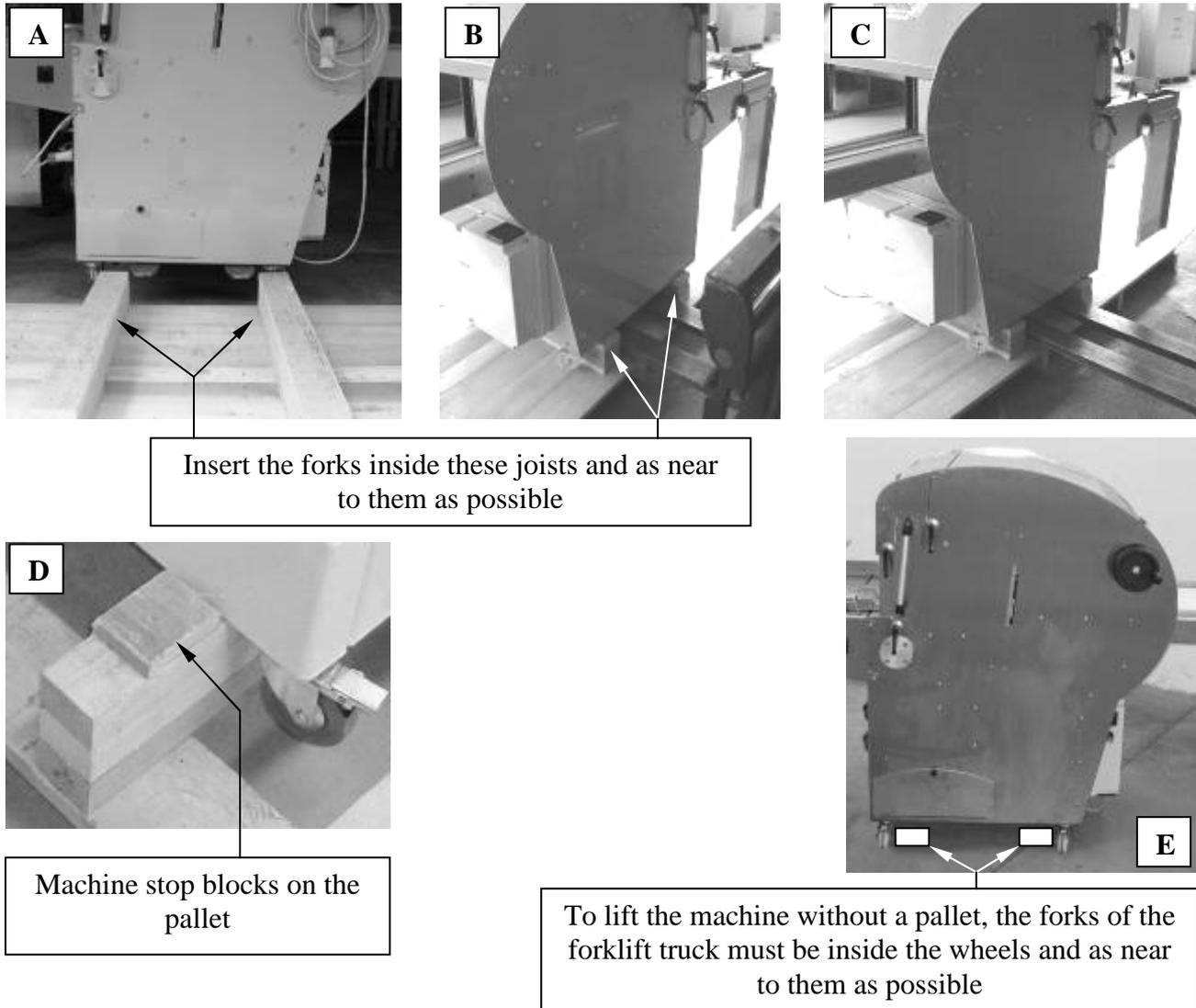
Loading/unloading from the transport vehicle is normally carried out by means of a forklift truck having a sufficient bearing capacity, and whose arms must be inserted in the special spaces at the bottom of the pallet. Remove the machine's packaging. Check its condition and that it is complete. Separate the materials by type (cardboard, plastic, wood, etc.), depositing them in the special collection sites accessible only to authorized persons, so that they are ready for collection by the specialist waste disposal companies. The wooden joists and pallet must also be taken to the specially-designated collection site.

**Environmental respect is a duty unequivocally enshrined in current legislation.**

Because of the machine's weight it is forbidden to handle it manually (high risk of injury to muscles-back); to move or position it from/on the pallet it must be handled with a forklift truck as shown in Figure 5, photo A - B - C, if it needs to be lifted once it is on the ground, to move it (e.g. to get passed an obstacle) place the forks of the forklift truck inside the wheels and as near to them as possible to ensure the greatest possible stability of the load (see Figure 5, photo E).

In all cases, the forklift arms must protrude beyond the opposite side of the machine by at

least 30 cm.



**Figure 5 – Machine lifting and moving**

Lift the machine as slowly as possible, and only as much as necessary to move the load without encountering obstacles. Avoid any unexpected jolts or sharp vertical movements. Accelerations and decelerations must be as gradual as possible. **Verify** constantly that there is no-one in the vicinity or, more seriously, that no-one obstructs the passage of the load. Make your own presence known to people who may be near by (even simply by calling out). As soon as possible, and very carefully, lower the machine onto the ground. After the machine is put down, it can be moved simply by pushing, making sure however to use always and only gentle movements without jolting (make sure also that the floor is flat without any holes and/or irregularities, and that no obstacles lie in the path to be traveled). **It is absolutely forbidden to move the machine on the wheels by towing using another means of movement, whether motorized or not. It must only be moved by hand, being careful to avoid obstacles, steps etc. to avoid the risk of it tipping over.** **WARNING! Do not use other lifting equipment or methods other than those described here.**

Around the machine, leave sufficient space to allow it to be used comfortably and for carrying out thorough, efficient cleaning operations, regulation and/or maintenance activities (1 m on each side should be sufficient).

Block the two wheels having brakes by lowering the related lever (Figure 6). If, for any reason in the future, it should be necessary to move the machine to a different location,

respect the measures and precautions described in this Section.

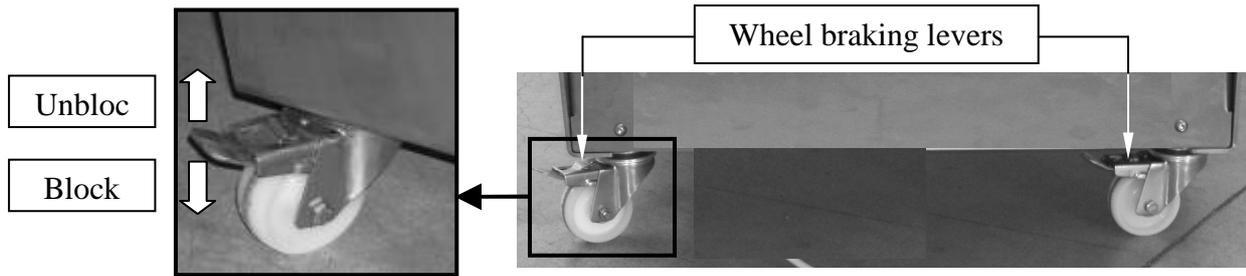


Figure 6 – Wheels with Braking System

### 3.3 ELECTRICAL CONNECTIONS

All electrical interventions at the operation site must be carried out exclusively by personnel meeting the specific technical-professional requirements, having the technical/legal knowledge to carry out the work properly, complying with current legislation and standards - also taking into account the type of environment - and authorized to issue a Declaration of Compliance if legally required.

On machine delivery, and before proceeding to set up the electrical connections, make sure that the line voltage supplied complies with that stipulated by the Manufacturer for the machine, and indicated on the identification plate (see also Section 2.4). Connection to the electrical plant at the work site must be performed observing the standards and legislation in force, and referring to the data and indications in this manual.

The machine is delivered complete with cable and three-phase plug with earth pin ) (see Figure 7).

The power cable must be kept far from heat sources and/or moving parts, and must not obstacle or impede the movement or passage of persons, animals or things.

**The electrical supply plug must always be easily accessible** (do not position either the machine or other things in front of the plug inserted into the socket).

Make use of the special earthed system, checking that it functions. Do not connect to gas or water pipes or generally any other metal elements.

**WARNING! A sectioning device, or in any case, a device to disconnect the electrical grid, must be anticipated before the power outlet, with adequate breaking capacity, in relation to the data reported in this manual and in the wiring diagram, and with sufficient spacing between the contacts (not less than 3 mm).**

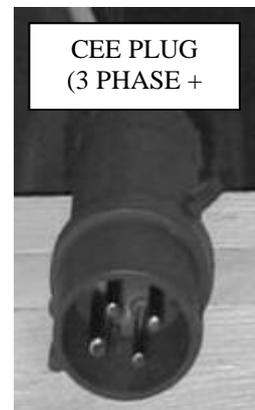
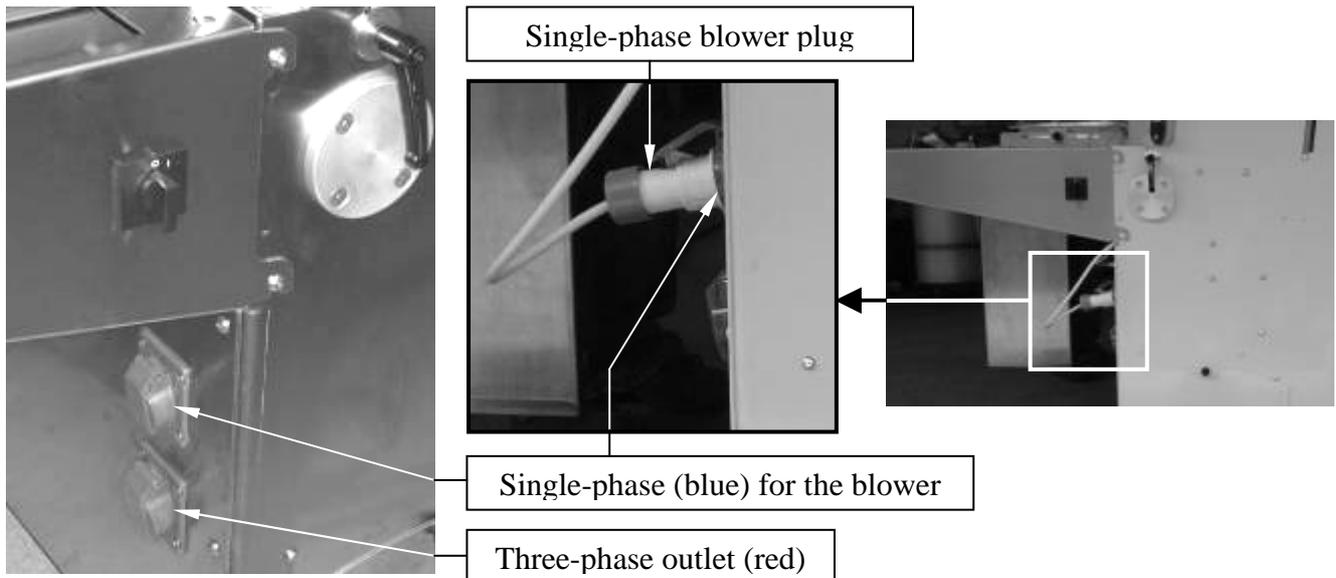


Figure 7 - Electrical power plug

**IMPORTANT! If the machine is equipped with a BLOWER, connect the single-phase power plug (blue plug) to the outlet (blue) located below the unloading platform (see Figure 8).**

**IMPORTANT! The single-phase and three-phase outlets must be used solely and exclusively to connect original Rollmatic accessories, not to power other types of devices**



**Figure 8 - Plug/outlet connection to provide power to the blower**

### 3.4 OPERATION AND USE

#### **WARNING!**

**A maximum of two assigned personnel may operate the machine at the same time if there are no other people in the vicinity. It is forbidden for anyone without the requisites stipulated in this manual to carry out any operation on or with the machine. These are the conditions necessary for a safe use of the machine, even if not providing a total guarantee.**

**The machine must be used only by personnel who have been adequately instructed and trained, and with explicit authorization.** It is the responsibility of the Employer to identify staff suitable for operating the machine, providing them with the information, instruction and training necessary.

Rollmatic s.r.l. accepts no liability for any type of damage to persons, animals and things deriving from non-observance of the indications given in this manual.

**The position occupied by the operator to use the machine for production purposes are in front of the feed belt (ref. 1 Figure 1) or the loading slide (ref. 8 Figure 1) to load the bread to be cut and in front of the unloading platform (ref. 4 Figure 1) or the blower (ref. 10 Figure 1), for unloading and possibly bagging of the cut slices and for using the control pad Figure 2/C.**

#### 3.4.1 PRECAUTIONS AND PRELIMINARY CHECKS

- Make sure that the wheels with brakes are blocked
- Before connecting the machine plug to the electrical socket, make sure that there are no inflammable and/or explosive products and/or substances in the vicinity, or equipment that uses and/or produces these types of substance.
- **At the start of every work day and/or shift**, make sure that the safety devices are working properly following the instructions in Section 5.2.3.

#### 3.4.2 GENERAL INFORMATION FOR NORMAL USE

Before using the machine for normal production, bear in mind the following important information:

- Before or while using the machine **make sure that no-one is near to or approaching the machine**. Otherwise do not proceed, but wait until the person has moved away to avoid exposing them unnecessarily to risks, low though they may be.
- Any emergency button, Ref. 1 Figure 2 commands stopping of the machine, disconnection

of the electrical supply to the actuators and deactivation of the start devices. To restart the machine, first of all make sure that no-one is near the machine, otherwise wait until they move to the safety distance (at least 3 meters), then reset the emergency button (turn the knob in the direction indicated by the arrow appearing on it).

- Access to the devices for regulating the machine, if present, and the adjustments themselves must be carried out **exclusively** by trained, authorized persons, or specialized technicians, expert in the related field. It is the responsibility of the Employer to provide operators with instruction regarding use of the machine as explained above, and make understood the need for it to be treated with respect (performing operations without feeling confident, or which are outside one's own skill area, could create risks to personal safety and to the safety of others, sometimes even serious).
- At the end of the day/work shift, turn off the machine and disconnect the plug from the electrical power supply; fold back the loading slide (if present) as shown in Figure 9 photo G
- If for any reason you need to bring your hands close to the blades, and in particular to their sharp side, **do it after ensuring the machine is off and de-energized and after having put on cut-resistant protective gloves to prevent injury** (the blades are very sharp and a slight contact could cause wounds and bleeding, more or less severe depending on the depth of the wound)

### 3.4.3 SWITCHING ON AND MAKING READY FOR OPERATION

To turn on the machine, connect the plug of Figure 7, to the electrical power socket, then turn on the main switch (ref. 16 Figure 9/E) switching it to **I**; the (ref. 6 and ref. 8 Figure 9/D) light up. When the two displays stabilize (in the meanwhile the system carries out self-diagnostics), the machine is ready for operation. **When the displays are on the machine is powered.**

### 3.4.4 MACHINE FUNCTIONING AND USE

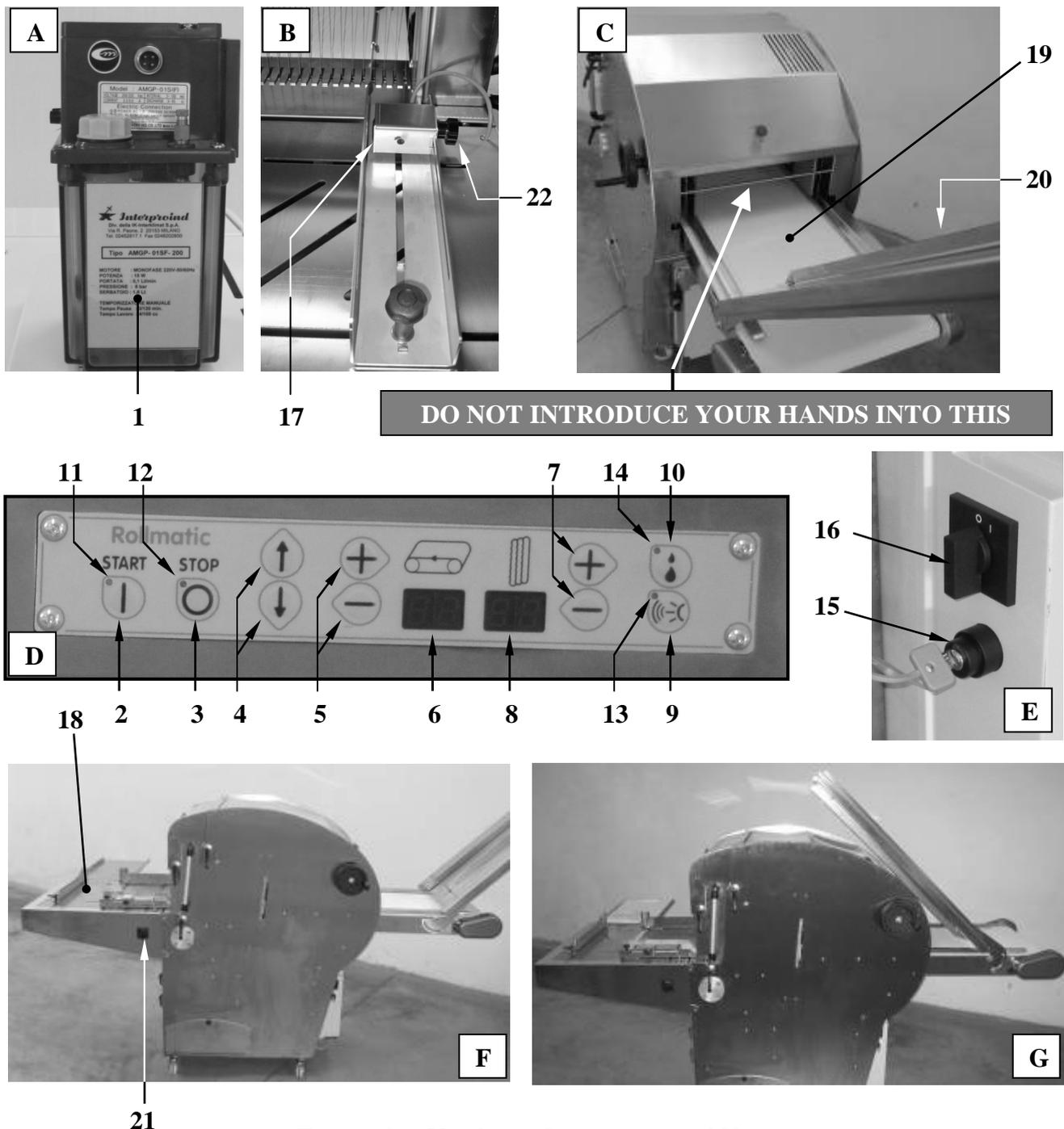
With reference to Figure 9, after having turned the machine on and enabled it as described in Section 3.4.3.

1. If necessary, adjust the aperture of the entrance guide bars and the exiting barriers (par. 3.4.6)
2. (version WITH OILER) depending on the product to be cut, enable the blade lubrication power unit (ref. 1 of photo A) pressing the button (ref. 10) (led of ref. 14 lit up = power unit enabled)
3. Turn on the photocell (ref. 17) (photo B) pressing the button (ref. 9) (led ref. 13 lit up = photocell activated), to prevent the exiting slices from falling to the ground or from accumulating; if necessary adjust the position of the photocell (simply loosen the knob (ref. 22) and move it along the barrier slot; when adjusted, tighten the knob)
4. Adjust the distance between the feed belts, as described in par. 3.4.7
5. Position the key selector (ref. 15) to **0** (photo E)
6. Quickly press the start button (ref. 2) to give the normal drive command
7. Place the bread on the feed belt (ref. 19), between the guide bars or (if present) on the loading slide (ref. 20) (photo C). In any case, **never for any reason place your hands beyond the bread entrance**, the feed belts may constitute an entanglement, entrainment, and crushing risk (the shorter the distance between the belts, the greater the risk) and a cutting risk may also exist due to interferences with the sharp edge of the blades arise (though this possibility is very remote).
8. The belts accompany the bread and push it against the blades in alternating motion which, penetrating the product, produce slices of constant thickness that exit from the opposite side; when the slices intersect the photocell beam ref. 17 (photo B), the belts stop (but not the blades) while waiting for the slices to be removed and the photocell beam to be liberated

9. (version WITH BLOWER) if you wish to bag the cut slices, turn the blower on (ref. 18) with the switch (ref. 21) (photo F) and proceed with packaging (see par.3.4.8 and 3.4.9) Depending upon the type of bread to be cut, it might be necessary to adjust the feed belt speed with the buttons of ref. 5 and/or that of the cutting blades with the buttons of ref. 7 (photo D); quickly pressing a + or - button entails the increase or decrease of one unit on the corresponding display (ref. 6 and ref. 8) in a scale that goes from 20 to at 90 for the belt speed, from 20 to 60 for the blade speed.

If, for any reason, it is necessary to rotate the feed belts in the opposite direction (i.e., in the direction away from the blades), stop the machine with the button (ref. 3), then hold the start button (ref. 2) for as long as required (not less than 2 seconds); to stop the belts from moving, in this case it is sufficient to release the button (ref. 2).

Quickly press the button (ref. 2) to restart normal operation.

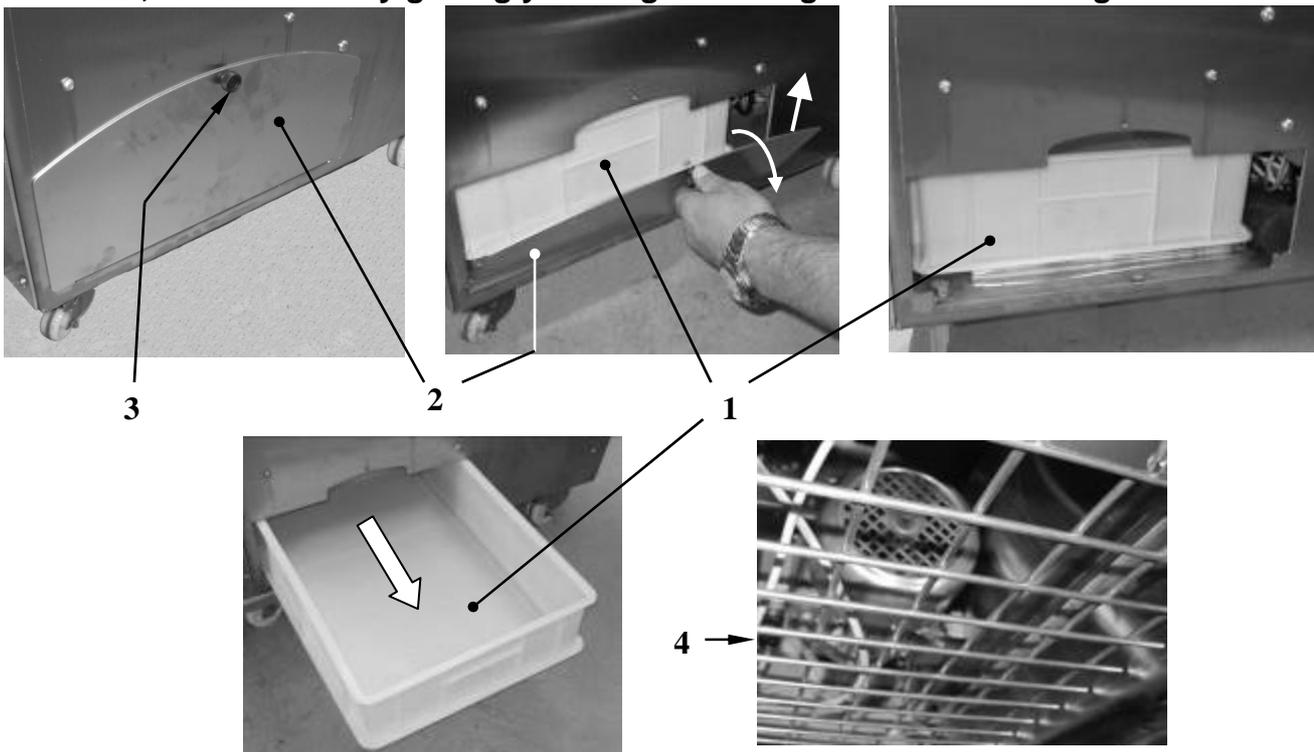


**Figure 9 – Machine Operation and Use**

### 3.4.5 CRUMB COLLECTION DRAWER

A drawer, ref.1, at the bottom of the machine (see Figure 10) collects crumbs and bread residuals. The drawer may be extracted (for ex. to empty and/or clean it) removing the hatch (ref. 2), normally kept in place by the threaded knob (ref. 3).

Before using the machine, make sure the drawer (ref. 1) is in its housing: if it isn't you will find that crumbs and bread residuals fall on the floor, dirtying it, and it is more than likely that mould and putrescible organic deposits etc., form with a risk for the health of those exposed and jeopardising the hygiene of foodstuffs that are on the premises. The hatch (ref. 2) must only be disassembled for as long as strictly necessary, after which it must be put back in place and secured with the threaded knob (ref. 3). The compartment that houses the drawer has a steel grid at the top, ref. 4, preventing dangerous parts from being reached; **it is, however, forbidden to try getting your fingers through the holes in the grid.**



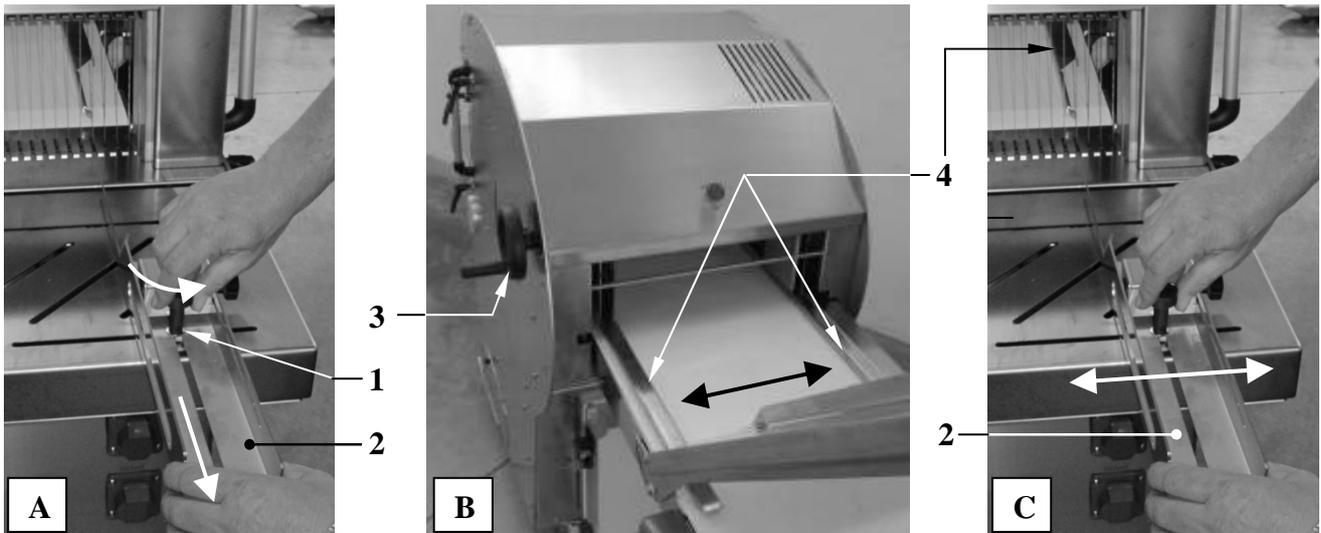
**Figure 10 - Crumb Collection Drawer**

### 3.4.6 ADJUSTING THE BREAD GUIDE BARS AT THE ENTRANCE AND THE CUT SLICE CONTAINMENT BARRIERS AT THE EXIT

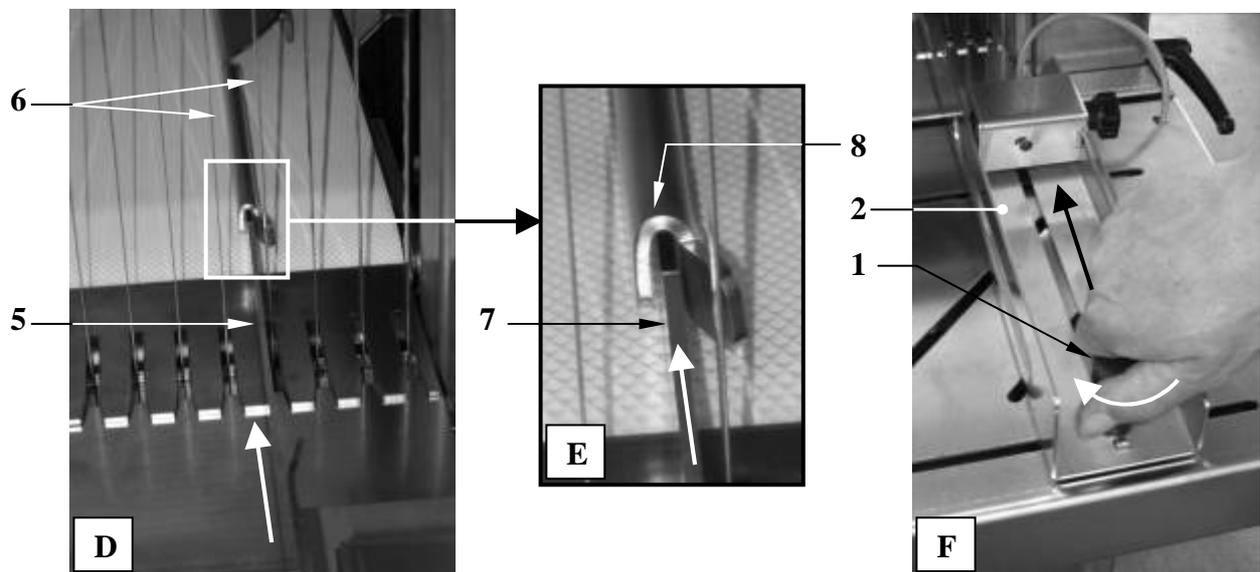
The entrance guide bars, the loading slide barriers (if present) and the exit containment barriers must be adjusted based on the length of the bread to be cut.

With reference to Figure 11:

- loosen the knob (ref. 1) and move the barriers back (ref. 2) until they are free from the blades (photo A)
- bring the entrance guide bars (ref. 4) to the desired distance with the handwheel (ref. 3) (photo B)
- bring the barriers (ref. 2) in line with the bars (ref. 4) (photo C)
- pass the end part (ref. 5) of the barriers (ref. 2) through the spaces between the blades (ref. 6) (photo D) until the tip (ref. 7) enters the V-shaped seat (ref. 8) at the head of the bars (ref. 4) (photo E)
- screw and fasten the knobs (ref. 1) to secure the barriers (ref. 2) in position (photo F)
- bring the loading slide guide barriers (if present) in line with the bars (ref. 4); simply loosen the nuts and screws that hold them secured and move them along the slots; when the adjustment is completed, tighten all nuts and screws to secure them



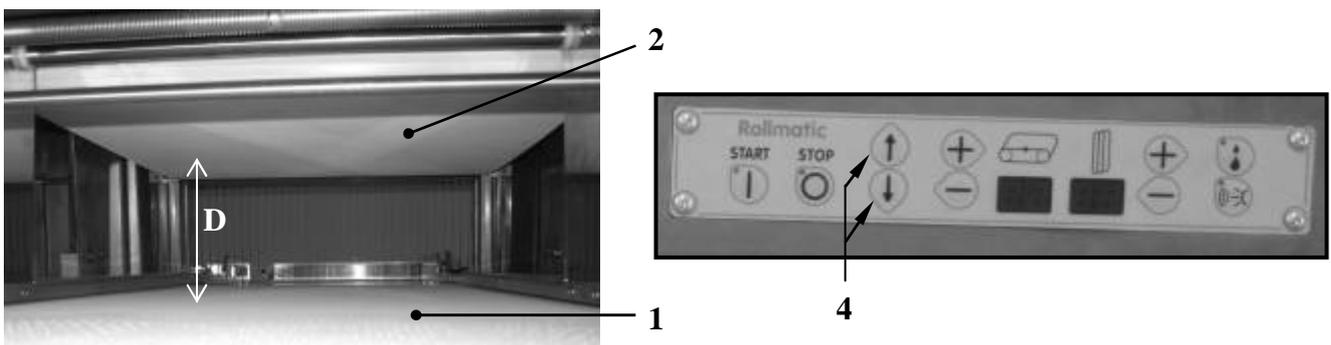
**Start Figure 11 - Adjusting the Position of Lateral Containment Barriers**

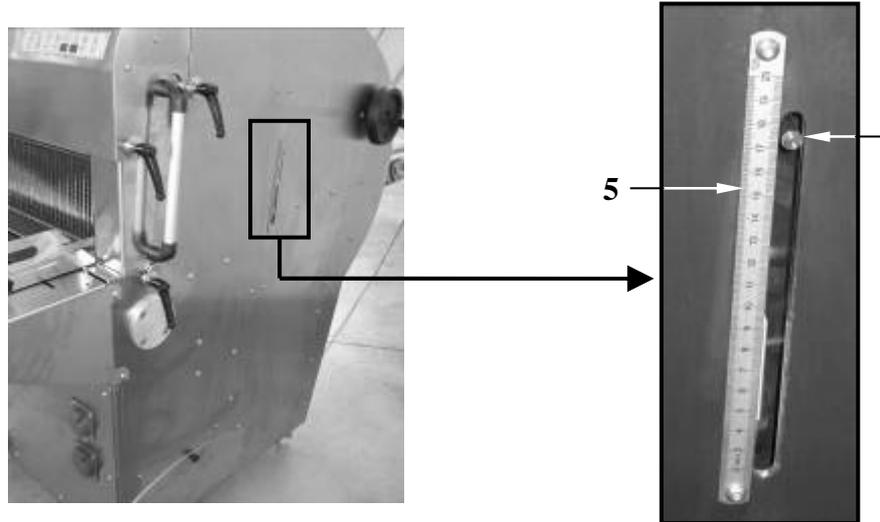


**End Figure 11 - Adjusting the Position of Lateral Containment Barriers**

### 3.4.7 ADJUSTING THE DISTANCE BETWEEN THE FEED BELTS

With reference to Figure 12, increase or decrease the distance D between the feed belts (ref. 1) and (ref. 2), using the buttons (ref. 4) (▲ to increase, ▼ to decrease); there is a moving indicator (ref. 3) on the side of the machine, integral with the top belt, and a fixed ruler divided into millimeters (ref. 5) that allows you to monitor the distance, D, to be adjusted.



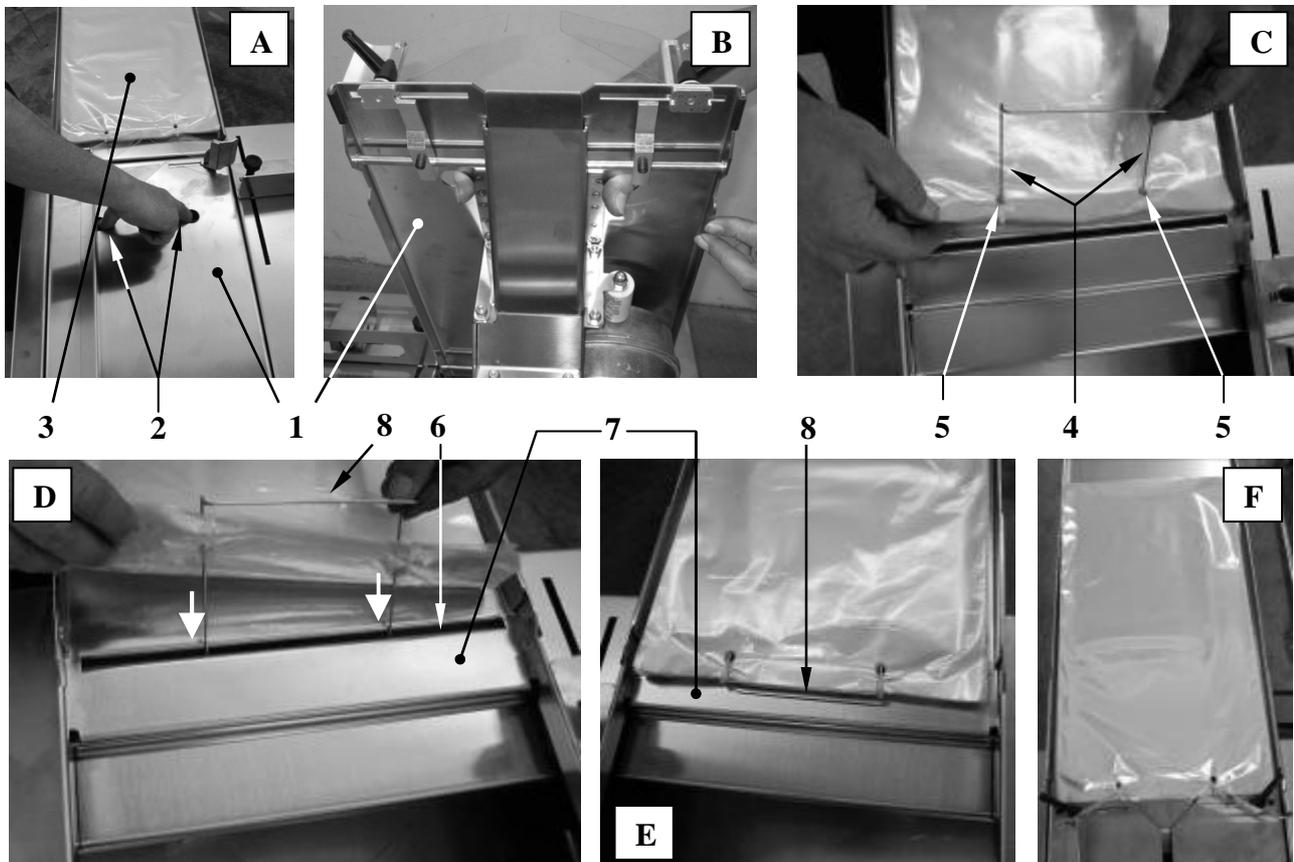


**Figure 12 - Adjusting the distance between feed belts**

### 3.4.8 LOADING THE BAGS (version WITH BLOWER)

With reference to Figure 13:

- raise the surface (ref. 1) use the two holes (ref. 2) (photos A-B)
- position the ream of bags (ref. 3) on the special shelf (photo A)
- pass the bag-holder wire (ref. 4) through the bag holes (ref. 5) (photo C), then insert them into the slots (ref. 6) (photo D) until the bags have been engaged between the surface (ref. 7) and the side stop (ref. 8) of the bag holder
- lower and insert the surface (ref. 1) as support (photo F)



**Figure 13 - Loading the packaging bags**

### 3.4.9 ADJUSTING AIR FOR THE BAGS (version WITH BLOWER)

With reference to Figure 14, raise the surface (ref. 1) using the two holes (ref. 2) (photos A-B), then increase (photo C) or decrease (photo D) the air flow adjusting the lever (ref. 3). When the adjustment has been completed, lower and insert the support surface (ref. 1)

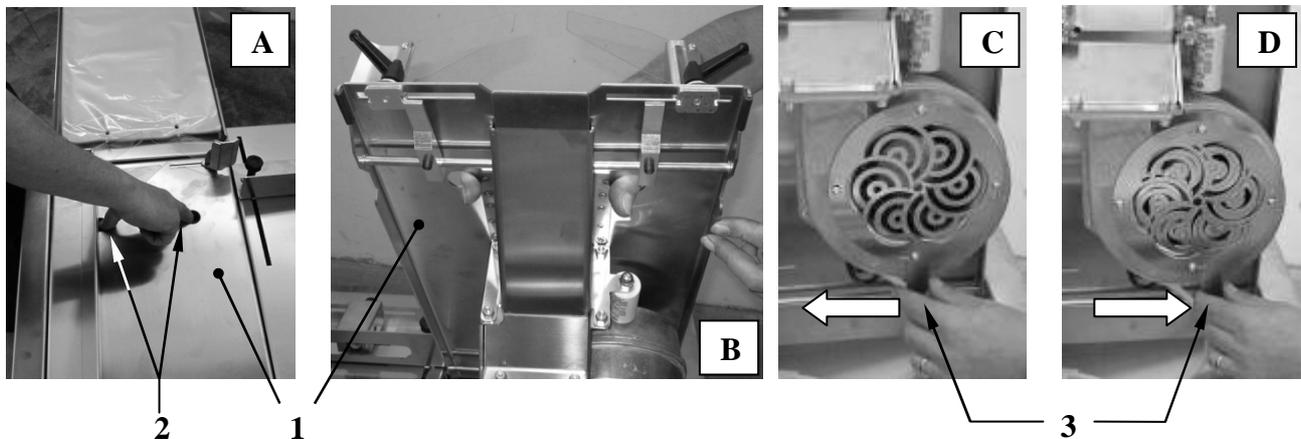


Figure 14 - Adjusting the air for inflating bags

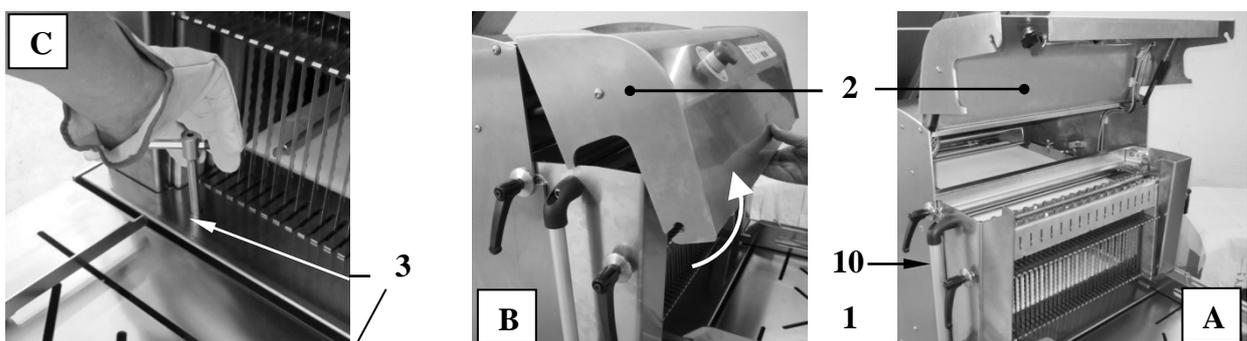
### 3.4.10 DISASSEMBLY/ASSEMBLY OF THE BLADE UNIT

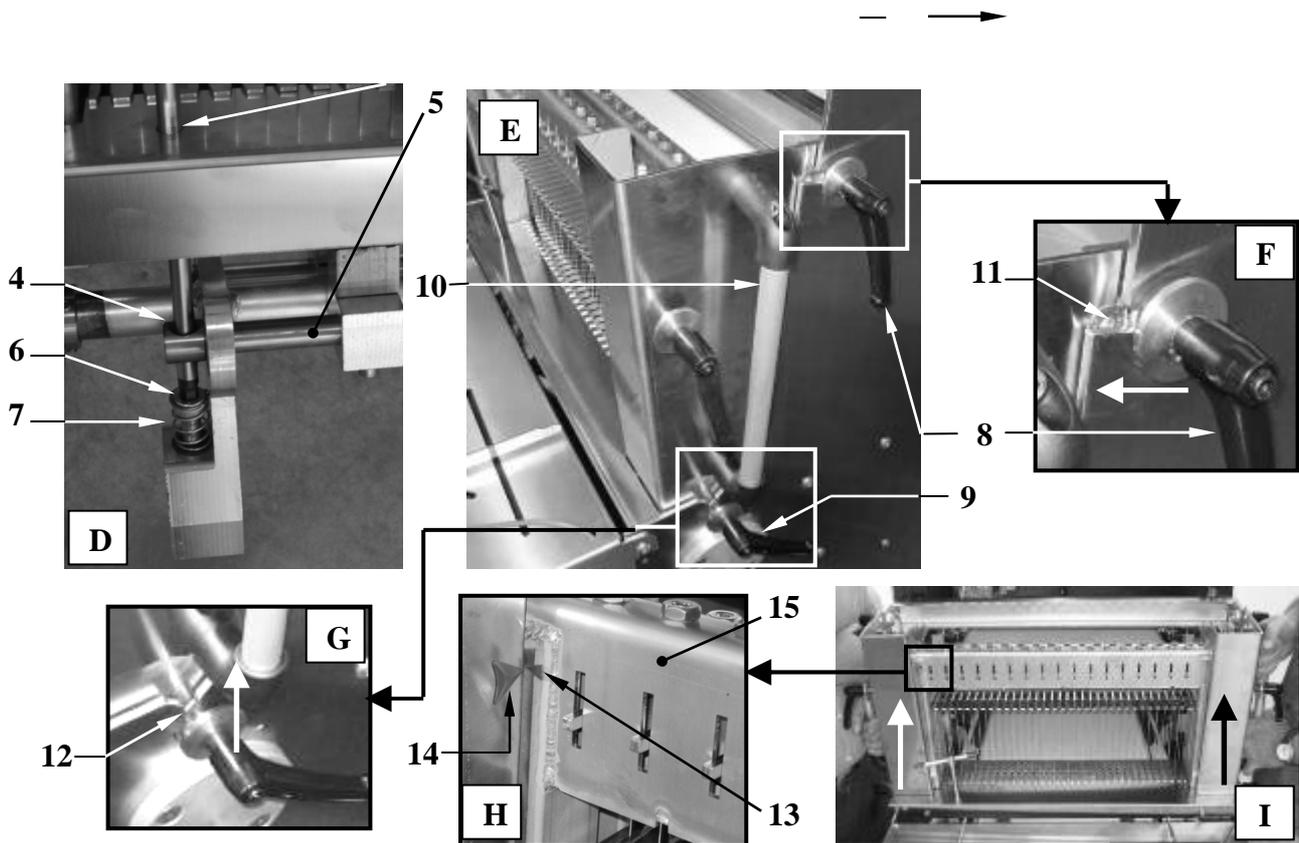
The operation requires the simultaneous intervention by **two workers**; they must wear **cut-resistant gloves and reinforced-toe work shoes**. To dismount the blade unit (Figure 15):

1. Extract the slice guide barriers exiting the blades and secure them in this position (see par. 3.4.6)
2. Turn the key selector (ref. 15 Figure 2) to position 1; wait until the top belt reaches the upper end stop, then turn the key selector (ref. 15 Figure 2) to position 2: the shaft that transmits the motion to the blade frame will go to the correct position for disassembly operations (wait until the symbols S Y n c appear on the pad display);
3. Loosen the knobs (ref. 1) and open the upper guard (ref. 2) (photo A-B)
4. Insert a long-shafted 6 mm Allen wrench in the hole (ref. 3) (photo C), pass it through the hole (ref. 4) of the shaft (ref. 5) and insert it in the head of the special M10 screw (ref. 6) (photo D).

The indicators (ref. 13 and ref. 14) (photo H) must be aligned, otherwise the wrench will not enter the head of the screw; if unaligned, move the blade-holder frame (ref. 15) until they are aligned.

5. Loosen the screw and remove it from the threads (you will feel the wrench vacillate as a consequence of the spring (ref. 7)). **IMPORTANT! If you have to later remount the same unit, leave the wrench in place**
6. Loosen the knobs (ref. 8 and ref. 9) (photo E)
7. Grasp the handle (ref. 10) at the sides of the unit; leave the knob (ref. 9) pins resting in place and remove the knob pin of ref. 8 from the slot (ref. 11) (photo F), then lift the unit (photo I); **its mass is approximately 42 kg**; exit the knob pin of ref. 9 from the slot ref. 12 (photo G). Set the unit in a safe place, protecting the blades (for ex. with a rigid and sturdy panel).



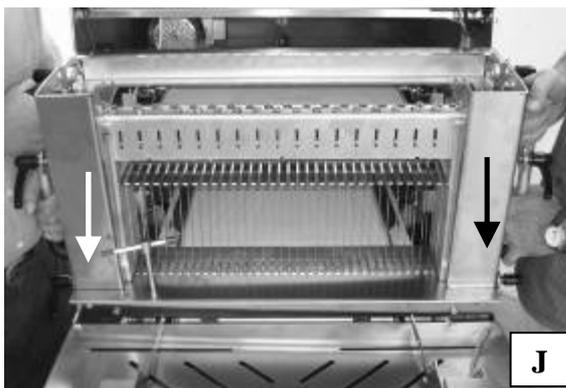


**Figure 15 - Disassembling the blade unit**

With reference to Figure 16, to mount a blade unit:

**8. Wear cut-resistant gloves and reinforced-toe work shoes**

9. Grasp the unit by the side handles with the sharp edge of the blades towards the feed belts (using two people, because **the weight is approximately 42 kg**) and lower it slowly into the housing (photo J-K) so that the knob pins (ref. 9) enter the slots (ref. 12) and rest on the base (photo L, movement 1); then push the unit towards the feed belts so that the knob pins (ref. 8) completely enter the slots ref. 11 (photo L, movement 2)
10. If the Allen Screw used to disassemble the unit is still in place, go on to step 11. Otherwise, make sure the indicators (ref. 13 and ref. 14) are aligned; if not, move the frame (ref. 15) until the two references are aligned (photo M). With the references aligned, insert the wrench in the hole (ref. 3), through hole (ref. 4) of the shaft (ref. 5) and into the socket head of the special screw (ref. 6) (photos N-O)
11. Screw and tighten the special screw (ref. 6) with force; then **remove the Allen wrench**
12. Screw and tighten, in order, knobs (ref. 8) and immediately after knobs (ref. 9) (tighten them so that that the blades are securely fastened)
13. Close the upper guard ref. 2 (photo P) and secure it tightening the knobs (ref. 1) (photo Q)



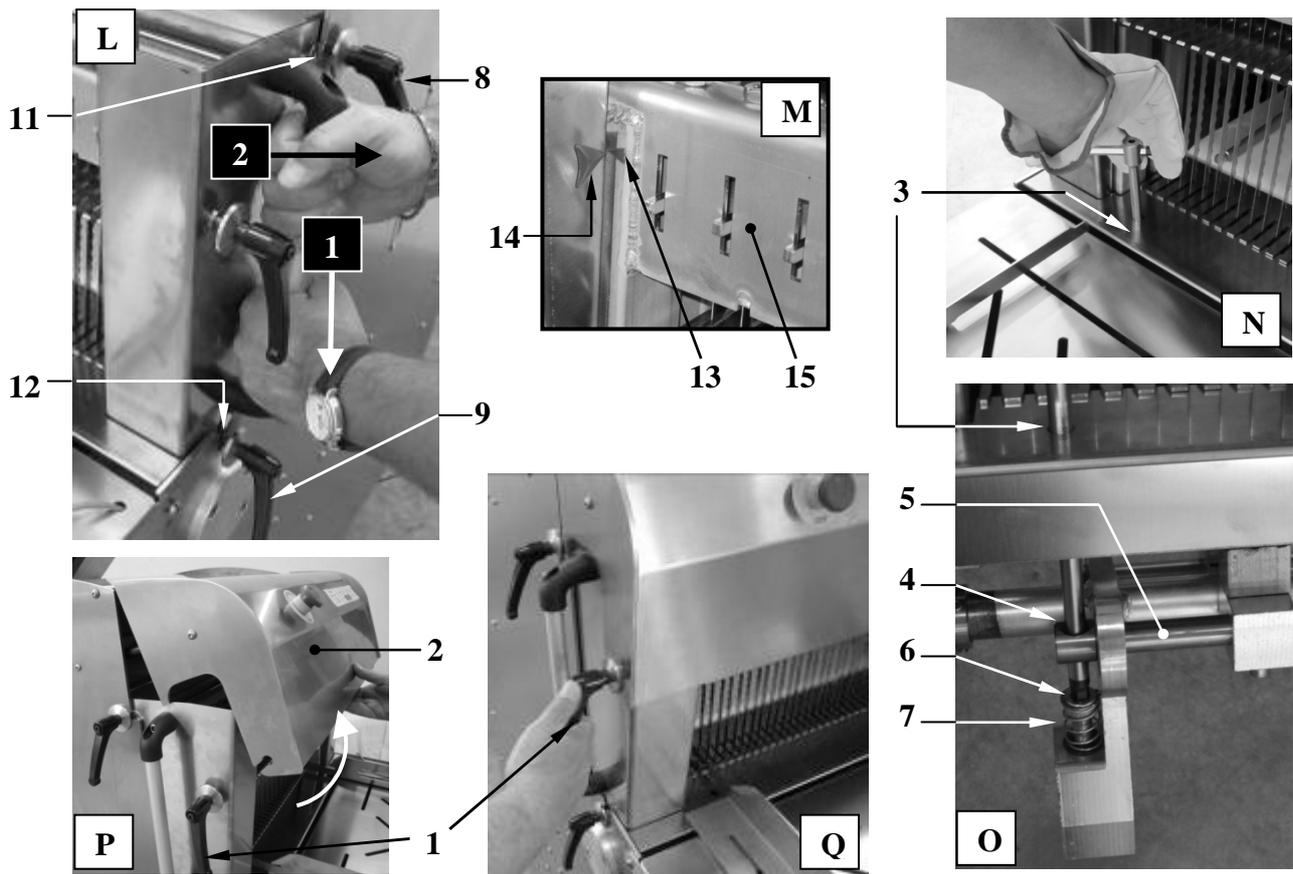


Figure 16 - Mounting the blade unit

## 4 MAINTENANCE

### 4.1 INTRODUCTION

Periodically it may be necessary to carry out maintenance operations on the machine which, for the purposes of this manual, and the risks associated with these interventions, can be of two types:

- **routine maintenance** interventions : all operations carried out periodically or even occasionally to maintain the machine in good, efficient working condition, not requiring the intervention of specialized personnel with specific preparation or professional qualifications. These operations therefore can be carried out by non-specialized personnel, such as the operator responsible for running the machine during the production phase, and provided that he follows the instructions provided in this manual scrupulously, and in particular the instructions in this Chapter.
- **extraordinary maintenance** interventions: all periodic and/or occasional operations required to maintain the machine in good, efficient working order, that require special preparation and/or professional qualifications and/or other specialist skills, therefore requiring the intervention of specialized, professionally-qualified personnel (where required by current legislation and standards), possessing all the technical and legal knowledge for carrying out the work properly.

All maintenance interventions described in this Chapter, whether periodical or not, and unless otherwise specified, relate to routine maintenance operations. As a consequence of this, all types of intervention that are not mentioned herein must be understood to be extraordinary maintenance. In case of doubt, contact the Manufacturer.

#### **WARNING!**

Unless otherwise specified, all maintenance and/or cleaning operations, no matter how simple, must be carried out only after you have disconnected the plug from the

power socket to avoid the possibility of the machine being put into motion, even accidentally, by others.

It is essential the disconnected plug be constantly within view so that anyone is able to constantly verify visually that the machine status is “not electrically powered”.

Should it be necessary to remove one or more guards or deactivate the safety devices to carry out certain intervention(s), adopt all measures necessary and possible to avoid putting others at risk (e.g. create a barrier around the work area with red and white chains, putting up also danger warning signs for the work in progress). **These guards must be put back exactly as before into place, and blocked using all the special fixing means provided and the safety devices must be reactivated as soon as there is no longer a reason for them to be removed.**

Anyone who, due to non-observance of the instructions contained in this manual (e.g. mishandling of the guards, including removing and/or omitting to put them back into place afterwards, and/or similar in relation to the safety devices), and/or due to improper or anyway non-compliant use of the machine in comparison with that foreseen, should cause direct or indirect damage to persons, things or animals, they should assume full responsibility.

## 4.2 PERIODIC MAINTENANCE

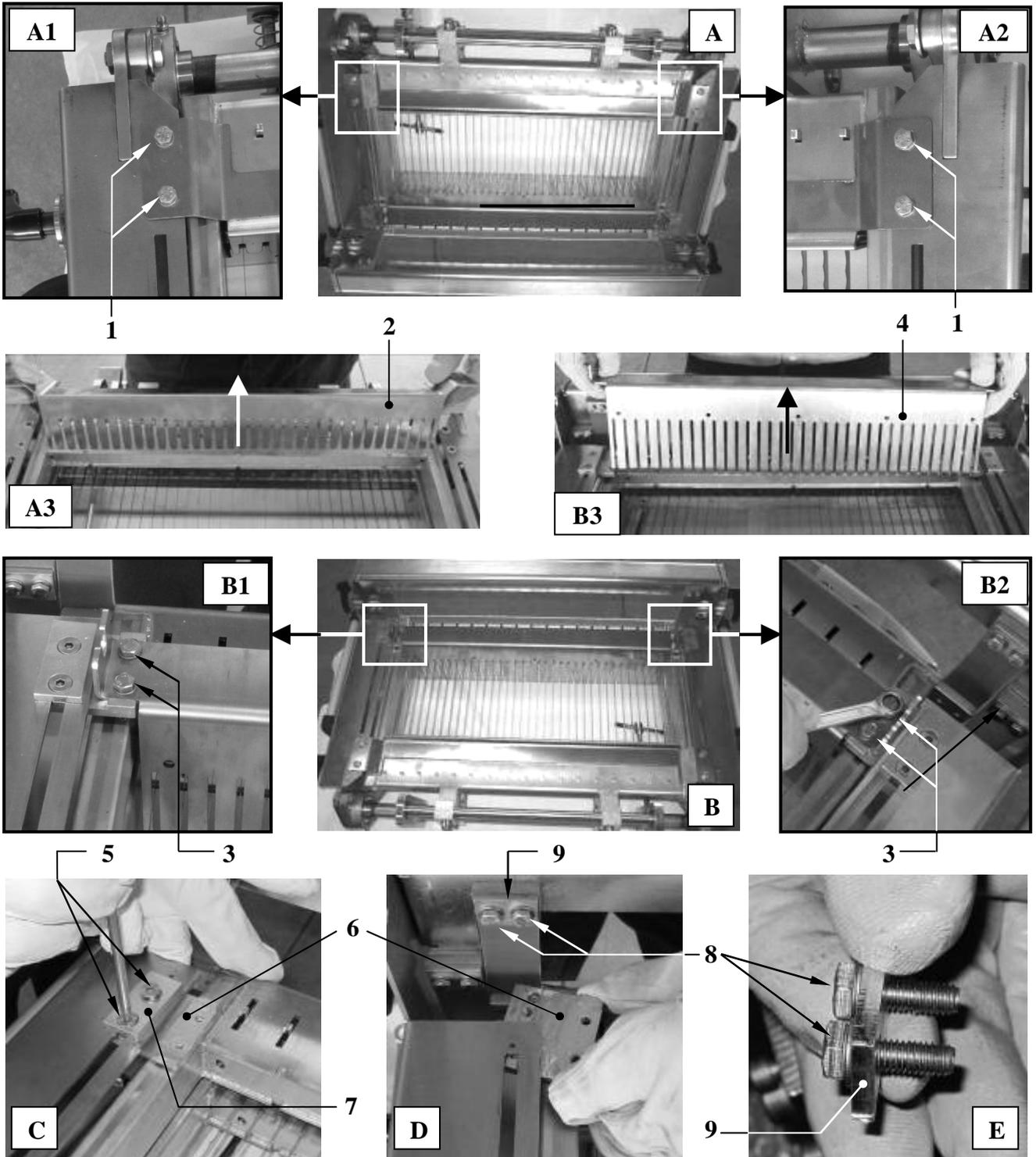
Before starting any operation, take the safety measures described in Section 4.1.

- **At the end of every work day or shift**, carry out a full, **meticulous cleaning of the machine**, following the instructions in Section . 4.9
- **At the end of every work day or shift**, verify that the safety devices are intact and working efficiently by performing the checks in Section 5.2.3

## 4.3 BLADE REPLACEMENT

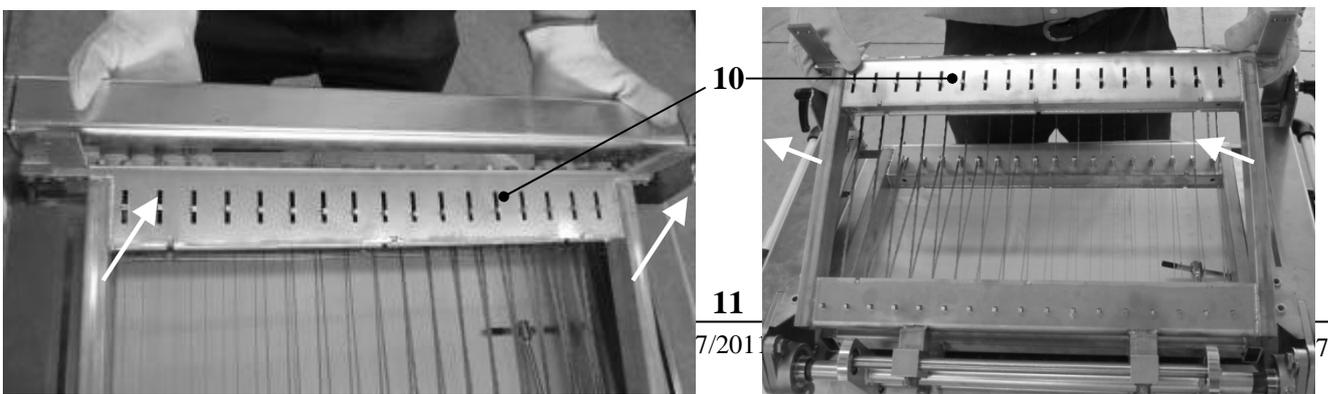
To perform this operation, restricted only for specialized technicians and experts in mechanical assemblies (extraordinary maintenance), the operator must **wear cut-resistant gloves**, especially before touching or getting close to the blades (the sharp edge of the blades is very sharp and slight contact could cause injury resulting in bleeding) **and reinforced-toe work shoes**. Referring to Figure 17 which consists of a series of images interspersed with their related instructions, proceed as follows to replace a blade:

1. Disassemble the blade unit (see par. 3.4.10) and place it, with the sharp sides upwards, on a plane of work having a width equal to that of the unit and a length at least twice the height of the unit
2. With a 10 mm hexagonal-head wrench (for castle nuts, pipe, etc.), remove the 4 screws (TE M6) and washers (ref. 1) (photo A-A1-A2), then remove the rack (ref. 2) (photo A3) and put it in a safe place
3. With the same wrench, remove the no. 4 screws and washers (ref. 3) (photo B-B1-B2), then slip off the rack (ref. 4) (photo B3) and put it in a safe place.
4. hold the plate from below (ref. 6) to prevent it from falling; with an Allen wrench, remove the 2 countersunk head M6 screws (ref. 5) (photo C), remove the plate (ref. 7) and slip off the small plate (ref. 6) (photo D); do the same on the other side.
5. with a 10 mm hexagonal-head wrench, remove the two TE M6 screws (ref. 8) with the small plate (ref. 9) (photo D-E); do the same on the other side.



**Start Figure 17 - Procedure for Replacing a Blade**

6. Lift the frame (ref. 10) above and, rotating it around the pin (ref. 11) rest it on the opposite side (photo F-F1); **watch out for your hands!**

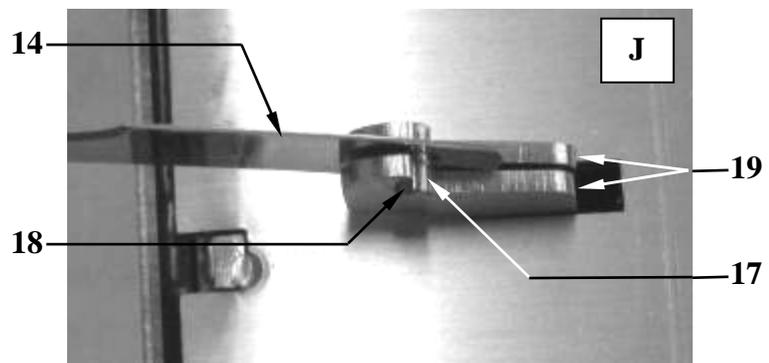
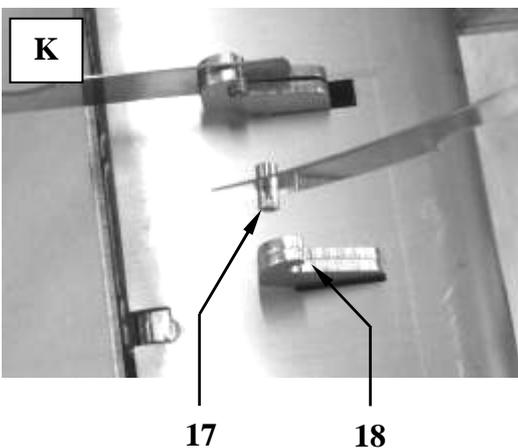
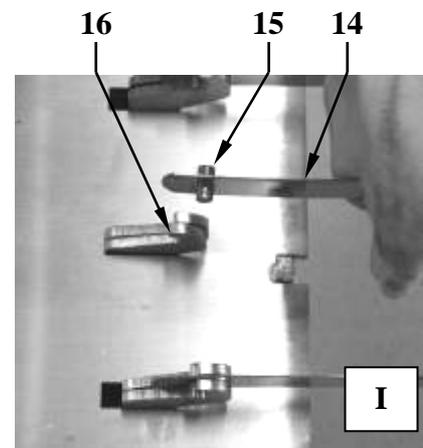
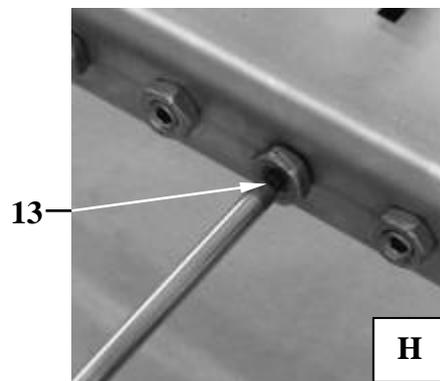
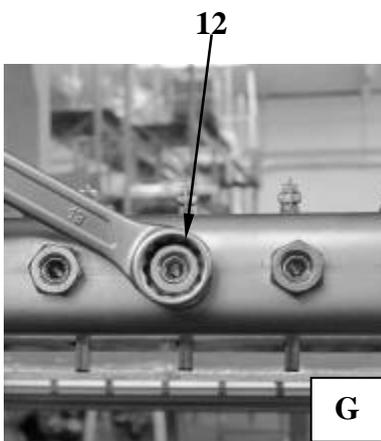


F

F1

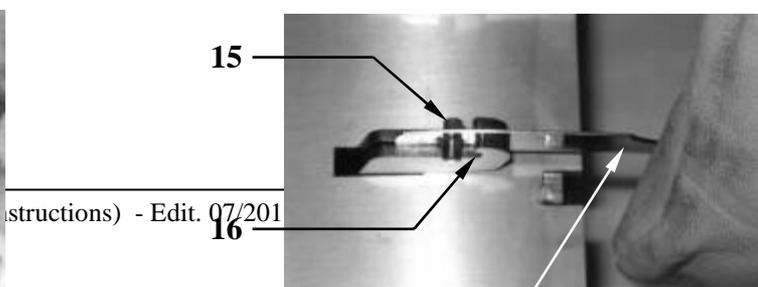
### Continue Figure 17 - Procedure for Replacing a Blade

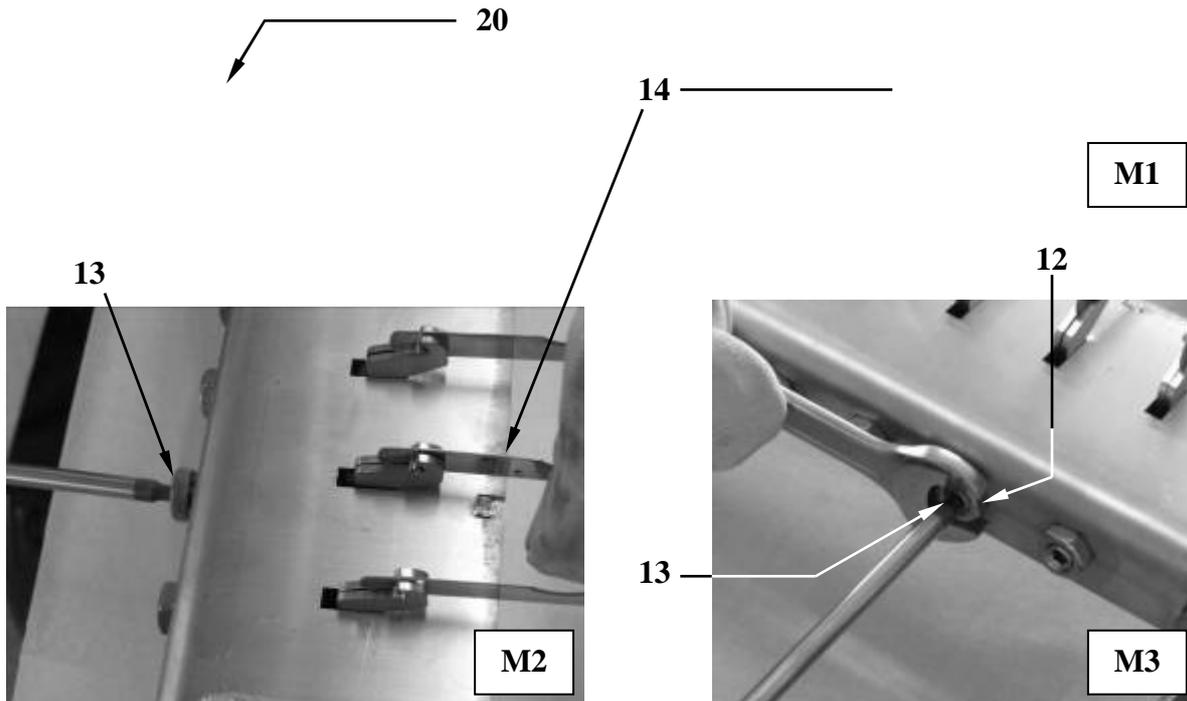
7. With a 13 mm wrench, loosen the lock nut (ref. 12) corresponding to the blade to be changed (photo G), then, with a 4 mm Allen wrench, unscrew the blade screw (ref. 13) (photo H) until it is barely loosened
8. Grip the blade Ref. 14 and unhook the pin, Ref. 15, from the hook, Ref. 16 (photo I).
9. Unhook the lower pin of the blade, Ref. 17, from its hook, Ref. 18 (photo K). Put the blade in a safe place to avoid the risk of it cutting anyone accidentally.
10. Insert the new blade (ref. 14) between the two halves of the coupling (ref. 19) (on the side opposite to where the screw (ref. 12) was loosened) and position the lower pin (ref. 17) in the notch (ref. 18) (photo J)



### Continue Figure 17 - Procedure for Replacing a Blade

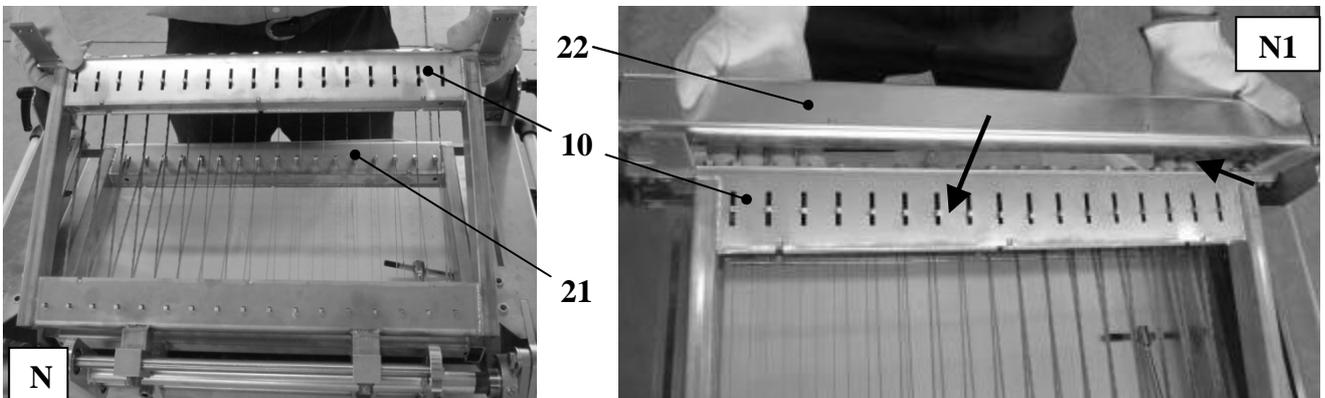
11. Keeping the hammer low and working with one hand on the protrusion, Ref. 20, on the opposite side of the rack, guide the upper pin, Ref. 15, of the blade Ref. 14, into its seat, Ref. 16 (photos M - M1).
12. Hold the blade in position (ref. 14) with one hand, and pull it taught with the other, tightening the screw (ref. 13) (photo M2); finally secure the screw (ref. 13) (hold it still with the Allen wrench) tightening the nut (ref. 12) (photo M3)





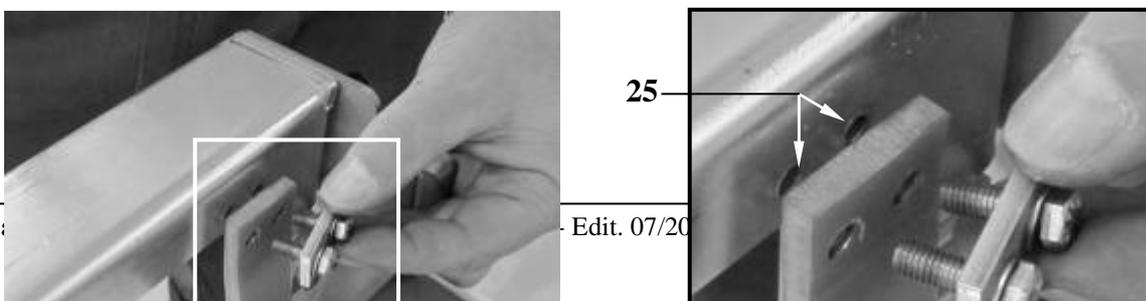
**Continue Figure 17 - Procedure for Replacing a Blade**

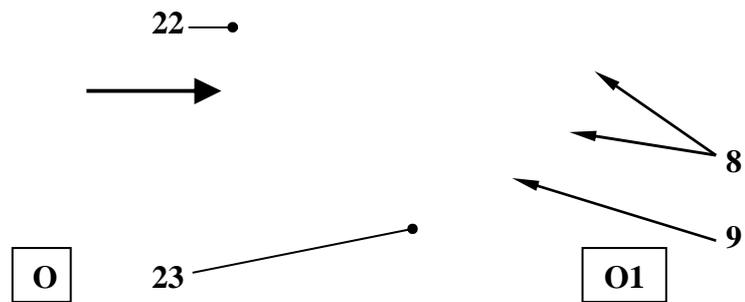
13. Bring the frame (ref. 10) to rest on frame of ref. 21 accompanying it slowly by hand (inverse operation of that described in the previous step 6 (photo F-F1); **be careful with your hands**, especially when passing above and below the cross bar (ref. 22) and when setting down the frame (ref. 10).



**Continue Figure 17 - Procedure for Replacing a Blade**

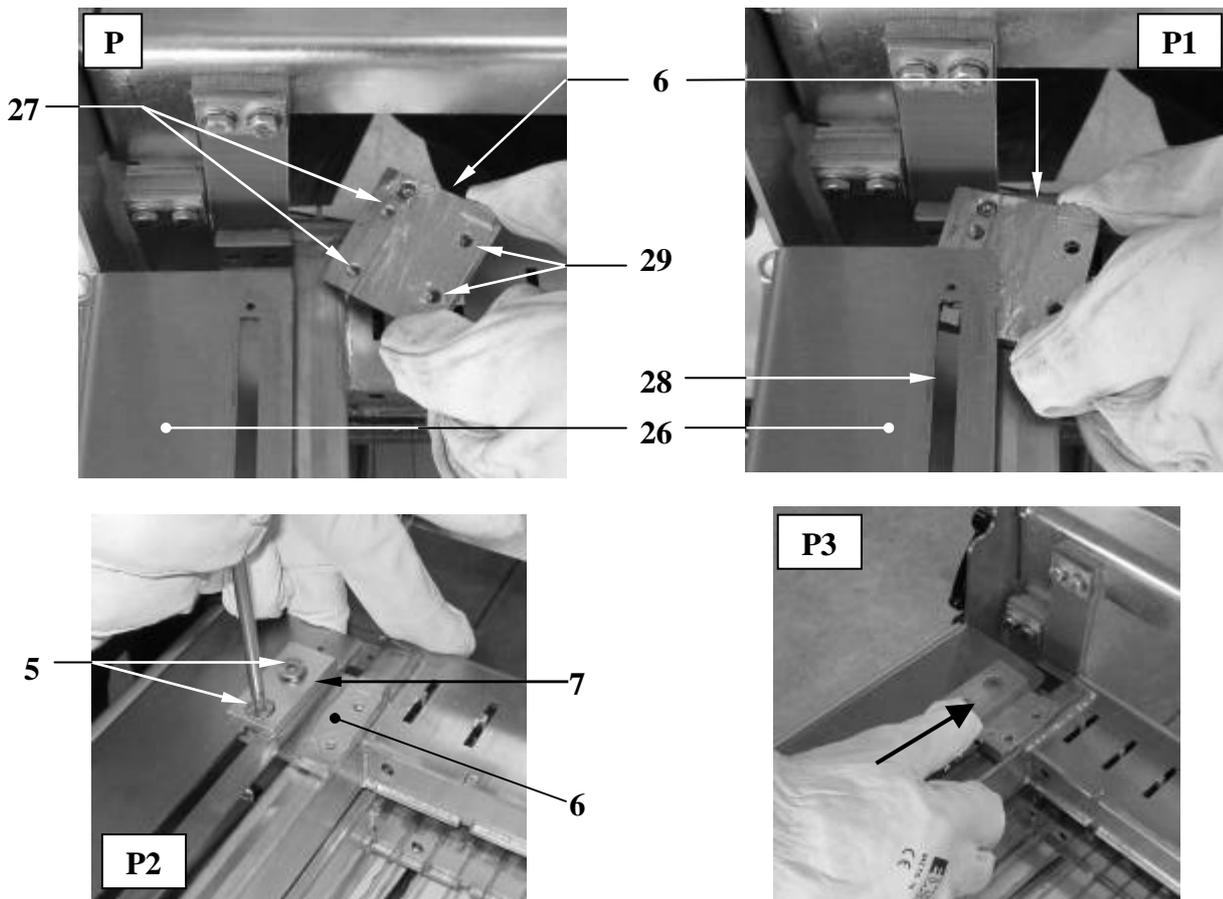
14. With a 10 mm hexagonal head wrench, secure the hard rubber plate, (ref. 23) with the small plate (ref. 9) and the TE M6 screws (ref. 8) which are screwed in the threaded holes (ref. 25) of the cross bar (ref. 22) (photo D-E) through the clearance holes (ref. 24); do the same on the other side





### Continue Figure 17 - Procedure for Replacing a Blade

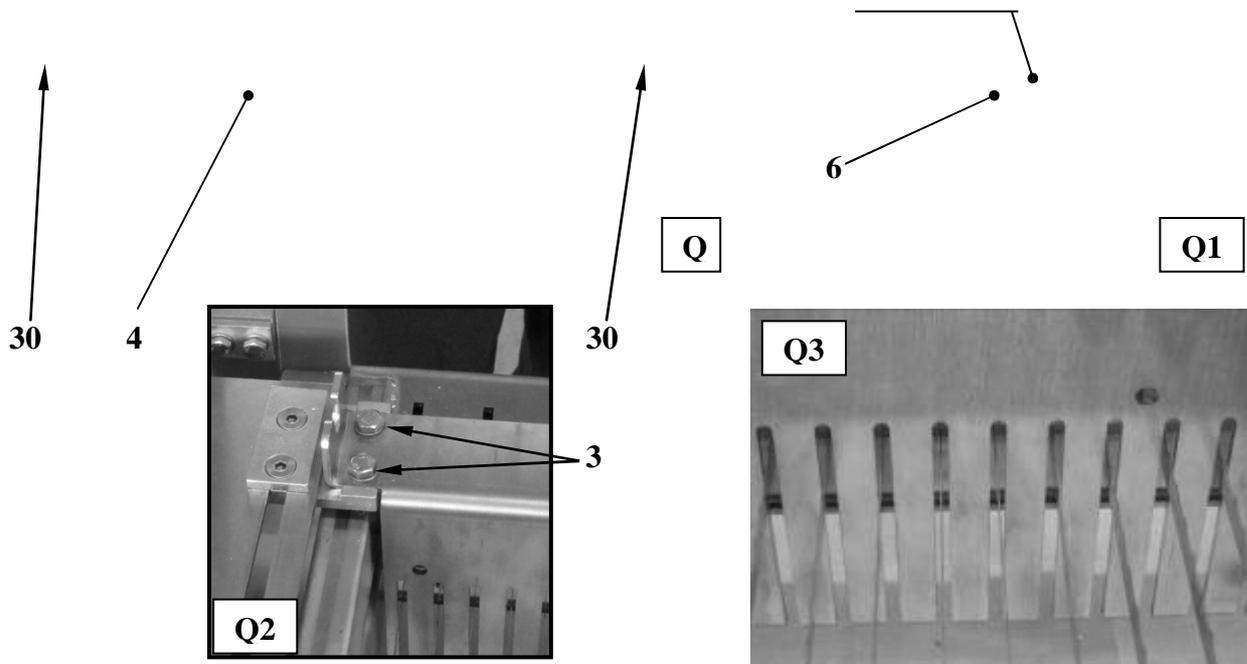
15. Insert the small plate (ref. 6) below the plate (ref. 26) so that the threaded holes (ref. 27) correspond with the slot (ref. 28). **IMPORTANT! The small plates are different for the two sides: insert them with the threaded holes (ref. 29) facing the blades** (as in photo P1). Hold the small plate (ref. 6) with one hand so that it does not fall, position the plate (ref. 7) so that its clearance holes coincide with the threaded holes (ref. 27), then, with an Allen wrench, securely screw and tighten with the 2 M6 countersunk head screws (ref. 5) (photo P2); finally, with your thumb, push the plate (ref. 7) and the small plate (ref. 6) joined together (photo P3) with force until they snap into place (you will hear a sharp click). Do the same on the other side



### Continue Figure 17 - Procedure for Replacing a Blade

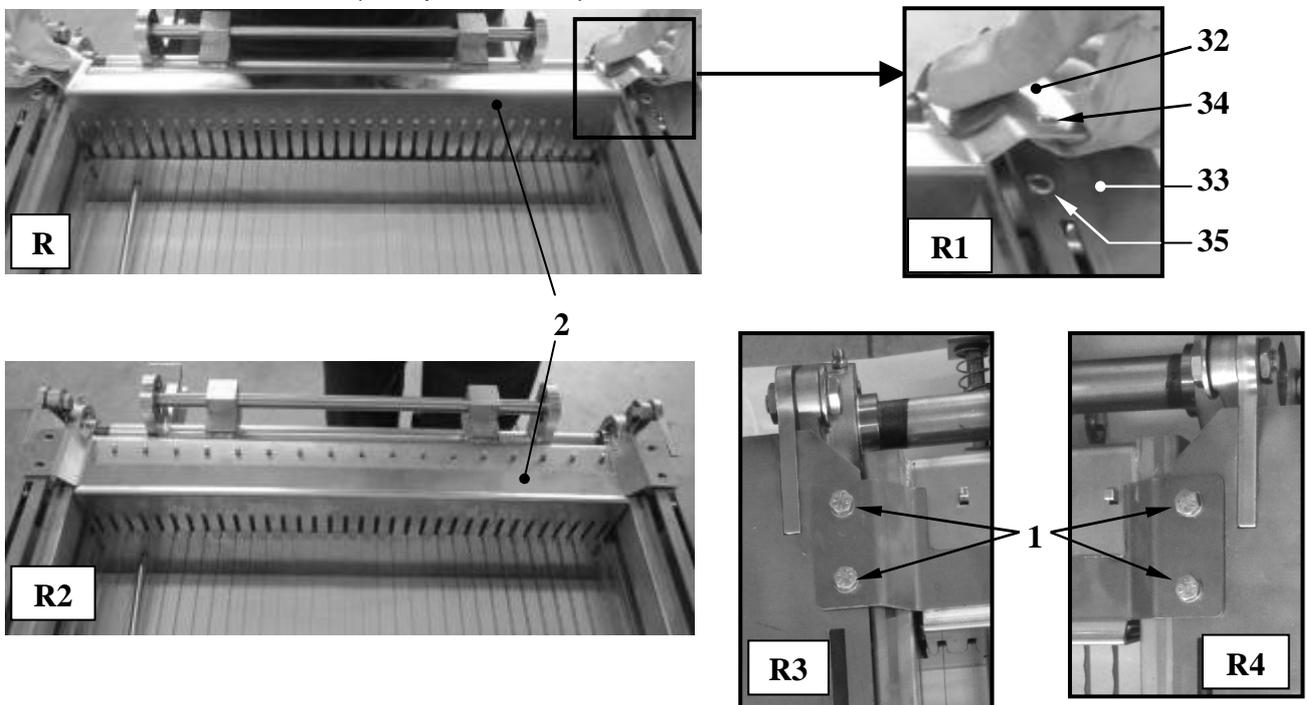
16. Insert the rack (ref. 4) between the blades from the top to the bottom (photo Q) taking care to not hit the sharp edge of the blades; set the protrusions (ref. 30) on the surfaces (ref. 31) of the plates (ref. 6) so that the holes coincide. With a 10 mm hexagonal head wrench (for castle nuts, pipe, etc.), screw, without tightening, the 4 screws (ref. 3) and the corresponding washers (photo Q2). Adjust the rack position so that the blades are at the center of the slots (photo Q3), then securely tighten the screws (ref. 3)





**Continue Figure 17 - Procedure for Replacing a Blade**

17. Insert the other rack (ref. 2) between the blades from the top downwards taking care to not hit the sharp edge of the blades; set the protrusions (ref. 32) on the surfaces (ref. 33) so that the holes (ref. 34 and ref. 35) coincide (photo R-R1-R2). Screw on without tightening the screws (ref. 1); center the blades in the slots of the rack (as shown in photo Q3), then securely tighten the screws (ref. 1)
18. Mount the blade unit (see par. 3.4.10)



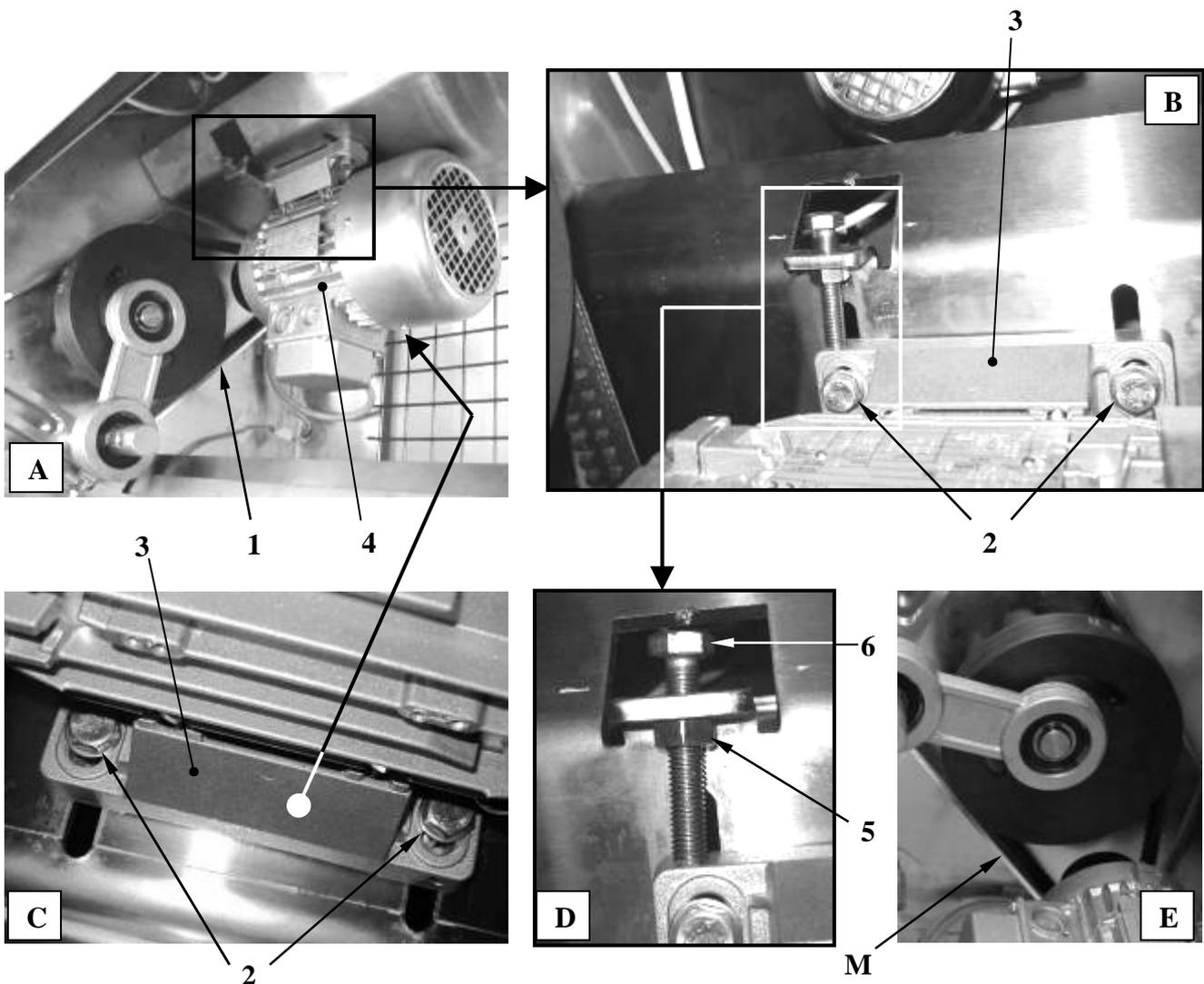
**End Figure 17 - Procedure for Replacing a Blade**

#### 4.4 TRASMISSION BELT REPLACEMENT AND TIGHTENING

To perform this activity, which is reserved only to specialized technicians, who are expert in mechanical assemblies, (extraordinary maintenance), the operator must **wear work gloves that provide good anti-abrasion protection.**

With reference to Figure 18, proceed as follows to adjust the tension of the two belts (ref. 1):  
1. Disassembling the blade unit (see par. 3.4.10); the transmission system (motor, pulleys,

- belts, connecting rods, etc.) will be accessible through the compartment thus remaining open (photo A)
2. Loosen the 4 screws (ref. 2) that secure the base (ref. 3) of the motor (ref. 4) (photos B-C)
  3. Loosen the nut (ref. 5) and rotate the screw (ref. 6) (photo B-D) to raise or lower the base ref. 3 as needed; the tension is correct, when, upon pressing the belts with a finger in the middle of the free section, (approximately at the point indicated with an M in photo E), they flex slightly.
  4. When the adjustment is complete, secure everything tightening the lock nut (ref. 5) and the 4 screws (ref. 2) that secure the base (ref. 3) of the motor (ref. 4)
  5. Remount the blade unit (see par. 3.4.10)
  6. Perform the test and any activities according to step 3 of par. 5.2.3.

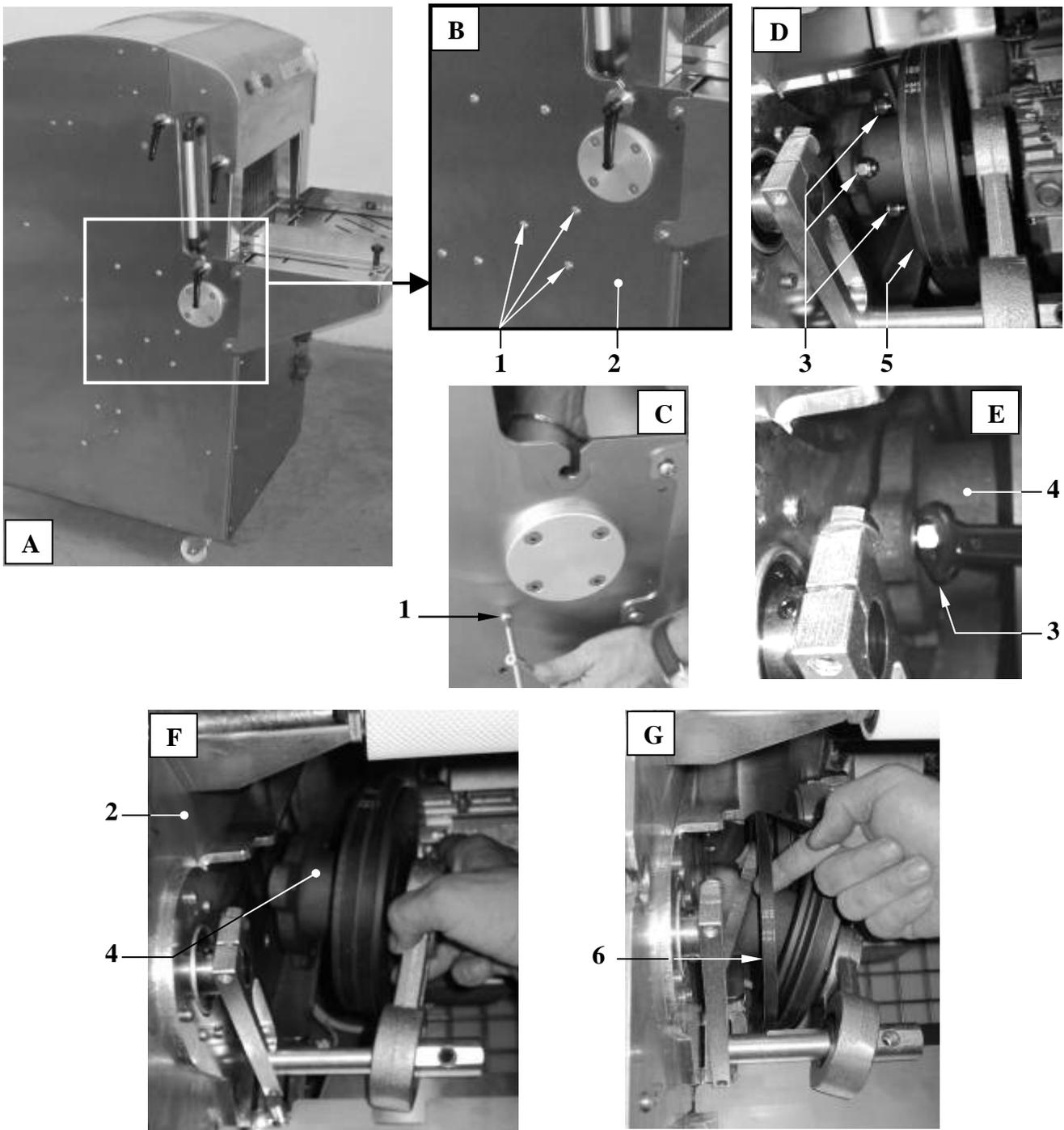


**Figure 18 - Adjusting the tension of the drive belts**

With reference to Figure 19, replace the belts (always both and never just one):

- a) Disassemble the blade unit (see par. 3.4.10)
- b) Loosen the belts as described in paragraphs 2 and 3 above

- c) Holding the screws (ref. 1) still with an Allen wrench from the outside of the shoulder (ref. 2) (photo B-C), remove the nuts (ref. 3) that secure the pulley (ref. 5) supports (ref. 4) (photo D-E)
- d) Detach the support (ref. 4) (photo F) from the shoulder (ref. 2) and slip the belts (ref. 6) off through the passage between the shoulder and support thus created (photo G)
- e) insert two new belts through the same passage and place them in the pulley rims
- f) Set the support base (ref. 4) against the inside of the shoulder (ref. 2) so that the through holes are inserted in the screws threads (ref. 1); finally, screw and tighten the nuts of the unit (ref. 3)
- g) Adjust the tension of the belts as described in paragraphs 3 and 4 further above.
- h) Remount the blade unit (see par. 3.4.10)



**Figure 19 – Transmission belts replacement**

#### 4.5 INTERVENTIONS PERFORMED EXCLUSIVELY BY ROLLMATIC

## AUTHORISED TECHNICIANS

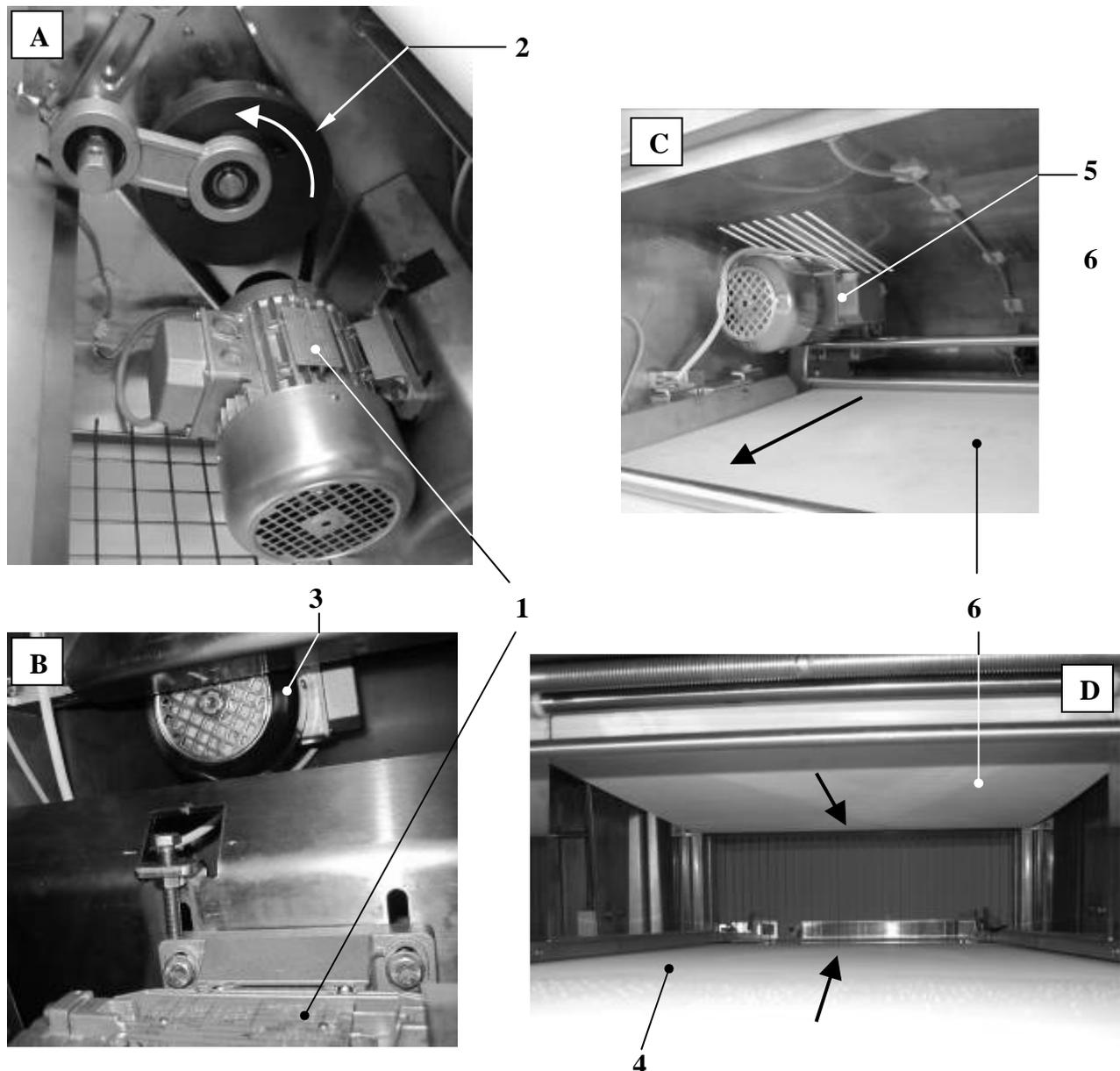
All maintenance interventions other than those previously described here must be considered extraordinary maintenance, and carried out exclusively by ROLLMATIC technicians, or technicians explicitly authorized by them, in particular for:

1. replacement of blade support racks
2. replacement of the motor. In this case, always verify that the direction of rotation is correct:

- motor (ref. 1) that drives the blade-holder frames (see Figure 20, photo A); as a rule, there is an arrow on the pulley (ref. 2) that indicates the correct direction of rotation (if the pulley ever has to be disassembled, it must later be reassembled exactly as it was before)
- motor (ref. 3) (see Figure 20, photo B) of the bottom feed belt (ref. 4)
- motor (ref. 5) (see Figure 20, photo C) of the top feed belt (ref. 6)

The direction of the feed belts must be such that (see Figure 20, photo D) their opposing sides move towards the blades (ref. 7)

If a motor's direction of rotation is incorrect, invert two phases within the corresponding terminal box (operation to be performed by an expert electrician); **never substitute the ground cable (yellow-green) with a phase cable for any reason.**



**Figure 20 – Correct Direction of Rotation**

#### 4.6 POSSIBLE BREAKDOWN AND/OR ERROR SITUATIONS

We indicate here some error situations that could occur while the machine is in service.

The subsequent intervention must be carried out in compliance with the instructions, where provided, and in any case **only after having switched off and disconnected the machine from the electrical supply.**

Problem	Possible causes	Solutions
<b>The machine does not start</b>	<ul style="list-style-type: none"> <li>• No electrical power supply</li> <li>• Fuse(s) blown</li> <li>• Emergency button pressed</li> <li>• The blade-unit cover is not closed correctly</li> <li>• Faulty control</li> </ul>	<ul style="list-style-type: none"> <li>- make sure the plug has been put in the socket properly; if it is and the numerical displays do not turn on (providing they are not malfunctioning!) then the problem lies upstream of the machine.</li> <li>- check the safety devices for the electricity line in the work place and, if necessary, reset them</li> <li>- Replace (<b>extraordinary maintenance</b>)</li> <li>- reset it</li> <li>- close it</li> <li>- Ask the manufacturer for help</li> </ul>
<b>The machine is very noisy and vibrates in an unusual way</b>	<ul style="list-style-type: none"> <li>• The rotation direction of the blade motor, Ref. 1 Figure 20 is wrong</li> </ul>	<ul style="list-style-type: none"> <li>- see par. 4.5 (<b>special maintenance</b>, reserved exclusively for ROLLMATIC authorized technicians)</li> </ul>
<b>The working of the machine is not uniform</b>	<ul style="list-style-type: none"> <li>• Belts tightening not correct</li> </ul>	<ul style="list-style-type: none"> <li>- See to its adjustment (Section 4.4; <b>extraordinary maintenance</b>)</li> </ul>
<b>Slicing quality is not acceptable</b>	<ul style="list-style-type: none"> <li>• Blades worn</li> <li>• Distance between feed belts not properly adjusted</li> </ul>	<ul style="list-style-type: none"> <li>- Replace (Section 4.3; <b>extraordinary maintenance</b>)</li> <li>- Adjust it (par. 3.4.7)</li> </ul>

#### 4.7 RECOMMENDED SPARE PARTS

When considered necessary or foreseen by the contract, a list of recommended spare parts is delivered together with the manual and, in this case, must be considered an integral part of it. When ordering spare parts, provide a brief description, an indication where they are located in the machine and the exact serial number of the machine. Store the spare parts carefully in a suitable place that takes into account their storage requirements (following the Manufacturer's indications), and make the place known to maintenance personnel. Verify periodically their traceability.

#### 4.8 ELECTRICAL MAINTENANCE

**WARNING! Before accessing any part of machine powered electrically, remove the plug from the electrical socket.**

Taking into account the high risk and seriousness of the damage that could result in case of accident, **all interventions** (even if they seem simple such as replacing a fuse), that

involves directly or indirectly the electrical equipment of the machine **be performed by specialized technical personnel, professionally-chosen, and possessing the technical and legal knowledge for carrying out the work properly, explicitly given responsibility for carrying out these operations, and who must beforehand have read this manual in its entirety.**

An electrical circuit diagram is provided as an annex to this manual, and constitutes an integral part of it.

#### **4.9 CLEANING THE MACHINE AND THE WORK PLACE**

In compliance with current legislation and standards, the work place and therefore the machine also must be maintained in perfect conditions of hygiene. They must be cleaned scrupulously at the end of every working day or work shift, and meticulous cleaning must always be carried out also when machine operation is to be suspended for a lengthy period. Empty the crumb collection drawer (see also Section 3.4.5) and wash it internally and externally with clean drinking water. Dry it carefully before putting it back into place.

**When cleaning the slot where the drawer is housed, limit yourself to cleaning only the volume occupied by the drawer itself.**

To clean the machine completely, it is necessary to dismount the blade unit (see par. 3.4.10), which, being practically made entirely of stainless steel, may be washed separately with water and kitchen detergent (**first put on water-proof cut-resistant gloves**; also see warning below); rinse each part of the blade unit with clean water; each part must be dry before remounting the unit.

Using a vacuum-cleaner, with a slim nozzle if necessary, remove residues and impurities from all parts of the machine. Plastic brushes or tools can be used to remove difficult stains while, only if necessary, and for brief periods, compressed air can be used to remove residues from areas which are difficult to reach. **In this case, as a preventive measure, wear a protective mask for the respiratory system and safety glasses offering full protection. Require anyone present to leave the area, and ventilate the environment well during use of the compressed air, and for at least 20 minutes afterwards.**

**Clean any stains with a clean cloth dampened with drinking water, but not dripping** (for normal cleaning operations do not use detergents or other chemical products, but only drinking water) **Do not use metal objects**, especially if they have cutting and/or pointed edges **in order not to damage any parts.**

#### **WARNING!**

**When cleaning or doing other work near the blades always wear cut proof gloves.** The cutting edges of the blades are extremely sharp and even the slightest contact could cause injury and even lead to haemorrhaging; **if this does happen do not use the machine until it has been properly disinfected by expert and specialized personnel.**

**Periodically** (depending on how often it is used) **disinfect all parts** that may come in contact with food, spraying them with normal kitchen detergent with disinfectant properties, not aggressive and not harmful to health (**first put on cut-resistant gloves and any other PPE indicated in the MSDS accompanying the product**); let detergent act for the time recommended by the detergent manufacturer, then wipe the detergent off the parts with a clean cloth wetted with potable water and rinsed frequently (after this operation it is necessary to cut about ten loaves of bread (the resulting slices must neither be sold nor eaten but must be disposed of in accordance with waste disposal laws in force).

After finishing the cleaning and/or disinfecting operations, **wash and disinfect your hands well.**

If necessary (e.g. if insects are found inside the machine), **the machine must be disinfested** by appointing a specialized firm.

## 4.10 PUTTING MACHINE OUT OF SERVICE FOR LONG PERIODS

In case the machine is put out of service or not used for a prolonged period, disconnect the machine from the electric supply, clean all parts carefully, and cover it with a clean, waterproof cover to protect it from environmental agents, dust, insects, rodents etc.

Adopt appropriate measures to avoid the machine risking being subject to jolts, tampering, damage, misuse etc.

Before putting the machine back into service, carry out a careful preliminary examination to ensure that it is intact, then proceed as for using the machine for the first time.

## 5 SAFETY

### 5.1 INTRODUCTION

The description of the risks and related considerations provided in this Chapter presume:

- knowledge of the normal working conditions of the machine and its intended use
- that the machine is destined for use in a working environment where bread and/or bakery products are produced
- that the operators have been adequately instructed and are aware of the specific and general risks present in the working environment, in compliance with current legislation and standards
- that access to the working environment is forbidden to anyone who is not an operator, and to outsiders and children.

#### **VERY IMPORTANT!**

Before using or putting the machine into operation, the user must read and understand the instructions and indications in this manual. Consequently, when using or putting the machine into service, the Employer at the site where the machine is used declares implicitly that they assume all civil and criminal responsibility resulting from damage to persons, animals and things, which may occur as a consequence of non-observance, even partial, of said instructions and indications.

### 5.2 DANGERS, SAFETY MECHANISMS AND RESIDUAL RISKS

In compliance with Directive 2006/42/EC is provided below, in clear, concise form, the information required on the dangers related to the machine and associated risks, as well as the measures adopted to eliminate or reduce them. Where it is not possible to eliminate completely certain types of risk, detailed information is provided on the related residual risk, and any further measures to be adopted by the user to limit even more their impact.

#### 5.2.1 COMMON HAZARDS RELATING TO MACHINE

The machine presents dangers of the following types:

##### **Mechanical:**

- **Cutting:** through contact with the cutting edge of the blades in movement, when passing:
  - from the loading side of the bread to be cut
  - via the bread output side
  - through slot normally occupied by crumb collection drawer
- **Squeezing, shearing, trapping, dragging through** contact with mechanical bodies in movement
- **Entanglement, entrainment, and crushing** between the feed belts in normal motion (the risk increases as the distance between belts shortens)
- **Injuries from cutting** due to contact with the cutting edge of the blade, even if stopped, during blade cleaning or replacement operations.

##### **Electrical:**

- **Electrocution** due to direct or indirect contact with electrical parts, or due to external factors that impact the electrical equipment

**Hygienic/ Biological:** alteration of foodstuffs for example due to multiplication of germs and bacteria, the presence of foreign substances etc.

Related risks have been eliminated or reduced as much as possible, and/or can be further reduced by taking the measures and implementing the safety devices described in Sections 5.2.2, 5.2.3, 5.2.4, 5.2.5, 5.2.6 and 5.4.

That more complete the information provided to operators, and the better instruction and/or training they receive on the correct use of the machine and its related risks, the more efficient will be the measures adopted.

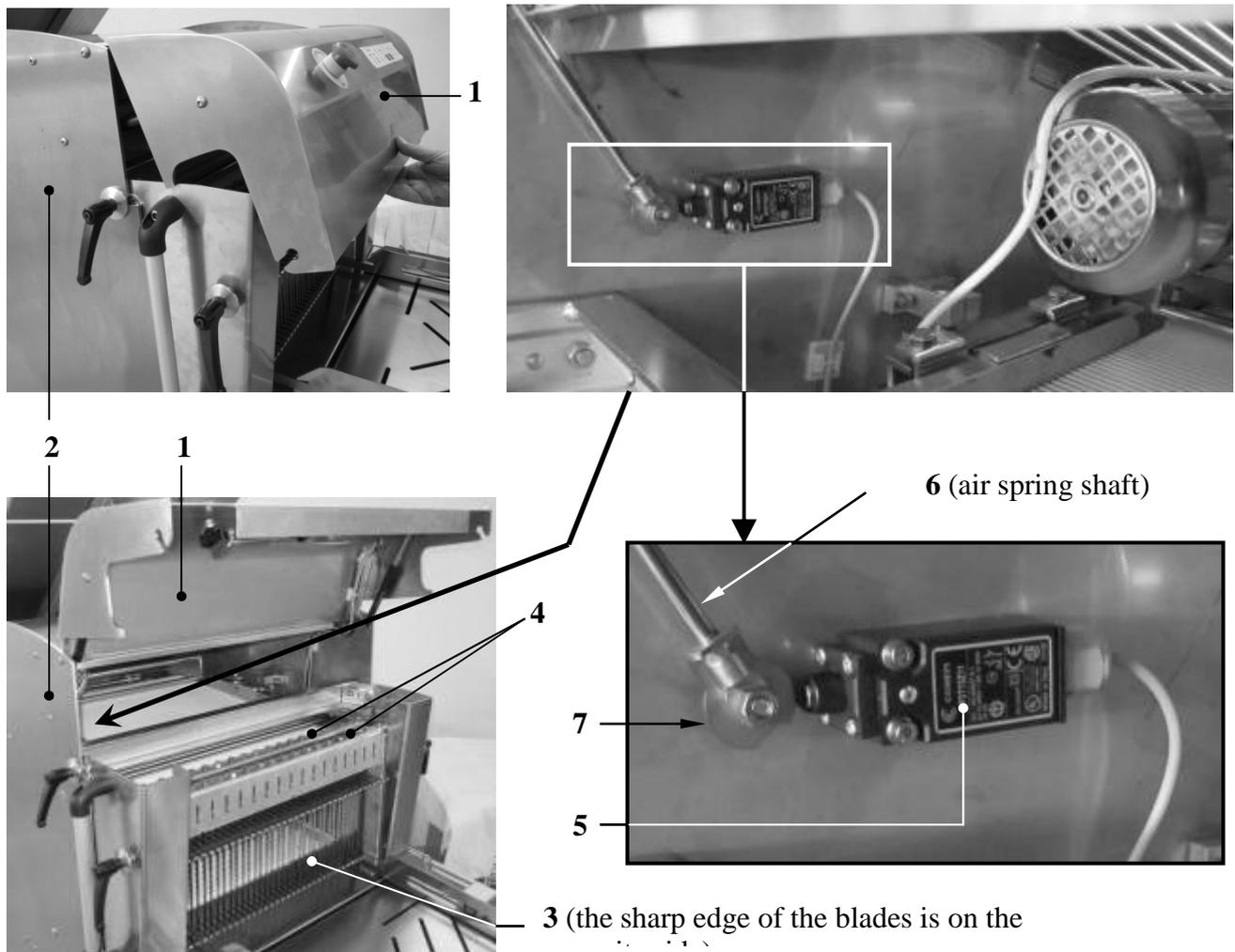
## 5.2.2 SAFETY MECHANISMS AND RELATED CONSIDERATIONS

1. Interlocked guard (ref. 1 Figure 21), which in association with the machine structure (ref. 2) makes access to the sharp edge of the blades (ref. 3) impossible while they are moving, passing above the blade-holder frames (ref. 4 and ) prevents access to the zone and possible crushing between frames and fixed parts, and also between the frames themselves in motion with respect to each other; in fact, if the safety microswitch (ref. 5) associated with the guard (ref. 1) through the air spring (ref. 6) and the corresponding cam (ref. 7) do not “sense” that the guard (ref. 1) is “closed,” the safety system blocks any start command (if instead the machine is operating, it makes an emergency stop command).

This is useful in particular in the blade unit assembly and disassembly process (par. 3.4.10) since it allows the assigned personnel to work safely. It should be noted however that when the guard (ref. 1) begins to open, the safety microswitch (ref. 5) does not intervene immediately, but only after the guard has moved from the closed position to a distance just sufficient for one's a hand to pass (though with difficulty) through the space between the cover and upper profile of the blade-holder frames (ref. 4) or other fixed parts.

A residual risk of collision, contusions, crushing and cutting does remain however (though very unlikely, practically null); for this reason **it is absolutely forbidden to even attempt to place your hands beneath the guard: there is no reason to do so and you would be unnecessarily exposed to a crushing and cutting risk** for the reasons already explained (do not perform similar actions even if the blades are still, remember they are very sharp and it is extremely easy to get injured).

When the guard (ref. 1) opens, the safety micro-switch (ref. 5) commands the moving parts to stop within approximately 1 second.



**Figure 21 - Top mobile guard with associated safety microswitch**

2. The blades are arranged with the blunt side towards the loaf output area. To prevent the possibility of the cutting side of the blades being reached from the product output side, the maximum pitch that can be provided by the blades is 18 mm. In case of specific requests for implementation of a larger pitch, Rollmatic reserves the right to evaluate the feasibility, indicating however that in no circumstances can the pitch exceed 25 mm.
3. The machine is equipped with two emergency stop buttons (Ref. 1 Figure 2). When one button is pressed, all parts of the machine are stopped in a brief lapse of time (within approximately one second), electricity to all parts of the machine is interrupted, and the start command is inhibited. The machine cannot be restarted until the emergency button is reset (after having removed the causes that led to its use).
4. Continuous action control holding the button (ref. 2 Figure 2) pressed for 2 seconds or more to drive the belts in the opposite direction; this measure was adopted to prevent the risk of accidental entanglement and entrainment due to the belts moving contrary to the normal direction
5. The machine is equipped with fixed guards (i.e. product unloading surface, blower, etc.), fastened to the structure with screws and which require at least one tool to be removed; with the devices described above, with the structure, and with other machine parts (blade, feed belts, etc.) they prevent access to the load-bearing structure of the machine where the mechanical drive gear located. Note the presence of steel grid that does prevents access to the transmission gear, which would otherwise be accessible above the

compartment that houses the bread crumb drawer (see Figure 22).

Access to the operating gear and to the feed belts in particular is not however completely prevented due to the presence of the aperture where the bread to be cut passes (also see par. 5.2.4); a steel cross bar has however been anticipated in correspondence with the bread feed opening that acts as a stop at shoulder and at least prevents access to the blades if someone places their arm in, (something absolutely forbidden however); this steel bar, visible in Figure 23, also assumes the connotation of "fixed guard".

#### **WARNING**

**It is forbidden to open and/or remove the guards and/or deactivate the safety devices, unless specifically necessary for requirements of work, and provided suitable measures are taken to make evident the resulting risks. These operations must only be carried out, and for the time strictly necessary, by expert personnel, trained and explicitly authorized. The safety devices must be reactivated and the guards put back into place and fixed using all the mechanisms provided as soon as the reasons that made their temporary removal/deactivation necessary no longer exist.**



View looking up from inside the drawer housing

**Figure 22 - Fixed grid enclosing the top of the crumb-drawer compartment**

### **5.2.3 VERIFYING EFFICIENCY OF SAFETY MECHANISMS**

**If even one of the following checks should have a negative outcome, do not use the machine but request the intervention of a specialized technician, who is an expert in the related field** with a thorough knowledge of the current safety legislation. With reference to the safety mechanisms described in Section 5.2.2, at the start of every work day and/or shift, you must carry out the following checks:

1. With the cover open, command the machine to start; no part must move. Close the cover without securing it with the knobs, start the machine and, pushing on the lower edge, with your hands, without passing beyond it with your fingers, raise the cover: each machine part must stop within a maximum period of 1 second; if the stopping period is greater than 1 second, have a specialized technician adjust the tension of the power transmission belts (par 4.4) until a stopping period less than 1 second is obtained
2. Check that the blades are all present, intact and without deformations. **The free space around each blade must never exceed the nominal pitch by more than 0.5 mm and, anyway, never exceed 25 mm.**
3. Start the machine; press one of the two emergency stop buttons while its parts are moving: all movements should stop in about 1 second. If the stopping time is more than 1 second, request a specialized technician to adjust the tightness of the transmission belts (Section 4.4) until a stopping time less than 1 second is achieved. With the emergency button pressed, action the start. No part of machine should begin to move. Before the

start can be commanded, the emergency stop button pressed must be reset. The test must be conducted separately for each of the two buttons.

4. Keeping your hands away from the other machine parts, hold the button (ref. 2 Figure 2) pressed for more than 2 seconds; with the belts in motion, release the button: the belts must stop.
5. By eye check that the fixed guards are in excellent condition, without signs of corrosion, dents etc., and fixed using all the means provided (screws, nuts, rivets, etc.).

#### 5.2.4 RESIDUAL RISKS OF A MECHANICAL NATURE

The residual risks inherent to the machine are the following and/or linked to the following phases:

##### **Risk of entanglement, entrainment, crushing**

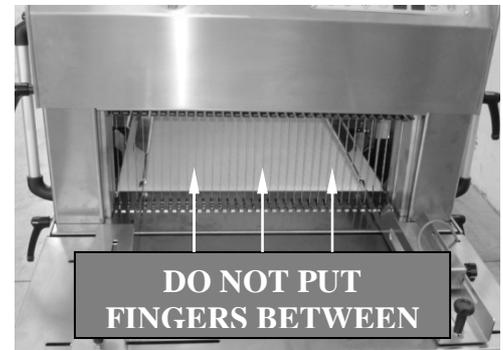
between feed belts when placing a part of your body (hand, arm) beyond the aperture where the bread to be cut passes (see Figure 23); a cross bar (visible in Figure 23) acts to prevent passage, however it is not particularly difficult to gain access to the feed belts through this opening, whereas the blades are in fact unreachable.

The risk increases as the distance between the belts shortens, therefore not only **it is absolutely forbidden to place your hands between, but also to bring your hands near the bread loading entrance** (after all there is no reasonably foreseeable reason to do so).



**Figure 23 - Residual risk of entanglement, entrainment, and crushing**

**Cutting risk** due to touching the cutting edges of the blades when someone tries to put their fingers in the free areas around the blades which, being thin, can break and widen (Figure 24). There are no reasonably foreseeable reasons for a person to place his or her fingers between the blades; however if this does occur, the very sharp cutting edges could cause severe injury to fingers, especially when the person extracts them. **Such behaviour is absolutely forbidden, even when cleaning which must only be done when the machine is completely still and electrically disconnected and, if it is necessary to go near the blades, only after having put on cut proof gloves.**



**Figure 24 – Residual Risk of Cutting**

**Risk of collision, crushing, cutting** if you attempt to place your hand below the movable upper guard, before the associated safety micro-switch intervenes and commands the stopping (Figure 25); one could in fact access (though with difficulty) the upper cross bars of the blade-holder frames and, in extreme cases, the sharp edge of the moving blades. For this reason **it is absolutely forbidden to even attempt to insert your hands beneath the guard: there is no reason to do so and you would unnecessarily expose yourself to the risks cited above** (do not perform similar actions even if the blades are still; remember they are very sharp and it is extremely easy to injure yourself)



**Figure 25 - Residual risk of collision, crushing, cutting**

**Risk of accidentally getting fingers stuck** in the slits on the cut bread unloading tray (Figure 26). An unusual or impulsive movement of the hand could result in painful pulling/twisting, resulting in the fracture of the fingers involved.



**Figure 26 - Residual Risks of Catching Fingers**

**All the residual risks** described above, although very low, **can be reduced further if:**

- the Employer supplies adequate information, instruction and training on the correct, safe use of the machine to the operators appointed, based on specific work procedures which must be observed with total respect.
- the operator respects scrupulously the indications given to him by his Employer and the instructions provided in this manual, maintaining high levels of concentration on the work that he is carrying out, and avoids erroneous movements and/or actions.

### 5.2.5 RESIDUAL RISKS OF A HYGIENIC AND/OR BIOLOGICAL NATURE

It needs to be stressed the importance of carrying out a meticulous cleaning of the machine on at least a daily basis, following the instructions in Section 4.9. This prevents, or at least acts as an obstacle to, the generation and multiplication of moulds, bacteria and so on, as difficult as this might be given that we are talking about residues from cooked, relatively dry foods, or foods that anyway dry very quickly at environmental temperatures. **Periodically** (depending on how much the machine is used, and how often it is cleaned) **disinfect and**, if necessary, **request disinfestation** of the machine, delegating the task to a specialized company.

If you are injured as a result of contact with the blades or for other reasons, disinfect the wound and dab it if there is any loss of blood. **If this happens, immediately disconnect the machine from the electric supply and make it inaccessible, afterwards see to its disinfection,** appointing staff specialized in this matter.

### 5.2.6 RESIDUAL RISKS OF ELECTRICAL NATURE

This risk is related to possible accidental contacts with live parts e.g.. during maintenance interventions. **WARNING! Before dismantling/opening any guards or parts, the removal of which permits access to live (or anyway dangerous) parts, and/or before starting any operation on live voltage parts, the technician appointed for the job must disconnect the plug from the electrical socket, and place it in a position that is constantly on view. This is necessary so that the technician can be sure at any moment that the machine is not electrically powered.** No motives can be reasonably foreseen why the technician should need to work on live voltage parts. The professionalism of the technician called on to carry out these operations, should offer enough of a guarantee of protection from the related risks. **Keep in mind that every intervention of an electrical nature must be performed exclusively by expert personnel, chosen for their professional qualifications, able to carry out the work properly, and aware of the current legislation on the subject.**

## 5.3 INFORMATION ON MACHINE NOISE LEVELS

Listed below are the LAeq [A] (equivalent A-weighted continuous sound pressure level) values measured at points M1 to M4 of Figure 27) , with Class 1 integrating noise meters, under the following conditions:

- machine operating without load

- WITH BLOWER version of the machine and equipped with loading slide
- feed belts in motion at maximum speed
- cutting blades in motion at maximum speed
- ambient background noise  $L_{Aeq(amb)} = 42.5 \text{ dB[A]}$
- Microphone positioned as shown with respect to machine in Figure 27 and 1.6 m from floor

Measuring point	M1	M2	M3	M4
$L_{Aeq} \text{ dB[A]}$	72,4	71,6	71,2	71,3

Maximum error: 2.0 dB(A)

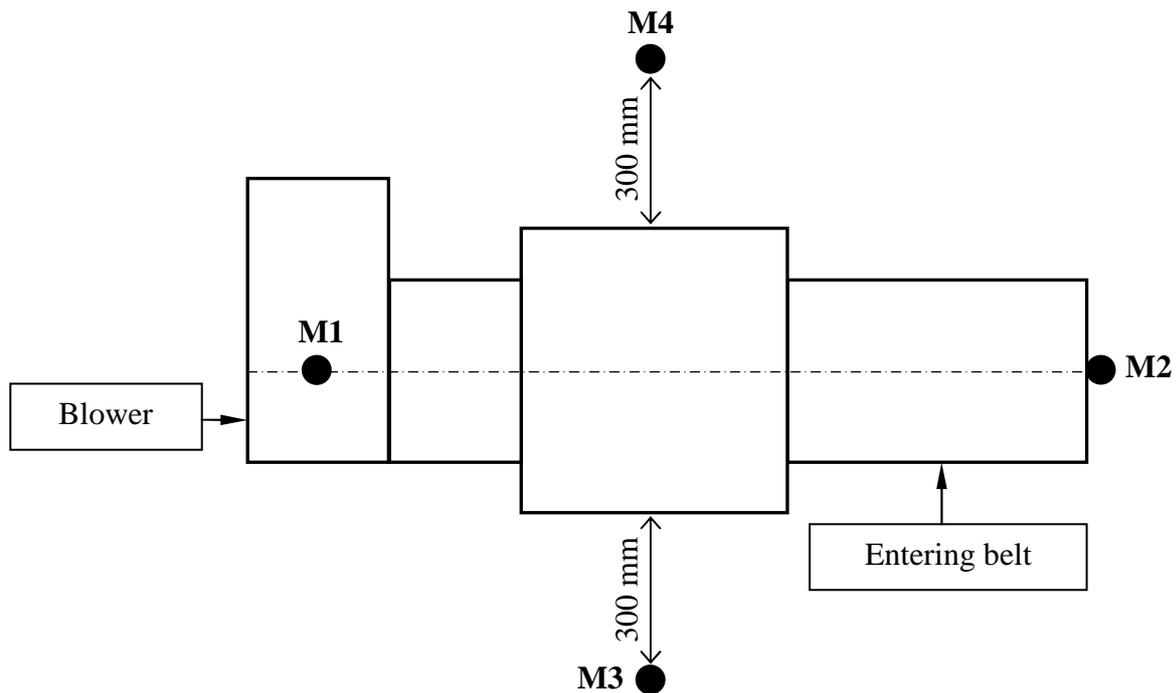


Figure 27 - Sound Emission measuring point

### 5.4 SAFETY SIGNS

The following safety signs have been affixed on the machine (see Figure 28):

A		Hand crushing hazard inside
B		Warning! Electrical shock hazard
C		Cutting injury hazard in case of contact with the sharp edges of the blades
D		It is forbidden to introduce ones hand.

E		Removal of guards is forbidden
F		It is forbidden to clean, oil or grease, adjust, the machine gears and components when they are in motion
G		The obligation to wear reinforced-toe work shoes <u>for the blade unit assembly and disassembly operations</u>
H		The obligation to wear cut-resistant gloves <u>for the blade unit assembly and disassembly, blade replacement, and cleaning operations</u>

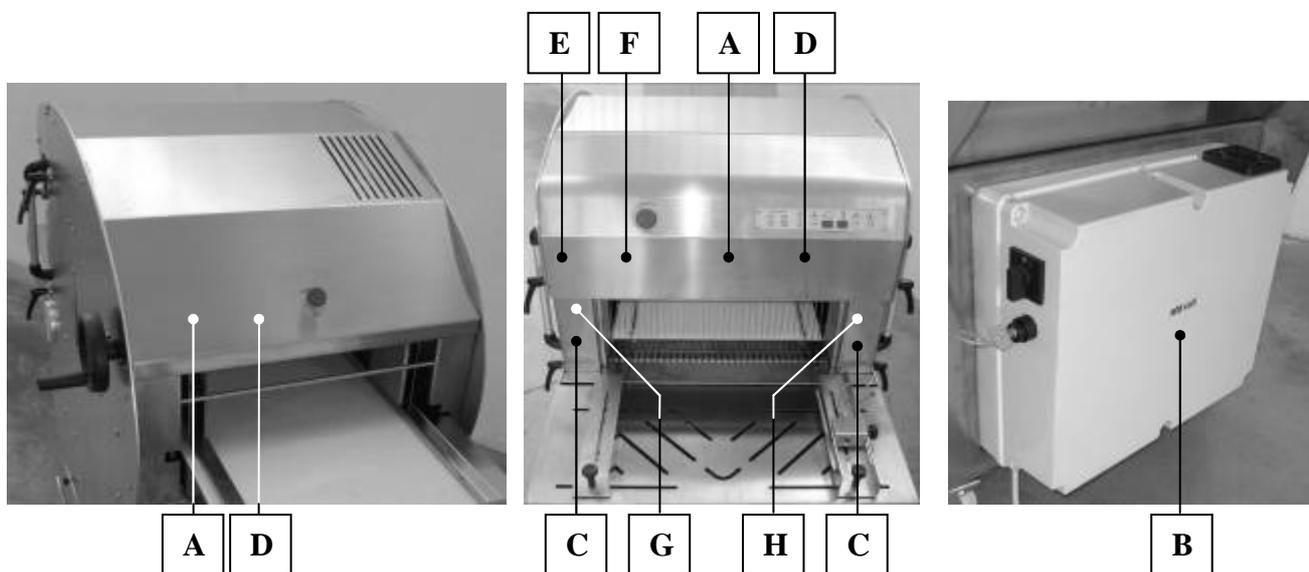


Figure 28 – Safety Signs

**Verify the perfect state of conservation of the images and the sign colors. For the most minimal signs of deterioration, replace them in a timely way, immediately advising the persons responsible and/or the manager who will take the measures necessary.**

## 6 DISMANTLING

When it is necessary to dismantle the machine, separate out its different components by material type, and then see to their disposal in compliance with current legislation and standards. Extract the used lubricants that must be treated separately for the purposes of waste disposal.

Contact the specialized companies for the specific waste disposal sector.

**Fe coated steel** or **Stainless steel**: machine structure, belt-support structure, movable upper guard, blower

**Stainless steel**: unloading surface, load-bearing structure of the blade, support frames, blades, racks

**Plastic, rubber**: base wheels, knobs, crumb collection drawer

**Miscellaneous materials:** electrical components, motors (copper windings)

The symbol that appears on the equipment shown here indicates that it must not be disposed of as normal urban waste, but must be taken separately to a WEEE waste collection depot, specifically equipped for treating electrical and/or electronic equipment in compliance with regulations.



In case of new equipment supplied in exchange, Rollmatic s.r.l. guarantees that it will take back the used equipment free of charge on the condition that it is of the same type, and has performed the same functions as the new equipment supplied (Legislative Decree of 25/07/2005, no. 151, art. 6, comma 1, letter b).

Incorrect disposal or an improper use of the equipment or of its parts could produce potentially negative effects, damaging to the environment and people's health.

On the other hand recycling the materials of which it is composed contributes to preservation of natural resources. For more information about recycling, you can contact the related the town council department, the recycling centre or, also, the Manufacturer or distributor of the product.

**DICHIARAZIONE CE DI CONFORMITÀ  
EC DECLARATION OF CONFORMITY  
DECLARATION CE DE CONFORMITE  
EG-KONFORMITÄTSEKTLÄRUNG**

Macchina/Machine/Machine/Maschine :

Modello/Model/Modèle/Typ :

Matricola/Serial Number /Numéro/Nummer :

Noi/Nous/We/Wir

ROLLMATIC S.R.L.  
Via Piemonte, 9  
36015 SCHIO (VI) - ITALIA  
P.IVA 03391250242

**(I)** Dichiaro sotto la nostra esclusiva responsabilità che il prodotto sopra descritto (macchina, codice, modello, matricola) è conforme alle disposizioni di cui alle seguenti direttive, loro successive modifiche e decreti nazionali che le recepiscono:

**(GB)** We declare under our responsibility that the item listed above (machine, code, model, serial number) is in compliance with the following regulations, their further modifications and the corresponding standards:

**(F)** Nous déclarons sous notre exclusive responsabilité que la machine ci-dessus désignée (machine, code, modèle, matricule) est conforme aux dispositions des règles de la Directive suivante, leur successives modifications et aux arrêtes nationaux :

**(D)** Wir erklären unter unsere komplette Verantwortung, dass der oben genannte Produkt (Maschine, Nummer, Typ, Nummern) der Bestimmungen der folgenden Richtlinie sowie, ihren weiteren Änderungen und den Landesverordnungen entspricht, gemäss :

- Direttiva/Directive/Directive/Richtlinie **2006/42/CE** del Parlamento Europeo e del Consiglio del / of European Parliament and Council of/ du Parlement Européen et du Conseil du / des Europäischen Parlaments und Rates vom **17/05/2006**
- Direttiva/Directive/Directive/Richtlinie **2006/95/CE** del Parlamento Europeo e del Consiglio del / of European Parliament and Council of/ du Parlement Européen et du Conseil du / des Europäischen Parlaments und Rates vom **12/12/2006**
- Direttiva/Directive/Directive/Richtlinie **2004/108/CE** del Parlamento Europeo e del Consiglio del / of European Parliament and Council of/ du Parlement Européen et du Conseil du / des Europäischen Parlaments und Rates vom **15/12/2004**
- Italian Legislative Decree no. 17 of 27/01/2010 (and subsequent updates and amendments)

The technical file has been prepared by Mr Antonio Lobbia, in the position as Managing Director.

Schio,

ROLLMATIC S.R.L.  
Lobbia Antonio  
*Managing Director*