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AVVERTENZA: in caso di dubbi sul contenuto del presente manuale, contattare il servizio di assistenza tecnica del costruttore, citando il n° di Capitolo ed il n° di Paragrafo con la procedura operativa che interessa.

LB ITALIA SRL si riserva i diritti di proprietà di edizione del presente manuale, diffidando la totale o parziale riproduzione, senza autorizzazione scritta.

CHAPTER 1 - GENERAL INFORMATION

1.1 GENERALITIES

This manual contains complete information necessary for the installation, the use and the maintenance for the automatic sheeter machines mod. CA 120 – CA 120 DV – CA 160 and CA 160 DV manufactured by LB ITALIA S.R.L.

The users of the manual are all the people who need or must give instruction or have to act operatively on the machine.

The original test of the present publication, in Italian language, is the only reference for the solution of eventual interpretative controversies connected to the translations in the commentaries languages.

The present manual is to be considered as integrating parts of the machine and must be kept , for future references, till the final dismantling and following wrecking of the machine.

1.2 AIM OF THE MANUAL

The aim of the manual is the one of allowing the users to know the machine and to use it in a correct safe and long-lasting way. The foreseen use of the machine is the only one allowed by the builder, in the present manual: do not use the machine not according to the indication given by the present manual. Furthermore the user must follow the law specification about work and safety, valid in the State where the machine operates

1.3 WHERE AND HOW TO KEEP THE MANUAL

This manual must be kept in a dry and sure place; furthermore it must be always available for the consultation. We also suggest to make a copy of it.

In case of communication between the user and the builder, always make reference to the identification data and to the serial number of the machine .The present manual must be kept during all the period of the working of the machine, till the wrecking of it . When it is damaged or dismantled, the user must request a copy to the builder. This new copy might be updated and therefore have had variations.

1.4 UPDATING OF THE MANUAL

The manual reflects the state of realization of the machine, at the moment of the sale of the machine and cannot be considered not proper only because it will be updated.

Eventually changes that the builder decides to do on the new machines, then commercialized, will be object of revision for the manual, which anyway represents the state of realization of the accompanied machine. Eventual revisions and updating of the manual which the builder will consider as necessary for the manual/s , that will be sent to the user, will have to be kept by him, together with the original one.

1.5 COOPERATION WITH THE USER

The user is at disposal at his customer to give any necessary information.

When the initial user sells the machine to other people , the user must give also the original manual, informing even the builder, in order to give him the opportunity of sending the new user further communications and/or revisions and updating of the manual.

The missing delivery of the manual to the new user exonerates the builder from any responsibility relative to the correct use of the machine. When the machine is sold by the initial user , to a country with a different language , the same is responsible for giving the manual in the language of the country where the machine is sold.

1.6 GUARANTEE OF THE BUILDER

The user, who wants to use the guarantee given by the builder, must not only correspond to the general features of guarantee foreseen in the buying contract of the machine, but also follow the dispositions of the present manual and in particular:

- a) Using the machine in the ways stated in the present manual and for the purposes for which the machine has been planed and built;
- b) Let the machine be used by qualified personnel and anyway duly instructed for the aim;
- c) Make a constant maintenance and a correct conservation of the machine ,as stated in the present manual .
- d) Send back to the builder the warrantee coupon enclosed in the instruction manual

The builder is exonerated from any direct or indirect responsibility coming out from:

- 1) Use of the machine for different aims of the ones stated in the present manual and anyway not authorized by the builder ;
- 2) Failure to observe the instructions stated in the present manual;
- 3) Reparations, modifications and /or interventions of any kind, without authorization of the builder ;
- 4) Use of the machine not according to the specific laws of the country of installation;
- 5) Use of not original spare parts;
- 6) Extraordinary events;
- 7) Installation and use of the machine in a room, which is not suitable for the aim foreseen by the builder.

1.7 ASSISTANCE SERVICE

For any request of technical information, the user must directly contact the builder:

LB ITALIA S.R.L.
VA AL CORBE' 45 – 22076 MOZZATE (CO)
TEL +39.0331.833872 FAX. +39.0331.833955
E-mail: info@lbitalia.it Internet: <http://www.lbitalia.it> <http://www.lbitalia.com>

Every intervention of assistance, reparation or extraordinary maintenance, eventually necessary for the machine, must be authorized by the builder. The missing observation exonerates the builder from any responsibility which might ever arise.

CHAPTER 2 - PRELIMINARY INFORMATIONS

2.1 PLATES – CONFORMITY MARKING

The machine is manufactured according to the DIRETTIVA MACCHINE 2006/42/CE and following amendments 2004/108/CE, 2006/95/CE and EN 453.

All the parts of the machine are according to the requests of the over mentioned DIRETTIVA and the marking CE demonstrates the conformity.

Picture 1 shows the different location of the plates on the machine.

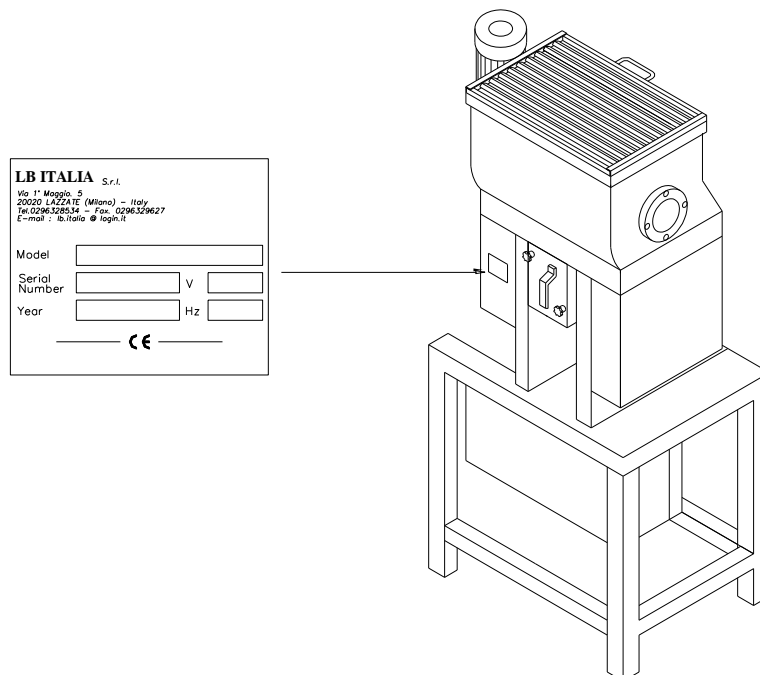
ATTENTION:

The plates must be left in their original locations, must be readable and periodically changed with original spare parts, requested by written to the builder, indicating the contents of technical identification.

When receiving the substitution plates, the user must fix himself the new ones.

Do not remove, do not cover and do not clean the plates with solvents . The plates fixed on the machine are safety signals and must be readable.

PICTURE 1



2.2 PACKING

The machine is always delivered with packing.

When the user takes away from the machine the parts of packing, he must be sure that inside the kneading basins of the machine there is no packet containing accessories or other, which must be in this case taken out. The user must put in the proper seats the accessories eventually removed for a practical transport; he must check that all the knobs, the handles and the levers are well fixed in their seats.

The user must also verify that all the closing screws of the machine are well fixed, because it is possible that in particular conditions of transports they can loose.

2.3 STORAGE OF THE MACHINE

If it is necessary to let the machine in a warehouse, it is allowed for a maximum period of 1 year, in a covered, dry room with a temperature between +5C and 40C and a humidity rate not higher than 80%: for periods and methods of storage different from the ones foreseen in the present manual, contact the builder to have the right indications.

2.4 CONTROLS

Before the delivery, the machine is duly controlled, anyway it is advisable for the user to verify it, who has to check that the machine is complete with its fittings, previously decided with the builder; the typical fitting of the machine foresees:

- a) Declaration of CE conformity
- b) Use , maintenance and installation manual of the machine

Eventual further fittings are decided with the builder at the moment of the buying contract.

The user must verify, when receiving the machine, eventual damages at the structure, crouches, deformations, breaks of electrical cables etc. which may verify during an incorrect transport : in such a case the user must promptly inform by written , the transport Company and the builder.

We remind that the user has 5 days time, from the receipt of the machine, within which he must inform the builder about eventual anomalies, defects and /or lacking , by written : after this limit the builder is exonerated from any responsibility.

The user, in this case, must wait for instruction before the intervention or the letting in of the machine .

2.5 MOVEMENT OF THE MACHINE

Before moving the machine verify the given overall dimensions and the weight of the machine .

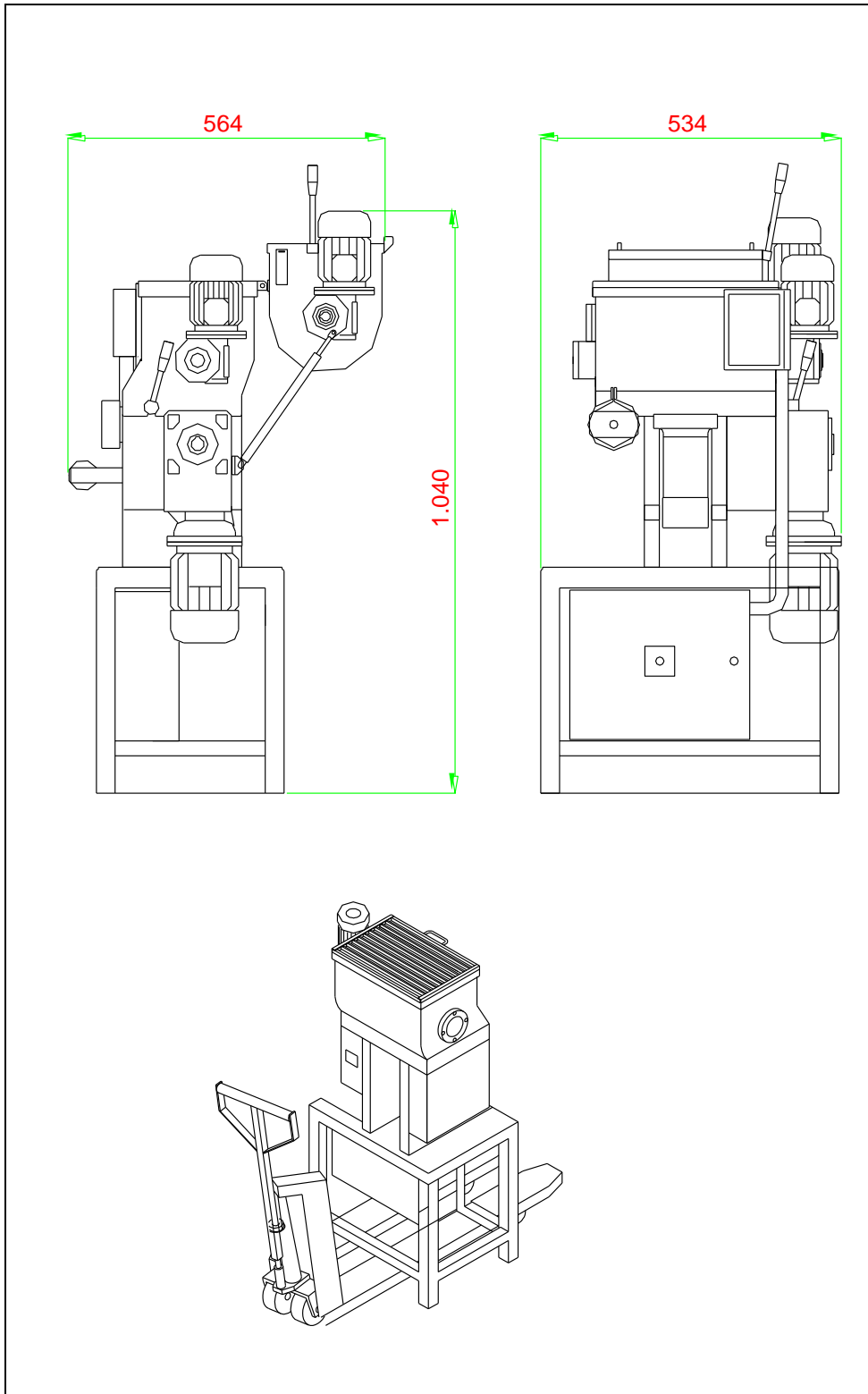
To reach the installation room of the machine , proceed with its moving by using only a slinging in clothes fibres and corner saving , or using a proper mullet and transpalett for transport, whose forks must be inserted under the machine , paying attention to the electrical cables which must not limit the operation.

Use mullets and/or transpallet suitable to the rising of the indicated weight of the machine.

ATTENTION: The indicated weights are only approximate.

See picture 2 FOR OVERALL DIMENSIONS, WEIGHTS AND MOVING FORMS.

PICTURE 2



CHAPTER 3 - TECHNICAL DESCRIPTION AND FORSEEN USE CONDITIONS

3.1 GENERAL FEATURES

The automatic layering machine, for its production of alimentary pastry, with or without eggs, is a machine with high productivity, suitable to feed former machines for cappelletti, ravioli, tortellini and cutters.

The principal features are:

- Structure in stainless steel for all the parts in contact with the pastry
- Building of the cushions inside the machine in stainless steel
- The internal sides, in stainless steel, are completely openable, to allow a deep cleaning and sanification
- The material in contact with the alimentary pastry correspond to the features forseen in the running laws and certifications.
- The careful project of the layering machines CA 120 – CA 120 DV – CA 160 and CA 160 DV - LB ITALIA S.R.L. – has allowed a practical access to the parts with get directly in touch with the pastry.
- The bronzes used are self-lubricating.
- The electrical implantation has been realized according to the running laws: stream 380 V 50 Hz, auxiliary circuits under low stream.
- Switch board

3.2 CONFIGURATION OF THE MACHINE

The automatic layering machine has a section for the dough, a section of layering rollers (laminator), a section for the rolling up of the dough on the proper rolling-pin and a section of drives functions.

SAFETY DEVICES

The machine is fitted with safety disposals foreseen in the running laws:

- 1) all the transmission organs of the machine are covered by covering panels;
- 2) on every kneading basin there is an electronic micron, which does not allow the machine to run when the protection grill is not closed.
- 3) on the cushion which close the laminator rollers, there are electromechanical micros that do not allow the machine to run when the cushion are not perfectly close.

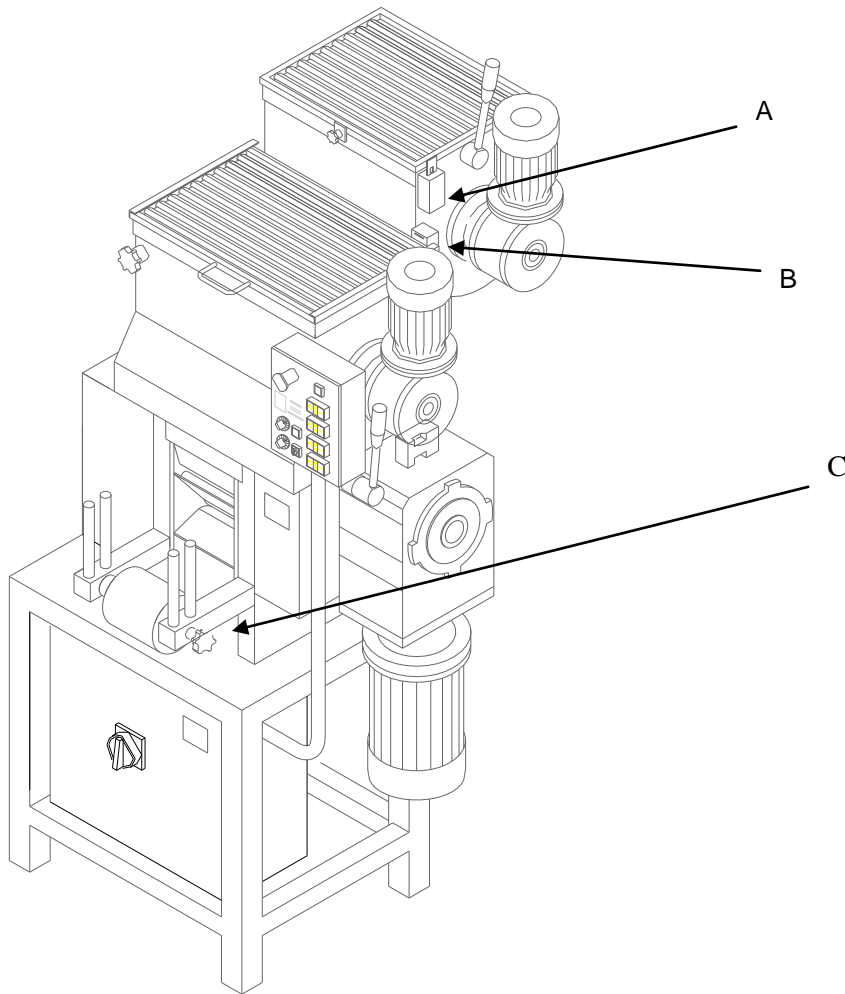
It is forbidden o mishandle, remove and/or modify all the safety disposal.

In case of maintenance and/or reparation intervention, the user must always contact the builder.

For the cleaning and maintenance operations described in the chapters of the present manual – before opening the panels (table 1 N. 28) – disconnect the machine from the distribution plant of electrical stream and set the general bottom (A1) in OFF .

Picture 3 page 9, shows the safety devices on the machine.

PICTURE 3



A – SAFETY MICRO SWITCH ON 1st KNEADING BASIN

SAFETY MICRO SWITCH CLOSED
Safety on the machine are activated.
The machine works

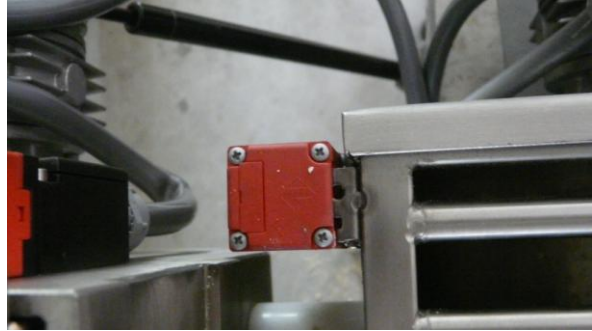


SAFETY MICRO SWITCH OPENED
Safeties on the machine are deactivated ,
The machine doesn't work



B – SAFETY MICRO SWITCH ON 2nd KNEADING BASIN

SAFETY MICRO SWITCH CLOSED
Safety on the machine are activated.
The machine works

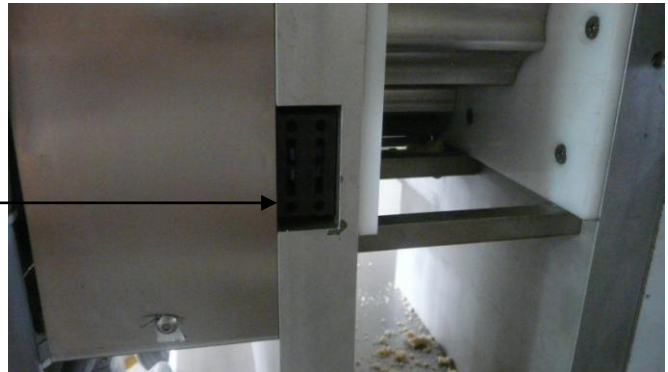


SAFETY MICRO SWITCH OPENED
Safeties on the machine are deactivated ,
The machine doesn't work



C – SAFETY MICRO SWITCH ON RIGHT BACK SHOULDER

SAFETY MICRO SWITCH ON
BACK RIGHT SHOULDER



PIN ON BACK RIGHT TEFLON PART:
When the back protection is opened, machine's
functions stop.



3.3 FORSEEN USE – REAL USE

The machine is exclusively planned for the working of flours ,of different kind and conformation , with the addition of dampness , for the production of ravioli and pasta - with or without egg - for alimentary consumption.

The indicated use is the only one which is allowed by the manufacturer .

3.4 OPERATIVE ROOM

The operative room where the machine must be , cannot have a temperature between +5°C and + 40°C; the humidity must not be more than 80%:

The machine cannot be used in open rooms and or rooms with risks of fire or explosion and anyway where it is obligatory the use of anti-deflagration components.

3.5 USER

The user of the machine must obligatory be a suitable person for this kind of work according to the running laws , must have any physical and mental handicap , furthermore he must a deep sense of responsibility.

The user of the machine must reach a complete formation and instruction use of the machine and the treatment of the product of the machine. It is very important that he has completely seen the present manual and that he has perfectly understood it.

The user must prevent the getting closer of strangers to the machine , when it is working and also present the use of it to people who are stranger in the running activity.

During the working phases it is necessary to have a total concentration , in order to avoid damages to the machine or to people and/or things , due to distractions.

During the working of the machine do not leave the working place.

CHAPTER 4 - INSTALLATION AND USE OF THE MACHINE

4.1 PRELIMINARY CONTROLS

Verify the conditions described in the present manual in the previous chapters, with the particular attention to Chapter 2 - Paragraph 4 and 5

4.2 INSTALLATION

Arrange a good working area, where the machine will be installed: it is necessary to leave, around the machine, a sufficient space for the user in order to work without any impediments and to have an easy access in case of maintenance and /or reparations. The machine is not fitted with a lighting system , that's why the working area , must have a good lighting ; avoid shadow areas on the machine to grant the operation on the machine in maximum security. In case of maintenance and/or reparation interventions, located in parts which are not efficiently lighted, it is necessary to use a suitable lighting system . The machine requests only an operator, during the phase of letting in and normal works.

During the use it is sufficient that the user is near the machine to intervene in the necessary moments, described in the following paragraphs and in case of bad operation.

4.3 DRIVES OF THE MACHINE

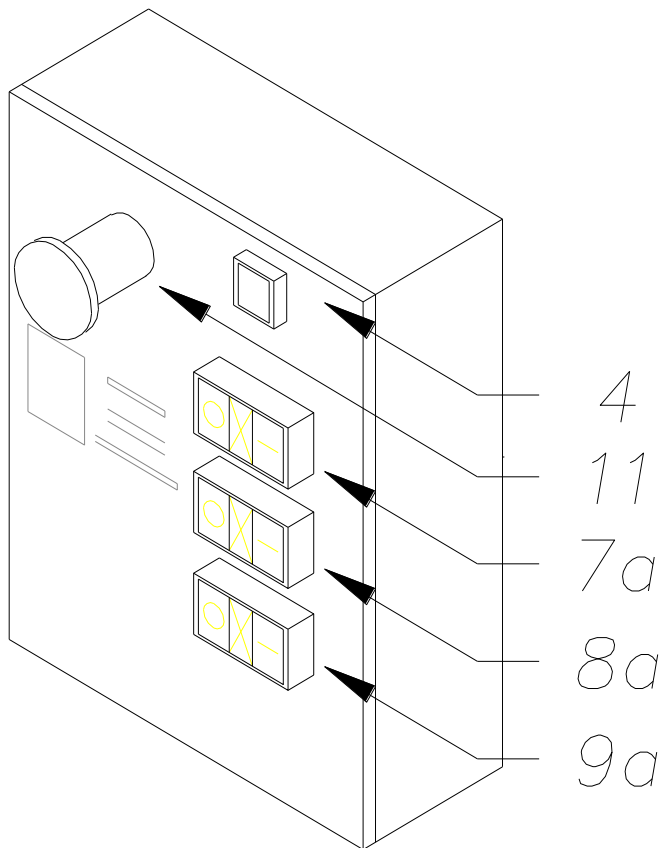
The drives of the machine are fixed on the pane (B) as indicated in picture 3.

If necessary, consult the electrical schemes enclosed in the present manual.

4	=	signalling flashing light indicating the voltage presence on the machine	
7a	=	kneading switch : I (green) = switch on	O (red) = switch off
8a	=	layering switch : I (green) = switch on	O (red) = switch off
9a	=	double bowl switch (if included) I (green) = switch on	O (red) = switch off
11	=	emergency button	

To deactivate the emergency button, turn it in clockwise sense.

FIG.4



PANNELLO B

4.4 CONNECTION TO THE ELECTRIC FEEDING LINE

ATTENTION: before starting any operation it is necessary to have read all the present manual and the enclosures.

The guarantee of good operation, in absolute sureness, at the foreseen service, strictly depends on the correct application of all the instructions of the present manual.

In fact the user must follow the indications of the present manual to obtain the maximum output, the maximum security for himself and for the others and the minimum consumption.

The user has the responsibility to prepare a suitable electrical plant of distribution.

Furthermore he must make the connection to a stream of electrical power with conductors of appropriate dimensions , controlling that at mount of the distribution plug there is a suitable onnipolar switch inserted to protect against overloading and short-circuits. The feeding source must be suitable to the machine and must be according to the running laws. The plant must have a system of automatic unhooking with magnetotermic differential switch and a system of earth placing which must grant the minimum parameters requested by the laws. Avoid to operate if the room is humid or wet , but only with the proper protections against electrical shocks. Before making the connection ,check that the features of the electrical feeding line are according to the technical information described in the scheme of the electrical plant, attached to the present manual and on the plate fixed inside the electric switch board. The connection of the machine to the electrical distribution plant must be effected by professional qualified staff.

4.5 QUALIFICATION

Feed the electrical switch board (A); start the electrical circuits by turning the general switch (A1) in position ON.

See picture at page 17.

CONTROL OF THE ROTATING SENSE

ATTENTION: this function is very important and must be effected:

- a) **at the moment of connection of the machine to the electrical switch board before any other operation**
- b) **any time the machine is moved**
- c) **any time the feeding plug is changed**

Put the general switch (A1) – placed on the electrical panel on the position “I”: the red light (4) will light, this will always indicate the presence of electrical tension.

Push the button (8a) , set on the drives panel and control the rotating sense, with the roller (D) which must slide in the direction indicated by the arrow. See figure 5 page. 17

ATTENTION : DO NOT START THE MACHINE WITHOUT HAVING CHECKED THERE IS NO OBJECT LEFT ON IT

4.6 PREPARATION OF SFOGLIA

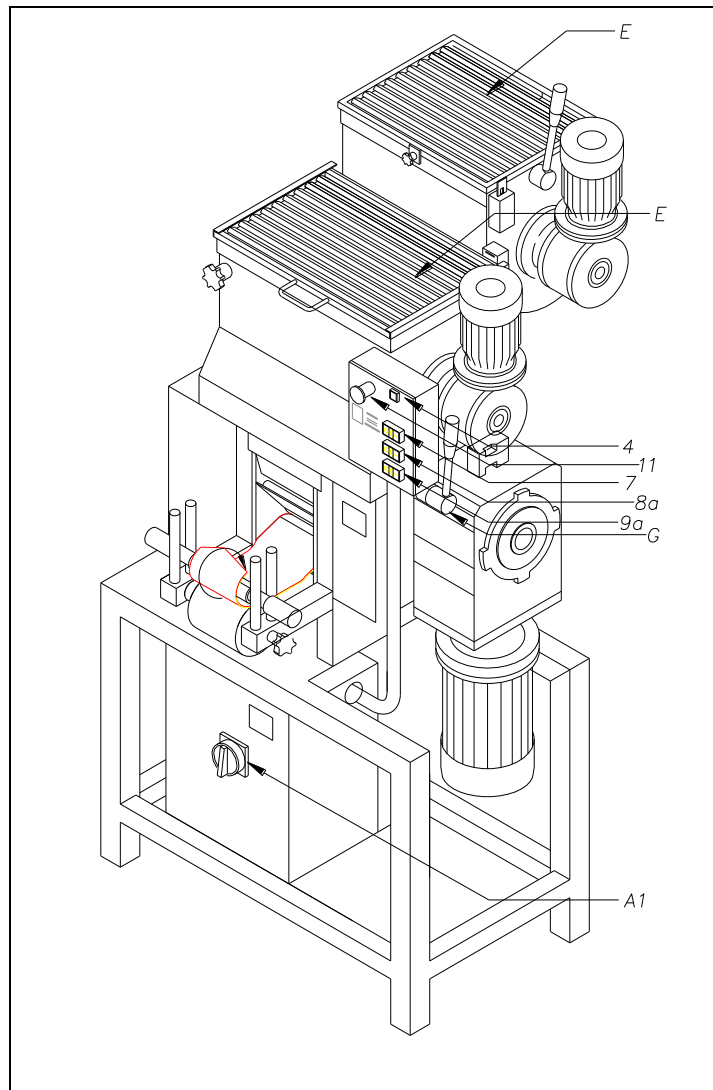
Close the doors inside the basin by means of the special lever (G).

Open the protection grill (E) of the basin, pour the flour and the humidity (eggs and/or water in the right proportions : 33-35%), close the grill (E), push the button (7a) and let the basin kneading for about 20/30 minutes .

The dough will be ready when you push it with the hand and it is compact and not crumbled. When the dough is ready, open the grills (G) and push the switch (8a) for starting of laminated rolls and wait some instants that the first dough coma out: stop the rolls of the laminator, pushing the red part of the switch (8a) and place the rolling-pin, on the special guides.

Start the laminator rolls: the initial part of dough must be manually put on the pin for the first time; let the leaf go under the pin and accompany it around it, from the outside, as indicated on the picture 9.

PICTURE 5



4.7 DURING THE USE

During the phases of production, carefully follows the notions stated in the present manual, even regarding sureness matter, keeping particular care to the following rule of behaviour:

- 1) take out the feeding stream from the machine in case of inspections, reparations, maintenance intervention, taking out the electrical feeding line from the switch;
- 2) keep the floor around the machine dry and clean;
- 3) in case of intervention on the electrical plant of the machine, please use qualified staff;
- 4) in case of doubtful interpretation of operative sequences, contact the builder: do not execute any operation if the process has not been well understood;
- 5) follow the maintenance program described in the present manual;
- 6) keep the maximum concentration during all operations described in the following manual.

4.8 NOT ALLOWED USE

The use of the machine for not allowed manoeuvres, the improper use of the machine, the lacking in maintenance and miss observance of some indications given by the present manual, may cause dangerous situations for the security of the personnel and compromise the functions and the sureness of the machine.

The below description actions, which may of course not include all the possibilities of "no proper use" of the machine, are "reasonably" considered as the most possible ones and are absolutely forbidden:

- 1) use the machine only in the environmental condition described in the present manual
- 2) do not use the machine with electrical connections of "flying" type, with temporary and not isolated cables
- 3) do not allow the use of the machine to inexperienced personnel, who don't have a complete vision of the present manual
- 4) do not allow the use of the machine to physically-mental not suitable people
- 5) do not use the machine with no suitable clothes
- 6) do not remove and/or modify the safety devices and all the protections of the machine
- 7) do not use the machine for a service different from the one for which it is planned
- 8) do not modify the features of the services and the functions of the machine and/or of its parts in order to increase its production potentiality
- 9) do not allow people to, who are stranger to the operation of the machine, to get closer to it in the working room
- 10) do not use the machine and/or make maintenance operations on the machine under a low light
- 11) do not give reparation interventions to not experienced staff; always contact the manufacturer
- 12) do not use spare parts, which are not original and not advised by the builder
- 13) do not ever let the machine dirty
- 14) carefully follow the indications given in the present manual regarding to ordinary and extraordinary maintenance.

4.9 DEACTIVATION

For each function of the machine the corresponding switch is divided into lighting (I) and arrest (0) - picture 4 page 15.

To stop the functions of the machine, push the section of arrest of the corresponding switch. In case of emergency push the mushroom switches (11); with this operation all the functions of the machine stop.

To restore the emergency switch, turn the same in clockwise sense and put it into lifting up position.

ATTENTION: if during the production there are anomalies, miss function and/or necessary regulations, inform the responsible person of the department, before leaving the working place and/or eventually put a notice on the machine, writing all the necessary things on it.

CHAPTER 5 – CLEANING

5.1 GENERALITIES

The cleaning and the maintenance of the machine are extremely important because they grant an optimum function and sureness of the machine and of the user, long-lasting in the time.

The cleaning of the machine must be executed every time it is used , at the end of the working cycle , carefully following the indications given in the present manual.

The ordinary and extraordinary maintenance must be executed carefully following the indications and the schedules foreseen in the present manual : furthermore they must be executed by qualified personnel.

ATTENTION: Every intervention of maintenance and cleaning must be effected after having disconnected the machine from the electrical feeding line.

5.2 CLEANING

At the reception, it is necessary clean the machine.

At the end of working process, proceed as follow:

KNEADING BASIN:

verify that the doors inside the basin are open; push the switch (7a) and (8a) and let the machine working some minutes in order that eventual residues of pasta come out. When the basin will be completely empty and all the leaf come out, stop the machine pushing the switch STOP (11) and put the general switch (A1) on position OFF, disconnecting the machine from the electrical feeding.

Proceed with the cleaning of the basins, using a cloth and a spatula to take away every resting parts of the machine.

ATTENTION: it is very important to take away all the resting parts from the inside room of the basins.

ROLLS

Unscrew the knobs (G7); take away the cushions (E2) through the proper handles (G) and remove every resting part of

pasta from the rollers of the laminator.

ATTENTION :do not use objects with points and/or shapes , which might engrave and/or scratch the rollers irremediably damaging them.

To obtain a perfect and complete cleaning, we suggest to use compressed air directly on the parts indicated.

ATTENTION: the machine must not be cleaned with steam or water jets

5.3 ORDINARY MAINTENANCE

Follow the indications stated in the present manual, regarding the cleaning.

5.4 PERIODICAL MAINTENANCE

EVERY MONTH	Oil the back nozze using a pump with suitable oil
EVERY 6 MONTHS	Open the side protection pannel and grease chains and gears

ATTENTION: when replacing the spare parts , always and exclusively use original spare parts.
Penalty , the falling of the guarantee.

Do not wait that the parts are damaged by the use. The replacement of the piece, at the proper time, means reaching a better running of the machine ,avoiding bigger damages for the machine.

5.5 PROBLEMS, CAUSES, SOLUTIONS

PROBLEM	CAUSES	SOLUTIONS
a) The machine doesn't start/ sudden stop	1) the protection grill/s is/are opened 2) the emergency switch is on	1) close the grill/s 2) disconnect the emergency switch
b) Soft or sticky dough	1) too much humidity in the flour	1) add more flour and knead again
c) dry / not mixed dough	1) not enough umidity in the flour	1) gradually add other humidity and knead again
c) acid dough	1) the kneading basin is not carefully cleaned	1) take away every resting part of dough and perfectly clean

CHAPTER 6 – WRECKING / DISMANTLING

6.1 GENERALITIES

When this machine must be wrecked, it will be necessary to dismantle the parts of it in different ways, considering the different nature of the same parts (ex: oils, grease, plastic ecc...) possibly using specialized company and qualified for this aim and in any case in observance of what is foreseen in the running law of the place where the machine is installed, regarding the dismantling of industrial rubbish.

CHAPTER 7 – WIRING DIAGRAMS

CHAPTER 8 – SPARE PARTS

8.1 SUBDIVISION OF TABLES

TABLE 1

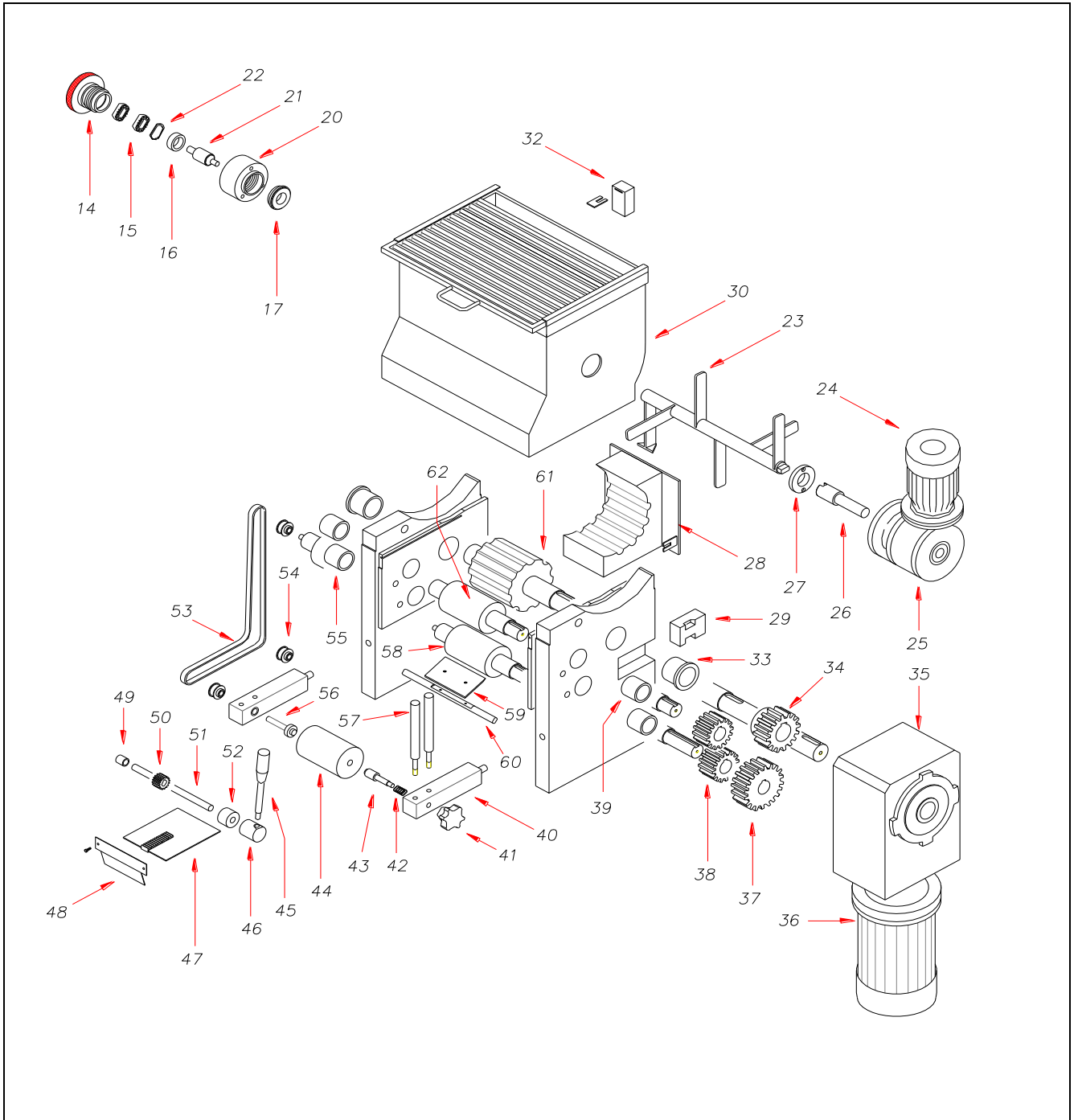
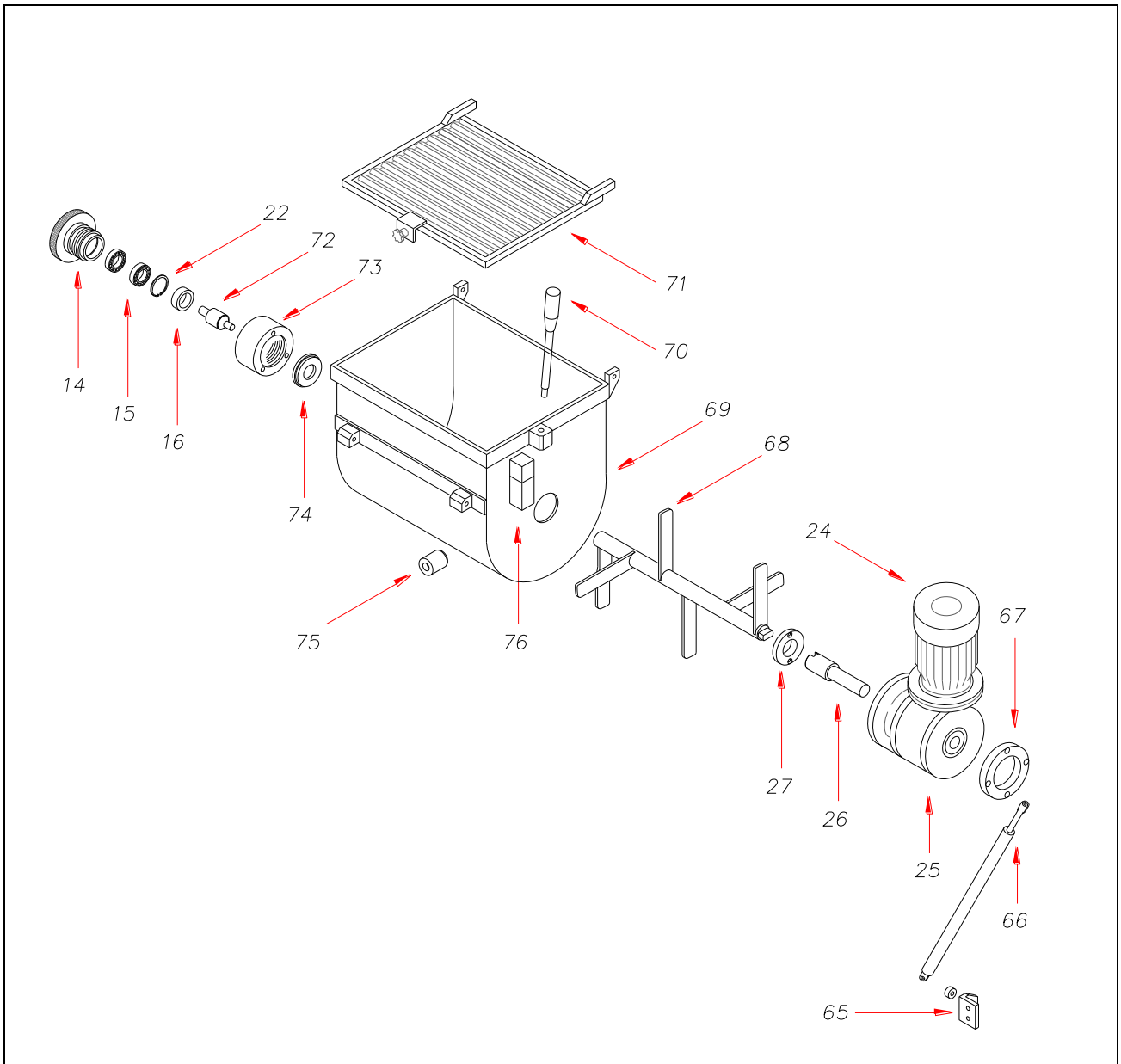


TABLE 2



CHAPTER 9 - SPARE PARTS ORDER

9.1 HOW TO ORDER SPARE PARTS

Always use the original spare parts, ordering them directly to the builder.

To order the spare parts it is necessary to give the following details:

- 1) Code of the manual
- 2) N. Table
- 3) N. Parts

The requested must be forwarded , by written, with fax message or registered mail, to:

LB ITALIA SRL – VIA AL CORBE' 45 – 22076 MOZZATE (CO) ITALIA

SUBSTITUTION UNDER GUARANTEE

For the substitution of parts under condition of guarantee, the user must have previously sent the builder the proper coupon. See page TECHNICAL DATA

9.2 SIMILAR COUPON FOR THE ORDER OF SPARE PARTS.

Trade name :

Address:

Fax Tel.....

LB ITALIA SRL
VIA AL CORBE' 45
22076 MOZZATE (CO) ITALIA

Date

We hereby confirm you the order of the following spare parts :

TAB.N.	PART.N.	MAN.CODE.N.....	QUANTITY.....
TAB.N.	PART.N.	MAN.CODE N.....	QUANTITY
TAB.N.	PART.N.....	MAN.CODE N.....	QUANTITY
TAB.N.	PART.N.....	MAN.CODE N.....	QUANTITY
TAB.N.	PART.N.....	MAN.CODE N.....	QUANTITY
TAB.N.	PART.N.....	MAN.CODE N.....	QUANTITY
TAB.N.....	PART.N.....	MAN.CODE N.....	QUANTITY

Please return the present order for confirmation, stating the prices of the parts ordered.

Yours faithfully

Stamp and signature