Operating Manual

Econom

STM, SSO

Edition BC517401

Technical specifications subject to change without notice

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EC Declaration of Conformity

We Seewer AG, Heimiswilstrasse 42, CH-3400 Burgdorf

declare under our sole responsibility, that the product

Model :	Dough sheeter	Econom
Type:	Table model	STE51
	Table model	STM51
	„A" framed base model	SSO51

to which this declaration relates correspond to the relevant basic safety and health requirements of the following Directives EEC:

Directive for machines	98/37/EC
Directive	73/23/EEC
Directive EMC	89/336/EEC

For the relevant implementation of the safety and health requirements mentioned in the Directives, the following standards have been respected.

EN12100-1, EN12100-2, EN294, EN954-1, EN60204, EN1674

Name: Mathis
First name: Werner
Function: Masch. Ing. HTL

Burgdorf, 22.07.2004

W. Mathis

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Hint for operating manual: The numbers of the illustrations (Ex.——1) are numbered chapterwise.

1 Safety Information

1.1 Explanation of Symbols

All the sections in this Operating Manual containing safety instructions which absolutely must be observed are marked with this symbol △ and with a number.

1.2 Explanation of Warning Signs

Sign indicating Prohibited Activity

Reaching under the closed safety guard is prohibited!

Instruction and Information Signs

Make sure to disconnect the plug before opening!

Danger Warning Sign

Danger Warning

High-Voltage Warning Sign

Warning against electrical shock
Disconnect mains plug before opening.

1.3 Safety Elements

1.3.1 Safety Guards

Operation

1. The safety guards protect the operator against inadvertent contact with the rollers.
2. The machine is stopped by lifting up the safety guard. Raising the safety guard even just slightly will cause the machine to discontinue operation.

1.4 Safety Instructions and Information which Must be Followed

- Rondo-Doge's dough sheeters are built for the food industry exclusively for the sheeting, booking and final sheeting of dough pieces.

- Any other use of these units is not in accordance with the purpose for which they are built. Therefore, the manufacturer will not be liable for any accidents or damage arising as a result of unauthorized use; the risk in any such instance will be borne solely by the user.

- Authorized use also means that the user must follow all instructions prescribed by the manufacturer in respect of operation, maintenance and service.

- Any work on the electrical components of the machine, in particular the correct professional mounting of the mains plug, may only be carried out by qualified personnel who are familiar with the prescribed safety instructions.
  Defective cables and mains plugs must be immediately replaced by qualified personnel.

- Protective covers over the electrical controls and the mechanical moving parts may only be removed by professionally qualified personnel and must be remounted before the machine is put back into operation.

- Any unauthorized changes made to the machine, and in particular, to the safety devices on the machine will automatically exclude any liability on the part of the manufacturer for accidents or damage sustained as a result of such changes.

- The machine may only be connected to electricity using the mains plug! No permanent electrical installation may be carried out using, for example, terminal screws.

- The machine may only be connected to the mains using the plug once the machine has been fully assembled.

- Before beginning any repairs, service or cleaning work on the machine, the electricity supply to the machine must be interrupted (pull out mains plug).

- Safety devices on the machine may not be adjusted, shorted-out or expanded.

- Operation of the machine when any of the safety devices is out of order is prohibited.

- Defective safety devices must be replaced immediately with new original parts from Rondo-Doge.

- Machine parts located in the area in which the dough is being processed, and whose surface coating becomes worn (e.g. chrome plate worn off) must be replaced.

- The machine may not be lifted on the machine base (SSO) when being moved. The machine should be fastened and transported on a pallet. The safety guard should be fastened in the upper position.

- Reaching under the closed safety guard is prohibited!

- The machine may only be operated with the machine tables mounted!

- Ensure that conveyor belt tension is correctly adjusted!

- Do not deposit any loose objects such as knives, tools, articles of clothing, etc. in the area where the dough is located.

- Table models (STM) must be placed so as to rest properly over the whole work table!

- Check to ensure that there are no loose screws in the area where the dough is located.

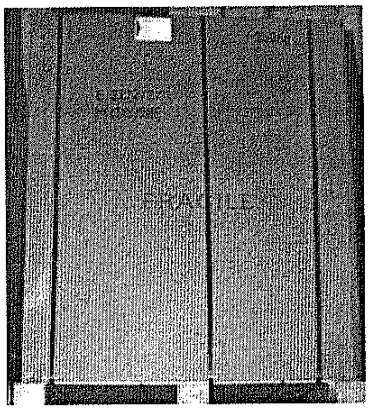
- The machine may not be operated without the use of a scraper.

- Flour dust can cause respiratory tract difficulties and allergies. Limit the use of flour to a minimum.

- Any disposal of the machine must be carried out in accordance with environmentally-accepted practices. The operators are fully responsible for ensuring that such practices are followed.

2 Transporting, Setting Up, Connecting, Dismounting, Storing

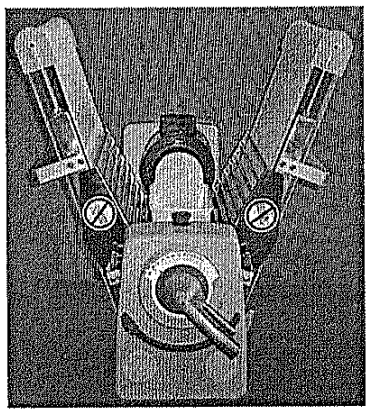
2.1 Machine Delivery



The machine is delivered in its original packaging.

- Report any claims for damage caused as a result of transportation directly to the freight handlers (see the packaging: The delivery documentation is found on the outside of the packaging)

2.2 Transportation



When being transported, the machine must be fastened onto a pallet. The tables must be dismounted and the safety guards fixed in the upper position.

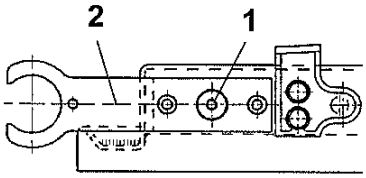
The machine must not be tipped over.
(for machine weight, see Technical Data, page 090 - 1)

2.3 Unpacking the Machine

The machine must be set up on a level, even floor surface (SSO).
For further information regarding the ambient conditions required for the machine, see General Information, page 030 - 1

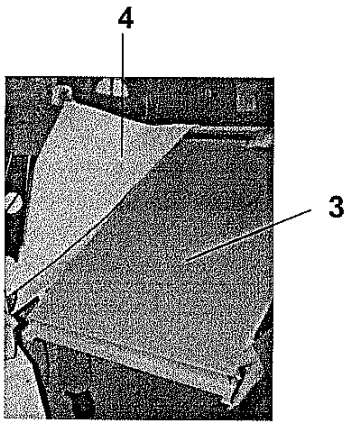
- Unpack tables and attachments
- Check all items received against the delivery slip to ensure completeness

2.4 Setting Up the Machine

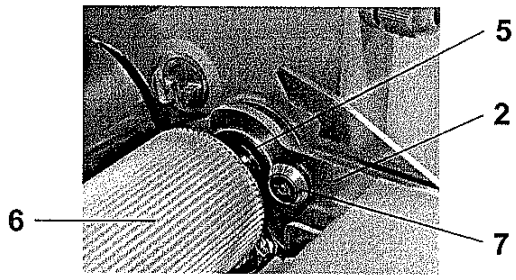


Two people are required to set up the machine

2.4.1 Installing the Machine Tables (SSO)

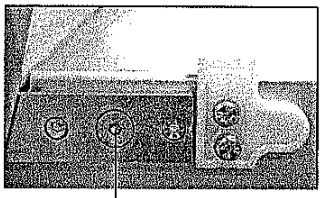


- Unscrew the screws (1) using a hexagon socket screw key
- Dismount the front and rear lateral bracket (2) on the machine table
- Lift the machine table (3) with the aid of a second person
- Put the machine table (3) between the conveyor belt (4)
- Place the lateral brackets (2) on the supports (5) of the roller drive (6)

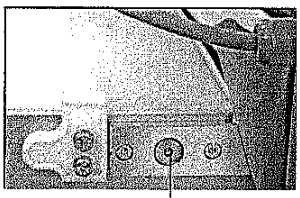


Lateral bracket with lock nut (7) must absolutely be at the rear!

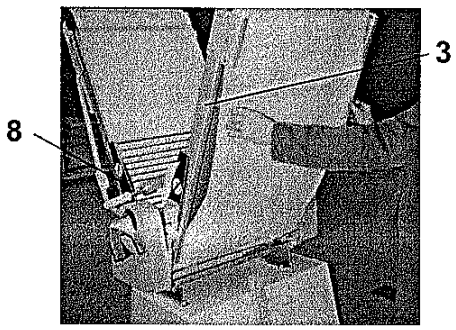
front side



rear side

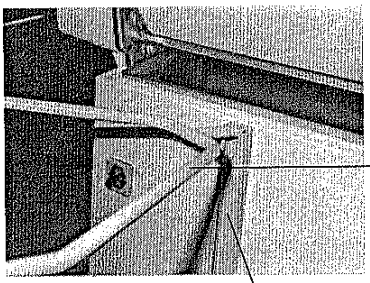


- Mount the lateral brackets (2), tighten the screws (1) using a hexagon socket screw key

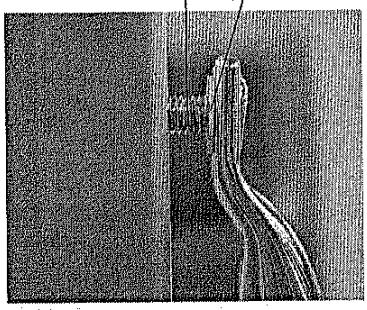


- Lift table (3) up until it is inserted into the safety guard (8)
  The machine table is now secured.

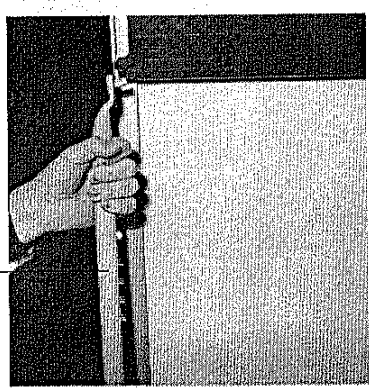
2.4.2 Mounting the Forked Supports (SSO)



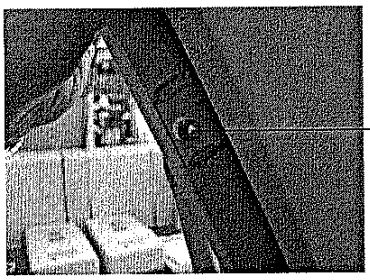
- Push forked support (9) into the support guide (10)



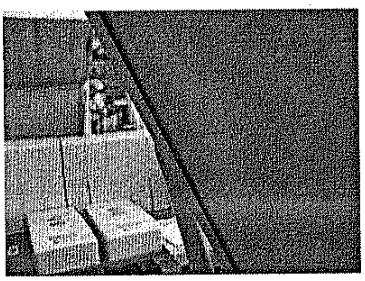
- Insert catch plug (11) of the forked support, with fitted washer (11a), into one side of the table



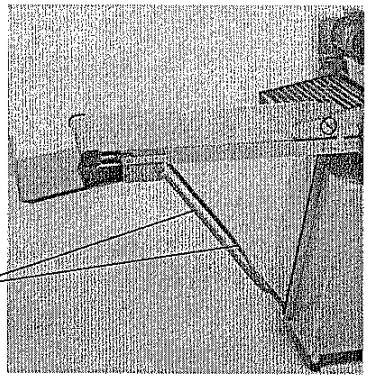
- Bend up the forked support (9) and secure it to the opposite side of the table (washer fitted on the catch plug)



- Fit the second washer on both sides on the inside, afterwards screw down the cap nut (11b)

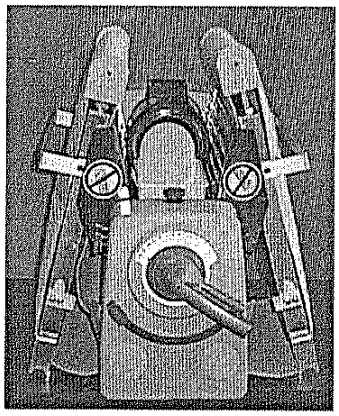


Attention: The conveyor belt has to be placed below the cap nut.

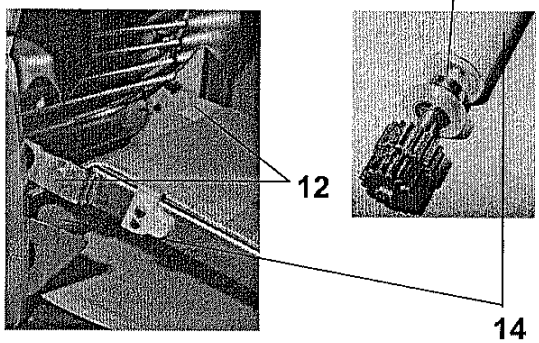


Position of the forked support (9) when the machine table is hinged down.

2.4.3 Installing the Machine Tables (STM)

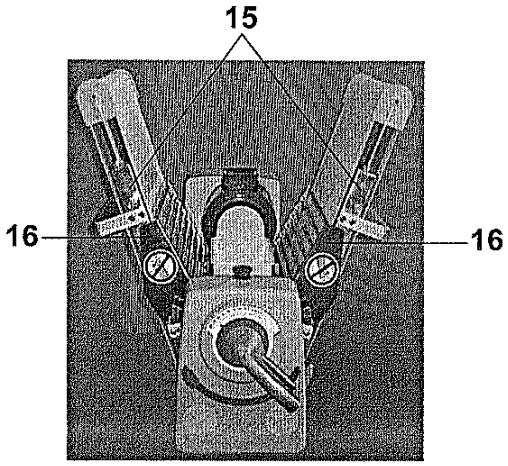


- Set the machine on a level work table
  (Make sure that the working height for the operator is correctly set)



- Place the forked supports (12) in the drive roller (14) mounting (13)
  (Do not dismount drive rollers)

- Tension the conveyor belts slightly in order to secure the table
  (see Tensioning the Conveyor Belts, page 020 - 5)

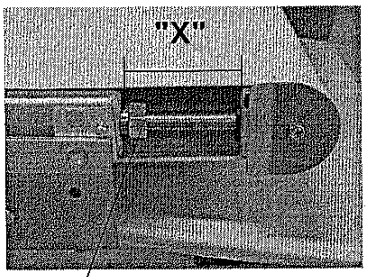


- Place machine tables (15) in upright position

- Secure machine tables (15) to the safety guards (16)

2.4.4 Tensioning the Conveyor Belts

Tense the conveyor belts only enough so that the heaviest pieces of dough (max. 4 kg) can still be moved along the belt without the conveyor belt dragging.



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Proceed as follows:

- Retighten the left and right tension nuts (17) so that they are even and parallel
- Remeasure distance "X" on both sides using a millimeter measuring instrument
  Distance "X" must be identical on both sides.
- Switch on the machine (see Putting the Machine into Operation, page 040 - 1/Operating Elements, Start push-button, page 030 - 4)
- Observe both the left and right running movement of the conveyor belt

If the belt runs off toward one side, proceed as follows:

- Retighten the side where it runs off using a tension nut

or

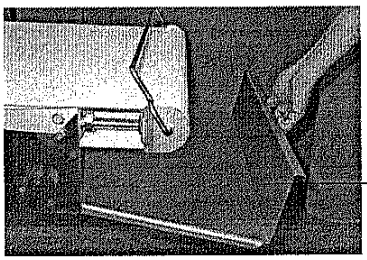
- Loosen on the opposite side using a tension nut
- Monitor the belt, and if necessary, correct it until it runs exactly in the middle of the table

Repeat this procedure several times, if necessary. Routinely monitor the belt during the initial hours that the machine is operational, and if necessary, correct again.

Tensioning and adjusting the conveyor belts demands patience!

Prior to carrying our each further correction, allow the machine to run for at least 30 seconds.
Before putting the machine into operation, the conveyor belts must be rubbed lightly with flour in order to prevent the dough from sticking to the belt.

2.4.5 Mounting the Dough Catch Pans (SSO)


18

- Remove the protective foil on the dough catch pan (18)
- Push in the dough catch pan on both sides

2.5 Requirements for Putting the Machine into Operation

Power supply and frequency at the mains circuit to which the machine is connected must be in accordance with specifications contained on the sign "Electrical connected loads" (This sign is found on the cable lead-through on the machine base).

Direct connection without a plug is prohibited! Ensure that the connection is made by professionally qualified personnel and that it is carried out in accordance with local regulations (An electrical schematic is delivered with every machine and it is to be found next to the electrical control in the rear of the machine housing).

- Connect the machine plug to the power supply

The machine may only be operated with tables mounted.

2.5.1 Ground fault interrupter is actuated when inverter is started

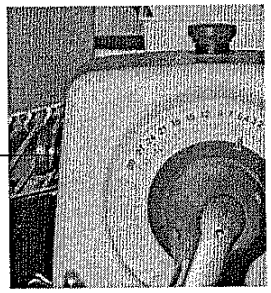
Leakage current flows through the inverter.

The inverter performs internal switching. Therefore, a leakage current flows through the inverter. This leakage current may actuate the ground fault interrupter, shutting the power off.

Use a ground fault interrupter with a high leakage-current detection value (sensitivity amperage of 200mA or more, operating time of 0,1 s or more) or one with high-frequency countermeasures for inverter use.

Reducing the carrier frequency value in n46 is also effective. In addition, remember that a leakage current increases in proportion to the cable length. Normally, approximately 5 mA of leakage current is generated for each meter of cable.

2.6 Moving Direction Test



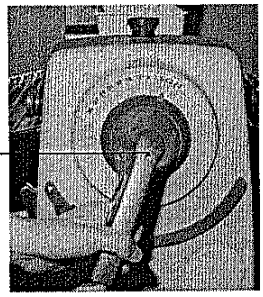
Monitor to ensure that the belts are properly tensioned.

- Press the Start push-button (19) (only impulse)
  The conveyor belts must move from left to right.

If the belts are moving in the wrong direction:

- Exchange two phases in the plug

2.7 Moving the Machine (SSO)

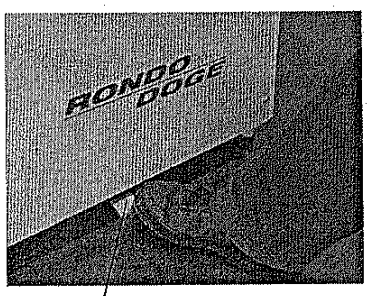


- Lift the machine on the roller gap adjusting mechanism (20)

  The front conveyor (21) will snap down.

Once the machine's permanent location is selected:

- Using both hands, tightly grip the roller gap adjusting mechanism (20)
- Gently lift up the machine
- Using one foot, push the pedal for the front conveyor belt (21)
- Gently lower the machine to the floor surface, do not let it "drop"



3 General Data about the Machine

3.1 General Information

3.1.1 The Machine's Applications

The machine is suitable for sheeting, booking and final sheeting of dough pieces for the food industry.
This product is a technical working tool which is designated to be used exclusively for work.

Booking

Booking in fat. Through sheeting to a thickness of approx. 6 - 11 mm and a subsequent folding of the dough there is a resulting formation of layers of fat and dough. A repetition of this process yields many thin layers.

Final Sheeting

Includes sheeting the piece of dough to the necessary final thickness required for further processing.

3.1.2 Noise Values

The emission value at place of operation is smaller than "70dB(A)", according to EN1674.

3.1.3 Temperatures

The ambient temperatures permissible for the machine:
+ 5° to + 40°C
Permissible temperatures for storage of the machine:
- 25° to + 55°, for brief periods of time up to + 70°C

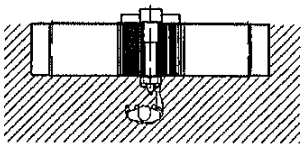
3.1.4 Ambient Humidity

The ambient humidity permissible for the machine lies in the area of 30 % - 95 %, relative humidity, uncondensed (for the dusting flour in the flour container, the relative humidity should not exceed 60 %).

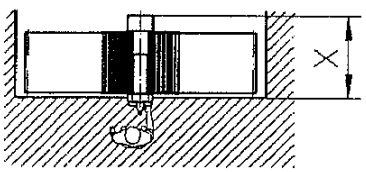
3.1.5 Machine Weight

Total weight of STM: approx. 80 kg, SSO: approx. 140 kg
(compare Technical Data, page 090 - 1)

SSO



STM



3.1.6 Working Area for the Operating Personnel

The hatched area shows the work area designated for the operating personnel.

On the STM model, the machine must cover the whole width of "X" on the work table!

3.2 Machine Models

3.2.1 STM 513

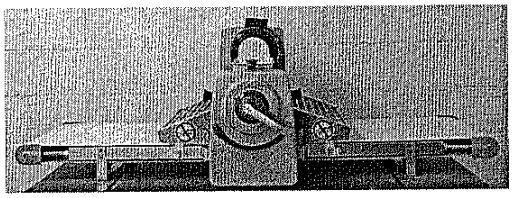
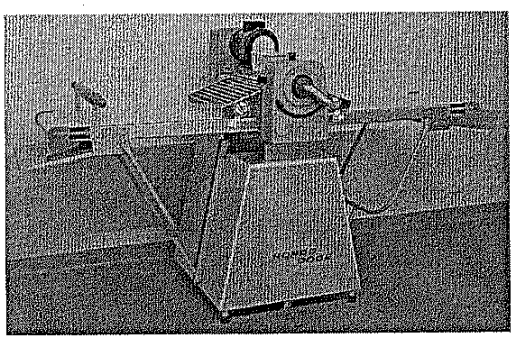


Table model
(see Technical Data, page 090 - 1)

3.2.2 SSO 514



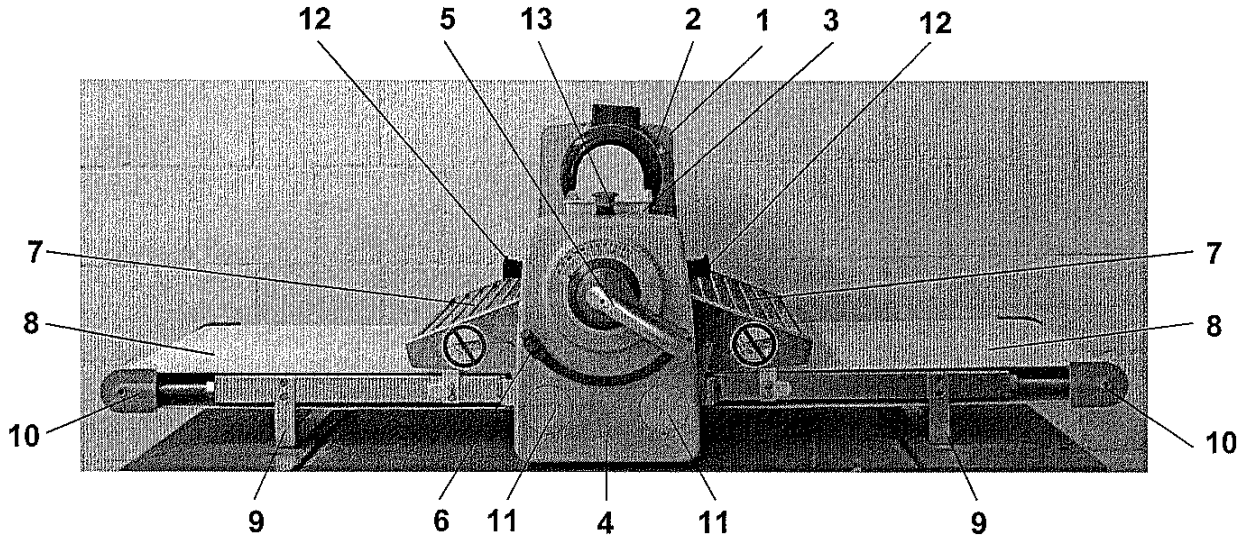
Socle model
(see Technical Data, page 090 - 1)

3.3 Prerequisites

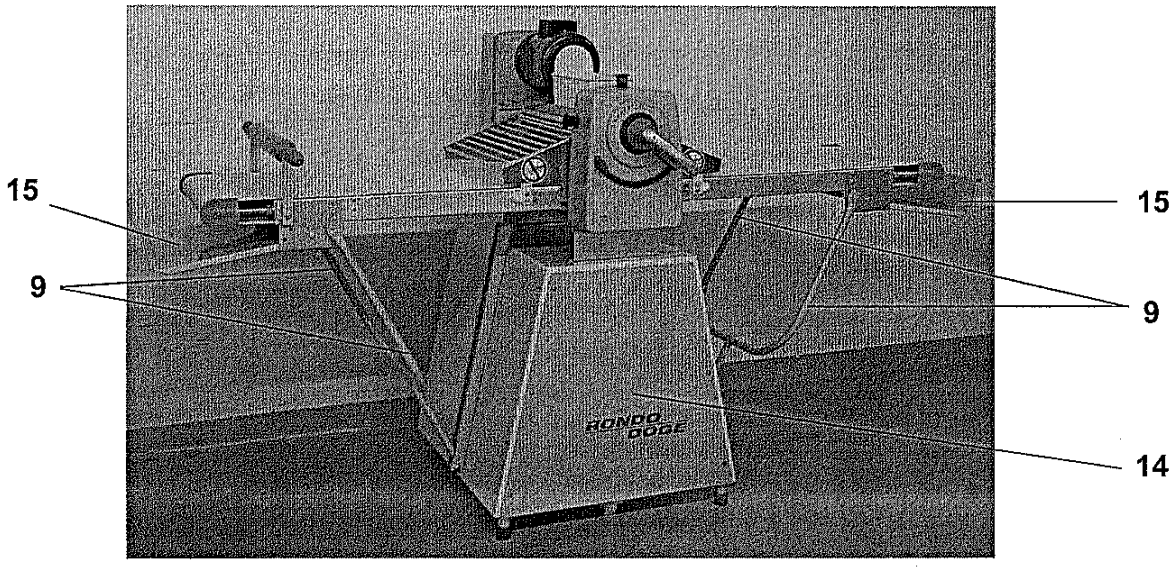
In order for the dough to be sheeted by the machine, the following prerequisites must be fulfilled:

- Max. dough piece weight 4 kg
- Flour the dough pieces
  This will serve to prevent the dough from sticking to the rollers and scrapers.

3.4 Complete View of the Machine

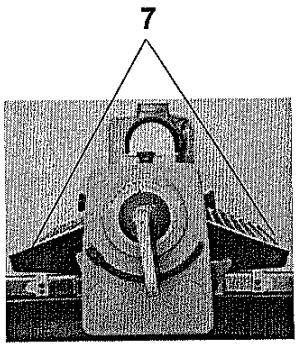


1	Rear housing
2	Motor
3	Flour container
4	Front housing
5	Roller gap adjusting mechanism
6	Roller gap limit stop
7	Safety guard
8	Conveyor belt
9	Forked support
10	Idle roller
11	Cover
12	Start push-button
13	Stop push-button
14	Machine Base
15	Dough catch pan



3.5 Operating Elements

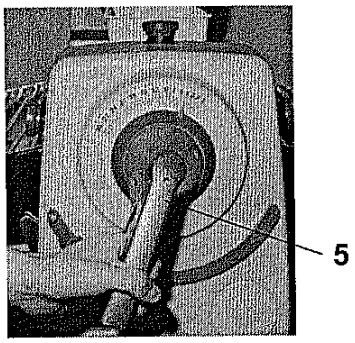
3.5.1 Safety Guards



The safety guards (7) protect the operator against inadvertent contact with the rollers.

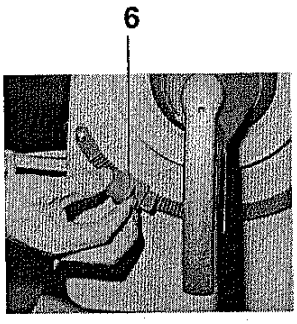
By raising the safety guards (7) the machine can also be stopped.

3.5.2 Roller gap Adjusting mechanism



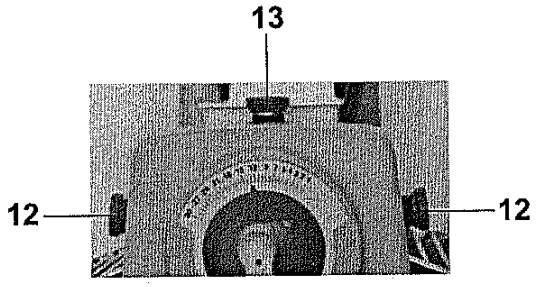
The desired roller gap is set using the roller gap adjusting mechanism (5).
(see also Sheeting, page 050 - 1)

3.5.3 Roller gap Limit stop



The roller gap limit stop (6) serves for mechanical Adjusting of the roller gap (repeatly sheeting)
(see also Sheeting, page 050 - 1)

3.5.4 Start push-button



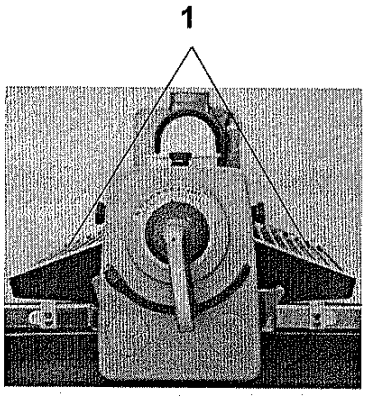
Both start push-buttons (12) (two push-buttons on the side of front housing) serve to start the machine. (see also Starting/Stopping the machine, page 040 - 1)

3.5.5 Stop push-button

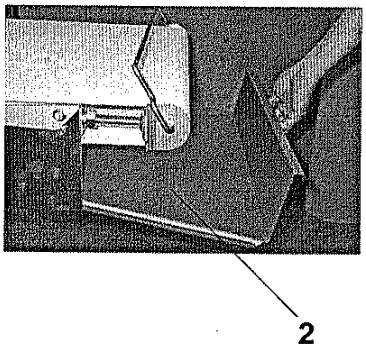
The stop push-button (13) (push-button at the top of front housing) serve to stop the machine.
(see also Starting/Stopping the machine, page 040 - 1)

4 Putting the Machine into Operation

4.1 Preparing for Operational Readiness



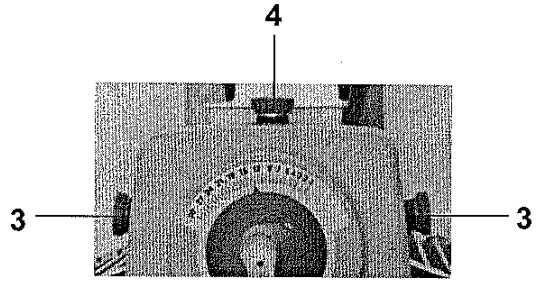
- Close both safety guards (1)
  (see Safety Guards, page 030 - 4)



On the SSO model:

- Pull out the dough catch pan (2) on both sides

4.2 Starting/Stopping the Machine



In order to start up the machine:

- Briefly press the left Start push-button (3)
  The conveyor belts begins to move from the left to the right.

or

- Briefly press the right Start push-button (3)
  The conveyor belts begins to move from the right to the left.

In order to stop the machine:

- Briefly press the Stop push-button (4)

5 Operation

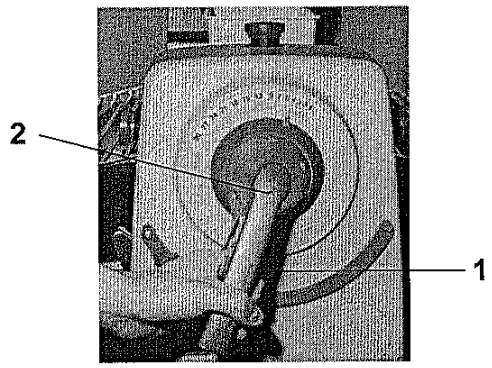
5.1 Operating Instructions

Reaching under the safety guard when it is closed is prohibited!

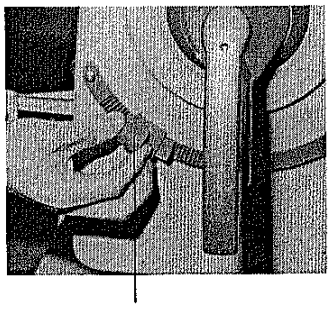
5.1.1 Sheeting

The machine is designed to accommodate dough pieces with a maximum weight of 4 kg!

Never leave loose objects such as knives, tools, articles of clothing, etc. lying in the area where the dough is located.

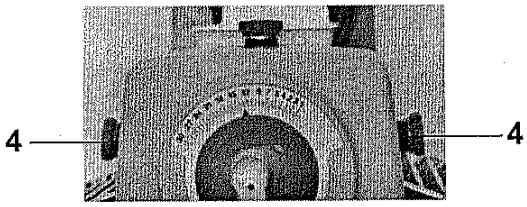


- Set desired roller gap (maximum 30 mm/ minimum 0.5 mm) as follows:
  - Push lever (1) towards the roller gap adjusting mechanism (2), do not release
  - By way of the roller gap adjusting mechanism (2), set the roller gap desired (Scale)
  - Release lever (1)
    Lever (1) must lock into place.

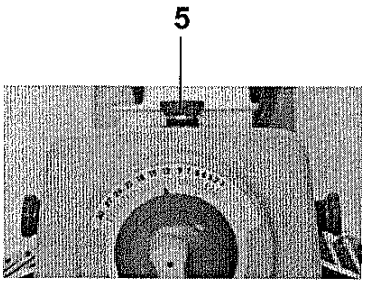


  - Compres Roller gap Limit stop (3) and push it against the lever (1) and release it

- Place the dough piece (max. 4 kg) on the machine table (do not "throw" it on the table!)

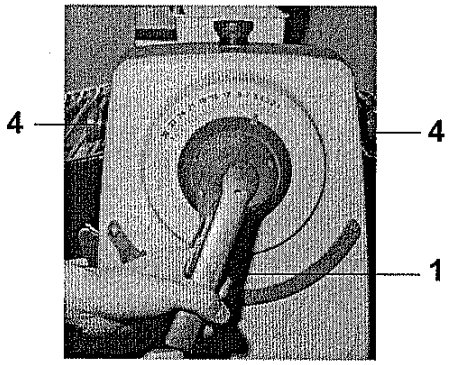


- Start up the machine as follows:
  - On the dough's infeed side, briefly press the Start push-button (4)
    (see Starting/Stopping the Machine, page 040 - 1)



Once the dough piece has fully cleared the rollers:

- Press the Stop push-button (5)
  The machine will stop.



- Manually set the next roller gap (depending on type of dough being processed) (see top of page 050 - 1)

- Release lever (1)
  Lever (1) must lock into place.

- On the dough's infeed side, briefly push the Start push-button (4)
  (see Starting/Stopping the Machine, page 040 - 1)

Once the dough piece has fully cleared the rollers:

- Press the Stop push-button (5)
  The machine will stop.

- Repeat this procedure until the desired final thickness of the dough has been obtained

5.2 Sources of Errors in the Sheeting Process

Fault finding	Cause / Defect	Remedy / to remove
1. Dough piece sticks, tears under neath.	Dough too moist. Dough piece rubs against scraper bar.	Flour dough piece more. Mount scraper properly (see Mounting the scraper unit, page 060 - 2).
2. Dough piece piles up (ripples).	Reduction steps too big.	Select smaller reduction steps: Let down the roller in smaller steps (see Sheeting, page 050 - 1).
3. Dough sheet tapers.	Reduction steps too small.	Select bigger reduction steps: Let down the roller in bigger steps (see Sheeting, page 050 - 1).

6 Cleaning

6.1 Cleaning

9

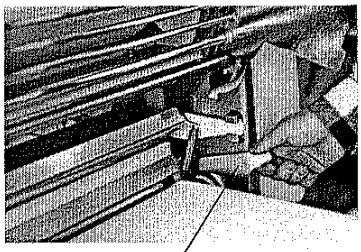
The machine must never be cleaned using spray water, high-pressure cleaners or a steam cleaning machine.

6.1.1 General Information

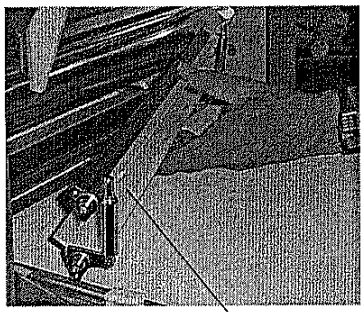
21

Dismounting the Scraper

- Open rollers fully
- Lock the safety guard into the upper position

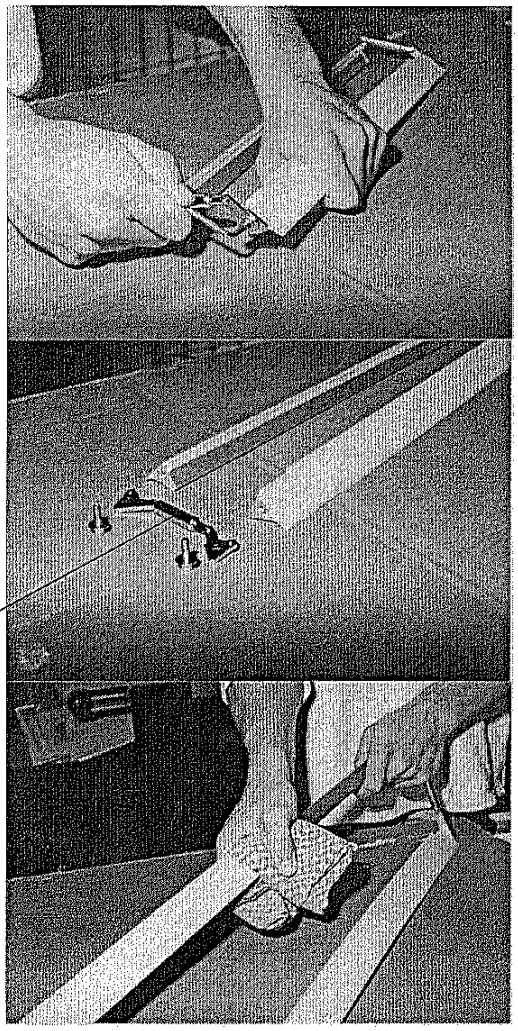


- Using the thumb, push the front and rear scraper blade (1) downwards



- Lift the scraper (2) out of the scraper mounting
- Pull out the scraper (2)
- Clean the scraper (see Care, page 060 - 4)

Exchange of scraper blades



Required tool: Allen key No. 4

Exchange of scraper blades:

- disassemble the spring clamp (3) on the left or right hand side

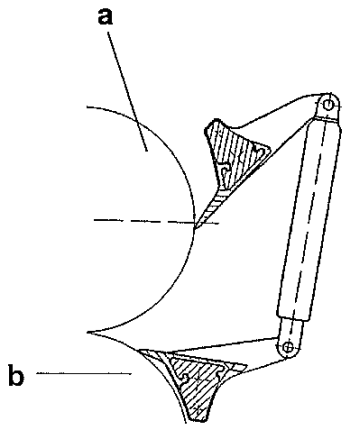
- slide the scraper blade off

Attention
For protection of the fingers, please use a cloth. The edges of the blades are sharp and there is danger of cutting oneself.

- Assemble the new scraper blades in reverse order

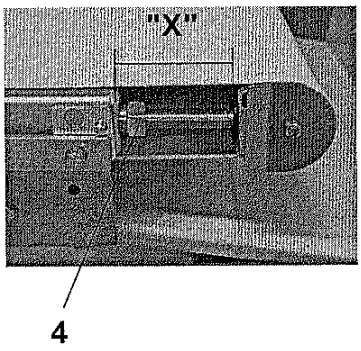
- Assemble the spring clamp in reverse order

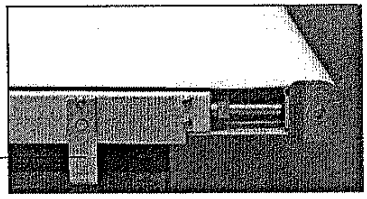
Mounting the Scraper

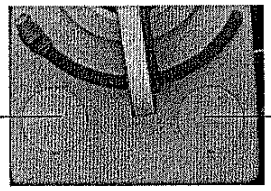


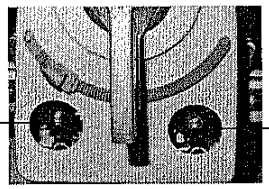
- To remount the scraper, carry out the dismounting instructions in reverse order.

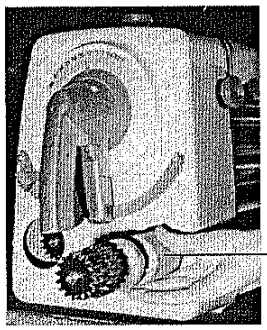
a upper roller
b lower roller











Dismounting Machine Tables/Conveyor Belts

In order to dismount the machine tables and conveyor belts, proceed as follows:

- Pull out the mains plug
- Lift up the safety guards
- Loosen the tension nuts (4) parallel, in order to retighten the conveyor belt
- Dismount the forked supports (only on SSO) (To remount forked supports, proceed in reverse order, see page 020 - 3)
- Dismount the forked supports (5) (STM)
- Dismount tables (To dismount, follow machine table mounting instructions in reverse order, see page 020 - 2)

In order to dismount the conveyor belts, proceed as follows:

- Remove covers (6) with aid of a screw driver
- Remove the drive rollers (7) towards the front out of the roller head
- Remove the conveyor belt
- The conveyor belt can now be cleaned or replaced (see Care, page 060 - 4/Replacement Parts List, page 070 - 1)

Mounting the Machine Tables and Conveyor Belts

Make absolutely sure that you do not confuse the left and right driving rollers or the left and right machine tables!

- Remount machine table and conveyor belts by proceeding in reverse order of the instructions for dismounting them

6.1.2 Care

Part	see	daily see legend	weekly see legend
Roller head and Machine base	Page 030 - 3		A
Scraper	Page 060 - 1	A	
Cotton conveyor belt	Page 060 - 3	B	(E)
Synthetic conveyor belt	Page 060 - 3	B	C
Dough catch pan	Page 020 - 5	A	
Driving roller	Pages 020 - 2 / 060 - 3		D
Idle roller	Page 020 - 5		D
Flour container	Page 030 - 3	B	

Alcohol, solvents or cleaning materials which exceed a ph value of 8 must not be used for cleaning purposes! Only those cleaning materials which are approved for use in the food industry may be used.

Legend

A Damp clean using cloth and soapy water.
B Dry clean using a brush.
C Wet clean using a brush.
D Remove excess dough using a brush and plastic scraper.
E Wash the cotton conveyor belt monthly as follows:
- Maximum washing temperature 40° C
- Hang the washed belt over a rod and weight it at the bottom with approx. 10 kg.

7 Maintenance

7.1 General Information on Maintenance of the Machine

Any defects on the machine must be repaired by an authorized customer service representative!

7.2 Maintenance List

What/Part	Activity	daily working time less than 4 h	daily working time 4 - 8 h	daily working time more than 8 h
Conveyor belts	check If necessary: replace	M	W	W
Scraper blade (Dough sheeter)	check If necessary: replace	M	W	W
Table drive and roller adjustment mechanism in the front housing	grease according to the Service manual	3 J	2 J	J
Roller drive and adjustment in the rear housing	grease according to the Service manual	3 J	2 J	J

Legend

W	weekly
M	monthly
J	annually
2J	every 2 years
3J	every 3 years

7.3 Replacement Parts List

The use of conveyor belts not supplied by Rondo-Doge can lead to premature wear or destruction on machine parts (coupling, drive rollers).

Item-no.	Description	Dimensions	Application
122773T02	Scraper complete	-	STM513, SSO514
122775T02	Scraper blade	-	STM513, SSO514
79302	Cotton conveyor belt	1490 x 475 mm	STM513
120750T04	Cotton conveyor belt	1940 x 475 mm	SSO514
121344T30	Synthetic conveyor belt	1470 x 475 mm	STM513
121344T31	Synthetic conveyor belt	2020 x 475 mm	SSO514
8934	Fuse 1,0 AT	1,0 AT slow ø 5 x 20 mm	all types

8 Trouble shooting

Fault finding	Cause / Defect	Remedy / To remove
1. Machine stands still after assembly.	Main switch not/not correctly plugged in. Safety guard not closed. Right or left Start push-button not pressed. Machine tables not level.	Plug in the main switch. Close safety guard. Press the desired Start push-button. Put the machine tables in a even level position.
2. When pressing the right Start push-button the conveyor belts move to the right.	Sense of rotation reverse (mains).	Moving direction test (see page 020 - 7).
3. Machine runs intermittently, stops, rattles.	Safety guard limit switch incorrect. Support for safety guard incorrect. Loose cables, wires.	Readjusting by an expert. Adjust supporting eccentric. Adjust loose wires, cables.
4. Main drive motor runs, rollers and conveyor belts stand still.	Belt drive defective.	Call after-sales service! Remove rear cover of machine base and roller head, replace belts or toothed belts if necessary.
5. Conveyor belts loops up, motor and rollers run.	Belt tension too weak. Driving roller dirty.	Tension conveyor belt equally (see Tensioning the conveyor belts, page 020 - 5). Clean driving roller (see Care, page 060 - 4)
6. Machine only runs to one side.	Defective motor contactor. Safety guard limit switch defective.	Call specialist (electrician). Replace motor contactor/limit switch.

Fault finding	Cause / Defect	Remedy / To remove
7. Discharge conveyor belt stands still or jerks.	Table drive defective Belt tension too weak.	Call after-sales service. Tension the belt equally (see Tensioning the conveyor belts, page 020 - 5).
8. Dough piles up before the roller or passes under the roller between scraper and infeed conveyor belt.	Scrapers inserted uncorrectly. Scraper blades worn out.	Close the scraper levers properly (see Cleaning, Mounting the scraper unit, page 060 - 1/2). Check and if necessary adjust scraper levers by means of eccentric (center of motion). If necessary replace scraper blades or the complete scraper.
9. Conveyor belts run to one side, tear at the edges.	Incorrect belt tension. Drive roller dirty	Tension conveyor belt (see Tensioning the conveyor belts, page 020 - 5). Clean drive roller (see Care, page 060 - 4).
10. Cotton conveyor belts too short after washing.	Washing temperature too high..	Washing temperature max. 40° C. Hang washed conveyor belt over a rod and weigh it down below with approx. 10 kg.
11. All other faults/falling outs		Inform nearest "Rondo-Doge" after-sales service giving as much information as possible.

9 Technical Data

9.1 Technical data Econom

Technical Data	STM 513 Econom	SSO 514 Econom
Machine base	No (table model)	Socle
Belt width	475 mm	475 mm
Table width	487 mm	487 mm
Total table length	1590 mm	2055 mm
Req. floor-space: in working position in resting position	 940 x 1590 mm 940 x 700 mm	 940 x 2500 mm (dough catch pans extended) 940 x 850 mm
Roller length	500 mm	500 mm
Roller gap	0,5 - 30 mm	0,5 - 30 mm
Sheeting speed of discharge conveyor	55 cm/sec	55 cm/sec
Rated power	0,75 kVA / 0,5 kW	0,75 kVA / 0,5 kW
Supply voltage	3 x 200 - 420 V, 50 / 60 Hz 1 x 200 - 230 V, 50 Hz 1 x 200 - 230 V, 60 Hz 1 x 110 V, 60 Hz	3 x 200 - 420 V, 50 / 60 Hz
Machine weight:	approx. 80 kg	approx. 140 kg

Subject to technical changes without notice.

9.2 Additional information

All sheeters from Rondo-Doge have the following quality features:

- The conveyor belts made of plastic material:
  All plastic coated conveyor belts used on our machines are approved for coming into contact with food stuff and correspond with the requirements of the FDA (Food and Drug Administration, USA).

- The conveyor belts made of cotton:
  The fabric consists of 100 % cotton and has a non-toxic finish.

- The rollers are hard-chrome plated. This coating is approved for coming into contact with food stuff.

- The scraper blades are made of POM-C plastic material. This material is approved for coming into contact with food stuff and corresponds with the requirements of the "Bundesgesundheitsamt BGA", Germany.

- The dough catch pans are made of stainless steel (chromium nickel steel, DIN Mat. no. 1.4301). This material is approved for coming into contact with food stuff.

- The rollers of the manual and the automatic dough reeler that are touching the dough are made of aluminium, anodised colourless and are approved for coming into contact with food stuff.