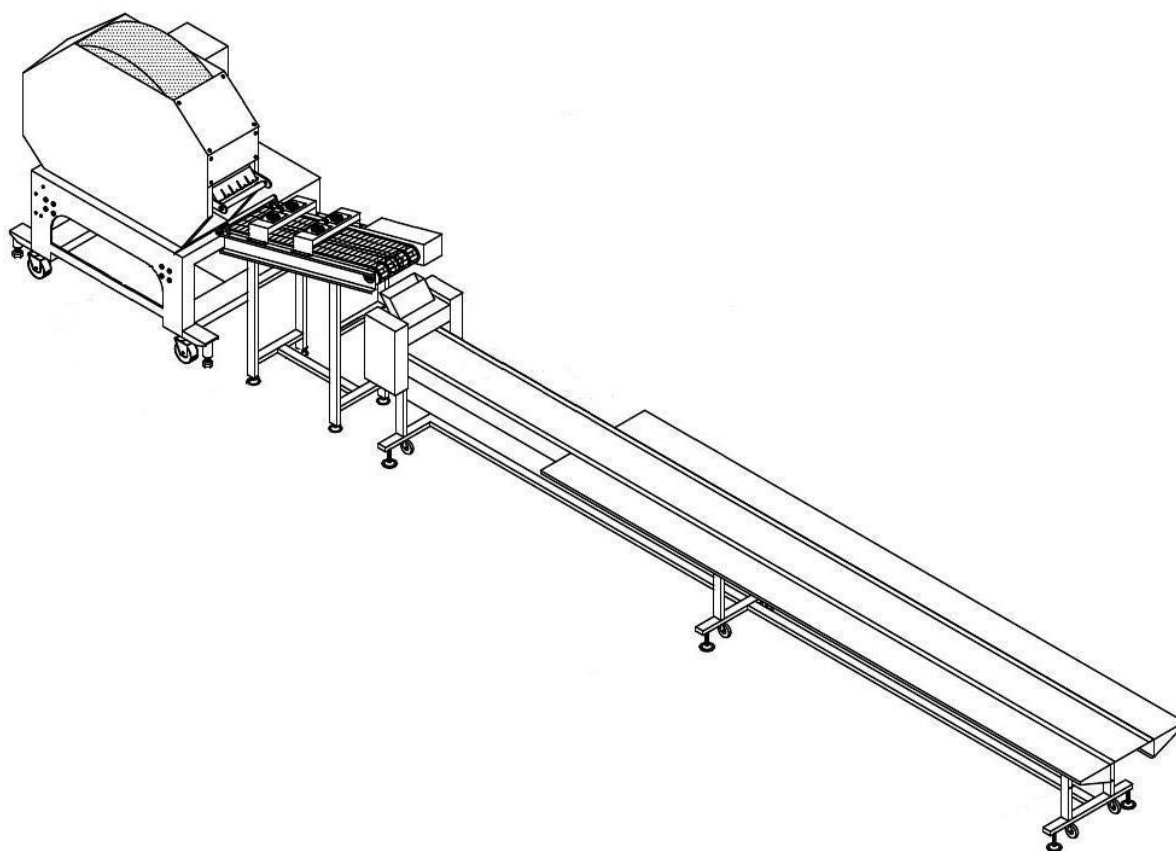


SRPF-45A

Semi-Automatic Spring Roll/Samosa Production Line

Operation Manual



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RE_1020917

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1. PRECAUTION :

1-1. CAUTION :

- a. "OPERATOR" is the person who is responsible for the installation, operation, maintenance, cleaning and transportation of the machine.
- b. This manual is an integral part of the machine and must be accompanied with the machine throughout its life time for reference.
- c. Always refer to the instructions in this manual before operating the machine.
- d. Always carefully follow all the steps described in the manual.
- e. Do not allow the machine to be used by the operator who is not familiar with the contents of the manual.
- f. Keep the manual in appropriate, legible condition for reference.
- g. Be sure to hand the manual over to any other operator or subsequent owner of the machine.
- h. Before operating the machine, the operator should take off personal ornaments or cloth which could hinder work or machine operation, such as bracelet, tie, etc.
- i. Ensure the input voltage conforms to the voltage requirement of the machine.
- j. The machine must be placed in the work area which can afford its weight.
- k. The operation steps or actions which may cause potential danger have **warning symbol** beside the instruction.





WARNING



Our company will have no responsibility for any malfunctions, breakages, accidents, etc., caused by not fully read or not follow the instructions contained in this manual.



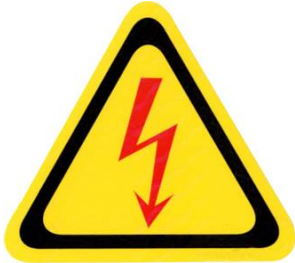


Our company will have no responsibility for any damage or accident caused by modifying, changing, adding extra equipment or adjusting the machine without our permit.



To protect operator safety, CE protect cover must not be removed during operation if it is installed on the machine. Anko will take no responsibility to any personnel injury caused by end-user removes the CE protect cover at will.

1-2. WARNING SYMBOLS :

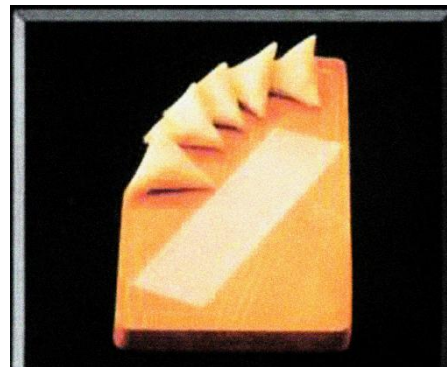
 <p>Caution of Rotation</p>	 <p>Caution of Rotation</p>
 <p>High Voltage</p> <p>This symbol indicates that dangerous voltage constituting a risk of electric shock is present within this unit.</p>	<p>380V 3Ø 50/60HZ</p> <p>Electric Power Instruction</p> <p>Instruction of input power specification required by machine.</p>

1-3. CHECK :

Please check if the amount of machine(s) & accessories are correct and not damage or malfunction during transportation. If there is any missing, damage or malfunction, please contact with us immediately.

2.INTRODUCTION :

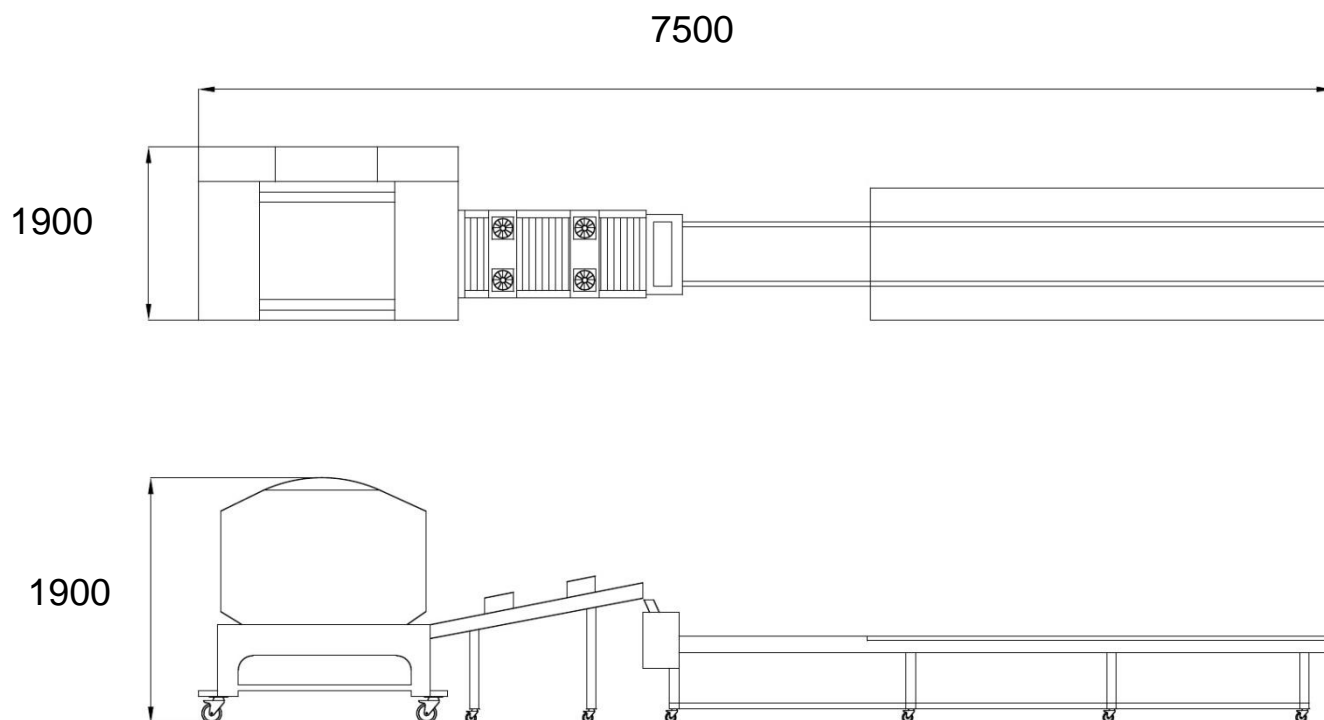
The SRPF Semi-Automatic Spring Roll production line is designed to produce Spring Roll pastries, cut in size and filling automatically, the only manual step is to wrap up the semi-finish product. Compare to traditional way, the SRPF helps you to save cost of pastry, increase the production capacity and quality at the same time. Other than baking drum, control panel and few electrical parts, whole machine are washable.



3. DIMENSIONS :

- SIZE : 7500 (L) x 1900 (W) x 1900 (H)

UNIT : mm



4. SPECIFICATION AND CAPACITY :

- Power : 220/380/415V, 50/60HZ, three phase
- Weight : 1200 Kgs
- Feature :
 - ✧ Customize machine, size is adjustable.
 - ✧ Sanitary and safety device.
- Capacity : About 150kg product/hr.
- The capacity mentioned above is based on 60HZ power supply. To 50HZ power, the capacity will reduce about 20%.



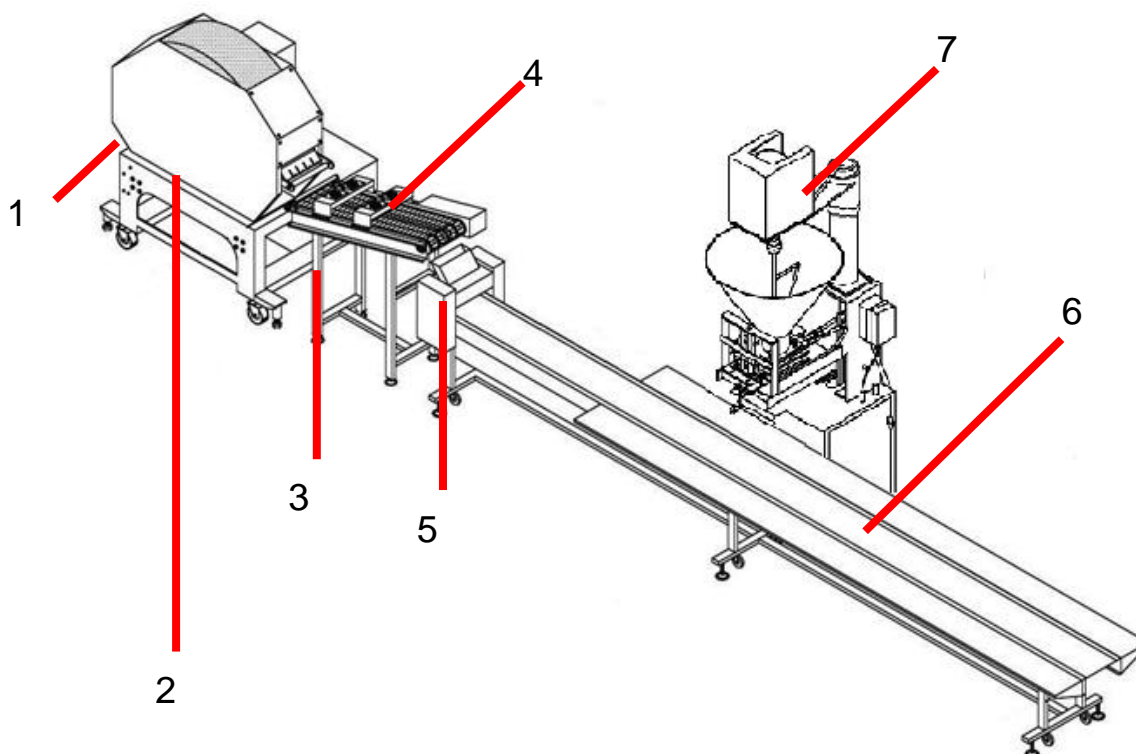
Capacity will be influenced either higher or lower by the product feature, recipe, size and weight. The capacity mentioned above is for reference only.



To ensure the performance and safety of the machine, Anko reserves the right to modify the machine without notification in advance.

5. MACHINE PARTS LIST :

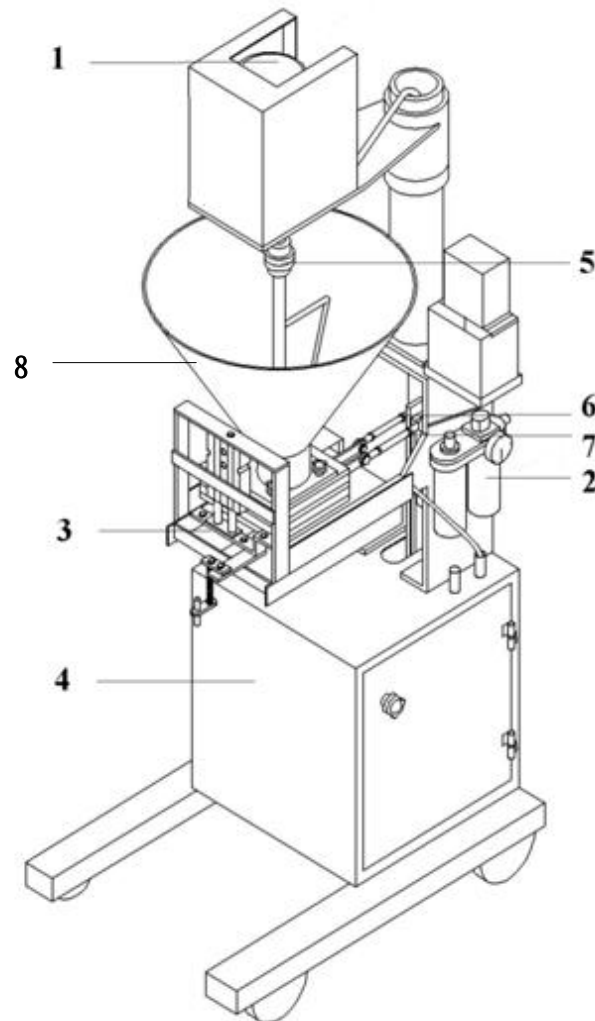
5-1. MACHINE MAIN PARTS:



Parts list 1. Machine Major Parts

No.	Parts Name.	No.	Parts Name.
1	Gear pump (Back)	5	Rotary cutter
2	Baking drum	6	Working table
3	Cooling conveyor	7	Filling depositor
4	Cooling fan		

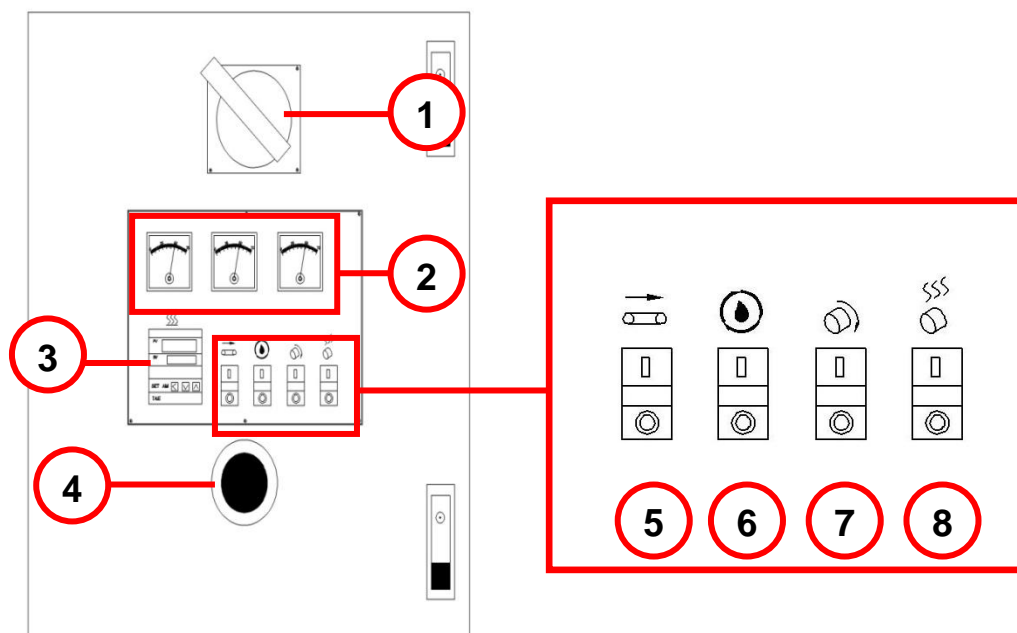
5-2. FILLING DEPOSITOR (FF-1)



Parts list 2. Filling Depositor

No.	Parts Name.	No.	Parts Name.
1	Motor	5	Propeller (filling screw)
2	Air cylinder	6	Long main drive stick
3	Deposit mold plate	7	Short main drive stick
4	Machine Frame	8	Filling hopper

5-3. CONTROL PANEL(BAKING DRUM) :



No	Name	Function
1	Main power switch	Switch on and switch off power of the machine
2	Amp meter	Display 3 phase ampere of heating system
3	Temperature controller	Set up working temperature for heating system
4	Emergency Stop	Press to stop all motors and whole system all together.
5	Conveyor ON/ OFF	Cooling conveyor ON/ OFF switches, cutter and stacking device. Green for on and red for off.
6	Cooling system ON/ OFF	Cooling system ON/ OFF switches. Green for on and red for off.
7	Baking drum ON/ OFF	Baking drum rotation ON/ OFF switches. Green for on and red for off
8	Heating system ON/ OFF	Heating system ON/ OFF switches. Green for on and red for off.

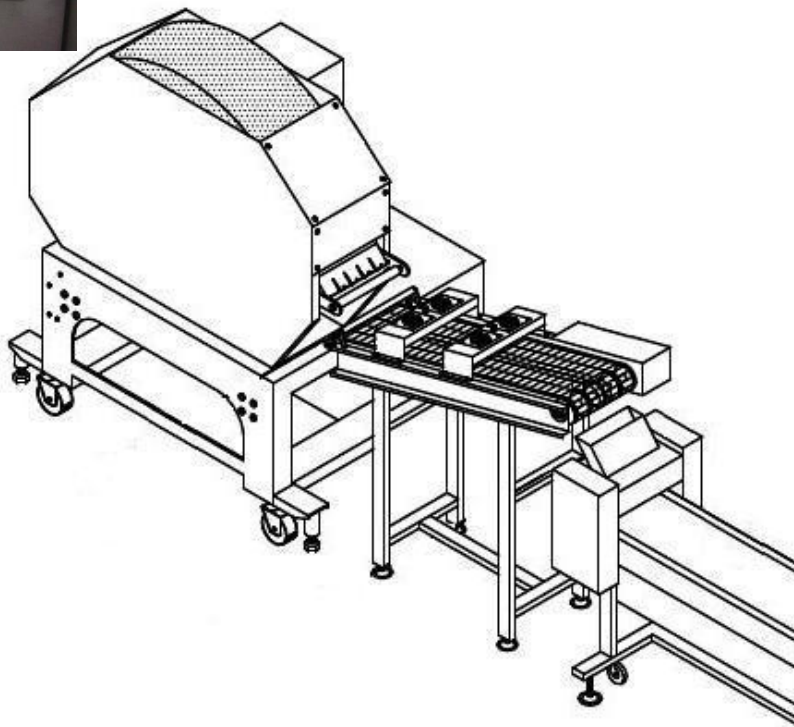
5-4. EMERGENCY STOP SWITCH :



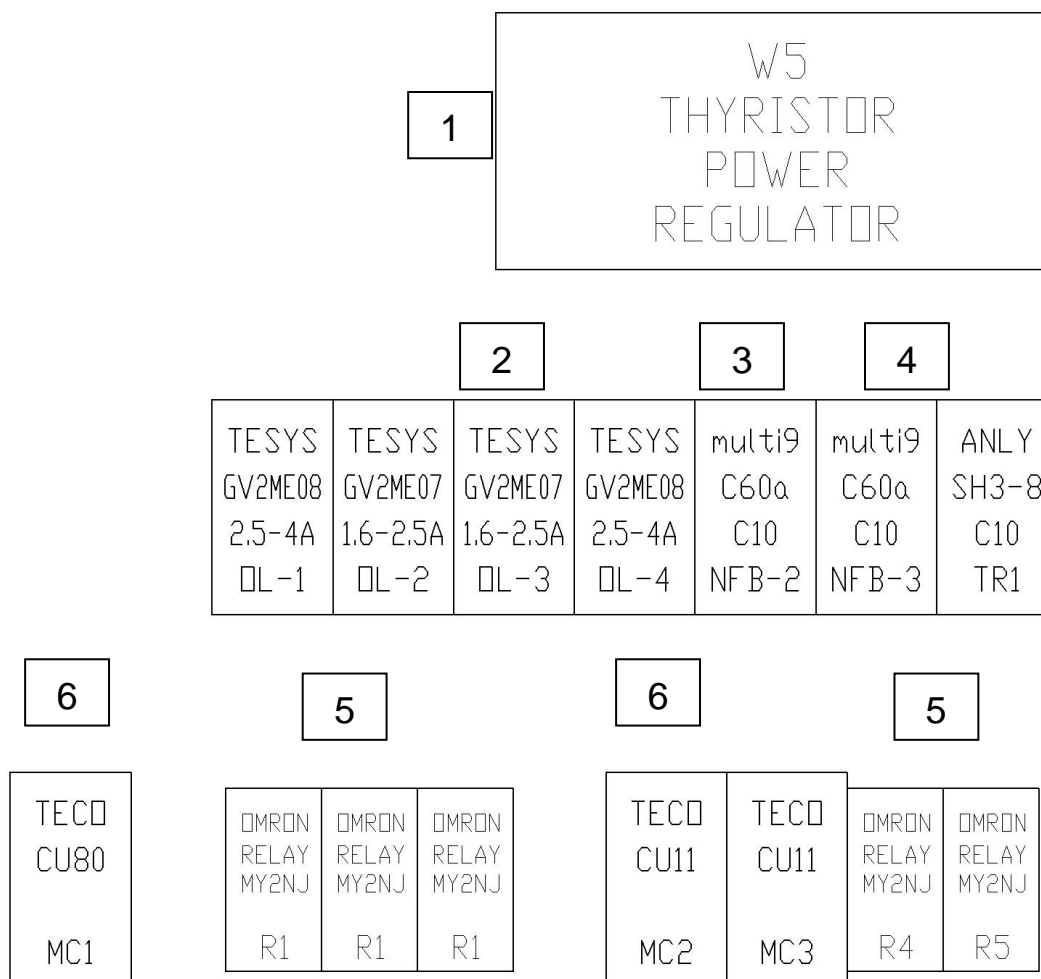
Whenever emergency condition occurs, press emergency stop switch button to cut off the main power and stop the machine immediately to ensure operator or machine safety.



CAUTION

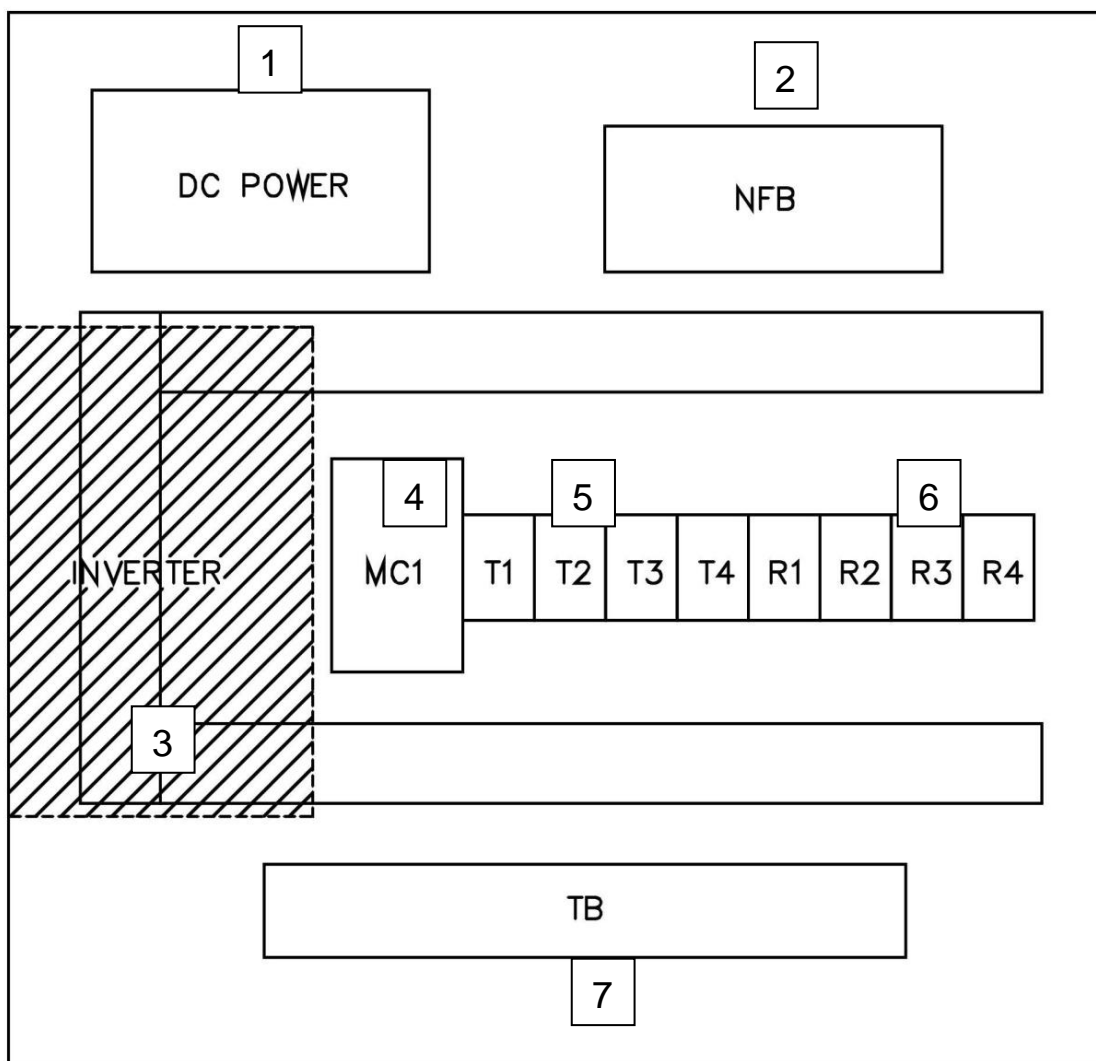


5-5. ELECTRIC BOX(BAKING DRUM) :



No	Parts Name.	No.	Parts Name.
1	Power regulator	4	Timer
2	Overload protector	5	Relay
3	Non-fuse breaker	6	Magnetic switch

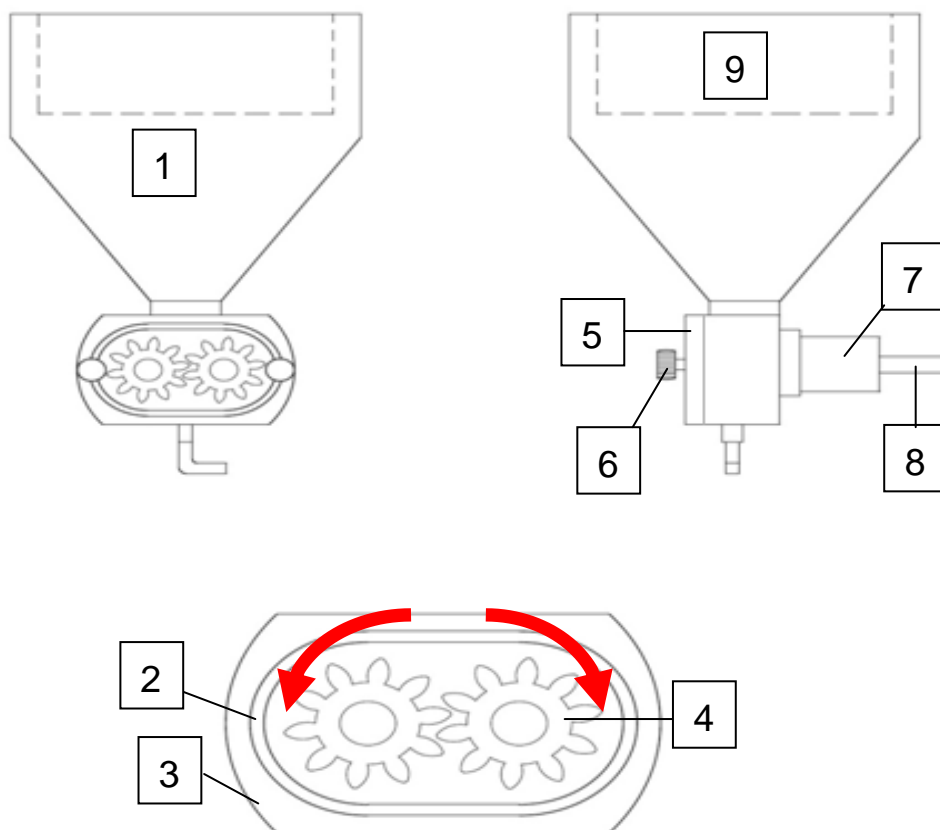
5-6. ELECTRIC BOX(FILLING DEPOSITOR) :



No	Parts Name.	No.	Parts Name.
1	Power regulator	5	Timer
2	Non-fuse breaker	6	Relay
3	Inverter	7	Terminal

4	Magnetic switch		
---	-----------------	--	--

5-7. BATTER PUMP



No.	Parts Name	No.	Parts Name
1	Batter Hopper	6	Knurled Knob Screw
2	O-ring	7	Copper Sleeve
3	Gear Pump Base	8	Transmission Axle
4	Gear	9	Filter
5	Acrylic Seal Cover		

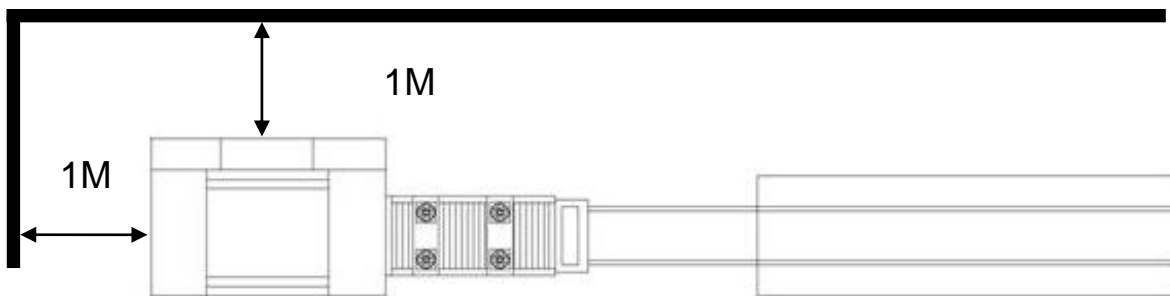
6. INSTALLATION :

6-1. CHECK

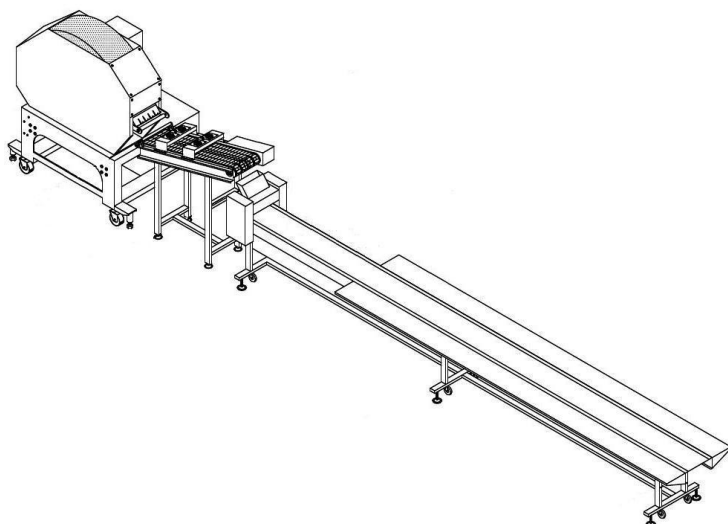
Please check if the amount of machine(s) & accessories are correct and not damaged or malfunctioned during transportation. If there is any missing, damage or malfunction parts, please contact with us immediately.

6-2. INSTALLATION SPACE SUGGESTION :

The minimum space required for machine production, cleaning and maintenance purposes is illustrated in the following drawing

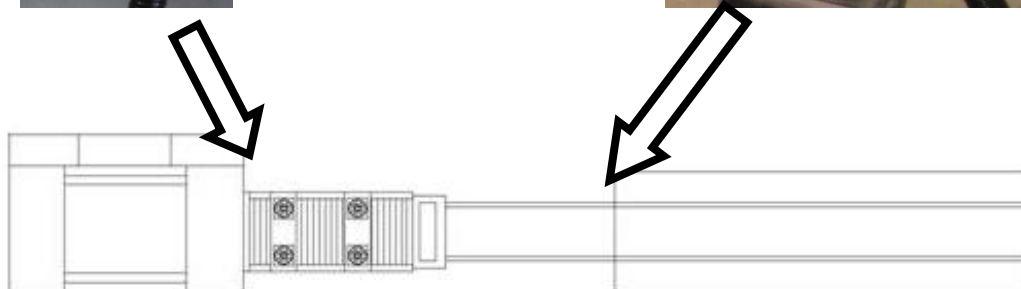


6-3. INSTALLATION STEPS :



(1). Set the machine as shown
(Baking drum→Cooling
conveyor→Working
conveyor)

(2). Connect the cable from the machine.

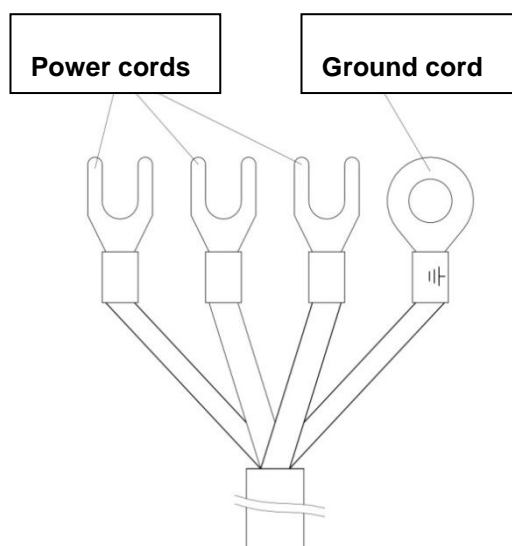


6-4. CONNECTING POWER CORD AND PNEUMATIC SOURCE

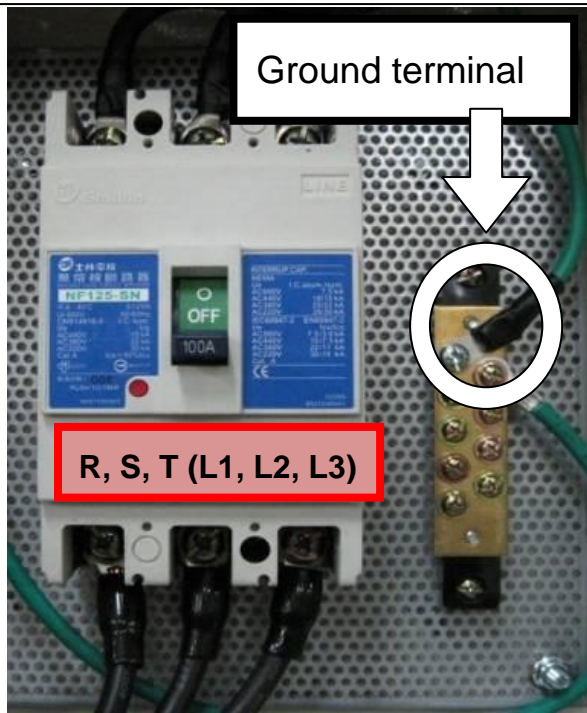
- CAUTION!!**
- Power should only be connected by qualified electrician.
- Please ensure the input power corresponds to the power required by the machine.

MODEL				
DATE.	2012/03	CYCLE	50/60HZ	
SERIES/N	XXXXXX	PHASE	3 PH	
VOLTAGE	380 V	HP.	5.5 hp	

380V 3Ø 50/60HZ



- (1). Please ensure the voltage and phase on machine nameplate are identical with input power.
Left figure is for example only. Please refer to the machine plate on machine for the actual electric specification.
- (2). Three phase power model has three black power cords and one yellow-green ground cord.

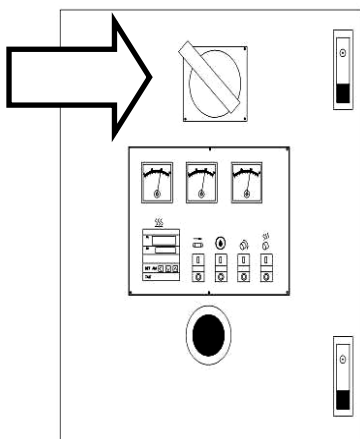


- (3). Please connect power cords to breaker and ground cord to ground terminal. °



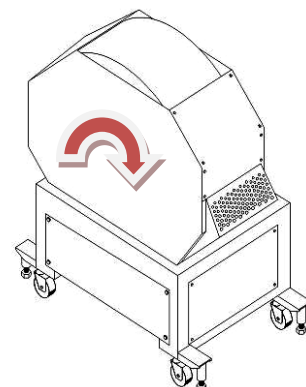
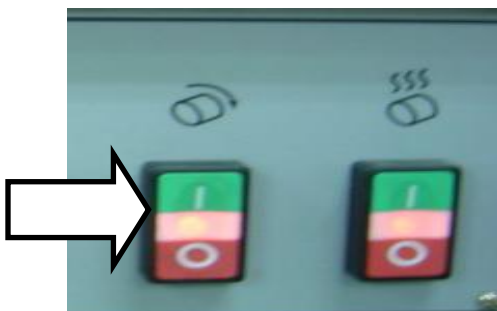
Caution:

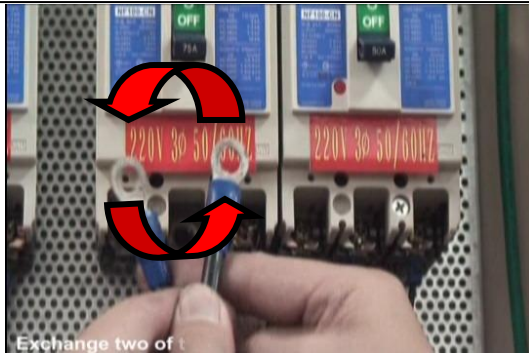
Ground cord must be properly connected, and must not to connect ground cord to power source to prevent machine damage or personnel electric shock from happening.



- (4). Make sure power supply and protection switch is normal and the connection is under protected. Then start the machine with main power switch,

- (5). Switch on the baking drum to check if the rotation direction is correct.





- (6). In case of wrong direction, switch off “STUFFING SCREW”, press the Emergency Stop Button, shut off the power from source breaker. Then exchange two of three phase core and test again.

7. DISASSEMBLY :

7-1. FILLING DEPOSITOR DISASSEMBLY:

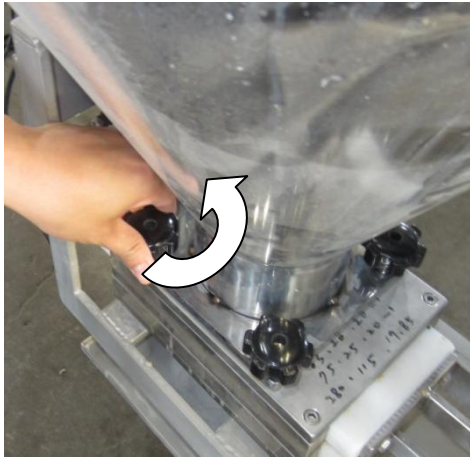
Before disassembling, always disconnect electrical power and compressed air source.



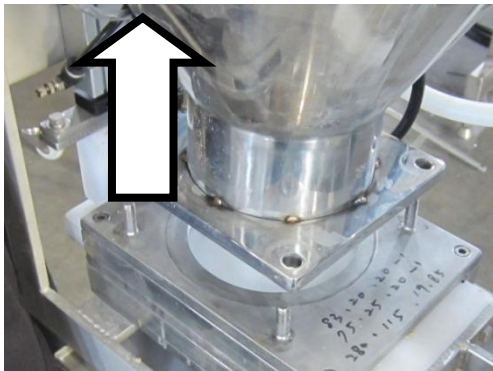
(1).Unlock the propeller (Stuffing screw)



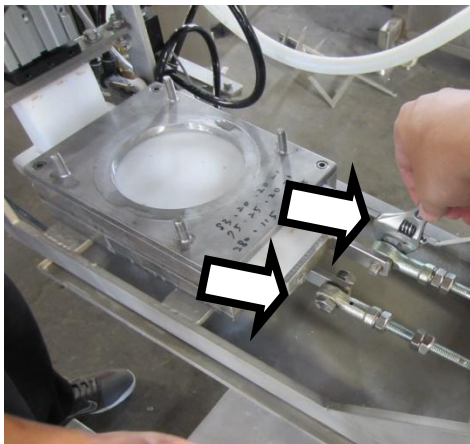
(2).Remove it from filling hopper.



(3).Remove 4 hopper fixing knobs.



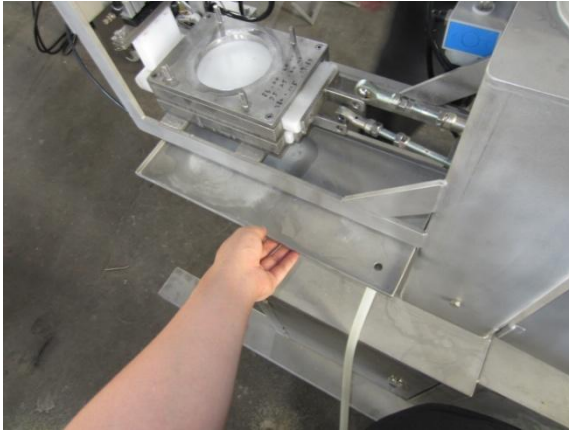
(4).Remove the hopper.



(5). Remove 2 connecting rod fixing screws.



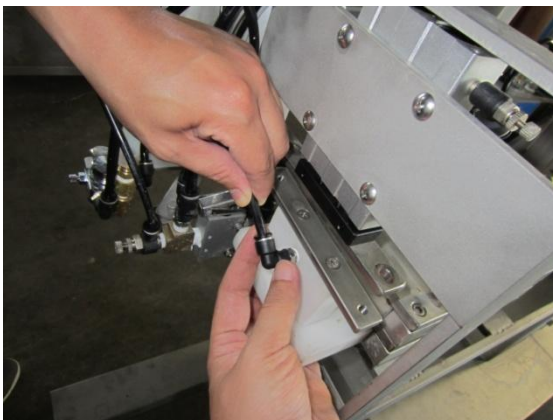
(6).Disconnect the connecting rods.



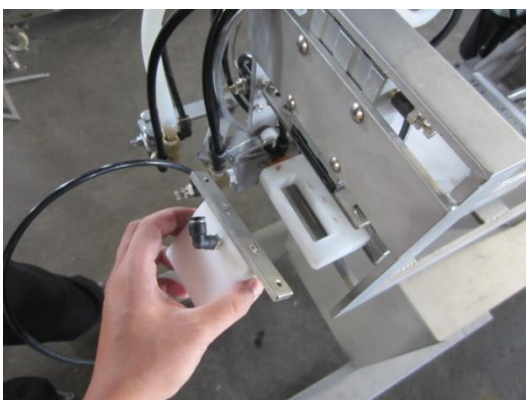
(7). Pull out the collecting plate.



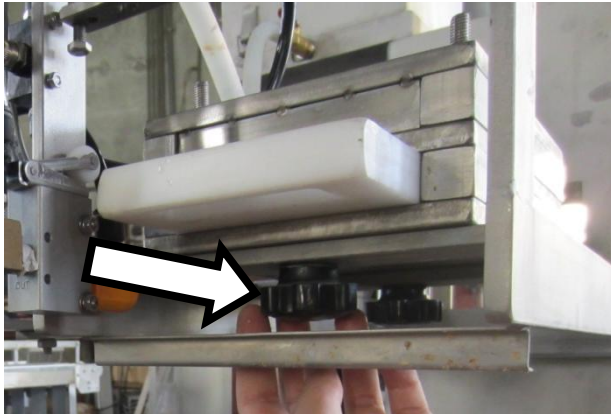
(8). Remove 2 vertical depositor fixing screws.



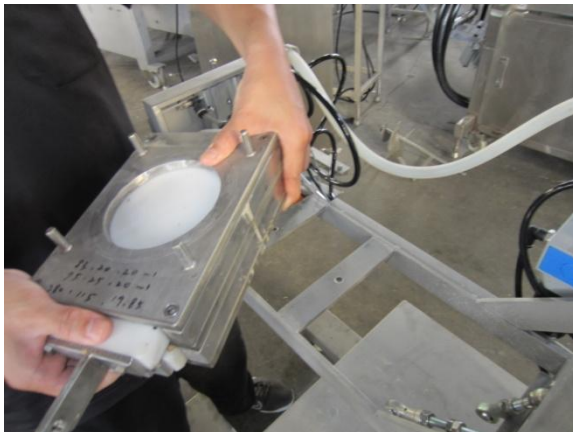
(9). Disconnect the pipe on the depositor.



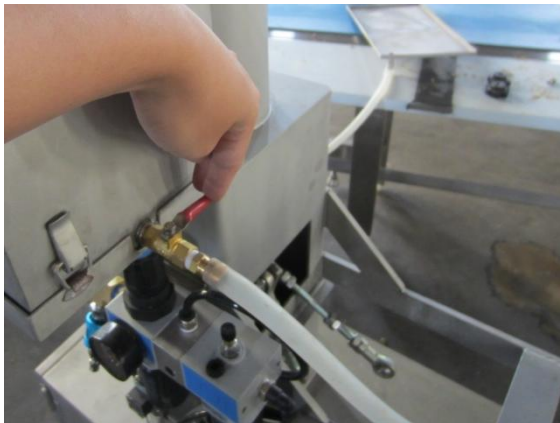
(10). Take off the vertical depositor .



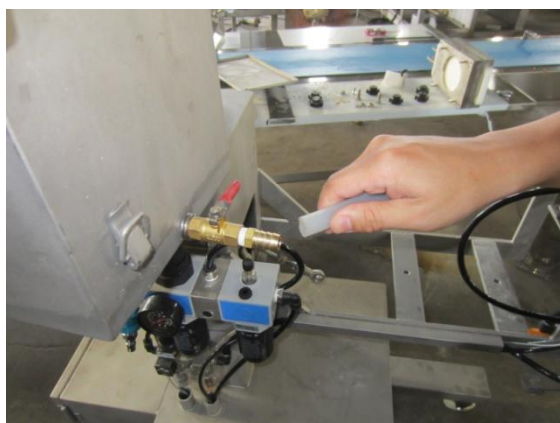
(11). Remove 2 fixing knob under the pump.



(12). Remove the main pump with the depositors.



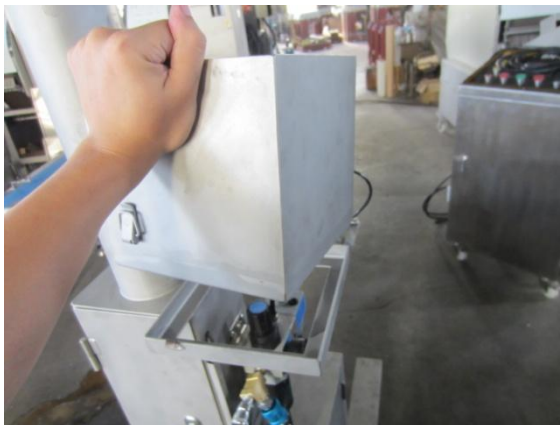
(13). Turn off the valve.



(14). Remove the water spray tube.

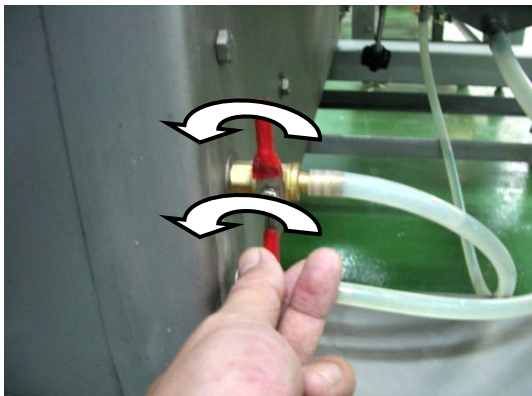


(15). Unlock the tank locker.

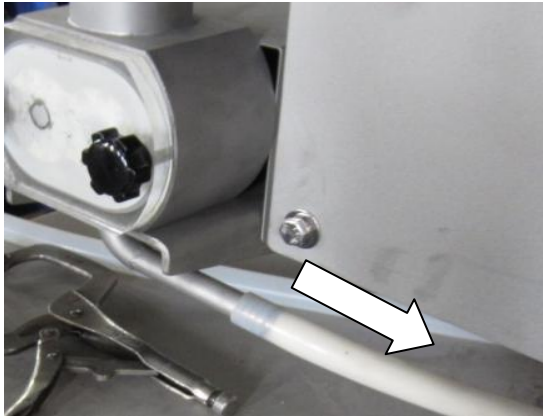


(16). Take away the water tank.

7-2. SPRAY NOZZLE DISASSEMBLY:



(1). Before removing all the hoses, make sure you turn off all the pump and the cooling water valve




(2). Remove gear pump hose

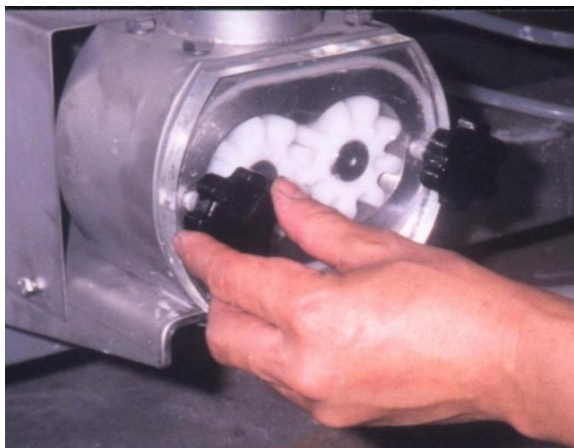


(3).(3). Remove the cooling water hose .



(4). Loosen the adjusting roller screw to remove the adjusting roller.

 **The roller is very hot after using.**



(5). Remove the fixing nuts



(6). Remove the acrylic seal cover



(7). Use the screw to take apart the gears



(8).Remove the spary nozzle

8. MACHINE CLEANING:

Before shipping, Anko will spray protection oil on the machine, please clean the entire machine surface which will contact food of this machine thoroughly before your first trial run. Check carefully before operation if there is any foreign part falls on the machine during shipping before operating to prevent unexpected machine damage from happening.

Please follow the cleaning steps to clean machine after finishing the production, Leave the baking drum on to air-cool. Do not flush it or use a fan to cool it in order to avoid the drum from becoming deformed

NO.	Ways of cleaning	Note
1	Rinse	Wash directly with soft detergent.
2	Scrub	Scrub the machine parts with soft detergent.
3	Air blow	Blow directly with high pressure air.

CLEANING SUGGESTION:



Do make sure to blow out moisture residue on machine and parts after cleaning to prevent machine getting rust.

Cleaning Suggestion List 1.

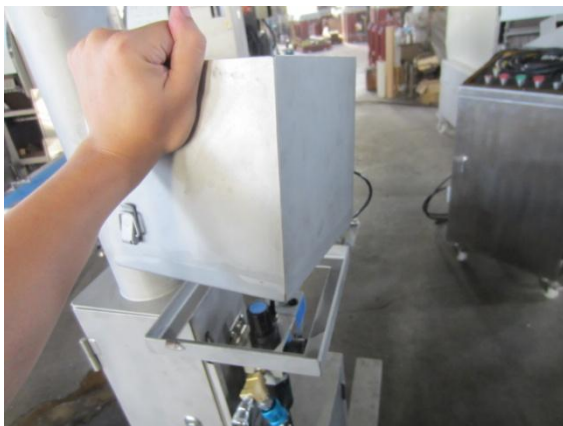
No.	Part Name.	Ways of cleaning	Frequency	Note
1	Batter pump unit	Scrub(With water and scrub sponge)	After every operation	After disassembly, use water and pressure air to clean the batter tank and gear pump, don't leave any batter inside the pump base, otherwise, the batter becomes dry will be hard to clean and the gear will be hard to put on
2	Spray nozzle	Rinse		After making pastry, please clean the spray nozzle as soon as possible, or it's not easy to clean inside the nozzle while the batter getting hard
3	Filling device unit	Rinse		Needs to be disassembled for cleaning, please refer to filling unit disassembly.
4	Cooling conveyor	Air blow		No need to disassemble, please clean on machine directly.
5	Forming conveyor	Air blow		No need to disassemble, please clean on machine directly.
		Rinse		
		Wipe off		

9. ASSEMBLY STEPS :

CAUTION:

Shut off machine power before starting machine assembly to prevent accident from happening.

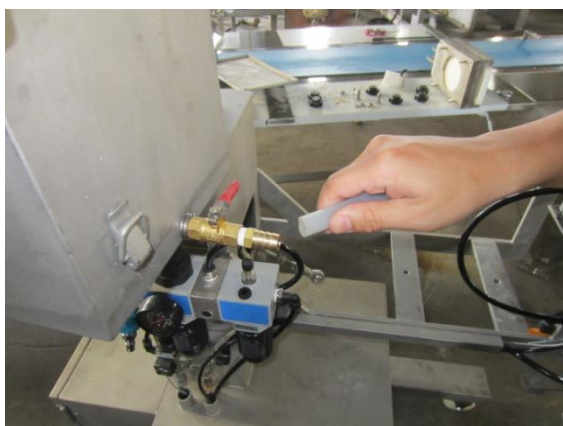
9-1. FILLING DEPOSITOR ASSEMBLY:



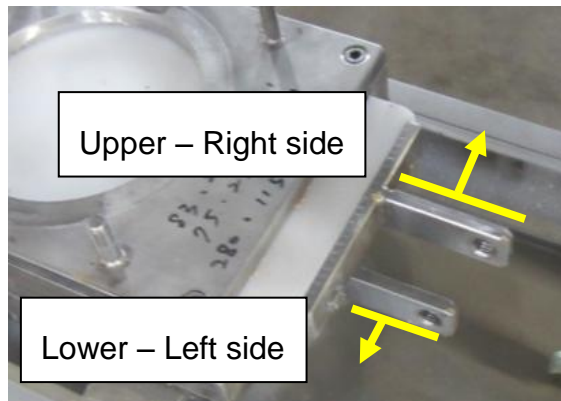
(1) Put back the water tank.



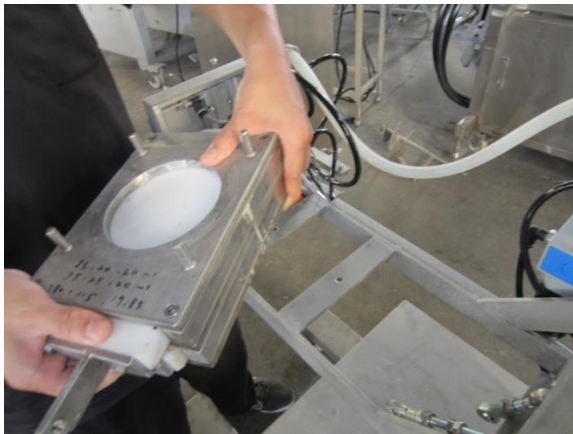
(2) Lock the tank locker.



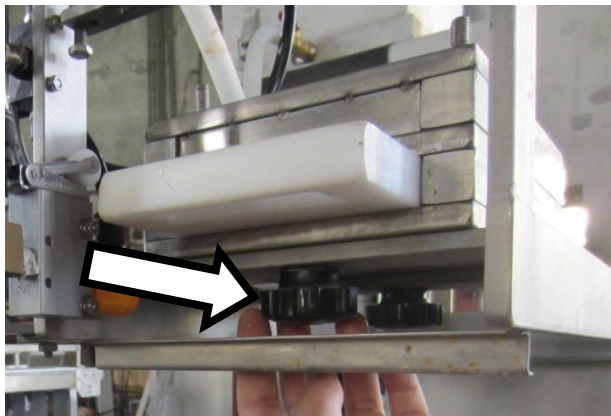
(3) Connect the water spray tube.



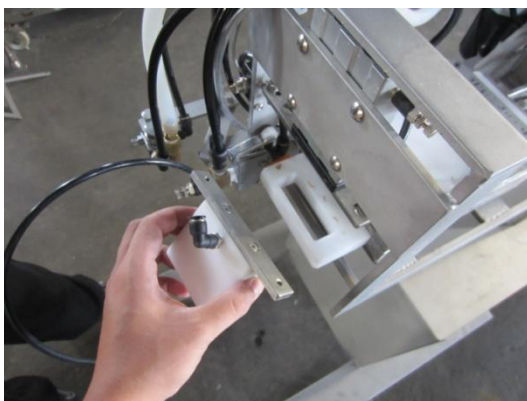
(4) Put upper depositor and lower depositor(**mold depositor**) into the main pump, the upper depositor fixing rod is at right side, the lower depositor fixing rod is at left side.



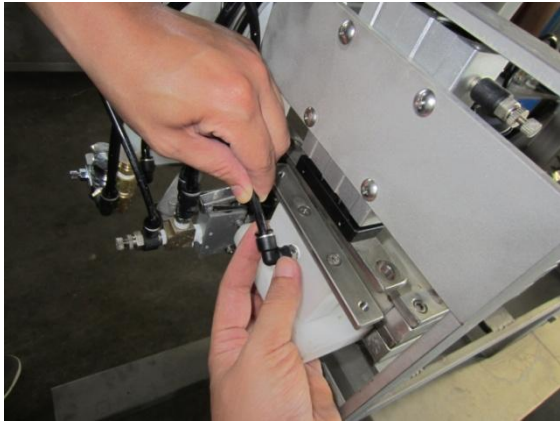
(5) Put on the main pump.



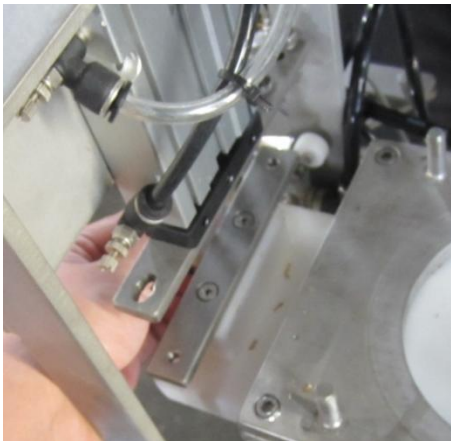
(6) Put on the fixing knob, tighten the knob.



(7) Put on the vertical depositor



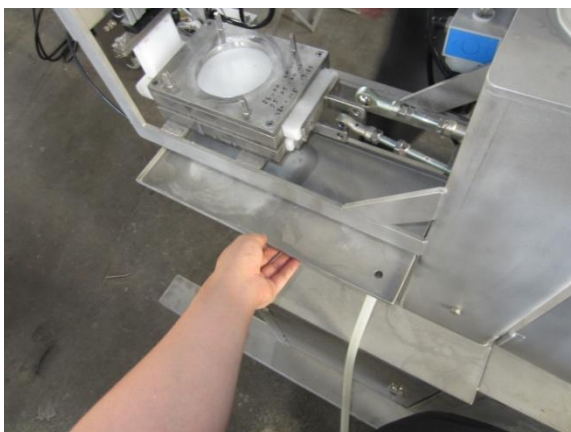
(8) Connect the pipe.



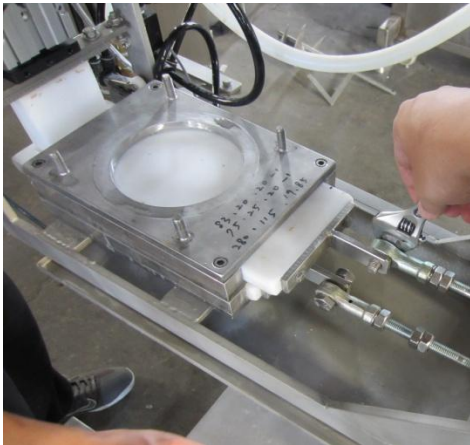
(9) Put vertical depositor into the lower depositor.



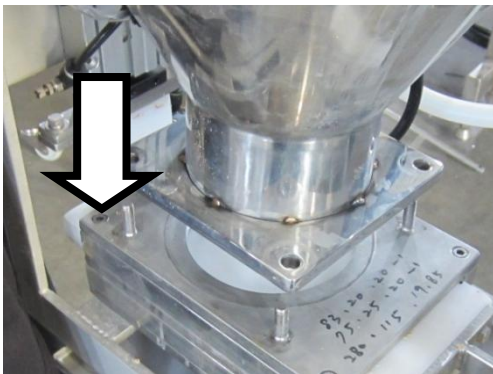
(10) Fixing 2 vertical depositor fixing screws.



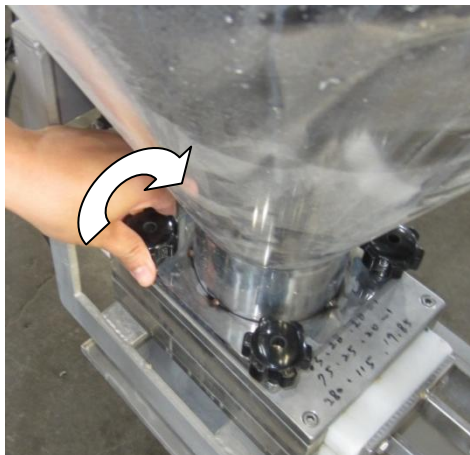
(11) Put back the collecting plate.



(12) Attach 2 connecting rods with fixing screws.



(13) Put on the hopper.



(14) Attach the fixing knob.

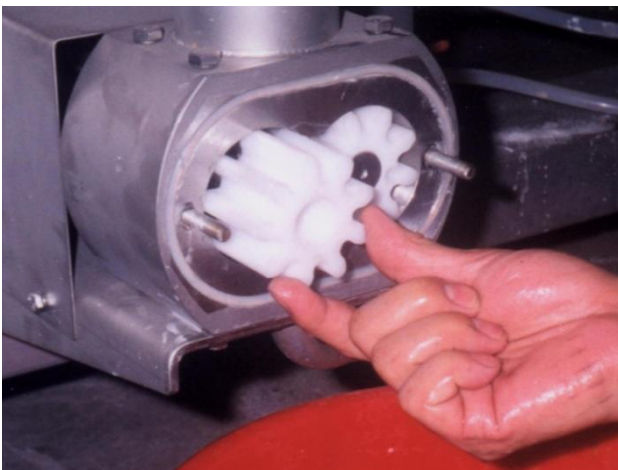


(15) Put back the propeller
(Stuffing screw)



(16) Lock the propeller.

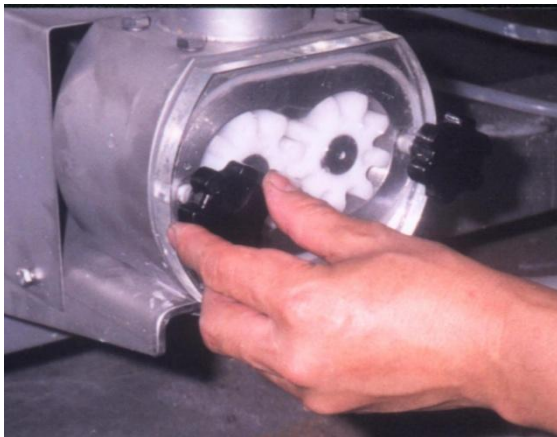
9-2. BATTER PUMP UNIT ASSEMBLY:



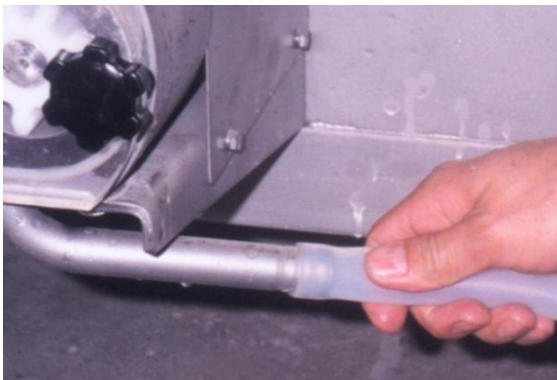
(1) Insert two pump gear into the
pump base(One with key slot, the
other one none)



(2) Put on the acrylic seal cover.



(3) Tighten the fixing nuts.



(4) Connect the batter pipe.

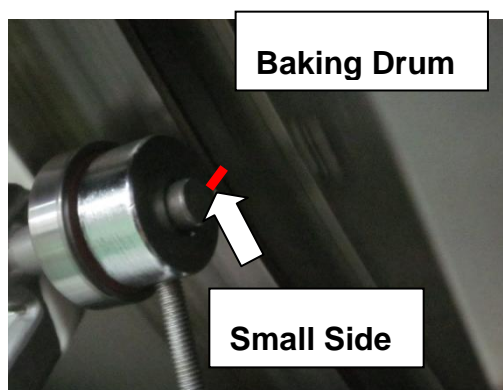


(5) Install the spary nozzle.

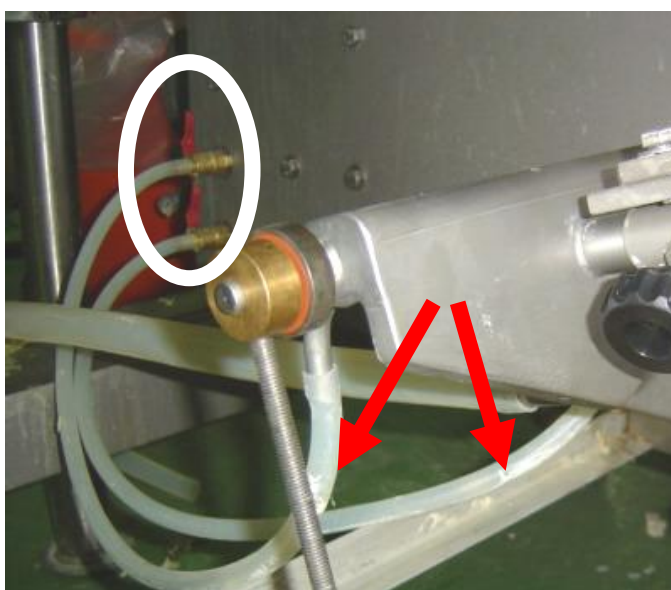


(6) Install the adjusting rollers at both ends of the batter spray nozzle.

The rollers should be exactly symmetrical to each other



(7) The small side of adjusting roller should face to the baking drum.



(8) Connect the cooling water pipes to the spray nozzle. There is no order for the two hoses connect to the inlet and outlet plug.

10. OPERATION STEPS :

10-1. PRE-CAUTION :

- a. Before starting the machine, please make sure all removable parts are securely tightened to prevent from parts damaging.
- b. Do make sure the ground cord has been properly connected to protect the life of inverter and other electric related components. If the power voltage is not stable in your area, please apply a voltage regulator for the machine to protect the machine working life.
- c. Please set the inverter value per the instruction on the operation manual. **Please be kindly notified that machine main body, sub parts, related components and inverter damage caused by overdriving, changing the inverter setting value or modifying machine without prior agreement by Anko will void the warranty.**
- d. Please apply food grade white oil or food grade Vaseline for parts lubrication, do not use salad oil or other grease which will deposit into solid/sticky residue.



Warning: Anyone who does not pass through the safety training should not operate the machine.

Ensure that the voltage of the electrical supply corresponds to that required by the machine.

10-2. OPERATION AND ADJUSTMENT STEPS :




(1). After assembling all the parts, switch on Cooling system, Baking Drum rotate and Heating system




(2). Set the temperature between 150~180°C (adjust it according to the thickness of the batter and pastry sheet required)



(3). Press  Key: The figures will begin to twinkle.

Press  or  Keys: To select the desired temperature reading.

Press  Key: To complete the setting procedure.



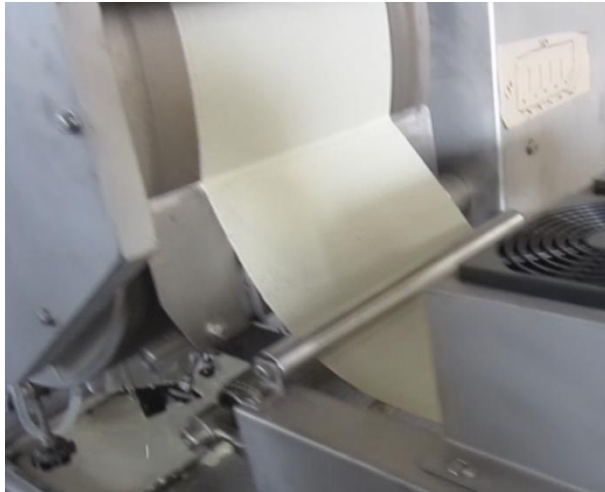
(4). Place the filter into the batter tank to filter out the granules in the batter



(5). Pour or pump the well-mixed batter into the batter tank.



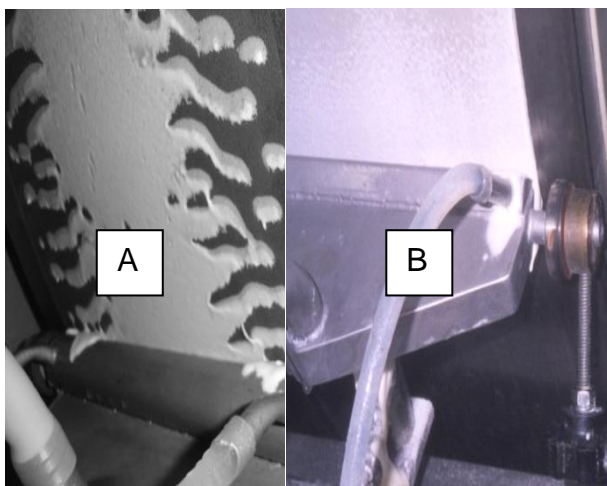
(6). When the temperature of the baking drum reaches the set temperature, turn on the batter pump switch to deliver the batter to the spray nozzle.



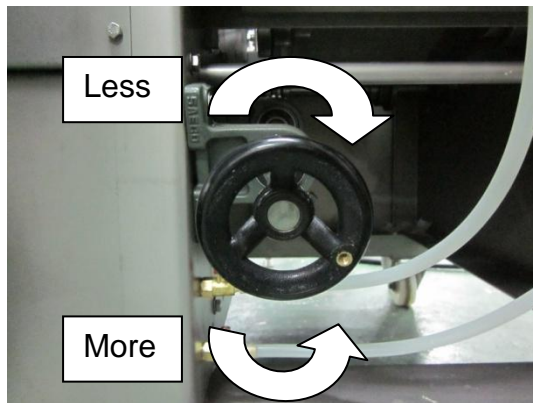
(7). Put on the scraper before you put on the batter, or the pastry won't separate from the drum.



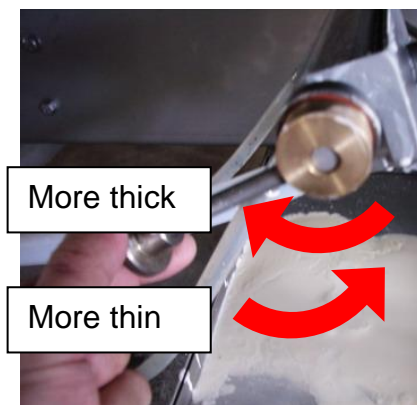
(8). Push up the spray nozzle to wipe a thin layer of batter onto the baking drum. The first cycle of pastry will be harder, but from the second cycle and on, a softer and more standard thickness pastry will be produced.



(9). Adjust the speed of batter pump , **A** is not enough(cause the wave shape), **B** is too much(batter overflows at both ends of the nozzle)

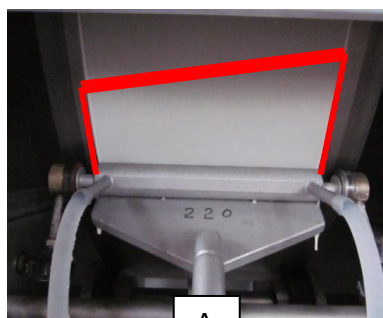


(10). The batter pump adjust hand wheel is beside the pump, turn clockwise to increase the batter, turn counterclockwise to decrease the batter.



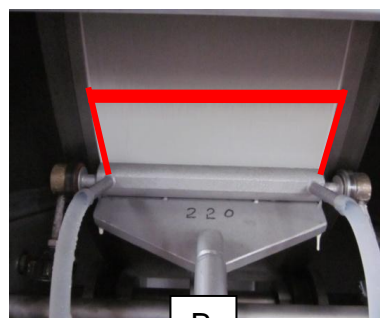
(11). Adjusting rollers to set the distance between spray nozzle and baking drum to allow adjustment of pastry skin thickness.

(12). When batter attaches on baking drum, it forms a horizontal border (dry line) between wet and dry area; the horizontal border is more far from the nozzle, the pastry will be more thick. If the border is not horizontal, turn the adjusting rollers(see 11) to make it horizontal, or the pastry thickness will be not even



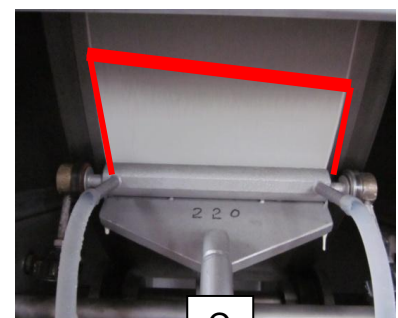
A

Left side is thin
Right side is thick
(Not good)



B

Both sides are even
(Good)



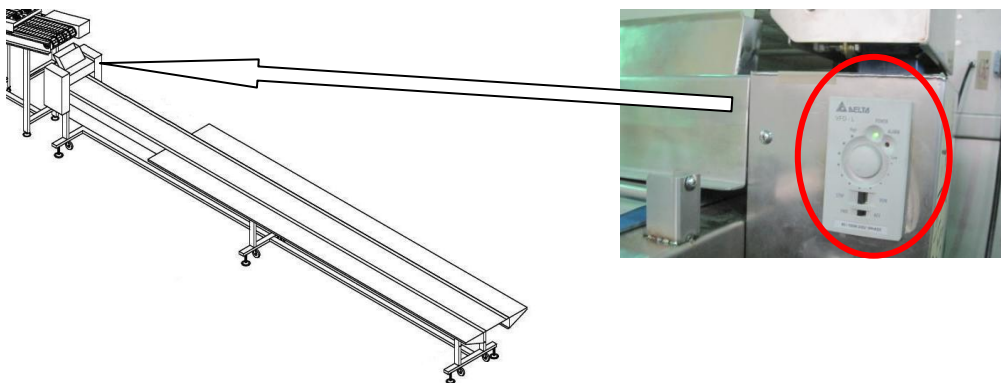
C

Left side is thick
Right side is thin
(Not good)

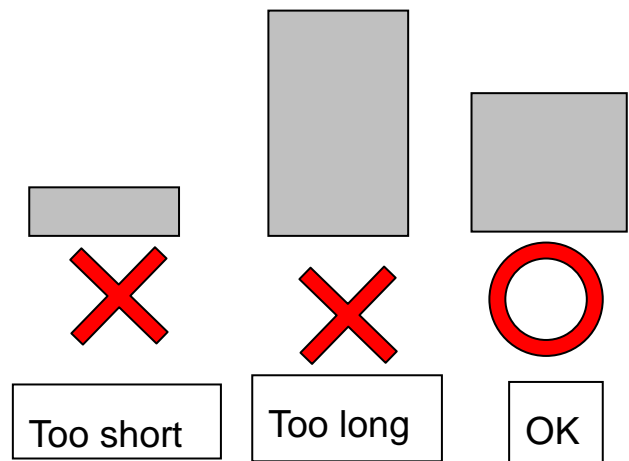
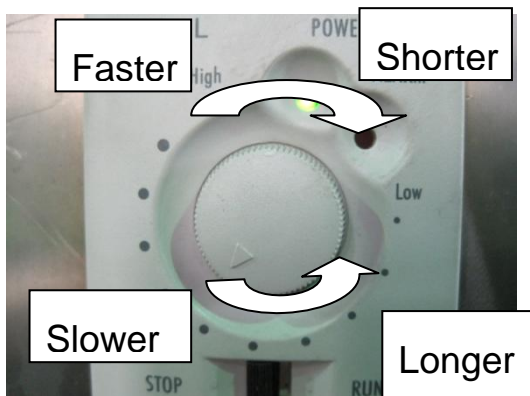


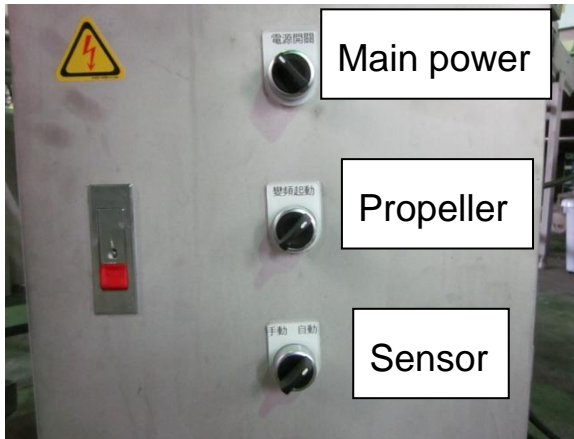
(13). After adjusting the pastry, put the pastry into the cutter.

(14). According to length of pastry required, adjust the speed of rotary cutter by adjusting the inverter beside the cutter.



(15). Turning the knob to change the speed of cutter, speed becomes faster, the pastry becomes shorter, slower becomes longer, adjust it to the appropriate length.



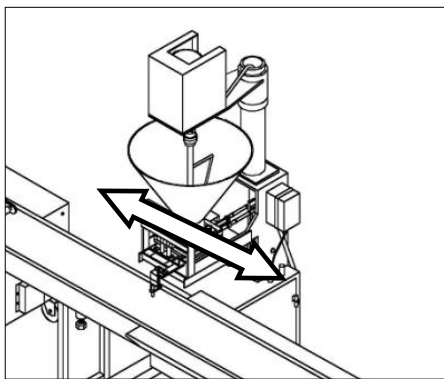


(16). Turn on all filling machine switches behind the machine.

Main power: Power on/off.

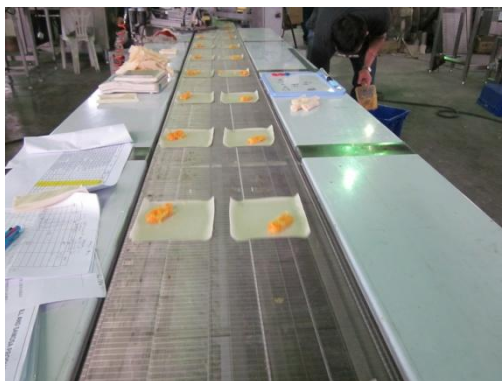
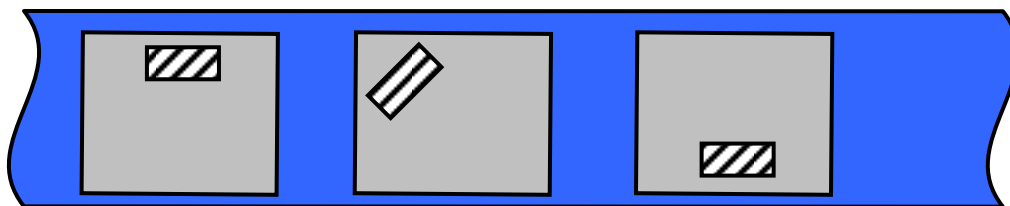
Propeller: Switch on the propeller it will rotate continuously.

Sensor: Start the sensor working to start filling system.



(17). Setting the filling depositor to the proper position.

(18). Start the conveyor to bring the pastries onto the conveyor. Start filling depositor and check if the fillings drop on the right position. Adjust the filling depositor position to drop the filling on the proper position.



(19). Picking up and folding the product on the working table.

11. TROUBLESHOOTING :

SYMPTOM	CAUSE	SOLUTION
Pastry Sticks on the baking drum	Pastry sheet is not baked well because the temperature is too low	Raise the baking drum temperature accordingly
	Surface temperature of the drum is not uniform.	Mark the sticking area. Remove the cover of the drum to tighten or replace the heating plates at the marked location
Scraper does not remove the pastry from the drum	The gap between scraper and drum is too large.	Adjust the sheet scraper to touch the baking drum correctly
Pastry sheet is not cut apart	Rotary cutter is not sharp	Sharpen the rotary cutter, please refer to "MAINTENANCE"
	Gap between roller and rotary cutter is too large	Adjust the rotary cutter to touch the roller and tighten it
Spray nozzle is blocked	Baking drum temperature is too high	Decrease baking drum temperature
	Temperature of cooling water is too high	Adjust cooling water temperature to 5 degree C
	Impurity or obstruction in batter	Make proper batter and use the batter filter
	Batter system was not cleaned thoroughly	Take apart the system to clean again.

Without cooling action	Cooling water is insufficient	Refill cooling water
	Cooling pump does not work	Replace it with a new cooling pump
	Magnetic contactor does not work	Replace it with a new magnetic contactor
	Temperature starter does not work	Replace it with a new starter
Filling system does not work	Filling system sensor was blocked	Clean the filling system sensor
	Filling system is not started	Switch on the filling system
Filling drop position is unstable	Conveyor slips from driving shaft to cause unstable speed	Clean the driving shaft with an air blower while the conveyor is running. <u>DO NOT apply wipe or hand or finger or any part of body to the shaft while it is running</u>
Filling volume reduce during operation	Hopper is empty	Refill filling hopper
Filling deposited is in loose particles instead of a firm block	Filling volume is not enough	Increase propeller speed to increase filling volume

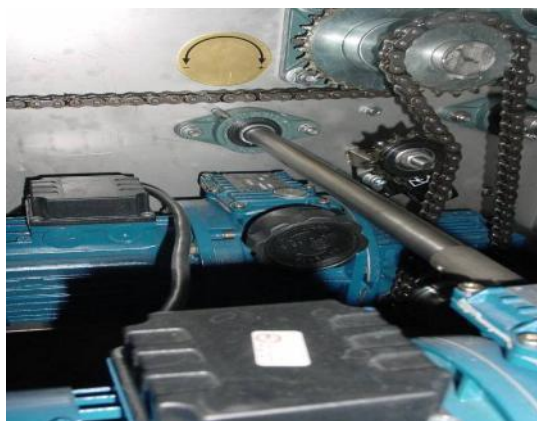
Filling volume is unstable	Frozen and fresh filling material were used alternately, different character of filling causes abnormal filling volume	Mix fresh and frozen filling together well to keep filling character consistent. Be noticed that frozen filling may not be the same as fresh filling material in many ways such as operation speed, product taste...etc.
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12. MAINTENANCE :

12-1. WATER REFILL AND LUBRICATION:



(1). Fill the water tank (Located at the back of machine base, it can be found when open the back door) until the water reaches to about 80% ~ 90% of the tank. Check daily, refill accordingly.

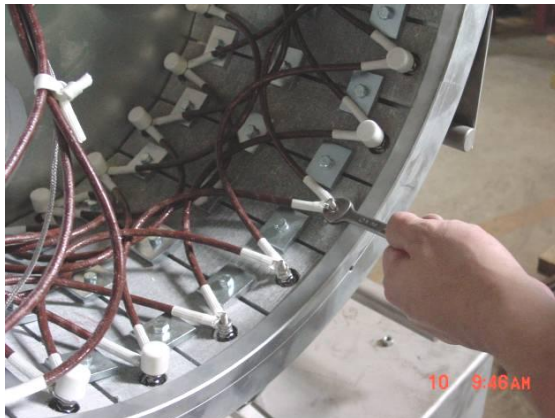


(2). Any exposed cogwheel, drive gears, chains and cams need to be lubricated with grease every month



(3). There is a grease pipe at the bearing drum axle to connect with the grease nipple near the machine frame. Use the grease gun to fill the grease pipe (squeezes 2-3 times) every month

12-2. HOW TO CHANGE THE HEATING PLATE:



(1). Take apart the heating wires



(2). Take off the fixing screw and then take out the pressing plate



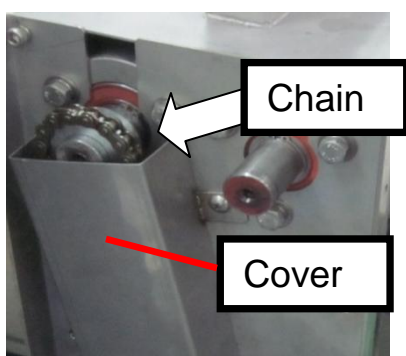
(3).Take off the insulation plate to change the heating plate. Follow the reverse steps to install a new heating plate.

12-3. HOW TO ADJUST THE CUTTER:

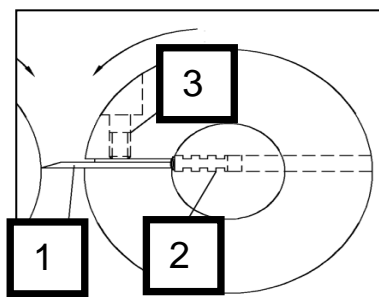


Remove cover

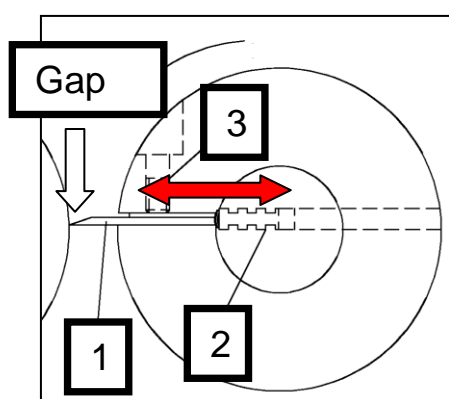
(1). Shut the power down and remove the cover.



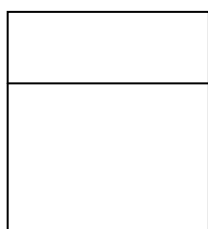
(2). Remove the inside cover , then remove the chain.



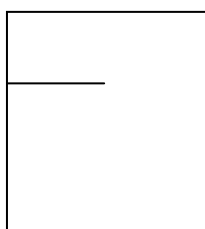
(3). Rotate the gear to the position as shown, loosen no.3 screw (**Do not loosen the screws when the blade at downside, it might cause the blade fall.**)



(4). Check the gap between the blade and wheel, the best stituation is no gap or barely touch each other, adjust no.2 screw to adjust the gap, the no.2 position will be about 4 screws, adjust the screw evenly to set the gap, every time you finish this step, please tighten the no.3 screw, otherwise, the blade might fall down and break.



A



B

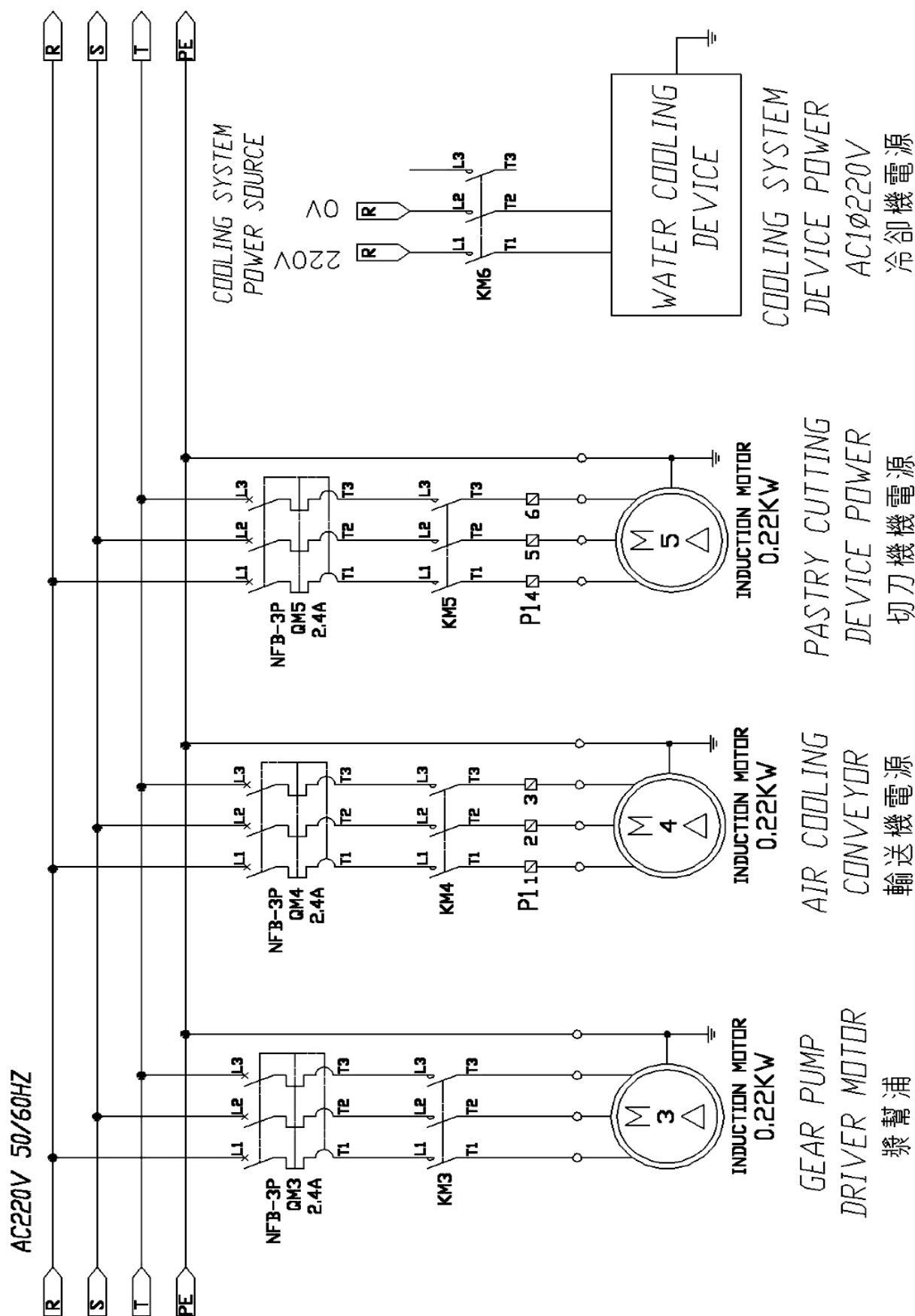
(5). The way to test the blade is putting one paper into cutter, rotate the cutter gear by hand, the situation **(A)** is good (full cut), the situation **(B)** is not good (just cut the left side), means the blade only touch the left side, need to adjust again or might need to change a new blade.

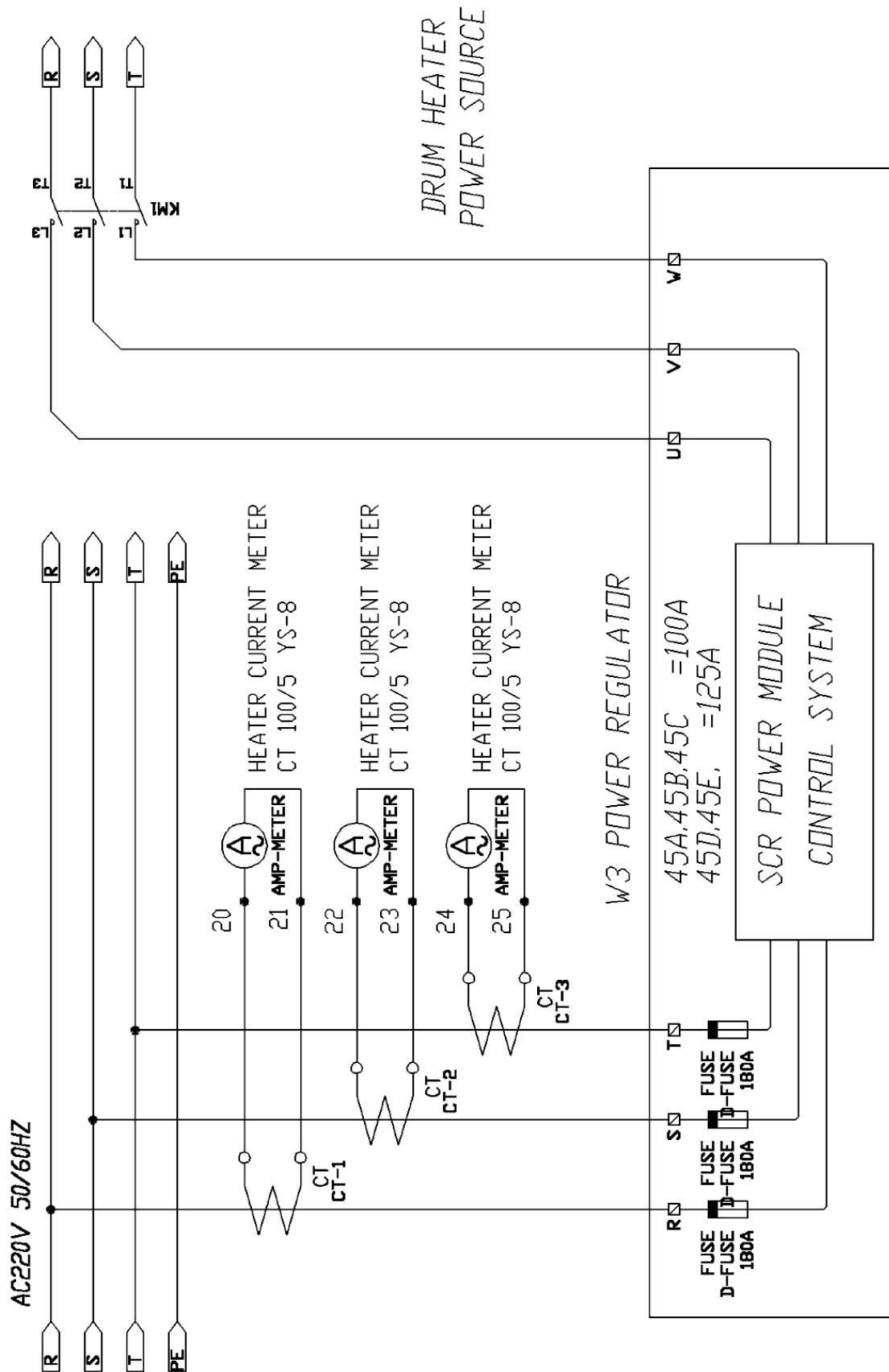
After adjusting/changing the blade, put back the chain and cover.

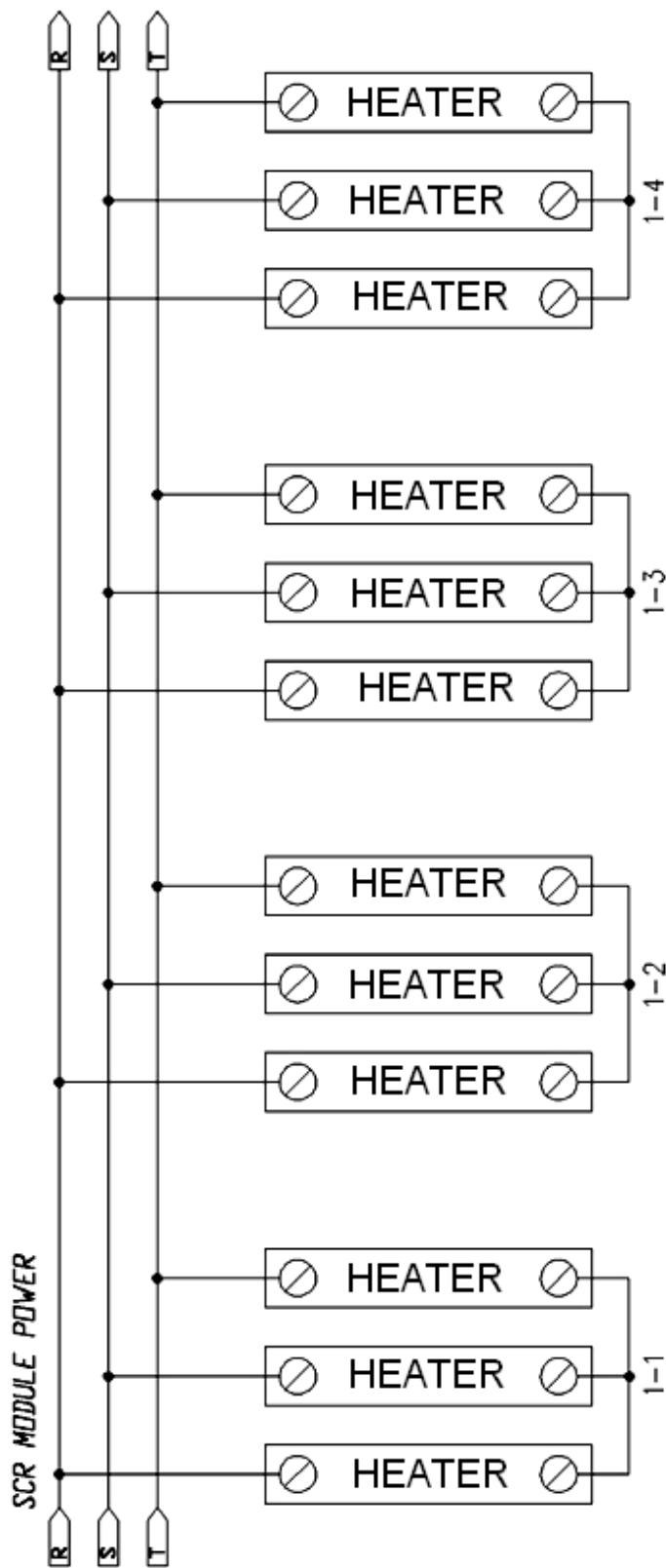
DO NOT ADJUST THE BLADE TOO TIGHT TO THE WHEEL, PLEASE ADJUST JUST TIGHT ENOUGH TO FULLY CUT THE PAPER, OTHERWISE, THE BLADE WILL BE WORN SOON.

13. TOOLBOX LIST :

No.	Part Name	Qty.	Note
1	Heating Plate	10pc	For baking drum
2	Fuse	3pc	For baking drum
3	Adjust screw	2pc	For batter pump
4	Fixing nuts	2pc	For batter pump
5	Gear	1pc	For batter pump
6	Acrylic seal cover	1pc	For batter pump
7	Tube	1pc	For cooling pump
8	Tube	1pc	For batter pump
9	Filter	1pc	For baking drum
10	O-ring	1pc	For baking drum
13	Blade	1pc	For baking drum
14	Grease gun	1pc	For baking drum
	High temperature grease	1set	
16	Flat Screwdriver	1pc	
17	Philips Screwdriver	1pc	
18	Ring spanner set	1set	
19	Hex Driver set	1set	
20	Open Wrench set	1set	
21	Adjustable Wrench	1pc	
22	Long Nose Pliers4	1pc	



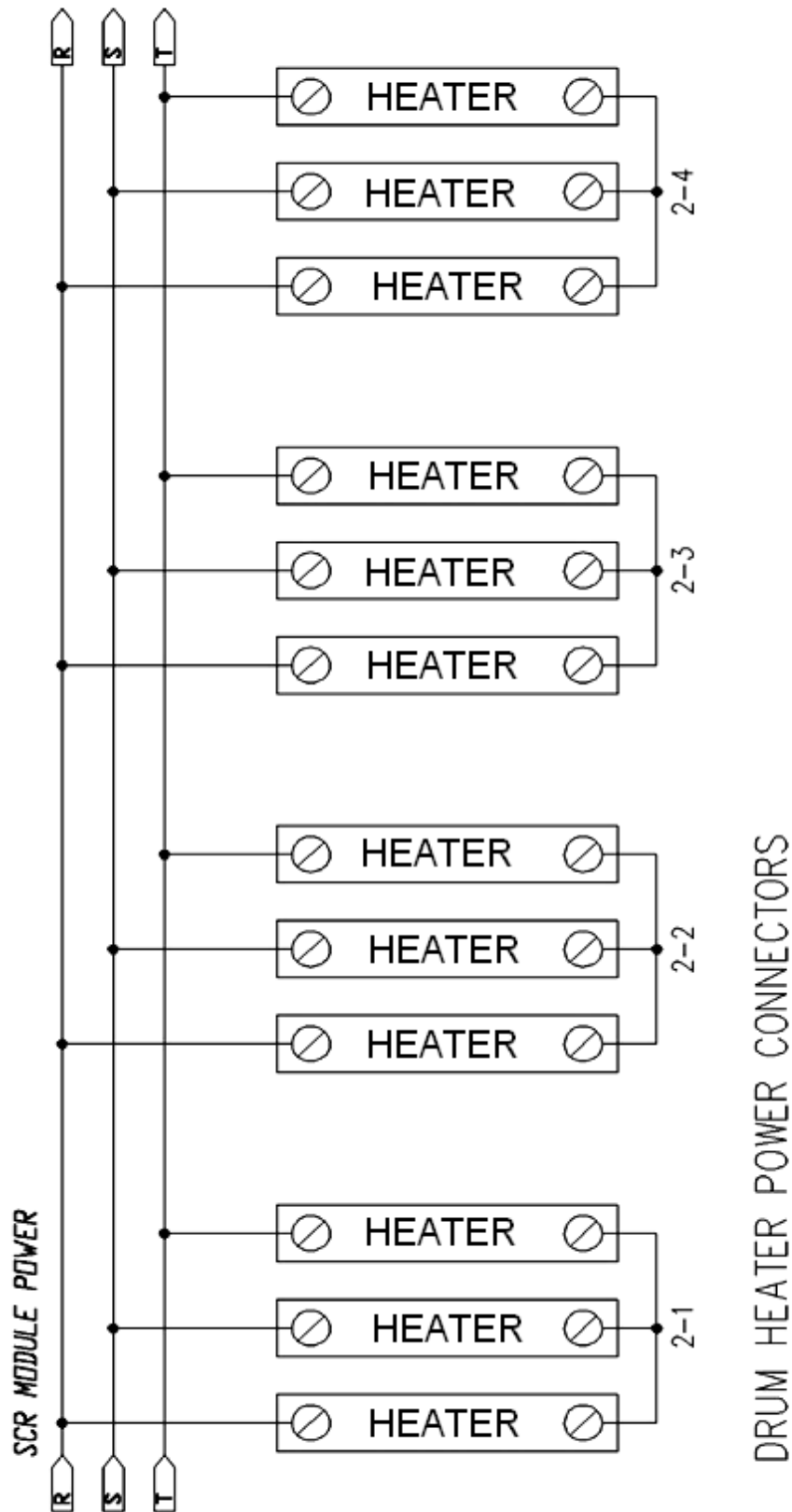


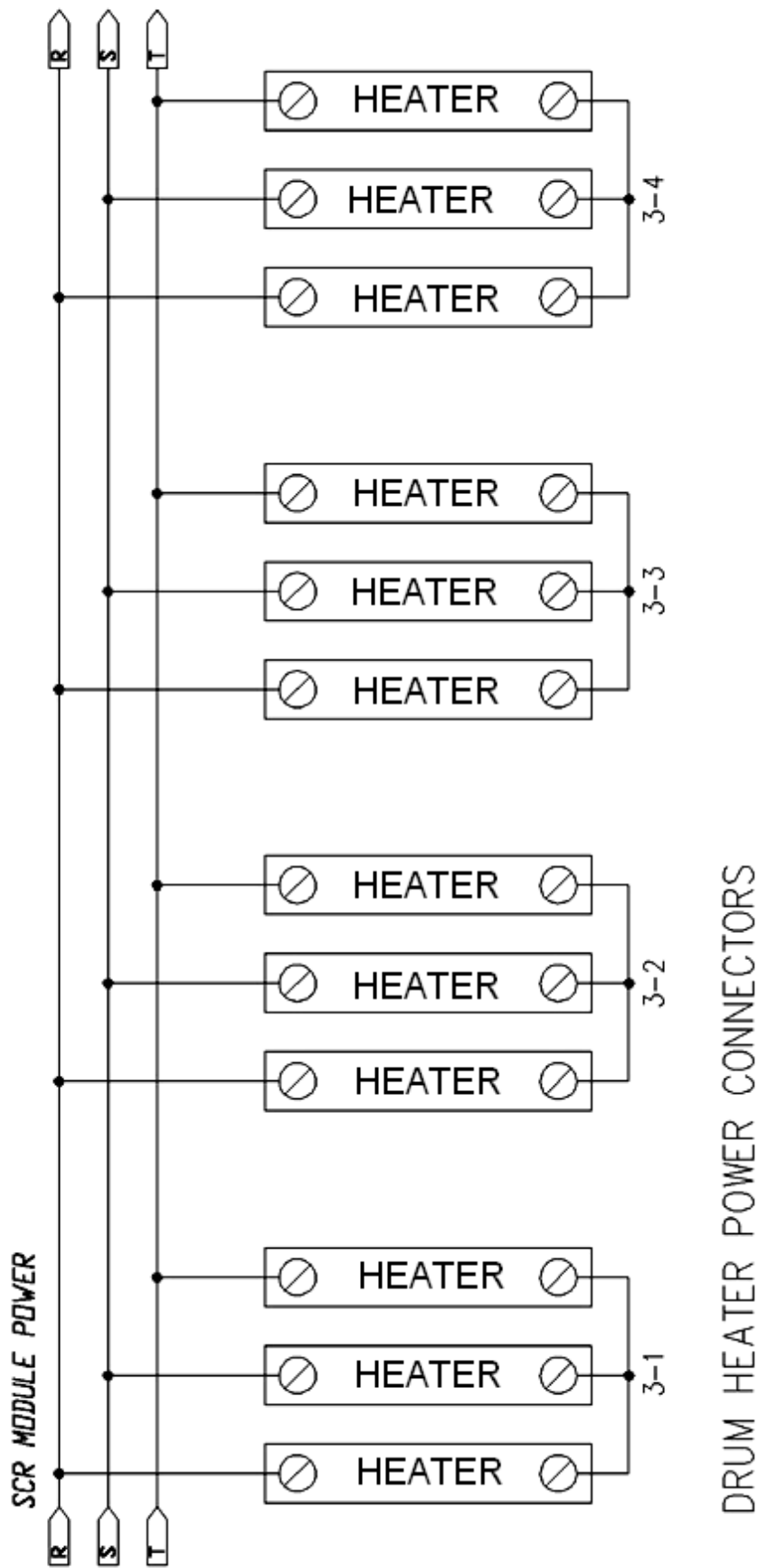


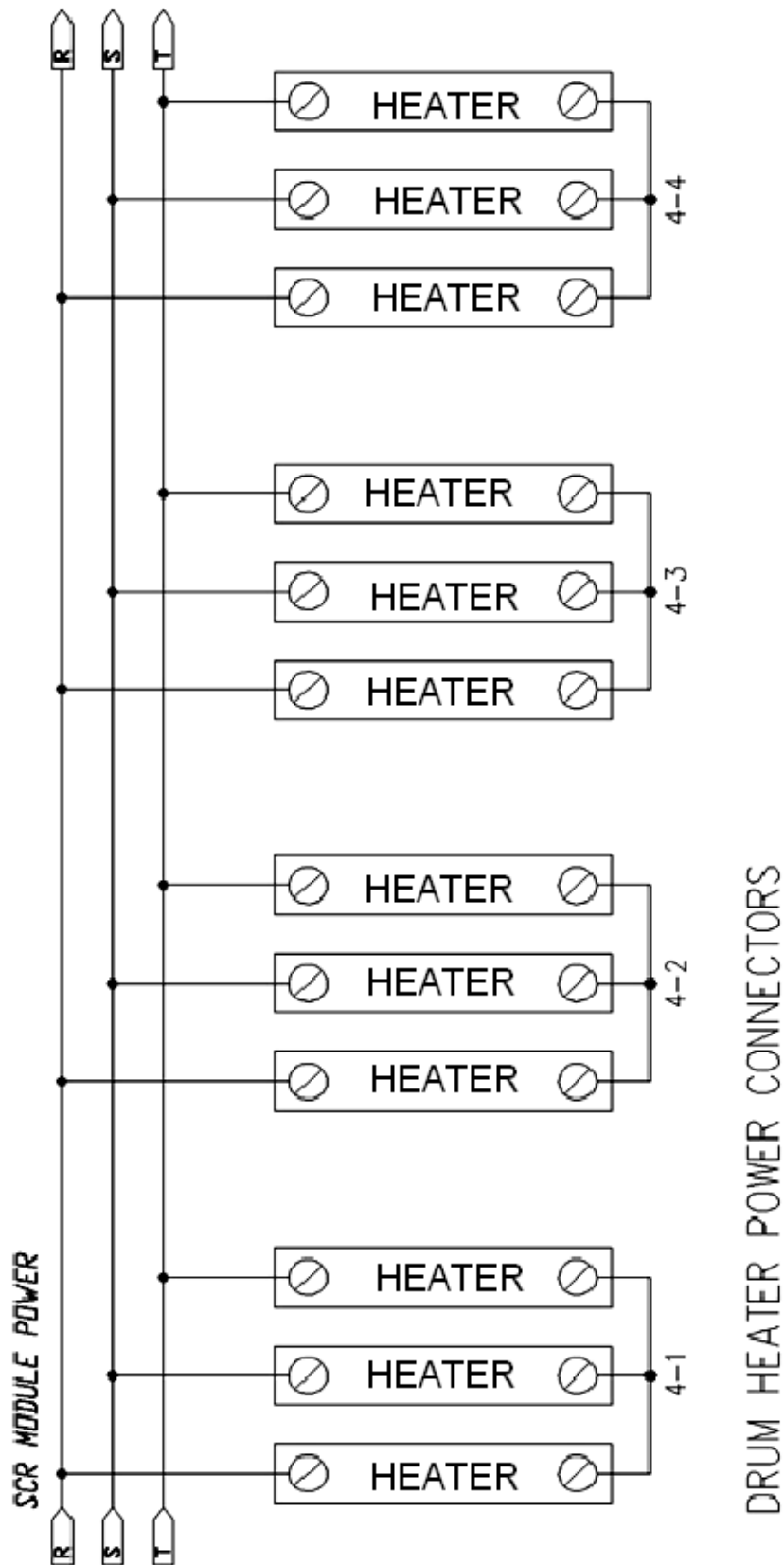
DRUM HEATER POWER CONNECTORS
TOTAL: 48PCS

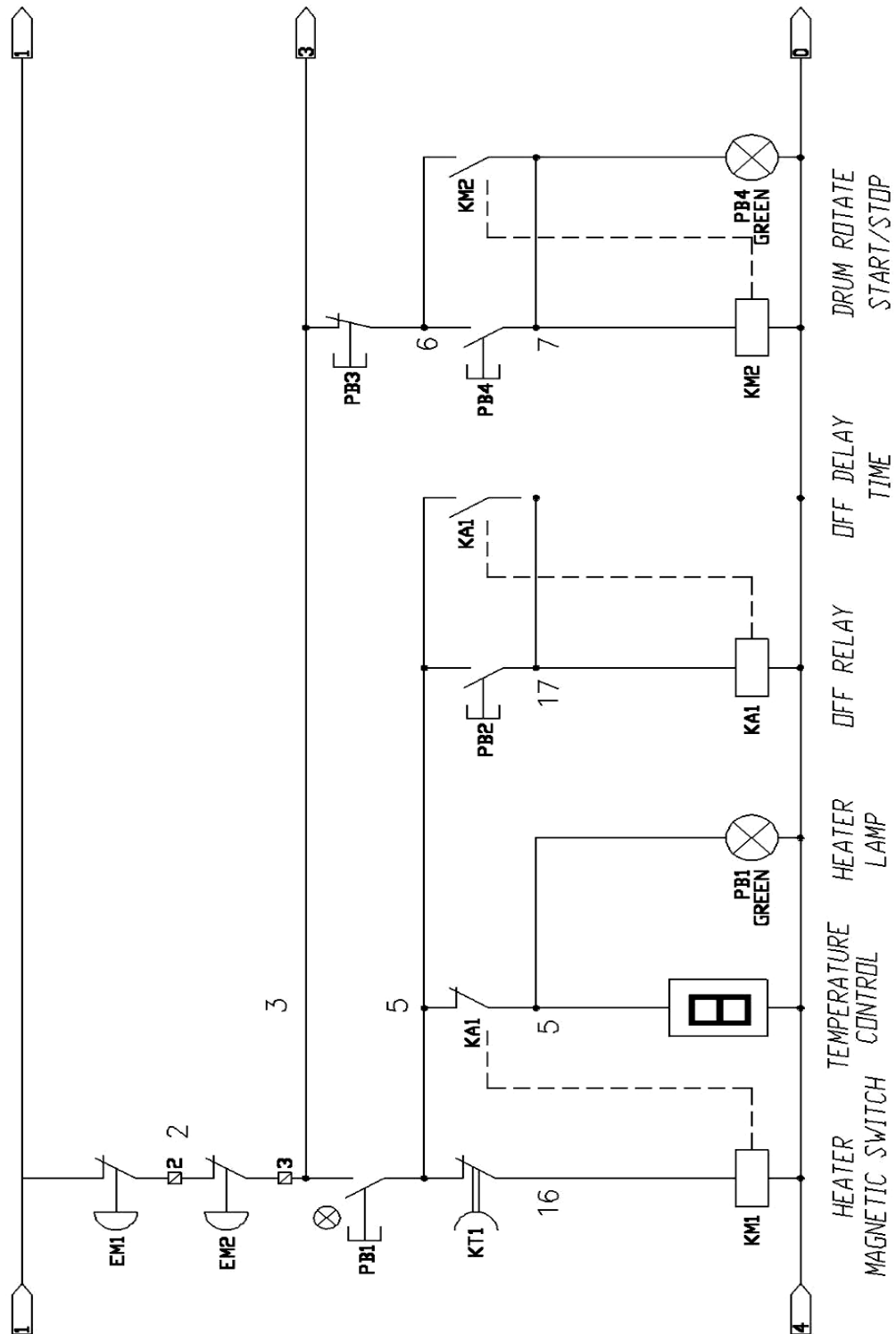
MAIN 45D: 1000W*48 TOTAL: 48KW
MAIN 45E: 1200W*48 TOTAL: 57.6KW

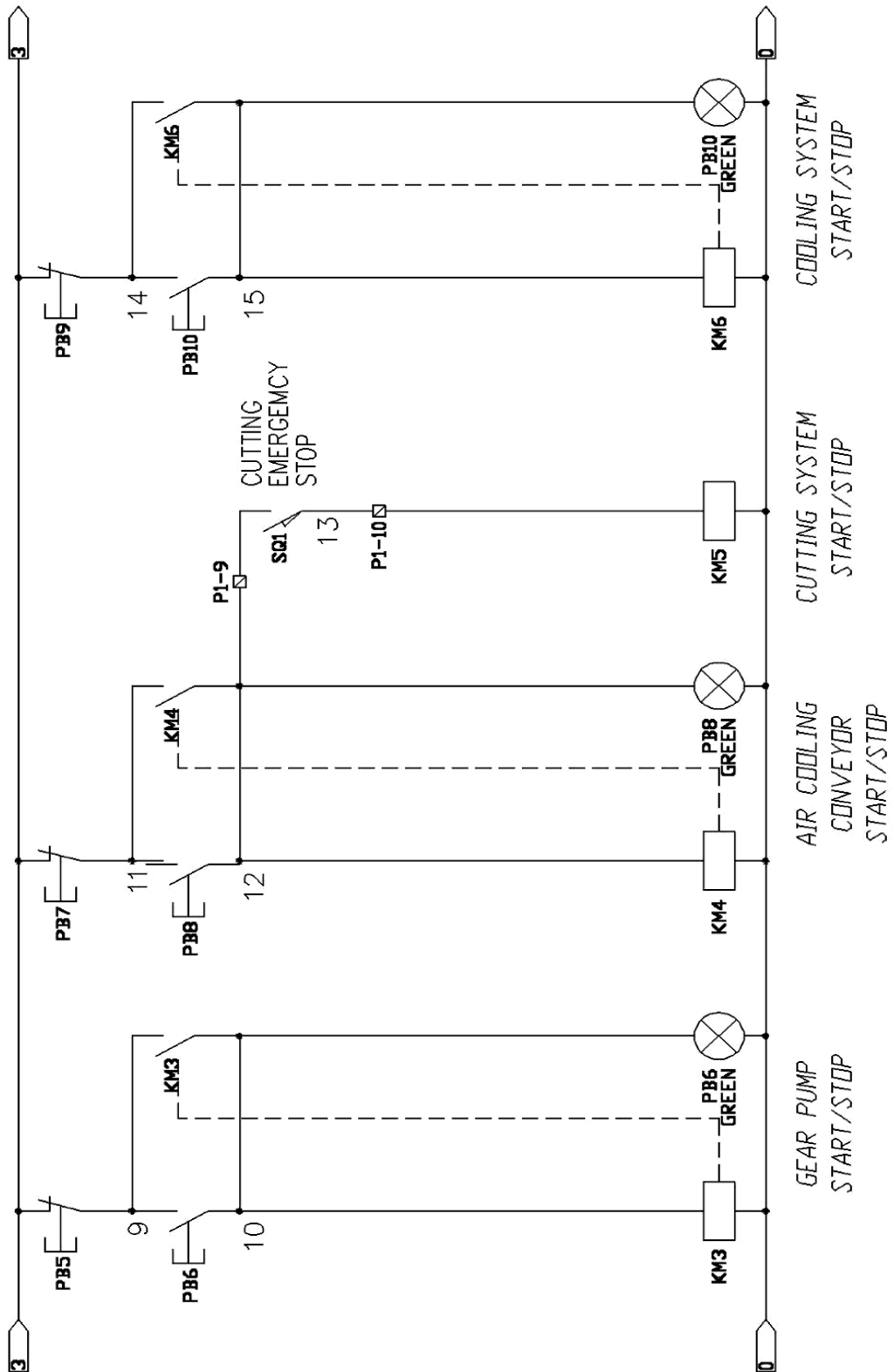
MAIN 45A: 650W*48 TOTAL: 31.2KW
MAIN 45B: 700W*48 TOTAL: 33.6KW
MAIN 45C: 750W*48 TOTAL: 36KW
MAIN 45D: 1000W*48 TOTAL: 48KW

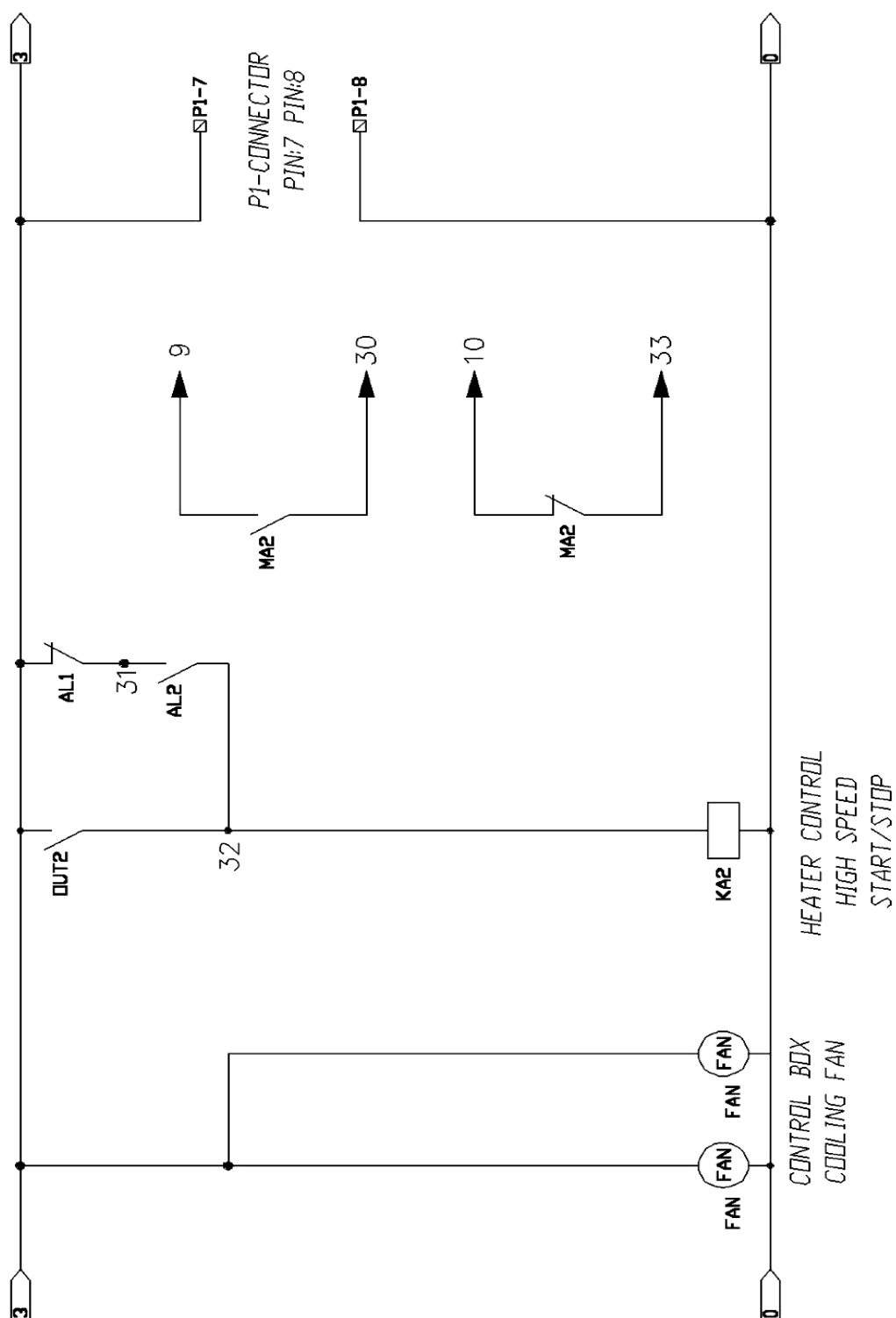


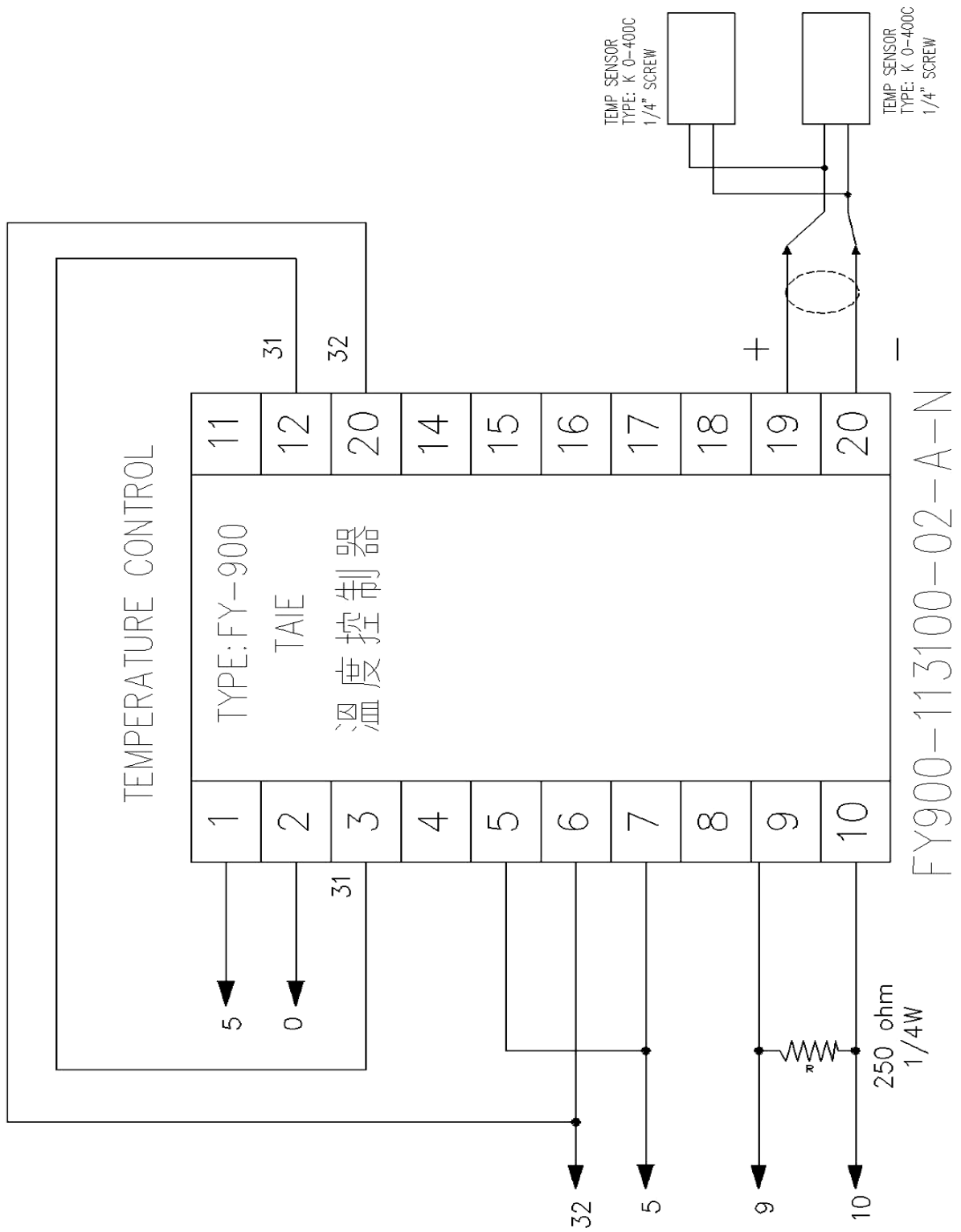


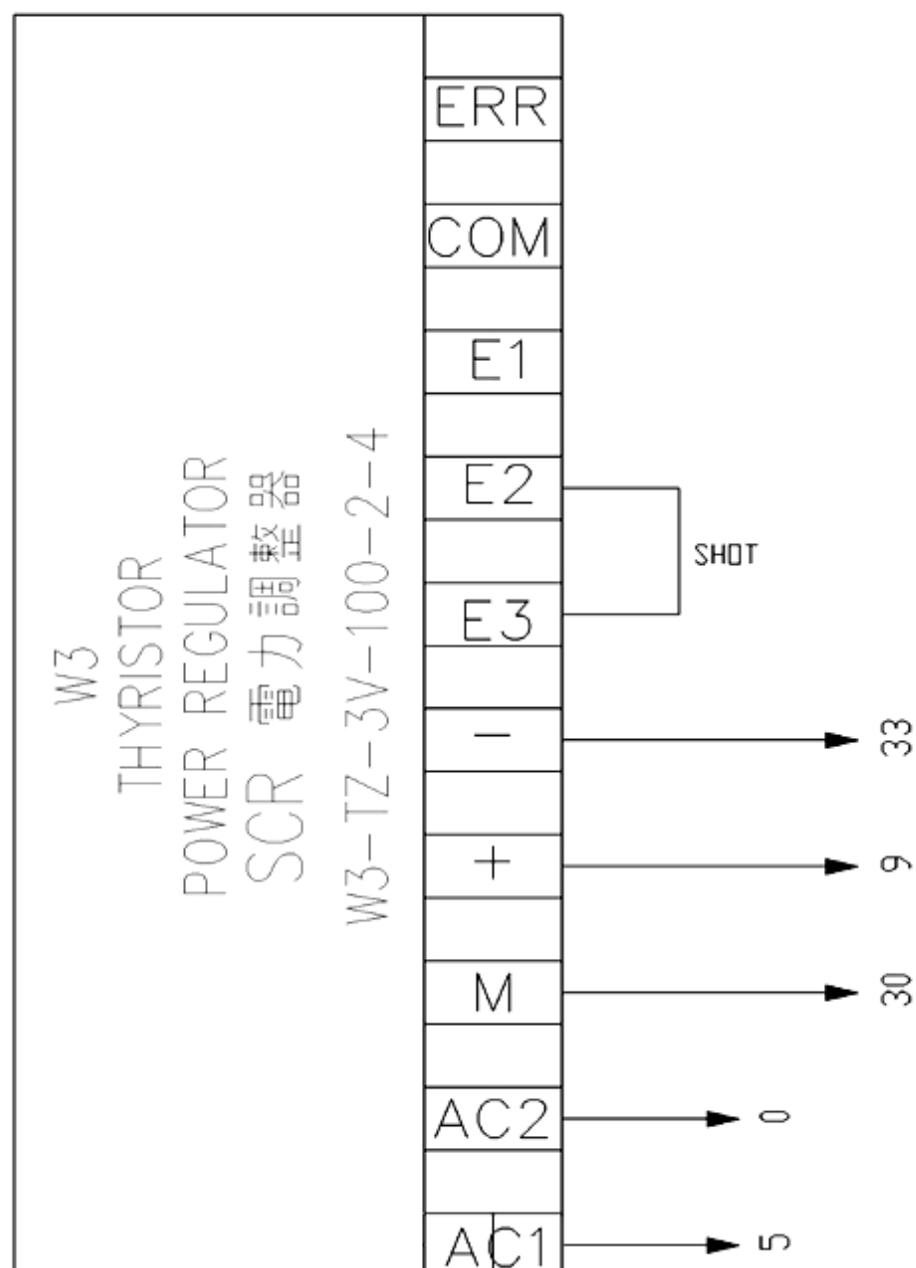




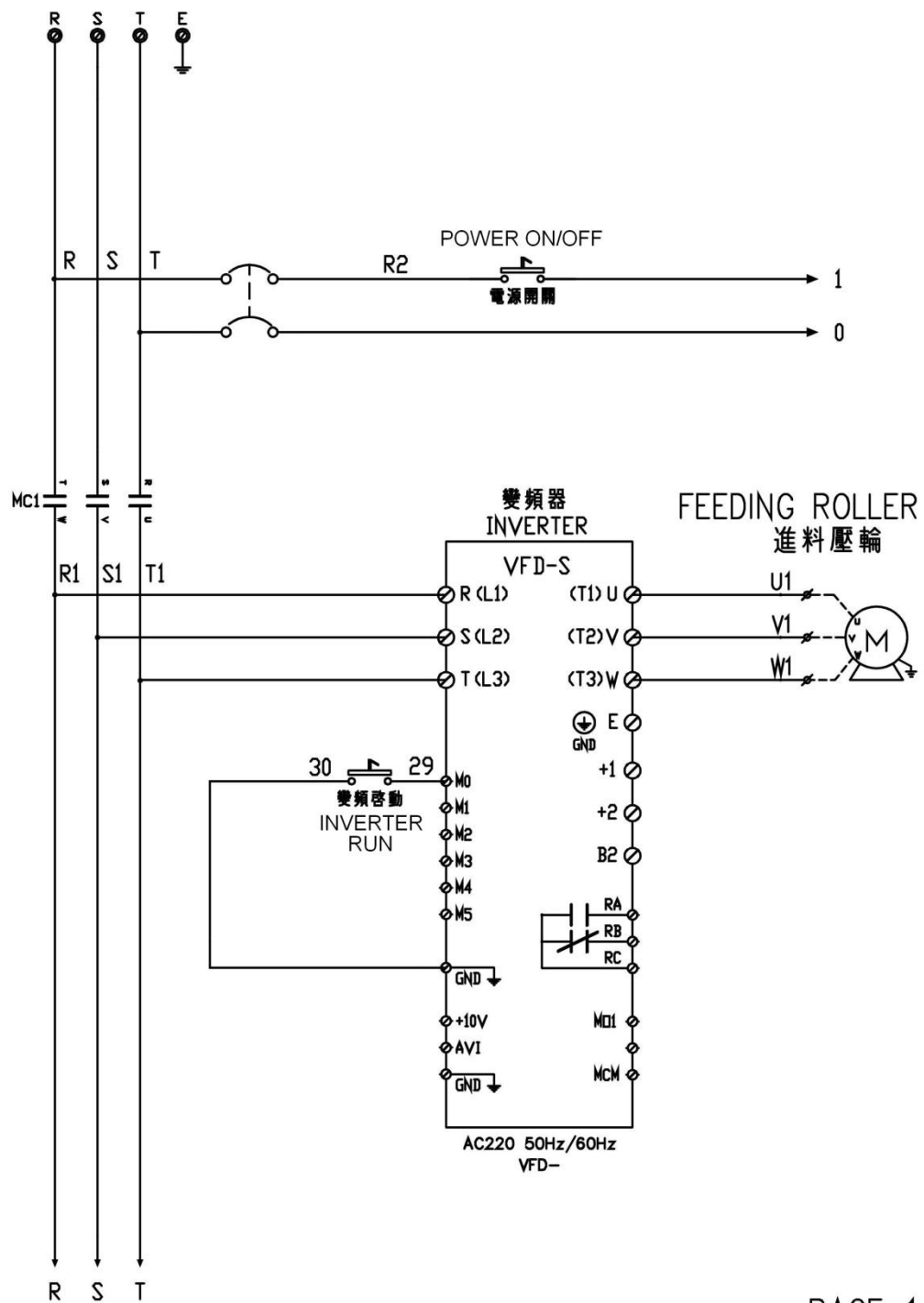








TION
SOURCE -R
SOURCE -S
SOURCE -T
L SENSOR +
L SENSOR -



1) :

