

MASTER
THE ATWOOD
ROUND - O - MATIC
MODEL: R900

INCLUDES: R-900C, R-900T SERIES MACHINES

OPERATIONS AND SAFETY MANUAL

INCLUDING PARTS CATALOG
AND MAINTENANCE INSTRUCTIONS

MODEL No. _____

SERIAL No. _____



CAUTION:

DO NOT OPERATE, CLEAN OR SERVICE THIS MACHINE BEFORE YOU READ THIS MANUAL, AND ARE FAMILIAR WITH THE SAFETY INSTRUCTIONS IN THIS MANUAL AND THOSE ON THE LABELS ON THE MACHINE. KEEP THIS MANUAL AND OTHER MATERIALS DELIVERED WITH THE MACHINE, ACCESSIBLE TO THE OPERATORS FOR EASY REFERENCE DURING USE.

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MANUFACTURING COMPANY

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(800) 342-6744 <http://www.ammfg.com>

OWNERS RESPONSIBILITY

NOTE:

THE PARTS AND EQUIPMENT DESCRIBED IN THIS MANUAL MAY BE COVERED BY ONE OR MORE U.S. AND FOREIGN PENDING PATENTS.



TO MAINTAIN MACHINE AND USER SAFETY, THE RESPONSIBILITY OF THE OWNER IS TO READ AND FOLLOW THESE INSTRUCTIONS AND TO ENSURE THAT ALL OPERATORS UNDERSTAND AND FOLLOW THESE AND OTHER SAFETY INSTRUCTIONS IN THIS MANUAL.

- FOLLOW ALL INSTALLATION INSTRUCTIONS.
- MAKE SURE INSTALLATION CONFORMS TO ALL APPLICABLE LOCAL, STATE, AND FEDERAL CODES, RULES AND REGULATIONS SUCH AS STATE AND FEDERAL OSHA REGULATIONS AND ELECTRICAL CODES.
- CAREFULLY CHECK THE UNIT FOR CORRECT INITIAL FUNCTION.
- READ AND FOLLOW THE SAFETY INSTRUCTIONS. KEEP THEM READILY AVAILABLE FOR MACHINE OPERATORS.
- MAKE CERTAIN ALL OPERATORS ARE PROPERLY TRAINED, KNOW HOW TO SAFELY AND CORRECTLY OPERATE THE UNIT AND ARE PROPERLY SUPERVISED.
- ALLOW UNIT OPERATION ONLY WITH ALL PARTS INCLUDING SAFETY EQUIPMENT, IN PLACE AND OPERATING SAFELY.
- CAREFULLY INSPECT THE UNIT ON A REGULAR BASIS AND PERFORM ALL MAINTENANCE AS REQUIRED.
- SERVICE AND MAINTAIN THE UNIT ONLY WITH AUTHORIZED OR APPROVED REPLACEMENT PARTS.
- KEEP ALL INSTRUCTIONS PERMANENTLY WITH THE UNIT ALONG WITH ALL DECALS AND WARNING LABELS ON THE UNIT CLEAN AND VISIBLE.

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IMPORTANT:

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ONLY USE FACTORY SUPPLIED REPLACEMENT PARTS TO MAINTAIN MACHINE SAFETY, PERFORMANCE AND SANITARY CONDITIONS. USE OF NON-APPROVED PARTS MAY VOID MANUFACTURERS WARRANTY.

KNOW YOUR UNIT. COMPARE DIAGRAMS IN THIS MANUAL WITH THE UNIT BEFORE STARTING SERVICE, TO OBTAIN MAXIMUM SAFETY AND PERFORMANCE.

TO ORDER REPLACEMENT PARTS:
TURN TO PAGE 28 OF THIS MANUAL.



WARNING:

THIS MANUAL CONTAINS CRITICAL SAFETY INSTRUCTIONS. READ AND FOLLOW THEM CAREFULLY. FAILURE TO FOLLOW WARNING AND INSTRUCTIONS MAY LEAD TO SERIOUS PERSONAL INJURY. THE OWNER IS RESPONSIBLE FOR MAINTAINING THE UNIT, ITS INSTRUCTIONS AND DECALS FOR OPERATION REFERENCE. FOR ADDITIONAL COPIES CONTACT A.M. MANUFACTURING: (800)342-6744

OPERATIONS AND SAFETY MANUAL

INCLUDING PARTS CATALOG

READ AND FAMILIARIZE YOURSELF WITH THIS MANUAL BEFORE OPERATING THIS MACHINE
FOLLOW INSTRUCTIONS DURING USE

INTRODUCTION

YOUR R900 ROUND - O - MATIC DOUGH ROUNDER HAS BEEN BUILT WITH THE BUSY BAKER IN MIND. IT'S VERSATILITY AND SIMPLICITY ARE UNMATCHED IN THE INDUSTRY. PRODUCTION DEPENDS ON THE DESIRED DOUGH BALL SIZE AND HOW FAST THE DIVIDED DOUGH PIECES ARE DROPPED INTO THE FUNNEL. SMALL PIECES CAN BE FED APPROXIMATELY TWO PER SECOND, WHEREAS LARGER DOUGH PIECES (UP TO 2 lbs.) MUST BE FED AT A LESSER RATE. GETTING THE FEEL OF THE MACHINE WILL BEST DETERMINE JUST WHAT THE FEED RATE SHOULD BE FOR ANY CERTAIN DOUGH BALL SIZE. NO ADJUSTMENTS ARE NECESSARY WHEN CHANGING THE SIZE OF YOUR DOUGH PIECE, IT WILL AUTOMATICALLY BE ROUNDED INTO A TIGHT, SMOOTH BALL, WITH NO MORE EFFORT THAN IT TAKES TO DROP THEM INTO THE FUNNEL.



CAUTION:

ALL OPERATORS MUST BE FULLY TRAINED AND INSTRUCTED IN SAFETY PROCEDURES BEFORE BEGINNING PRODUCTION.

SPECIFICATIONS

R900-C		R900-T	
CONVEYOR LENGTH	18 1/2" FROM FRONT OF MACHINE. (23" OVERALL LENGTH)	TABLE DIAMETER	35 1/2"
CONVEYOR BELT	2 PLY PVC	MACHINE WIDTH	24"
OVERALL HEIGHT	42 1/2"	OVERALL HEIGHT	42 1/2"
MACHINE WIDTH	24"	HEIGHT UNDER TABLE	36 1/4"
HEIGHT UNDER CONVEYOR	32 3/4"	VOLTAGE (STANDARD)	115 VOLT SINGLE PHASE
VOLTAGE (STANDARD)	115 VOLT SINGLE PHASE	VOLTAGE (OPTIONAL)	208/220 (3) PHASE
VOLTAGE (OPTIONAL)	208/220 (3) PHASE	AMPERAGE	15 AMPS.
AMPERAGE	15 AMPS.	PRODUCTION RANGE	1 oz. TO 2 1/2 lbs.
PRODUCTION RANGE	1 oz. TO 2 1/2 lbs.	PRODUCTION RATE	UP TO 7200 PIECES PER HOUR
PRODUCTION RATE	UP TO 7200 PIECES PER HOUR	SHIPPING WEIGHT	350 lbs.
SHIPPING WEIGHT	350 lbs.		

INSTALLATION INSTRUCTIONS

LOCATION:

SELECT LOCATION CAREFULLY. THE AREA SHOULD PROVIDE THE OPERATOR WITH ENOUGH SPACE TO USE THE EQUIPMENT IN A SAFE MANNER. THE FLOOR AREA SELECTED SHOULD BE A FLAT SURFACE AND EASY TO CLEAN AND SHOULD BE FREE OF OIL, GREASE, ECT. AVOID AREAS WHERE BYSTANDERS AND CUSTOMERS MAY BE PRESENT.



CAUTION

PROPER UNIT INSTALLATION IS NECESSARY FOR SAFE AND EFFICIENT OPERATION. PROPER INSTALLATION ALSO HELPS PROTECT THE UNIT FROM DAMAGE AND MAKES SERVICE EASIER.

SAFETY

THIS MACHINE IS DESIGNED TO PROVIDE FOR SAFE OPERATION IF NORMAL OPERATING PROCEDURES AND SAFETY MESSAGES LOCATED ON THE MACHINE AND IN THIS MANUAL ARE FOLLOWED.

THIS IS A
SAFETY
MANUAL



SAFETY ALERT SYMBOL. YOU WILL FIND IT ON VARIOUS LABELS ON THE MACHINE AND IT WILL ALSO APPEAR IN THIS WHEREVER SAFETY MESSAGES ARE GIVEN.

GET FAMILIAR WITH SIGNAL WORDS:

CAUTION, WARNING & DANGER

CAUTION:

INDICATES A POTENTIALLY HAZARDOUS SITUATION WHICH, IF NOT AVOIDED, MAY RESULT IN MINOR OR MODERATE INJURY. IT MAY ALSO BE USED TO ALERT AGAINST UNSAFE PRACTICES.

WARNING:

INDICATES A POTENTIALLY HAZARDOUS SITUATION WHICH, IF NOT AVOIDED, COULD RESULT IN DEATH OR SERIOUS INJURY.

DANGER:

INDICATES AN IMMINENTLY HAZARDOUS SITUATION WHICH, IF NOT AVOIDED, WILL RESULT IN DEATH OR SERIOUS INJURY. THIS SIGNAL WORD IS TO BE LIMITED TO THE MOST EXTREME SITUATIONS.

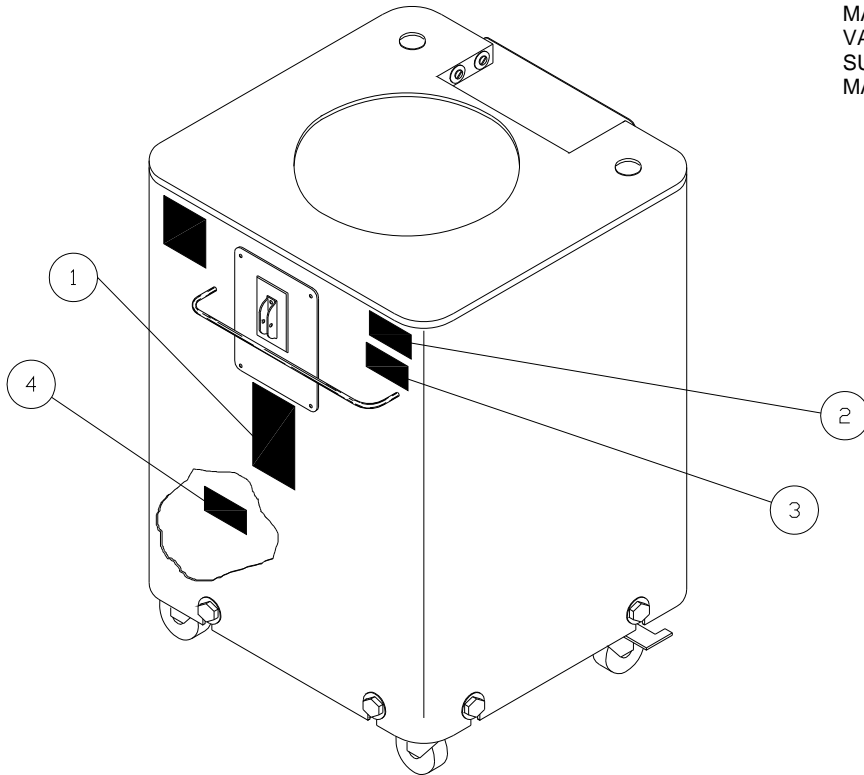
NOTE:

A NOTE PROVIDES KEY INFORMATION TO MAKE PROCEDURES EASIER AND CLEARER.

WARNING LABELS

TYPICAL CONTENT AND LOCATION ON ROUND - O - MATIC

NOTE:
 MACHINE DESIGN AND SPECIFICATIONS MAY VARY. ACTUAL LABEL DESIGN AND PLACEMENT SUBJECT TO CHANGE WITHOUT NOTICE AND MAY VARY FROM THIS ILLUSTRATION.



CAUTION:

IF ANY SAFETY LABELS ARE MISSING, THEY MUST BE REPLACED! CONTACT YOUR DEALER OR AM MFG. FOR REPLACEMENT.

IMPORTANT SAFETY INFORMATION © 1992 A.M. MFG. #21

- DO NOT OPERATE THIS MACHINE BEFORE YOU HAVE READ AND UNDERSTAND THE OPERATIONS AND SAFETY MANUAL.
- NEVER LEAVE THIS MACHINE RUNNING UNATTENDED.
- NEVER OPERATE THIS MACHINE IF SAFETY GUARDS ARE NOT IN PLACE.
- NEVER REMOVE ANY SAFETY GUARDS AND NEVER MAKE ANY OTHER SAFETY EQUIPMENT INOPERATIVE.
- NEVER OPERATE THIS MACHINE IF YOU HAVE NOT BEEN TRAINED.
- NEVER OPERATE THIS MACHINE IF YOU ARE TIRED, ILL, OR IF YOU ARE ON MEDICATION THAT MAKES YOU TIRED, OR IF YOU ARE UNDER THE INFLUENCE OF ALCOHOL OR DRUGS.
- WEAR TIGHT FITTING CLOTHES AND MAKE SURE THAT LONG HAIR AND JEWELRY OR OTHER LOOSE PERSONAL ITEMS DO NOT GET CAUGHT IN THE MACHINE.
- MAKE SURE YOU CAN EASILY REACH THE CONTROLS.
- ALWAYS DISCONNECT THE MAIN ELECTRICAL POWER SOURCE BEFORE YOU CLEAN, MAINTAIN, OR SERVICE THIS MACHINE.
- IF YOU HAVE ANY QUESTIONS ABOUT SAFETY, TALK TO YOUR SUPERVISOR OR CALL

A.M. MANUFACTURING
 TOLL FREE 1-(800)-342-6744

1
 FRONT PANEL BELOW ELECTRICAL SWITCH PLATE

2
 FRONT PANEL UPPER RIGHT CORNER

	WARNING
	<p>EXPOSED CHAIN AND GEARS. CAN CAUSE SERIOUS INJURIES.</p> <p>STAY AWAY WHEN CHAIN IS MOVING.</p> <p>© 1993 AM MFG. #24</p>

3

IMPORTANT THIS MACHINE MUST BE PROPERLY GROUNDED BEFORE OPERATING.

AM MFG. #5

FRONT PANEL UPPER RIGHT CORNER CABINET CASE.

4
 FRONT PANEL LOWER M
 FRONT PANEL LOWER MID

	DANGER
	<p>HAZARDOUS VOLTAGE, WILL SHOCK, BURN, OR CAUSE DEATH</p> <p>DISCONNECT ALL ELECTRICAL POWER BEFORE REMOVING PROTECTIVE SHIELDS OR TOUCHING ELECTRICAL EQUIPMENT WHILE SERVICING OR CLEANING THIS MACHINE...</p> <p>© 1992 AM MFG. #10</p>

SAFETY RULES



IMPORTANT:

READ AND FOLLOW THESE SAFETY RULES. THEY ARE FOR YOUR PROTECTION AND THE PROTECTION OF THOSE WORKING WITH YOU.

- **DO NOT** OPERATE THIS MACHINE BEFORE YOU HAVE READ AND UNDERSTOOD THE OPERATIONS AND SAFETY MANUAL.
- FOLLOW ALL INSTRUCTIONS DURING USE OF THIS MACHINE.
- LEAVE ALL GUARDS IN PLACE. INSTALL ALL GUARDS IF THEY WERE REMOVED FOR CLEANING, MAINTENANCE, REPAIR OR OTHER REASONS.
- **NEVER** OPERATE THE MACHINE IF YOU HAVE NOT BEEN TRAINED TO OPERATE THE MACHINE PROPERLY.
- **NEVER** OPERATE THE MACHINE IF YOU ARE TIRED, ILL, ON MEDICATION, OR UNDER THE INFLUENCE OF ALCOHOL OR DRUGS.
- WEAR TIGHT FITTING CLOTHES. MAKE SURE THAT LONG HAIR, JEWELRY, OR LOOSE PERSONAL ITEMS ARE SECURED SO THEY CANNOT GET CAUGHT IN THE MACHINE. THIS CAN LEAD TO SERIOUS INJURIES.
- MAKE SURE YOU CAN EASILY REACH ALL CONTROLS. IF NOT, A STABLE AND SAFE ELEVATED PLATFORM OR OTHER WORK-AID MUST BE PROVIDED.
- **ALWAYS** DISCONNECT THE MAIN ELECTRICAL POWER SOURCE AND TURN MACHINE SWITCH TO THE OFF POSITION BEFORE CLEANING, IF MAINTENANCE OR SERVICE IS PERFORMED, OR IF THE MACHINE IS OUT OF SERVICE.
- **NEVER** LEAVE THIS MACHINE RUNNING UNATTENDED.

IMPORTANT:

IF YOU HAVE ANY QUESTIONS ABOUT THESE SAFETY RULES, SEE YOUR SUPERVISOR OR CALL A.M. MANUFACTURING Co. TOLL FREE: (800) 342-6744

OPERATING INSTRUCTIONS



WARNING:

UNIT MUST BE PROPERLY OPERATED AND MAINTAINED TO PREVENT MACHINE DAMAGE OR PERSONAL INJURY. REVIEW INSTRUCTIONS WITH ALL EMPLOYEES BEFORE USE.

I. PRELIMINARY START - UP PROCEDURE

- A. BE SURE DRUM, TABLE AND CONVEYOR ARE CLEAR OF PACKING, PACKING SLIPS, DOCUMENTS AND OTHER OBSTRUCTIONS.
- B. MAKE SURE THE MACHINE SWITCH IS IN THE IS IN THE **OFF** POSITION.
- C. LOWER DISCHARGE CONVEYOR (FOR **R900C** MODELS **ONLY**) TO OPERATING POSITION.
- D. PLUG POWER CORD INTO PROPER RECEPTACLE.
- E. SWITCH MACHINE TO THE "ON" POSITION.
- F. THE ROUNDING DRUM SHOULD BE TURNING IN A COUNTER CLOCK-WISE ROTATION.
- G. THE ROUNDER TABLE SHOULD BE TURNING IN A COUNTER CLOCK-WISE ROTATION, / THE DISCHARGE CONVEYOR SHOULD BE RUNNING FORWARD OUT FROM MACHINE. ALL THIS DEPENDING ON THE MODEL OF ROUND - O - MATIC YOU HAVE PURCHASED. (**NOTE**) **NEVER** OPERATE THE MACHINE WITH THE DISCHARGE CONVEYOR IN THE UPRIGHT POSITION.

NOTE:

IF THE MACHINE YOU HAVE PURCHASED IS A (3) PHASE MACHINE AND THE ROTATION OF THE ROUNDING DRUM IS NOT CORRECT, CONSULT A PROPERLY TRAINED ELECTRICIAN.

II. OPERATING THE ROUND - O - MATIC

- A. THE R-900 TABLE OR CONVEYOR MODEL IS READY TO ROUND AFTER:
- B. POSITION ROUND - O - MATIC IN THE DESIRED LOCATION AND SET THE TWO (2) LOCKING CASTERS.
- C. PLUG THE POWER CORD INTO PROPER RECEPTACLE.
- D. CHECK FOR PROPER ROTATION OF ROUNDING DRUM, REFER TO PRELIMINARY START - UP PROCEDURE.
- E. TO ROUND SIMPLY DROP DOUGH PIECES (1oz. TO 2 lbs.) INTO FUNNEL. THE DOUGH WILL AUTOMATICALLY BE ROUNDED AND THEN DEPOSITED ONTO THE TABLE OR CONVEYOR FOR PANNING.

CAUTION:

DO NOT ATTEMPT TO OPERATE THIS MACHINE WITHOUT READING THE MANUAL. ALWAYS HAVE THE TABLE OR TOP COVER IN PLACE!

CLEANING INSTRUCTIONS

ALL A.M. MANUFACTURING MACHINES ARE TESTED WITH DOUGH DURING THE IN - HOUSE, RUN - IN AND QUALITY AUDIT PROCEDURE. ALTHOUGH THE MACHINE HAS BEEN CLEANED, SOME EVIDENCE OF DOUGH ON AND IN THE MACHINE MAY BE DETECTED, THIS IS NORMAL.

ALL PARTS IN CONTACT WITH DOUGH SHOULD BE WASHED THOROUGHLY AFTER USE, USING A MILD SOAP AND WATER SOLUTION. DISASSEMBLY OF THIS MACHINE FOR CLEANING IS OUTLINED AND ILLUSTRATED FOR YOUR CONVENIENCE. INSTRUCTIONS IN THIS MANUAL INDICATES THE NEED FOR REGULAR INSPECTION AND CLEANING TO PREVENT INFESTATION.

- A. CAUTION: SHUT OFF ALL ELECTRICAL POWER, AND UNPLUG POWER CORD.
- B. REMOVE ROUNDER TABLE (PART NO. R211TA) BY LIFTING STRAIGHT UP (IF APPLICABLE).
- C. REMOVE FUNNEL. (PART NO. R116RA).
- D. REMOVE ROUNDER SCREW, USING TWO PEOPLE TO LIFT ROUNDER SCREW (PART NO. R122RA).
- E. REMOVE DRUM (PART NO. R117RA).
- F. REMOVE PLASTIC SEAL RING (PART NO. R141RA).
- G. REMOVE EXCESS DOUGH FROM ROUNDER BASE.
- H. REASSEMBLE IS IN REVERSE OS DISASSEMBLE OF STEP 1 THRU 8.
- I. MAKE SURE TO REPLACE PLASTIC SEAL RING.
- J. SLIP THE DRUM OVER THE ROUNDER BASE SO THAT THE DRIVE SLOTS ARE LOCKED OVER THE DRIVE PINS IN THE ROUNDER BASE.
- K. CARE SHOULD BE TAKEN TO SEE THAT THE EXIT RAMP ON THE SCREW IS APPROXIMATELY OPPOSITE THE ON / OFF SWITCH AFTER THE SCREW HAS DROPPED INTO PLACE.
- L. ON TABLE MODELS, BE SURE THAT THE RING GEAR (MOUNTED ON THE UNDER SIDE OF THE TABLE) IS ENGAGED OVER ALL FOUR (4) BEARINGS AND MESHED WITH THE DRIVE GEAR. WHEN PROPERLY ENGAGED, THE TABLE WILL SIT FIRM AND LEVEL AROUND THE DRUM. KEEP FINGERS AWAY FROM UNDERNEATH ROTATING TABLE DURING OPERATION.

NOTE:

PARTS SUCH AS THE ROUNDER SCREW AND DRUM SHOULD BE HANDLED WITH EXTREME CARE; WHEN CLEANING THE ROUNDER DRUM THE WATER TEMPERATURE MUST NOT EXCEED 190°.

IF UNABLE TO REMOVE ROUNDER SCREW: **NEVER** PUT HANDS OR ARMS INTO ROUNDER SCREW.

- A. PLUG MACHINE IN. TURN MACHINE ON.
- B. ADD A SMALL AMOUNT OF WARM WATER TO CONTACT AREA BETWEEN SCREW AND DRUM.
- C. AFTER DOUGH SOFTENS, TURN OFF ROUNDER.
- D. UNPLUG MACHINE.
- E. REMOVE ROUNDER SCREW. USING TWO PEOPLE TO LIFT ROUNDER SCREW.



PRACTICE SAFETY FIRST

ALWAYS DISCONNECT ELECTRICAL SERVICE AND TURN MACHINE SWITCH TO THE OFF POSITION BEFORE CLEANING OR MAINTAINING THIS MACHINE, THUS AVOIDING CHANCE OF SERIOUS INJURIES. MACHINES ARE NOT DANGEROUS IF COMMON SENSE IS APPLIED AND THE INSTRUCTIONS ARE FOLLOWED. THINK AND PRACTICE SAFETY FIRST.

GUIDE TO GENERAL MAINTENANCE

READ AND FOLLOW MAINTENANCE INSTRUCTIONS BELOW TO HELP KEEP THE UNIT IN GOOD OPERATING CONDITION. REFER TO OTHER MATERIALS RECEIVED WITH THE UNIT AND TO SERVICE BULLETINS FROM THE MANUFACTURER FOR ADDITIONAL INSTRUCTIONS FOR PROPER MAINTENANCE AND SERVICE. REGULAR INSPECTIONS AND PROPER MAINTENANCE ARE ESSENTIAL TO HELP PREVENT ACCIDENTS AND INJURIES.

PRACTICE SAFETY FIRST:

ALWAYS DISCONNECT ELECTRICAL SERVICE AND TURN MACHINE SWITCH TO THE OFF POSITION BEFORE CLEANING OR MAINTAINING THIS MACHINE, THUS AVOIDING CHANCE OF SERIOUS INJURIES. MACHINES ARE NOT DANGEROUS IF COMMON SENSE IS APPLIED AND THE INSTRUCTIONS ARE CAREFULLY FOLLOWED. THINK AND PRACTICE SAFETY FIRST...

WARNING:

BEFORE MAKING ANY INSPECTION, ADJUSTMENT OR REPAIR, BE CERTAIN POWER SOURCE IS DISCONNECTED AND THE MACHINE SWITCH IS IN THE OFF POSITION WITH ALL MOVING PARTS BEING BLOCKED OUT TO PREVENT INJURY. WEAR PROTECTIVE CLOTHING.

- A. THE TABLE TOP AND OTHER WORKING SURFACES SHOULD BE CLEANED REGULARLY.
- B. MAKE SURE THAT ALL FASTENERS ARE TIGHTENED SECURELY.
- C. MAKE CERTAIN THAT ALL GUARDS AND COVERS ARE IN PLACE.
- D. CHECK FOR WORN, DAMAGED OR MISSING PARTS INCLUDING BELTS, SAFETY GUARDS AND PROTECTIVE COVERS.
- E. ON A DAILY BASIS, INSPECT THE UNIT AND CHECK TO BE CERTAIN THAT ALL SYSTEMS ARE OPERATING NORMALLY. DETAILED INSPECTION AND TESTING PROCEDURES ARE SPECIFIED FOR VARIOUS COMPONENTS AT REGULAR INTERVALS. SET UP A CHART AND ASSIGN RESPONSIBILITY FOR THESE ITEMS.

CAUTION:

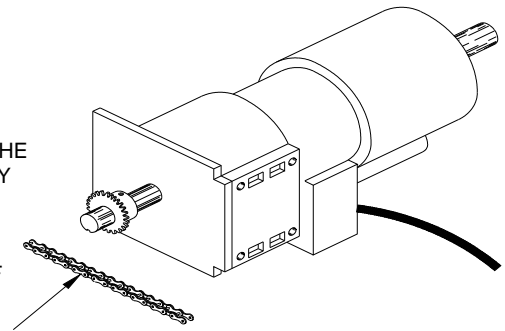
REPLACE ANY DAMAGED OR MISSING SAFETY LABELS. THEY ARE AVAILABLE FROM THE MANUFACTURER.

MAINTENANCE FOR THE ROUND - O - MATIC ALWAYS BEGINS WITH KEEPING THE MACHINE CLEAN. PROPER CLEANING PROCEDURES CAN BE FOUND ON PAGE (6) OF THIS MANUAL. STANDARD LONG TERM MAINTENANCE CONSISTS OF LUBRICATING MAIN WEAR POINTS.

ALL RECOMMENDATIONS FOR MAINTENANCE ARE BASED ON A 7 DAY, 8 HOUR PER DAY WORK SCHEDULE.

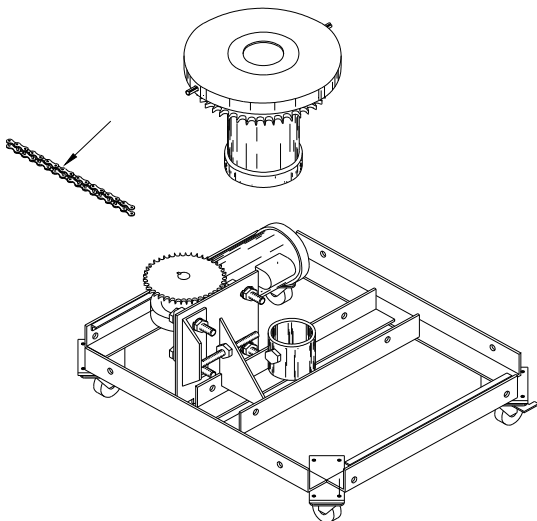
NOTE:
INDICATES
GREASE POINT

THE R-900 CONVEYOR MODEL HAS A MOTOR AND DRIVE CHAIN (PART NO. 113CA) LOCATED BELOW THE CONVEYOR. THIS PART MUST BE OILED REGULARLY WITH A LIGHT WEIGHT MACHINE OIL TO PROLONG LIFE OF THE SPROCKETS, AS WELL AS THE CHAIN. CHAIN CONDITION AND TENSION SHOULD BE CHECKED EVERY 60 DAYS OR MORE FREQUENTLY IF EXCESS NOISE OR VIBRATION IS NOTED.



THE R-900 ROUND - O - MATIC HAS A SINGLE DRIVE CHAIN (PART NO. R105RA). THIS PART MUST BE OILED REGULARLY WITH A LIGHT MACHINE OIL TO PROLONG LIFE OF THE SPROCKETS, AS WELL AS THE CHAIN.

AGAIN, CHAIN CONDITION AND TENSION SHOULD BE CHECKED EVERY 60 DAYS OR MORE FREQUENTLY IF EXCESS NOISE OR VIBRATION IS NOTED.

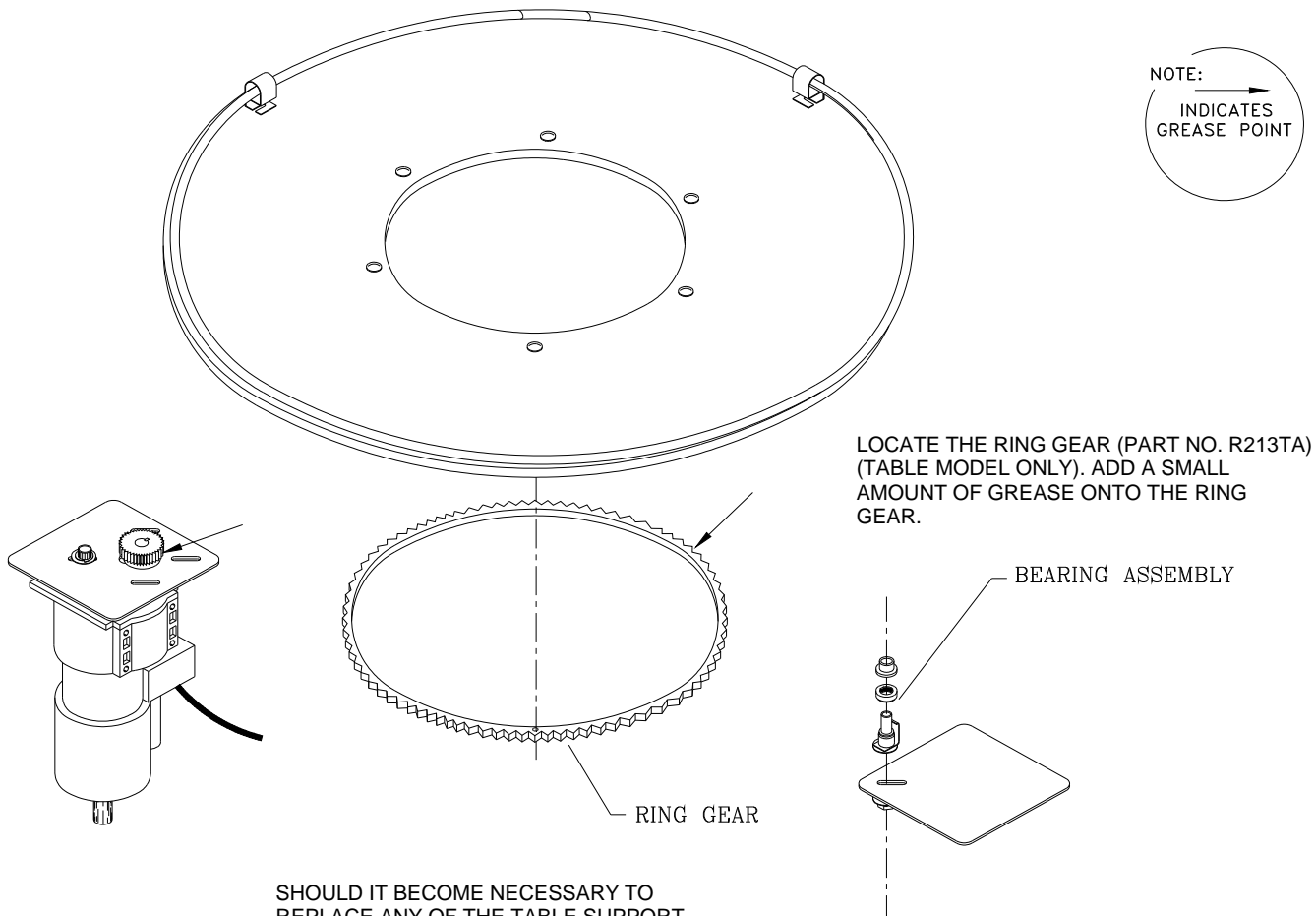


GUIDE TO GENERAL MAINTENANCE



DANGER:

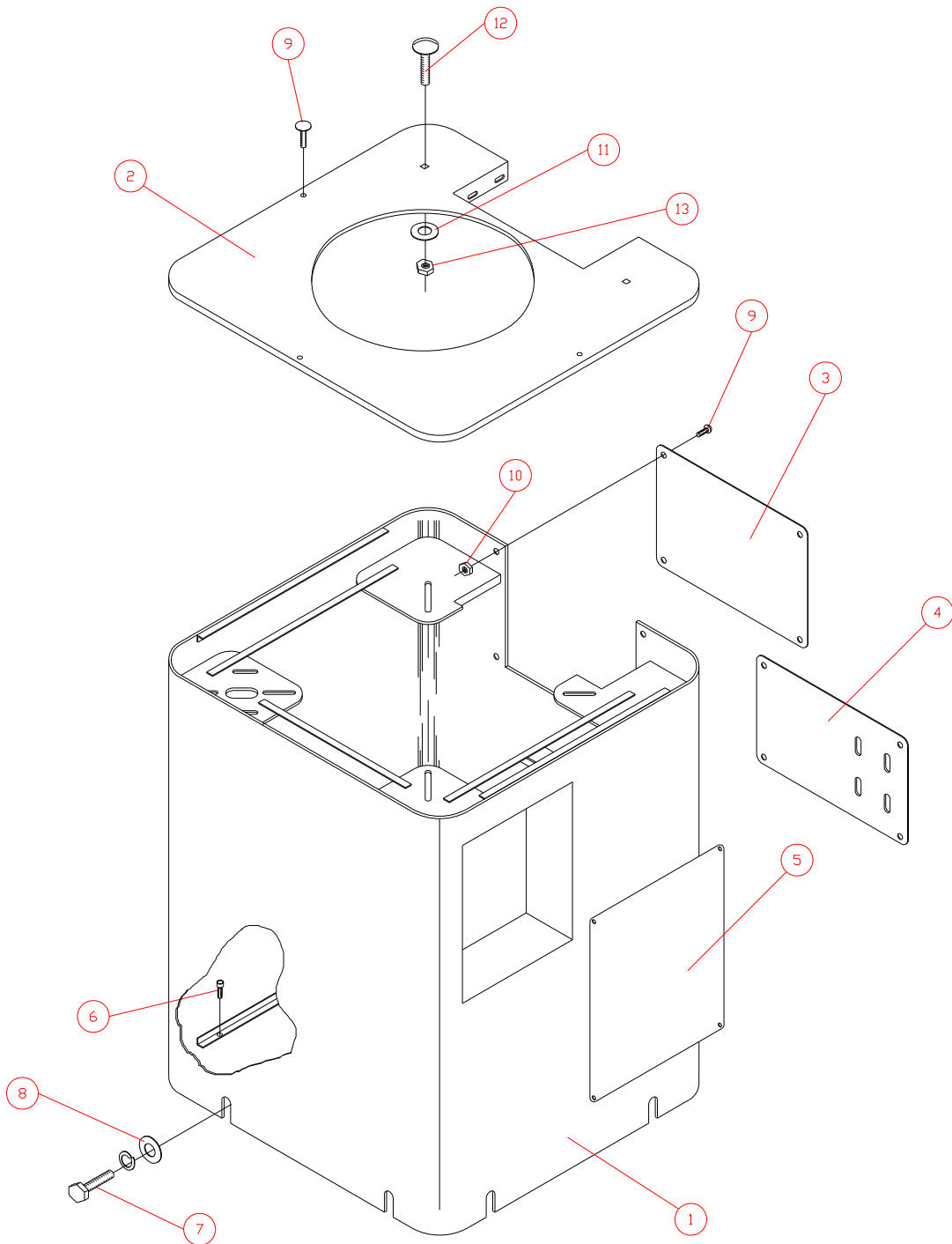
ALWAYS DISCONNECT ELECTRICAL POWER SOURCE AND TURN MACHINE SWITCH TO THE OFF POSITION BEFORE CLEANING, MAINTAINING OR REPAIRING THIS MACHINE...



SHOULD IT BECOME NECESSARY TO REPLACE ANY OF THE TABLE SUPPORT BEARINGS, (PART NO. R214TA - R216TA), CARE SHOULD BE TAKEN NOT TO LOOSEN THE NUTS SECURING THE TABLE SUPPORT POSTS, AS TABLE DRUM ALIGNMENT WILL BE LOST. SIMPLY PULL ASIDE THE CLIP HOLDING THE BEARINGS DOWN, AND LIFT THE BEARINGS STRAIGHT UP.

NOTE: THESE INSTRUCTIONS WILL HELP YOU SERVICE THE UNIT. INSTRUCTIONS ARE FOR A PERSON WITH SOME MECHANICAL ABILITY AND TRAINING. NO ATTEMPT HAS BEEN MADE TO DESCRIBE ALL BASIC STEPS, FOR EXAMPLE, HOW TO LOOSEN OR TIGHTEN FASTENERS. ALSO, BASIC PROCEDURES LIKE HOW TO CYCLE SYSTEMS AND CHECK OPERATION OF THE EQUIPMENT ARE NOT DESCRIBED SINCE THEY ARE KNOWN TO ANYONE WHO DOES MECHANICAL AND SERVICE WORK. DO NOT ATTEMPT TO PERFORM WORK BEYOND YOUR ABILITY OR AT WHICH YOU HAVE NO EXPERIENCE. IF YOU NEED ASSISTANCE, CALL AN AUTHORIZED SERVICE CENTER OR CONTACT A.M. MANUFACTURING AT (800) 342-6744...

CABINET ASSEMBLY



CABINET ASSEMBLY

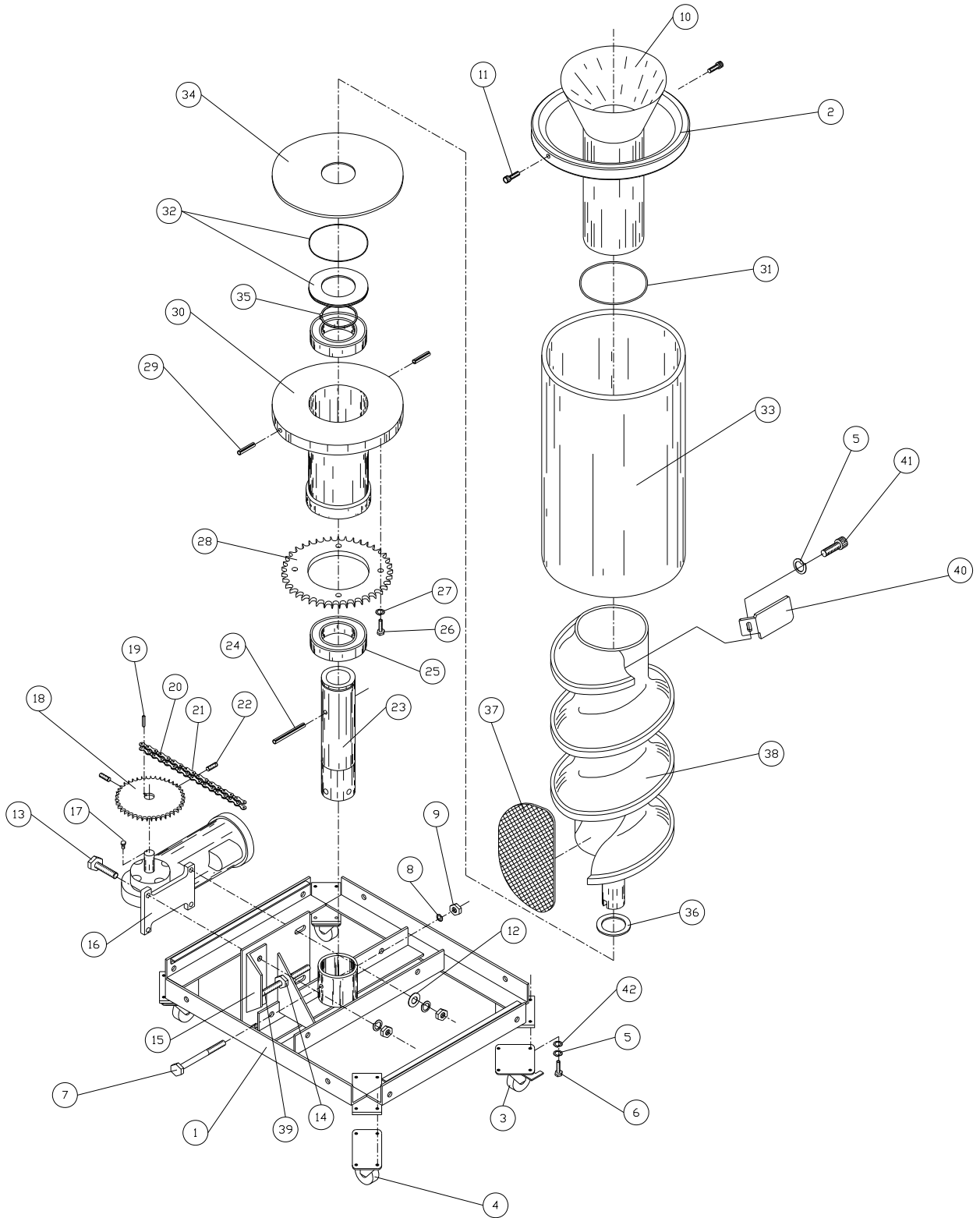
ITEM	PART NO.	DESCRIPTION	NO. REQ'D
1	R416CA	CABINET	1
2	R411CA	TOP COVER	1
3	R418CA	COVER PLATE (R-900T ONLY)	1
4	650CA	MOTOR MOUNTING PLATE (R-900C ONLY)	1
5	R422CA	SWITCH PLATE	1
6	F0404SH	SOCKET / CAP HEAD BOLT	4
7	F0403HH	BOLT	8
8	F0400HFW	FLAT WASHER	8
9	F9702TH	BOLT (R-900T ONLY)	6
	F0402TH	BOLT (R-900C ONLY)	4
10	F9700NC	NUT	4
11	F0400FW	FLAT WASHER	2
12	F0408CB	BOLT	2
13	F0400LN	NUT	2



CAUTION:

KNOW YOUR UNIT. COMPARE DIAGRAMS IN THIS MANUAL WITH THE UNIT BEFORE STARTING SERVICE TO OBTAIN MAXIMUM SAFETY AND PERFORMANCE.

ROUNDER ASSEMBLY



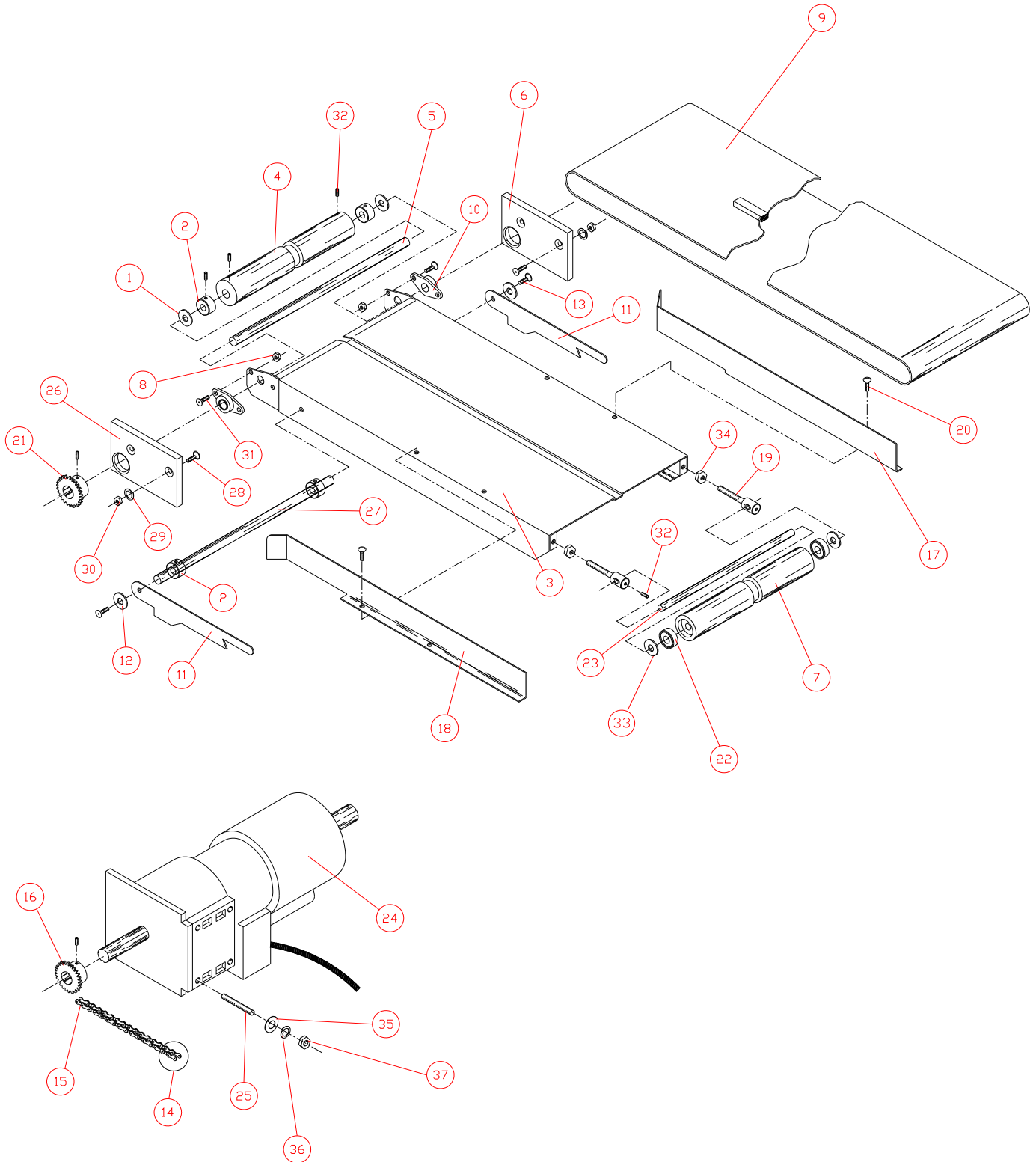
ROUNDER ASSEMBLY

ITEM	PART NO.	DESCRIPTION	NO.REQ'D
1	R130RA	FRAME WELDMENT	1
2	R115RA	RING	1
3	621CA1	LOCKING SWIVEL CASTER	2
4	621CA2	SWIVEL CASTER	2
5	F0400LW	LOCK WASHER	16
6	F0403HH	BOLT	16
7	F0818HH	BOLT	1
8	F0800LW	LOCK WASHER (UN-PLATED)	1
9	F0800NC	NUT	1
10	R116RA	FUNNEL	1
11	F0404FH	SCREW	2
12	F0600FW	FLAT WASHER	4
13	F0606HH	BOLT	4
14	F0800NC	NUT	2
15	R144RA	MOTOR ADJUSTING BRACKET	1
16	SEE ELEC. ASSY. P. 20-23	GEAR MOTOR 3/4 H.P. (NEED VOLTAGE & PHASE OF MACHINE)	1
17	R133RA	BREATHER	1
18	R103RA	SPROCKET 27T (INCLUDES F0525SS)	1
19	F0404KY	KEY 1/4"	1
20	R105RA	DRIVE TRAIN #50 UN-PLATED (31 LINKS) (INCLUDES 106RA)	1
21	106RA	CONNECTING LINK #50 UN-PLATED	1
22	F0525SS	SET SCREW 5/16-18 X 3/8 LG. (CUP TYPE)	2
23	R108RA-S	SPINDLE(Includes: F0612RP, R145RA)	1
24	F0612RP	3/8" X 3" ROLL PIN	1
25	R135RA	BALL BEARING	2
26	F0504HH	BOLT	4
27	F0500LW	LOCK WASHER	4
28	R109RA	SPROCKET 45T	1
29	F0606RP	DRIVE PIN 3/8" DIA.	2
30	R108RA-B	ROUNDER BASE	1
31	R143RA	"O" RING	1
32	R134RA	PLASTIC INSERT W/ "O" RING	1
33	R117RA	DRUM	1
34	R141RA	PLASTIC SEAL RING	1
35	R145RA	SNAP RING	1
36	R142RA	RUBBER WASHER	1
37	R124RA-F	FACING (GUIDE PLATE)	1
38	R122RA	ROUNDER SCREW	1
39	F0824SD	STUD	1
40	R121RA	EXIT RAMP	1
41	F0402SH	SCREW	1
42	F0400FW	FLAT WASHER	1

NOTE:

THE ROUNDER SCREW AND DRUM ARE SUBJECT TO ABUSE. CARE MUST BE TAKEN IN HANDLING, WHEN NOT IN USE WITH MACHINE, LAY ROUNDER SCREW DOWN FLAT ON GROUND AND PLACE ROUNDER DRUM ON GROUND STANDING VERTICAL TO PREVENT WARPING.

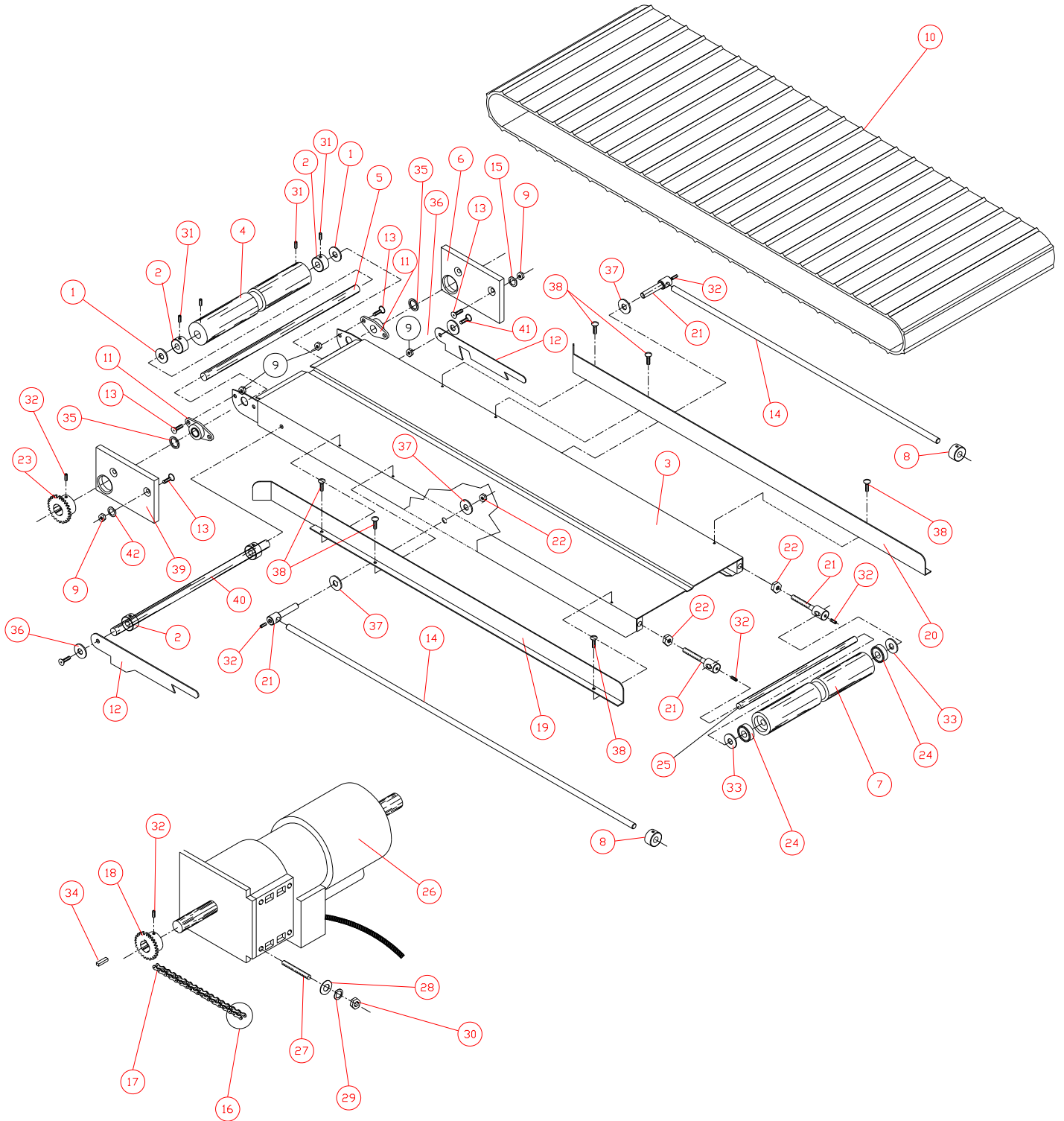
CONVEYOR ASSEMBLY (STANDARD)



CONVEYOR ASSEMBLY

ITEM	PART NO.	DESCRIPTION	NO. REQ'D
1	F0800NW	NYLON WASHER	2
2	119CA	½" LOCKING COLLAR	4
3	118CA	CONVEYOR FRAME	1
4	101CA	DRIVE ROLLER	1
5	115CA	DRIVE ROLLER SHAFT	1
6	11959	SIDE CONVEYOR MOUNTING BRACKET (RIGHT)	1
7	109CA	IDLER ROLLER	1
8	F0400LN	¼-20 LOCK NUT	4
9	104CA	CONVEYOR BELT	1
10	102CA	SELF-ALIGNING BRONZE FLANGE BEARING	2
11	105CA	CONVEYOR ELEVATOR	1
12	F0400FW	¼-20 FLAT WASHER	2
13	F0402HH	¼-20 X ½ HEX HEAD	2
14	114CA	NO. 35 CONNECTING LINK UNIT	1
15	113CA	CHAIN NO. 35 AT 16 LINKS	1
16	112CA	MOTOR SPROCKET	1
17	106CAL	CONVEYOR GUIDE (LEFT)	1
18	106CAR	CONVEYOR GUIDE (RIGHT)	1
19	600SC	ROLLER SUPPORT	2
20	F9702RH	8-32 ROUND HEAD SCREW	4
21	116CA	ROLLER SPROCKET	1
22	603SCA	BALL BEARING	2
23	108CA	IDLER ROLLER SHAFT	1
24	SS252	CONVEYOR MOTOR	1
25	F0504SD	SOCKET HEAD STUD	4
26	11960	SIDE CONVEYOR MOUNTING BRACKET (LEFT)	1
27	11958	CONVEYOR ELEVATOR SHAFT	1
28	F0406SFH	¼-20 X 1.5 SOCKET FLAT HEAD	4
29	F0400LW	¼" LOCK WASHER	4
30	F0400NC	¼-20 COURSE NUT	4
31	F0402FSH	¼-20 X ½ FLAT SOCKET HEAD	4
32	F0401SS	SET SCREW	4
33	F0600NW	NYLON WASHER	2
34	F0500LN	5/16 LOCK NUT	2
35	F0500FW	5/16 FLAT WASHER	8
36	F0500LW	5/16 LOCK WASHER	4
37	F0500NC	5/16 COURSE NUT	4

LONG TAKE-OFF CONVEYOR ASSEMBLY



LONG TAKE-OFF CONVEYOR

ITEM	PART NO.	DESCRIPTION	NO. REQ'D
1	F0800NW	NYLON WASHER	2
2	119CA	½" LOCKING COLLAR	4
3	118CAL	CONVEYOR FRAME	1
4	101CA	DRIVE ROLLER	1
5	115CA	DRIVE ROLLER SHAFT	1
6	11959	SIDE CONVEYOR MOUNTING BRACKET (RIGHT)	1
7	109CA	IDLER ROLLER	1
8	161CA	3/8" I.D. SHAFT COLLAR	2
9	F0400NC	¼-20 COURSE NUT	8
10	104CAL	CONVEYOR BELT	1
11	102CA	SELF-ALIGNING BRONZE FLANGE BEARING	2
12	105CA	CONVEYOR ELEVATOR	2
13	F0406SFH	¼-20 X 1.5 SOCKET FLAT HEAD BOLT	8
14	158CAL	CONVEYOR SUPPORT ROD	2
15	F0400LW	¼-20 LOCK WASHER	3
16	114CA	No. 35 CONNECTING LINK UNIT	1
17	113CA	No. 35 CHAIN (16 LINKS)	1
18	112CA	MOTOR SPROCKET (INCLUDES F0401SS)	1
19	106CALL	CONVEYOR GUIDE (LEFT)	1
20	106CARL	CONVEYOR GUIDE (RIGHT)	1
21	A600SC	ROLLER SUPPORT (INCLUDES 1- F0600NC and 1- F0402SS)	4
22	F0600NC	3/8" COURSE NUT	2
23	116CA	ROLLER SPROCKET	1
24	603SCA	BALL BEARING	2
25	108CA	IDLER ROLLER SHAFT	1
26	SS252	CONVEYOR MOTOR	1
27	F0504SD	5/16" X 1" SOCKET HEAD STUD	4
28	F0500FW	5/16" FLAT WASHER	8
29	F0500LW	5/16" LOCK WASHER	4
30	F0500NC	5/16" COURSE NUT	4
31	F0402SS	¼" - 20 X ½" SET SCREW	4
32	F0401SS	¼" - 20 X ¼" SET SCREW	6
33	F0600NW	3/8" NYLON WASHER	2
34	F0304KY	KEY	2
35	F1500NW	1-1/8" NYLON WASHER	1
36	F0400FW	¼" - 20 FLAT WASHER	1
37	F0600FW	3/8" FLAT WASHER	4
38	F9702PH	8-32 X 3/8" PAN HEAD SCREW	4
39	11960	SIDE CONVEYOR MOUNTING BRACKET (LEFT)	1
40	11958	CONVEYOR ELEVATOR SHAFT	1
41	F0402HH	¼"-20 X ½" HEX HEAD	2
42	F0400FW	¼-20 FLAT WASHER	2

TABLE ASSEMBLY

ITEM	PART NO.	DESCRIPTION	NO. REQ'D.
1	SEE ELEC. ASSY. P. 18-21	1/15 H.P. GEAR MOTOR	1
2	F0400FW	FLAT WASHER	3
3	F0400LW	LOCK WASHER	3
4	F0402HH	HEX HEAD BOLT	3
5	F0304KY	3/16" KEY	1
6	R206TA	32T DRIVE GEAR (INCLUDES F0304KY AND F0401SS)	1
7	F0401SS	SET SCREW	1
8	R208TA	RING CONNECTOR	1
9	R209TA	RING	1
10	R210TA	RING CLIPS	3
11	F9704TH	TRUSS HEAD BOLT	6
12	R211TA	TABLE	1
13	R213TA	RING GEAR	1
14	R214TA	PLASTIC BEARING	4
15	R215TA	THRUST BEARING	4
16	R216TA	BRONZE BEARING	4
17	R217TA	TABLE SUPPORT POST	4
18	R218TA	BEARING RETAINER	4
19	F0500FW	FLAT WASHER	8
20	F0500LW	LOCK WASHER	4
21	F0500NC	HEX NUT	4
22	F9902TH	TRUSS HEAD BOLT	3
23	11942	TABLE ROLLER GUIDE BRACKET	4
24	11943	TABLE GUIDE ROLLER	4
25	F0605SHB	38" X 1 1/4" SHOULDER BOLT	3

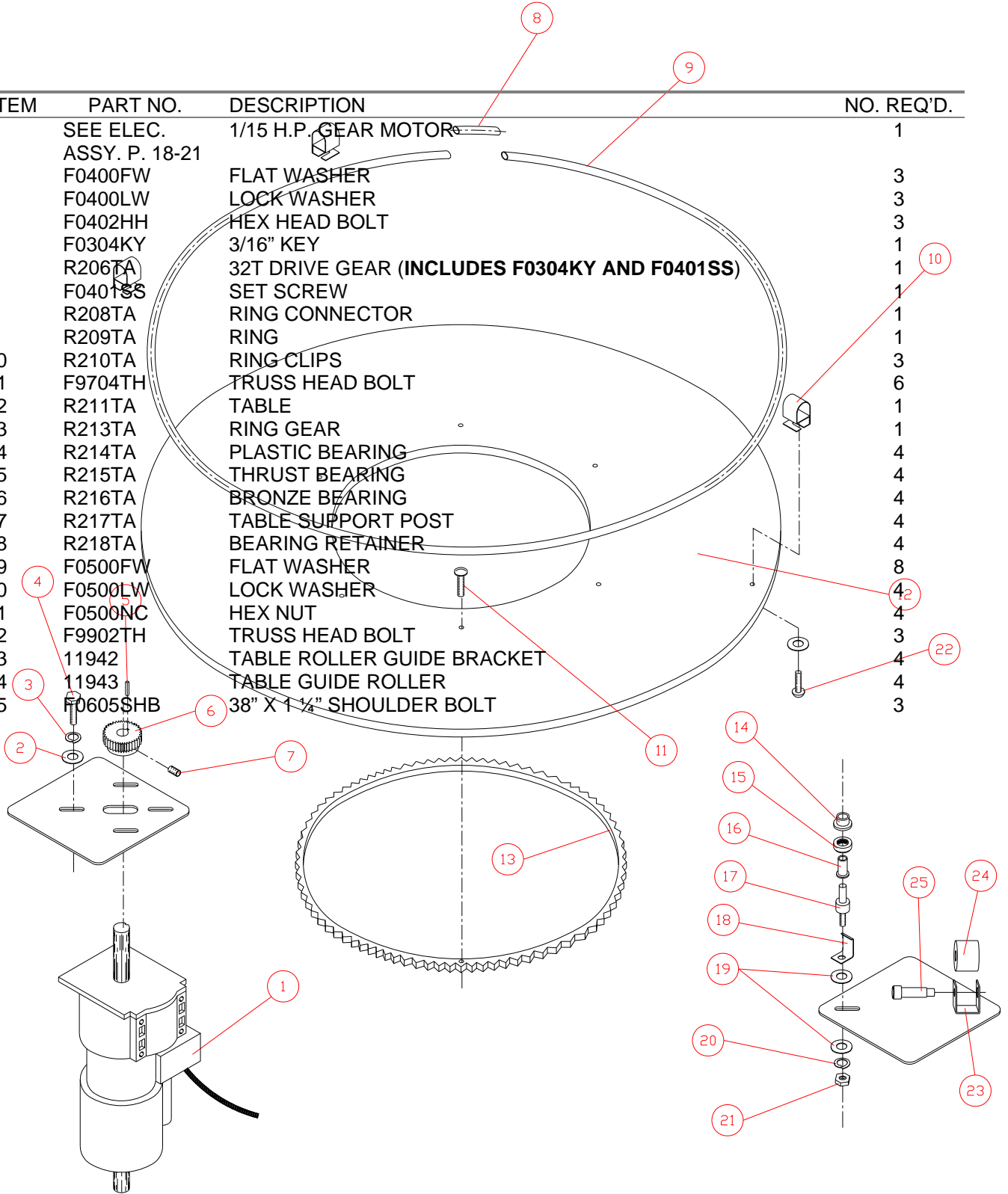


TABLE ASSEMBLY

ASSEMBLIES:

RTA = ITEMS 14 THROUGH 21
INCLUDES: ONE (1) OF EACH -

R214TA, R215TA, R216TA, R217T
R218TA, F0500LW, F0500NC

ONE (1) ASSEMBLY

TWO (2) OF EACH-

F0500FW

RTAC = ITEMS 14 THROUGH 21
INCLUDES: ONE (4) OF EACH -

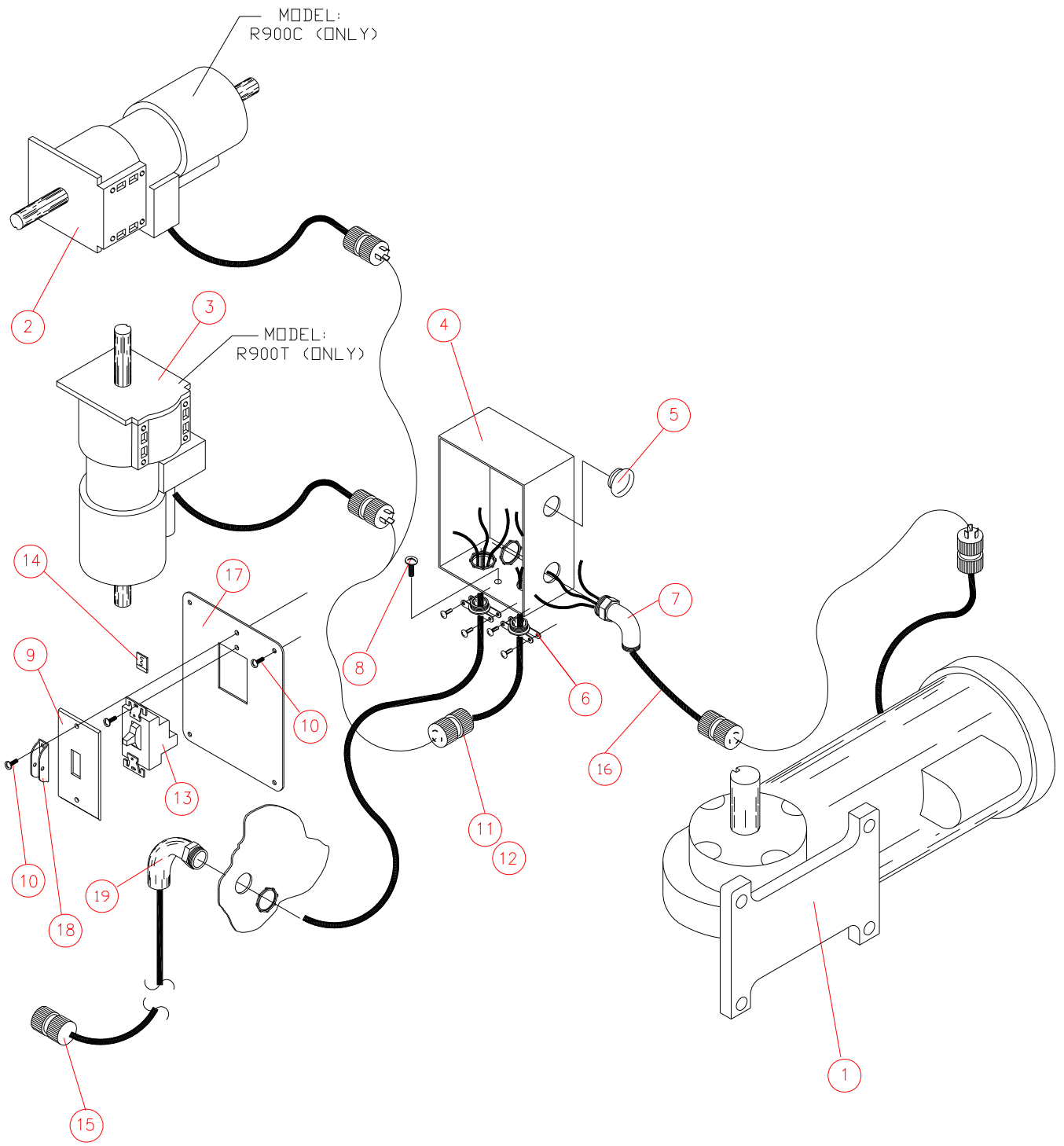
R214TA, R215TA, R216TA, R217T
R218TA, F0500LW, F0500NC

FOUR (4) ASSEMBLIES

TWO (2) OF EACH-

F0500FW

**ELECTRICAL COMPONENTS
SINGLE PHASE**



ELECTRICAL COMPONENTS

115/220 SINGLE PHASE

ITEM	PART NO.	DESCRIPTION	NO. REQ'D.
1	R500EC1	GEAR MOTOR ASSEMBLY	1
		W/ SS255 - GEAR MOTOR	1
		SS221 - 14/3 CAROLPRENE CORD	18"
		SS153 - PLUG (115Vac)	1
		SS155 - PLUG (220Vac)	1
2	R501EC1	CONVEYOR MOTOR ASSEMBLY	1
		W/SS252 - CONVEYOR MOTOR	1
		SS221 - 16/3 CAROLPRENE CORD	19"
		SS149 - PLUG (115Vac)	1
		SS153 - PLUG (220Vac)	1
3	R502EC1	TABLE MOTOR ASSEMBLY	1
		W/SS252-TABLE MOTOR	1
		SS221 - 16/3 CAROLPRENE CORD	19"
		SS149 - PLUG (115Vac)	1
		SS153 - PLUG (220Vac)	1
4	R421CA	ELECTRICAL BOX	1
5	SS108	S.S. HOLE PLUG	1
6	SS100	CORD CONNECTOR	2
7	SS103	90° ELBOW	2
8	F9702TH	SCREW	1
9	SS115	COVER PLATE	1
10	F9702RH	SCREW	6
11	R503EC1	TABLE CONNECTOR ASSEMBLY	1
		W/SS221 - 16/3 CAROLPRENE CORD	13"
		SS150 - CONNECTOR (115Vac)	1
		SS154 - CONNECTOR (220Vac)	1
12	R504EC1	CONVEYOR CONNECTOR ASSEMBLY	1
		W/SS221-16/3 CAROLPRENE CORD	44"
		SS150 - CONNECTOR (115Vac)	1
		SS154 - CONNECTOR (220Vac)	1
13	SS212	MANUAL MOTOR STARTER	1
14	SS211	OVERLOAD	1
15	R505EC1	POWER CORD PLUG ASSEMBLY	1
		W/SS220 - 14/3 CAROLPRENE CORD	12'
		SS148 - PLUG (115Vac)	1
		Ss155 - PLUG (220Vac)	1
16	R506EC3	GEAR MOTOR CONNECTOR ASSEMBLY	1
		W/ SS220 - 14/3 CAROLPRENE CORD	16"
		SS154-CONNECTOR (115Vac)	1
		Ss156- CONNECTOR (220Vac)	1
17	R422CA	SWITCH PLATE	1
18	R406CA	LOCKING ATTACHMENT	1
19	SS277	90 DEGREE CORD GRIP	1

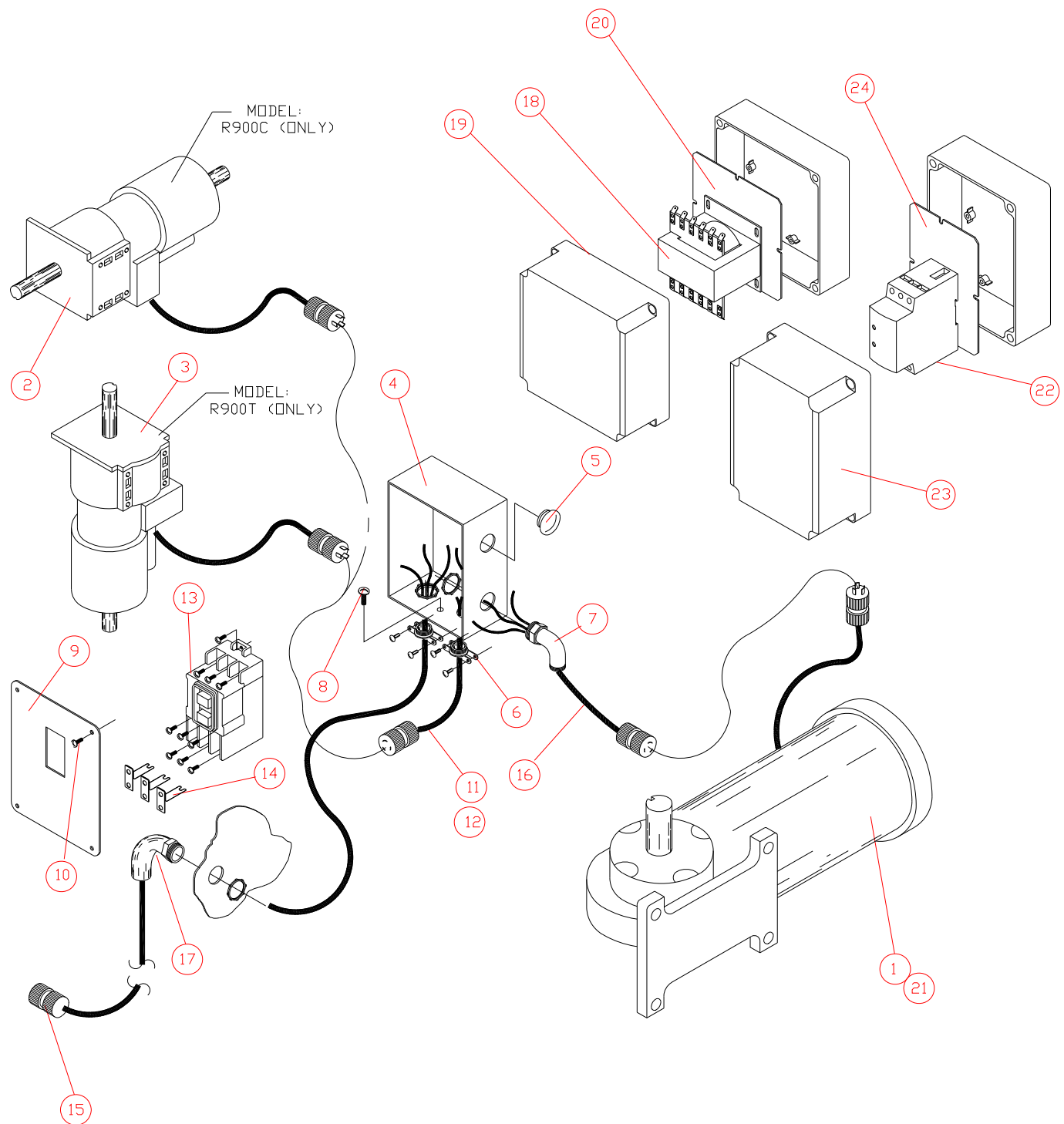


CAUTION:

USE EXTREME CARE WHEN REPLACING ELECTRICAL COMPONENTS. ELECTRICAL SHOCKS CAN BE FATAL. REPLACEMENT OF ELECTRICAL COMPONENTS SHOULD BE MADE BY A QUALIFIED TECHNICIAN

ELECTRICAL COMPONENTS

(3) PHASE



ELECTRICAL COMPONENTS

208-480 (3) PHASE

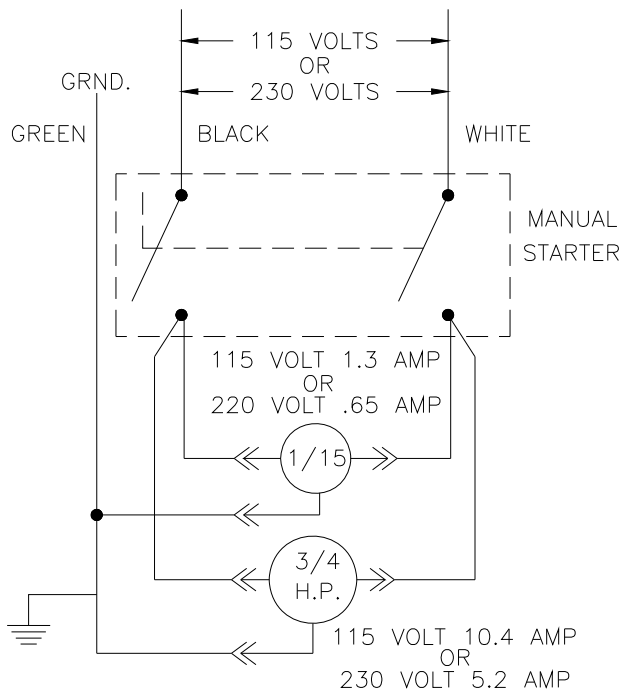
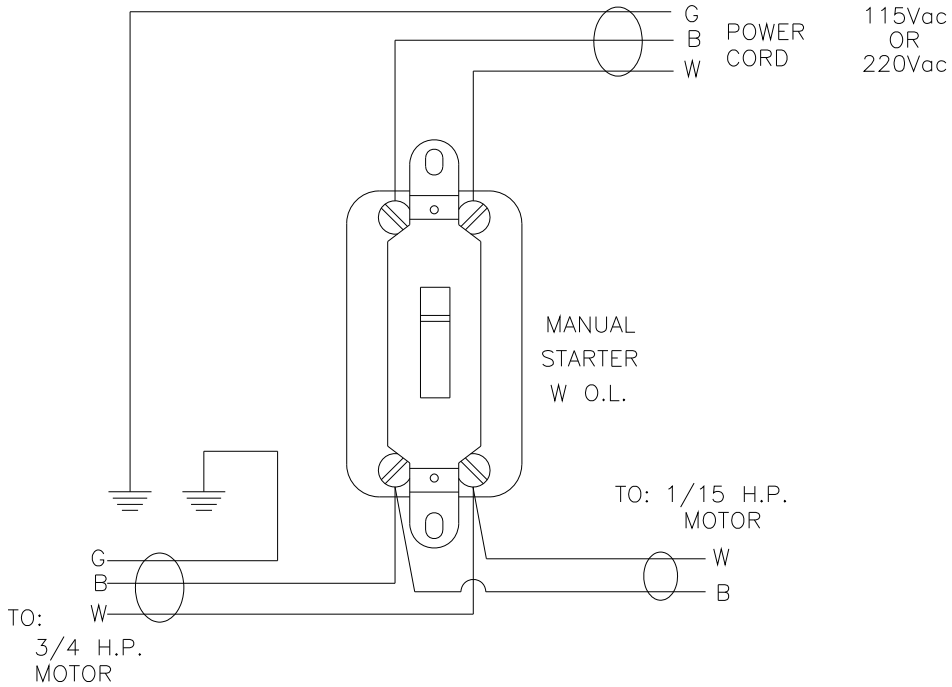
ITEM	PART NO.	DESCRIPTION	NO. REQ'D.
1	R500EC3	GEAR MOTOR ASSEMBLY	1
		W/ SS256 - GEAR MOTOR	1
		SS221 - 16/4 CAROLPRENE CORD	18"
		SS159 - PLUG (208-220Vac)	1
		SS161 - PLUG (380-480Vac)	1
2	R501EC3	CONVEYOR MOTOR ASSEMBLY	1
		W/SS252 - CONVEYOR MOTOR	1
		SS221 - 16/3 CAROLPRENE CORD	19"
		SS153 - PLUG	1
3	R502EC3	TABLE MOTOR ASSEMBLY	1
		W/SS252-TABLE MOTOR	1
		SS221 - 16/3 CAROLPRENE CORD	19"
		SS153 - PLUG (220Vac)	1
4	R421CA	ELECTRICAL BOX	1
5	SS108	S.S. HOLE PLUG	1
6	SS100	CORD CONNECTOR	2
7	SS103	90° ELBOW	2
8	F9702TH	SCREW	1
9	R425CA	SWITCH PLATE	1
10	F9702RH	SCREW	4
11	R503EC3	TABLE CONNECTOR ASSEMBLY	1
		W/SS221 - 16/3 CAROLPRENE CORD	13"
		SS154 - CONNECTOR	1
12	R504EC3	CONVEYOR CONNECTOR ASSEMBLY	1
		W/SS221-16/3 CAROLPRENE CORD	44"
		SS154 - CONNECTOR (220Vac)	1
13	SS239	MANUAL MOTOR STARTER	1
14	SS201	OVERLOAD	3
15	R505EC1	POWER CORD PLUG ASSEMBLY	1
		W/SS220 - 14/3 CAROLPRENE CORD	12'
		SS159 - PLUG (208-220Vac)	1
		SS161 - PLUG (380-480Vac)	1
16	R506EC3	GEAR MOTOR CONNECTOR ASSEMBLY	1
		W/ SS225 - 16/4 CAROLPRENE CORD	16"
		SS160-CONNECTOR (208-220Vac)	1
		SS162- CONNECTOR (380-480Vac)	1
17	SS277	90 DEGREE CORD GRIP	1
18	EL-0220	TRANSFORMER (380-480Vac MACHINES)	1
19	SS381	ELECTRICAL ENCLOSURE (380-480Vac MACHINES)	1
20	SS380	ELECTRICAL ENCLOSURE PANEL (380-480Vac MACHINES)	1
21	SS260	2 H.P. MOTOR (OPTIONAL)	1
22	SS384	SOFT START (240Vac MACHINES - OPTIONAL)	1
	SS385	SOFT START (380Vac MACHINES - OPTIONAL)	
	SS386	SOFT START (480Vac MACHINES - OPTIONAL)	
23	SS387	ELECTRICAL ENCLOSURE	1
24	SS388	ELECTRICAL ENCLOSURE PANEL	1
25	SS105	LIQUIDTIGHT CONNECTOR	2



CAUTION:

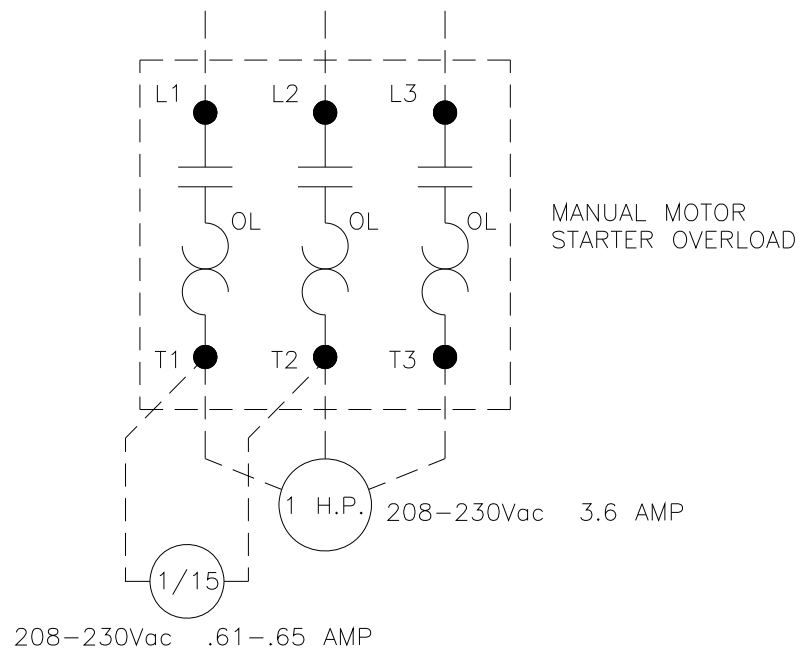
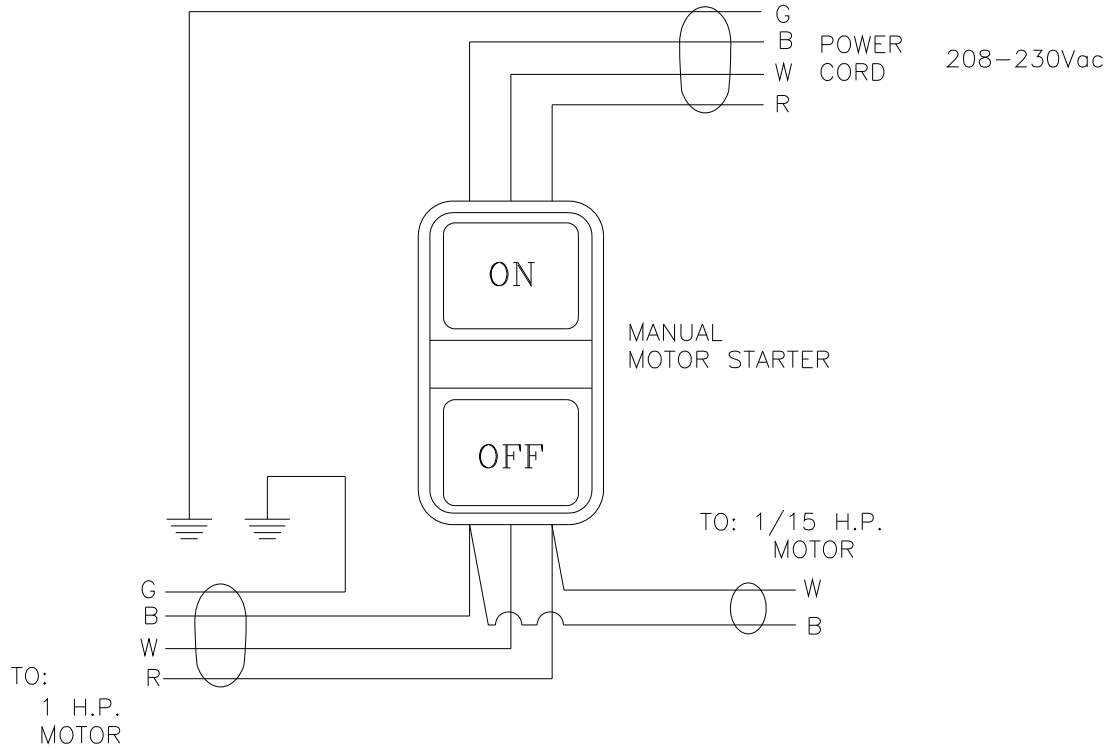
USE EXTREME CARE WHEN REPLACING ELECTRICAL COMPONENTS. ELECTRICAL SHOCKS CAN BE FATAL. REPLACEMENT OF ELECTRICAL COMPONENTS SHOULD BE MADE BY A QUALIFIED TECHNICIAN

ELECTRICAL SCHEMATIC / HARDWARE SINGLE PHASE



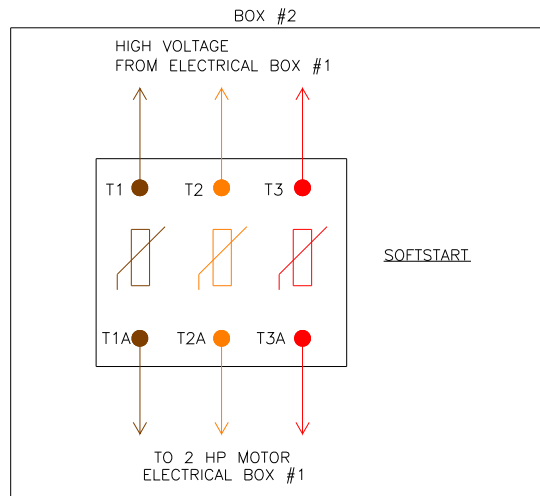
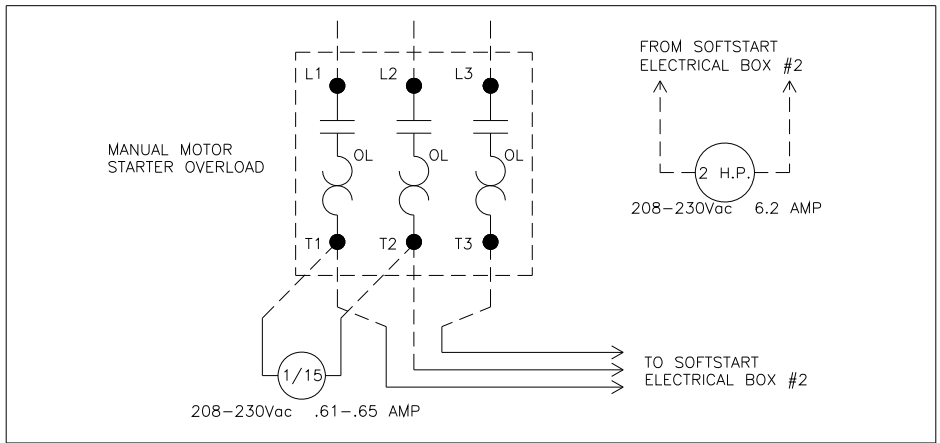
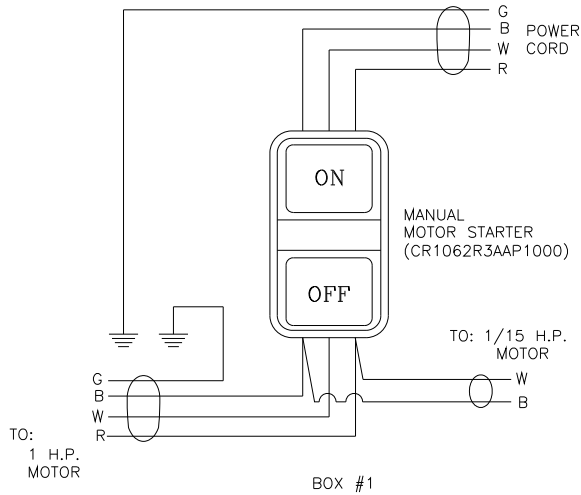
ELECTRICAL SCHEMATIC / HARDWARE

208-230 THREE PHASE



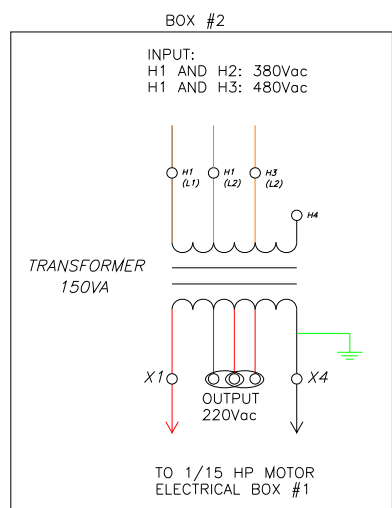
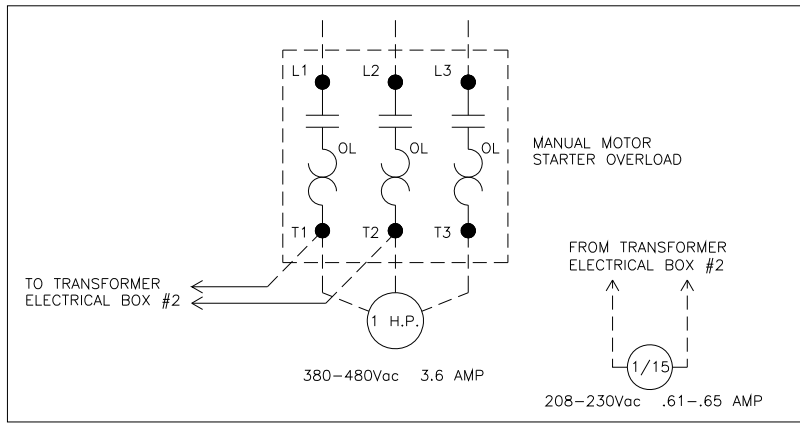
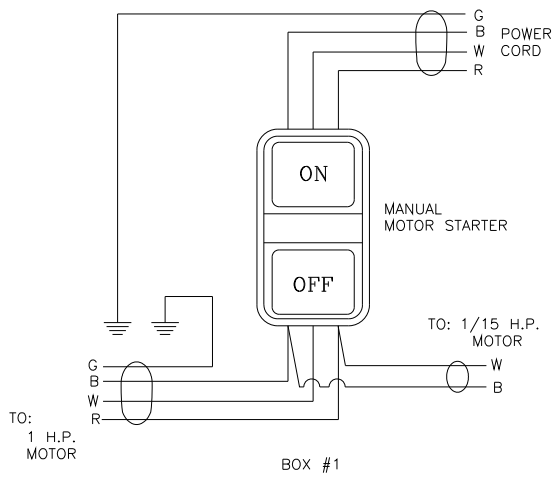
ELECTRICAL SCHEMATIC / HARDWARE

208-230 THREE PHASE w/ SOFT START



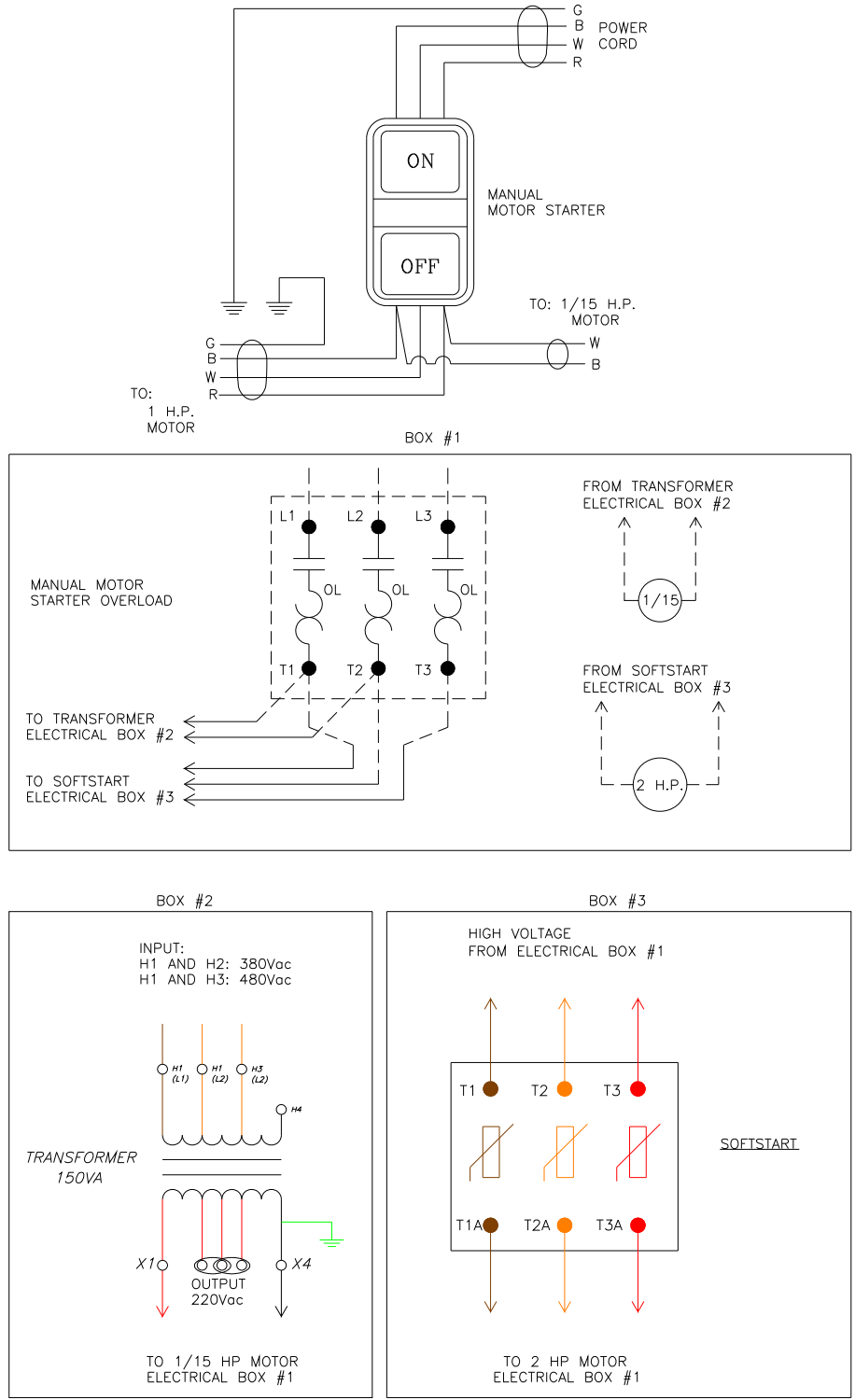
ELECTRICAL SCHEMATIC / HARDWARE

380-480 THREE PHASE



ELECTRICAL SCHEMATIC / HARDWARE

380-480 THREE PHASE w/ SOFT START



ORDERING REPLACEMENT PARTS

IMPORTANT:

ONLY USE FACTORY SUPPLIED REPLACEMENT PARTS TO MAINTAIN MACHINE SAFETY, PERFORMANCE AND SANITARY CONDITIONS.

USE OF NON-APPROVED PARTS MAY VOID MANUFACTURES WARRANTY.

TO ORDER REPLACEMENT PARTS ALWAYS:

- 1) CHECK THE MACHINE TO IDENTIFY MISSING, DAMAGED OR NON-FUNCTIONAL PARTS INCLUDING GUARDS, WARNING LABELS AND INSTRUCTIONS.
- 2) COMPARE THE LIST WITH THE PARTS DIAGRAMS SUPPLIED.
- 3) RECORD THE COMPLETE MODEL AND SERIAL NUMBER OF THE UNIT.
- 4) CALL A.M. MANUFACTURING (800) 342-6744 AND PROVIDE ALL INFORMATION NOTED ABOVE TO EXPEDITE ORDER PROCESSING AND HELP REDUCE SHIPPING COST.
- 5) PROVIDE COMPLETE DETAILS FOR (SHIP TO) AND (BILL TO) INFORMATION. TO ASSIST PROMPT DELIVERY, SPECIFY TYPE OF CARRIER PREFERRED IN SHIPMENT.
- 6) ALL MAJOR CREDIT CARDS ACCEPTED.

