

MASTER

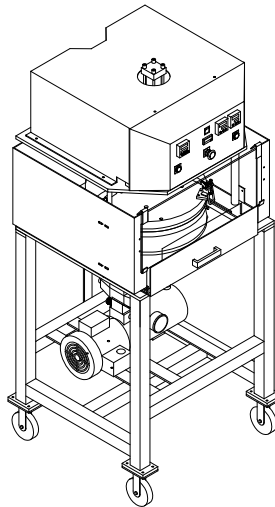
THE ATWOOD

LITTLE TORO 1800BH HYDRAULIC PRESS

OPERATIONS AND SAFETY MANUAL

INCLUDING PARTS CATALOGUE
AND MAINTENANCE INSTRUCTIONS

SERIAL No. _____



CAUTION:

DO NOT OPERATE, CLEAN, OR SERVICE THIS MACHINE BEFORE YOU READ THIS MANUAL AND ARE FAMILIAR WITH ITS SAFETY INSTRUCTIONS 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.

IF YOU SHOULD HAVE ANY (?)
QUESTIONS ABOUT GUARDS OR
PLACEMENT CALL (708) 841-0959.

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MANUFACTURING COMPANY

DIVISION OF THE ATWOOD CORPORATION
14151 IRVING AVENUE DOLTON, ILLINOIS 60419
(708) 841-0959 (800) 342-6744 FAX: (708) 841-0975

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, IT IS THE RESPONSIBILITY OF THE OWNER TO READ AND FOLLOW THESE INSTRUCTIONS AND TO ENSURE THAT ALL OPERATORS UNDERSTAND AND FOLLOW THESE AND OTHER SAFETY PROCEDURES DESCRIBED 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 SUPERVISED – AND TRAINED TO OPERATE THE UNIT SAFELY AND CORRECTLY.
- MAKE CERTAIN THAT THE UNIT IS NEVER ACTIVATED UNLESS ALL PARTS - **INCLUDING SAFETY EQUIPMENT** – ARE IN PLACE AND FUNCTIONING PROPERLY.
- 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. MAKE CERTAIN THAT 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 40 OF THIS MANUAL.



WARNING:

THIS MANUAL CONTAINS CRITICAL SAFETY INSTRUCTIONS. READ AND FOLLOW THEM CAREFULLY. FAILURE TO FOLLOW WARNINGS AND/OR INSTRUCTIONS MAY LEAD TO SERIOUS PERSONAL INJURY. THE OWNER IS RESPONSIBLE FOR MAINTAINING THE UNIT, ITS INSTRUCTIONS, AND ITS DECALS TO ENSURE PROPER OPERATION AND CORRECT INFORMATION. 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

THE LITTLE TORO 1800BH PIZZA/TORTILLA PRESS DELIVERS HIGH-PRODUCTION QUALITY AND CONSISTENCY IN A SMALL, AFFORDABLE UNIT. BY UTILIZING A HEATED MOLDING PROCESS AND CUSTOM PRESS DIES, THIS DEVICE IS CAPABLE OF FORMING NEARLY ANY SIZE AND STYLE CRUST OR TORTILLA (INCLUDING RAISED-EDGE VARIETIES) THAT WILL FIT ON ITS 20" CIRCULAR WORK SURFACE. IN ADDITION, THE LITTLE TORO IS FITTED WITH CUSTOM "QUICK RELEASE" CLAMPS THAT ALLOW THE USER TO REMOVE ONE PRESS DIE AND REPLACE IT WITH ANOTHER IN A MATTER OF MINUTES.



CAUTION:

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

SPECIFICATIONS

HEIGHT	5 ½ FEET
WIDTH	2 ¼ FEET
DEPTH	2 FEET
SHIPPING WEIGHT	730 lbs.
PRESS FORCE	UP TO 1000 PSI (ADJUSTABLE)
PRESS TIME (DWELL TIME)	FULLY ADJUSTABLE
TEMPERATURE RANGE	AMBIENT - 450° F.

VOLTAGES: SINGLE PHASE / 220 VOLT / 60 HZ / 20 AMPS.

INSTALLATION INSTRUCTIONS

LOCATION:

SELECT THE LOCATION FOR YOUR LITTLE TORO 1800BH CAREFULLY. THE MACHINE SHOULD BE PLACED TO PROVIDE THE OPERATOR ENOUGH SPACE TO COMFORTABLY MOVE THE DRAWER IN AND OUT OF THE PRESS AREA. THE FLOOR BENEATH THE MACHINE SHOULD BE FREE OF OIL, GREASE, ETC. AND EASY TO CLEAN. AVOID AREAS WHERE BYSTANDERS AND CUSTOMERS MAY BE PRESENT.

YOUR LITTLE TORO DEVICE WILL ARRIVE WITH ALL GUARDING IN PLACE AND THE DIE SECURELY CLAMPED TO THE HEATER PLATE. REMOVE ALL PACKING MATERIAL FROM THE MACHINE AND ROLL IT CAREFULLY TO THE DESIRED LOCATION.



WARNING

THE HYDRAULIC LITTLE TORO ARRIVES ALREADY BOLTED TO ITS STAINLESS STEEL FRAME. THIS FRAME PROVIDES AMPLE SUPPORT FOR THE MACHINE – AND ROLLS EASILY OVER FIRM, FLAT SURFACES. DUE TO THE WEIGHT OF THE DEVICE, HOWEVER, PROPER CAUTION MUST BE EXERCISED TO ASSURE THE MACHINE WILL NOT BE JOSTLED OR TIPPED BY CRACKED AND/OR UNEVEN FLOORING. ONCE THE MACHINE HAS BEEN LOCATED, BE SURE TO ENGAGE THE LOCKING CASTERS TO KEEP IT IN PLACE.



CAUTION

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

ONCE THE MACHINE IS IN PLACE, INSPECT IT FOR ANY DAMAGE. IF THE HOOD OR GUARDS CONTAIN ANY DENTS – OR IF ANY COMPONENTS ARE MARRED OR BROKEN, CONTACT AM MANUFACTURING IMMEDIATELY.

SAFETY

THIS MACHINE IS DESIGNED TO RUN SAFELY IF NORMAL OPERATING PROCEDURES AND SAFETY MESSAGES LOCATED ON THE MACHINE AND IN THIS MANUAL ARE FOLLOWED.



THIS IS A SAFETY ALERT SYMBOL. YOU WILL FIND IT ON VARIOUS SAFETY LABELS ON THE MACHINE. IT WILL ALSO APPEAR IN THIS MANUAL 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:

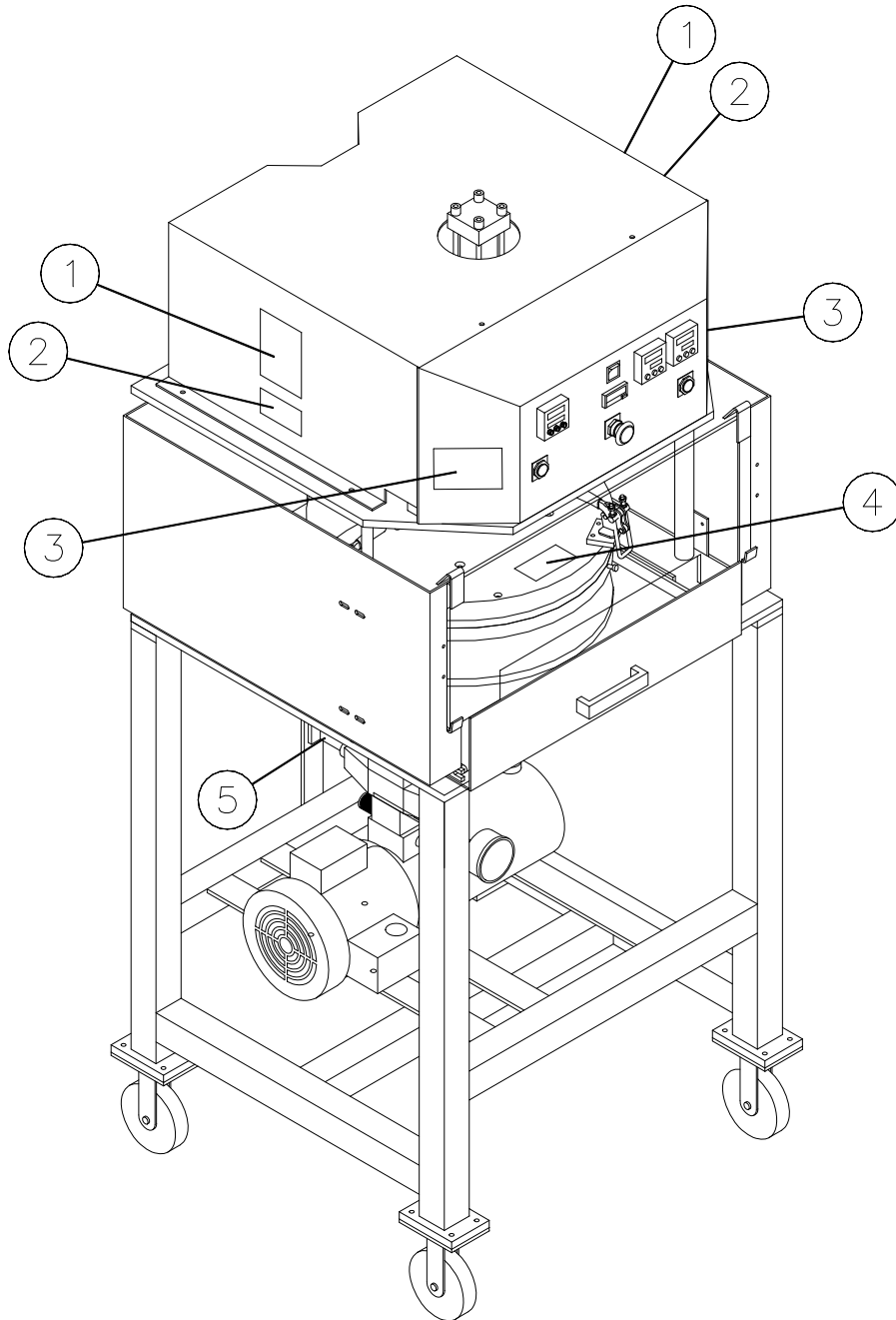
INDICATES AN IMMINENTLY HAZARDOUS SITUATION WHICH, IF NOT AVOIDED, WILL RESULT IN DEATH OR SERIOUS INJURY. THIS SIGNAL WORD IS TO BE LIMITED TO THE MOST EXTREME SITUATIONS.

NOTE:

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

WARNING LABELS


TYPICALLY FOUND ON THE LT1800BH PRESS



WARNING LABELS

TYPICALLY FOUND ON THE LT1800BH PRESS


1 PART NO. AM MFG. #21

	IMPORTANT SAFETY INFORMATION <small>© 1992 A.M. MFG. #21</small>
<ul style="list-style-type: none"> • 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	

MACHINE HOOD (LEFT & RIGHT SIDES)

MACHINE - HOOD (LEFT & RIGHT SIDES)

2 PART NO. AM MFG. #11

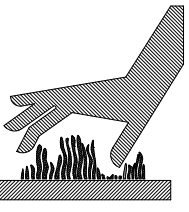

 WARNING
ALL GUARDS AND SAFETY SHIELDS MUST BE IN PLACE BEFORE STARTING MACHINE. NEVER OPERATE THIS MACHINE WITHOUT SAFETY SHIELDS IN PLACE. DO NOT CHANGE THIS MACHINE IN ANY WAY TO INTERFERE WITH OR ELIMINATE THESE ESSENTIAL SAFETY FEATURES.
© 1992 AM MFG. #11

3 PART NO. AM MFG. #9A

	 DANGER
	MOVING PLATEN WILL CUT OFF OR CRUSH HANDS. KEEP HANDS OUT OF PLATEN OPERATING AREA WHILE MACHINE IS IN OPERATION
	© 1992 AM MFG. #9A

MACHINE - HOOD (LEFT & RIGHT SIDES)



4 PART NO. AM MFG. #54

	WARNING  HOT SURFACE!!! SURFACE WILL BE VERY HOT WHEN IN USE. DISCONNECT POWER AND ALLOW MACHINE TO COOL BEFORE ATTEMPTING TO CHANGE DIES OR SERVICE MACHINE.
	© 2000 A.M. MFG. #54

- PRESS UPPER PLATE

FRAME - ELECTRICAL BOX

5 PART NO. AM MFG. #10

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

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 A.M. MFG. FOR REPLACEMENT.

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 READ AND UNDERSTAND THIS OPERATIONS AND SAFETY MANUAL.
- FOLLOW ALL INSTRUCTIONS DURING USE OF THIS MACHINE.
- LEAVE ALL GUARDS IN PLACE. RE-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 BEFORE CLEANING, MAINTENANCE OR SERVICE IS PERFORMED - OR IF THE MACHINE IS OUT OF SERVICE.
- NEVER LEAVE THIS MACHINE RUNNING UNATTENDED.
- MACHINE MUST BE LOCATED IN A WELL-VENTILATED AREA.

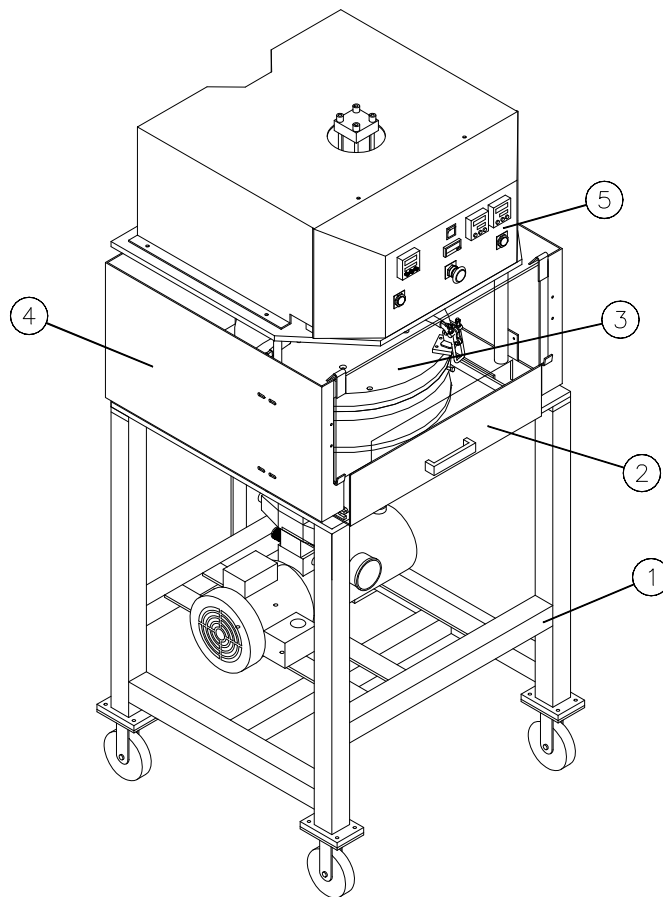
IMPORTANT:

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

MACHINE COMPONENTS & OPERATION

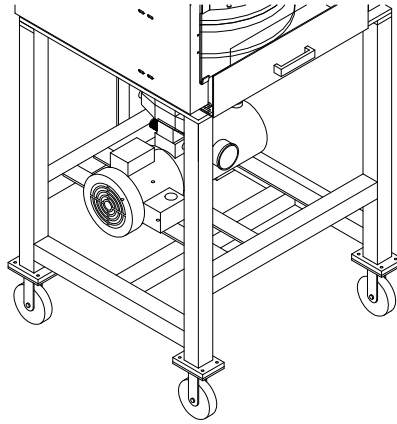
THE HYDRAULIC LITTLE TORO 1800BH PRESS CAN BE BROKEN DOWN INTO 5 GENERAL REGIONS:

1. THE MACHINE FRAME
2. THE TEFLON BELT DRAWER
3. THE PRESS MECHANISM
4. THE PRESS GUARDING
5. THE MACHINE HOOD



SOME OF THESE AREAS (THE PRESS GUARDING, FOR EXAMPLE) ARE SELF-EXPLANATORY AND NEED LITTLE ADDITIONAL DESCRIPTION. OTHERS, HOWEVER, CONTAIN SPECIFIC COMPONENTS THAT THE OPERATOR MUST UNDERSTAND AND UTILIZE ON A REGULAR BASIS. THE FOLLOWING SECTION ILLUSTRATES THESE 5 MACHINE REGIONS AND, IF NECESSARY, GIVES A MORE DETAILED ACCOUNT OF THE COMPONENTS THAT EXIST THERE.

1. THE MACHINE BASE



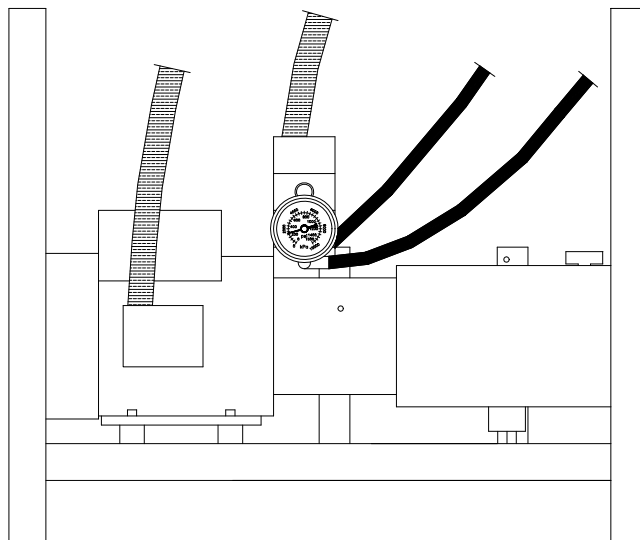
THE FRAME OF THE LITTLE TORO 1800BH HOUSES THE HYDRAULIC TANK AND PRESSURE REGULATOR – AND THE TUBULAR OPEN-FRAME DESIGN ENSURES NATURAL AIR FLOW TO KEEP THE UNIT SUFFICIENTLY COOLED DURING OPERATION. LOCKING CASTERS ON THE BASE ALLOW THE UNIT TO BE MOVED WITH EASE WHEN NECESSARY.

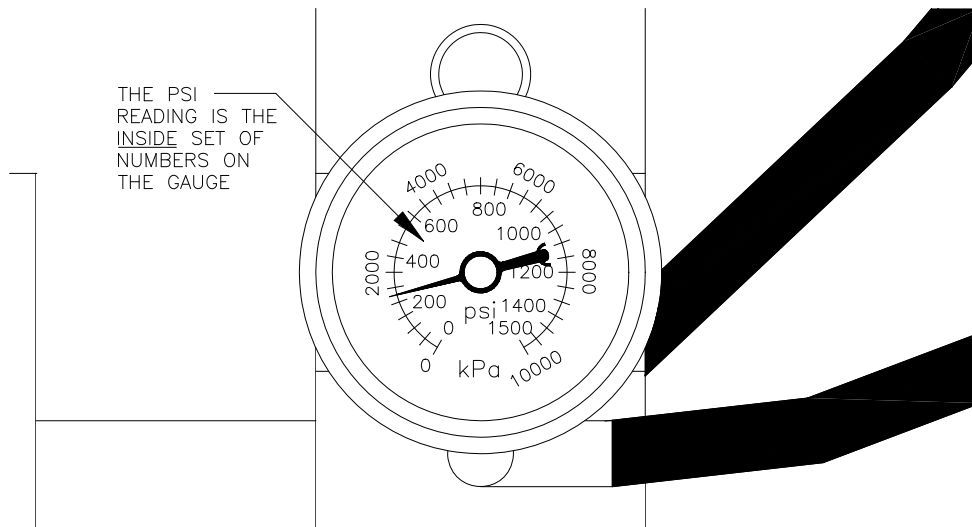


CAUTION

MAKE CERTAIN TO LOCK THE CASTERS IN PLACE ONCE THE MACHINE HAS BEEN ROLLED TO ITS OPERATING POSITION.

ON THE FRONT OF THE HYDRAULIC UNIT IS A GAUGE THAT INDICATES THE AMOUNT OF PRESSURE THE UNIT IS PRODUCING. ALTHOUGH THE DIAL CAN READ UP TO 1,500 PSI, THE DEVICE HAS BEEN PRE-SET SO THE MAXIMUM PRESSURE CANNOT EXCEED 1000.





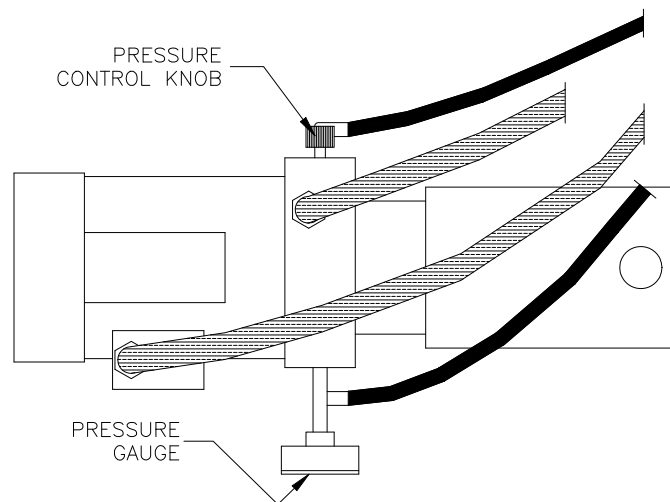
NOTE:

THE GAUGE ONLY INDICATES THE CORRECT PRESSURE WHILE THE DIE IS PRESSING ONTO THE LOWER PLATEN. FOR THIS REASON, THE PRESSURE CAN ONLY BE SET DURING THE PRESS DWELL TIME (SEE THE DWELL TIMER – ITEM D OF THE MACHINE HOOD SECTION).

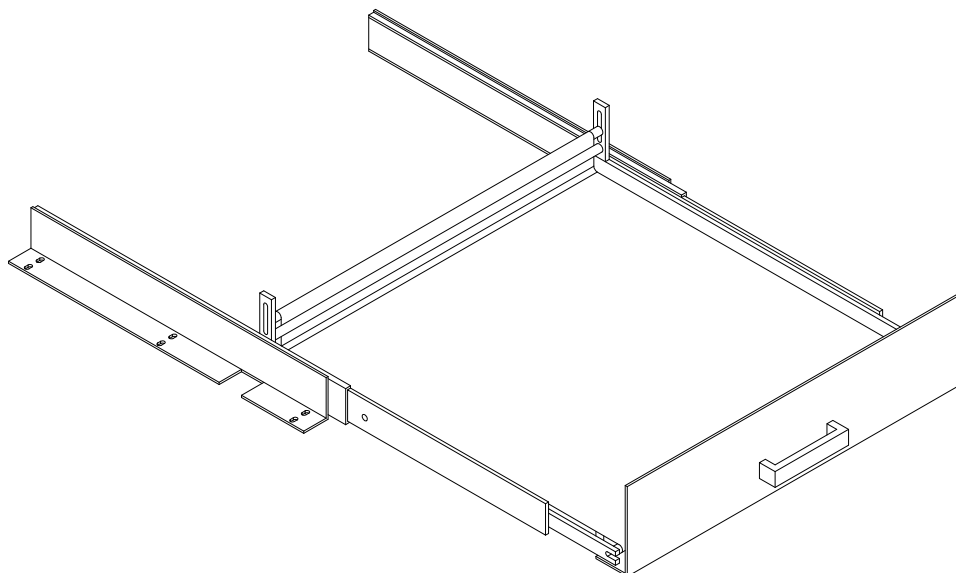
TO SET THE PRESS PRESSURE, FIRST SET THE DWELL TIMER TO 20 SECONDS (THIS WILL ALLOW ENOUGH TIME TO MAKE THE ADJUSTMENT). WITH THE MACHINE ON **AND ALL GUARDING IN PLACE**, DEPRESS THE TWO GREEN START BUTTONS. THIS WILL ACTIVATE THE PRESS MECHANISM. WHEN THE DIE IS ALL THE WAY DOWN AND PRESSING ON THE BELT, THE PRESSURE GAUGE OF THE HYDRAULIC UNIT WILL SHOW THE AMOUNT OF PRESSURE BEING APPLIED.

DIRECTLY BEHIND THE GAUGE IS A BLACK ADJUSTMENT KNOB (SEE BELOW). TURNING THIS KNOB CLOCKWISE INCREASES THE PRESSURE, WHILE COUNTER-CLOCKWISE MOVEMENT DECREASES IT. TURN THE DIAL AS NEEDED – THE GAUGE WILL INDICATE PRESSURE CHANGES INSTANTANEOUSLY.

IF THE 20 SECOND TIME ELAPSES BEFORE THE ADJUSTMENT IS COMPLETED, SIMPLY DEPRESS THE TWO GREEN BUTTONS A SECOND TIME TO BEGIN ANOTHER CYCLE.



2. THE TEFLON BELT DRAWER



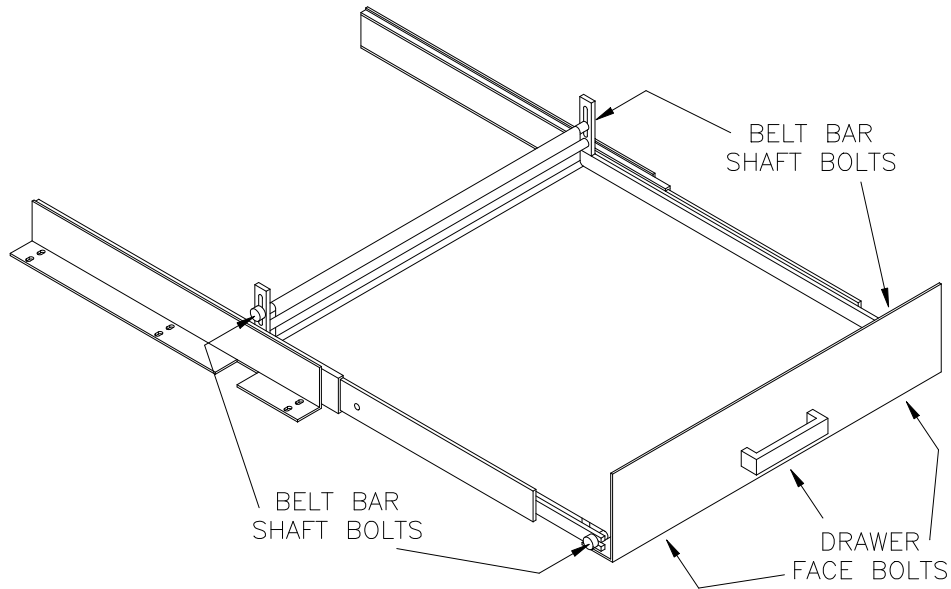
DURING PRODUCTION, THE OPERATOR WILL GRASP THE HANDLE OF THE TEFLON BELT DRAWER AND PULL OUTWARD UNTIL HE OR SHE CAN EASILY REST A DOUGH BALL UPON ITS CENTER. THE DRAWER WILL THEN BE RETURNED TO ITS ORIGINAL POSITION, WHERE THE PRESS MECHANISM WILL DESCEND AND FORM THE DOUGH BALL INTO A CRUST OR TORTILLA. WHEN THE MECHANISM COMPLETES ITS CYCLE, THE OPERATOR WILL ONCE AGAIN OPEN THE DRAWER SO THE CRUST/TORTILLA CAN BE REMOVED (WITH A SPATULA OR OTHER MANUAL DEVICE) AND ANOTHER DOUGH BALL ADDED. THE SURFACE OF THE DRAWER IS A PIECE OF STRETCHED TEFLON BELTING WHICH ENSURES EASY TRANSFER OF THE PRODUCT.



NOTE

AN ELECTRONIC SENSOR AT THE REAR OF THE MACHINE IS TRIGGERED WHEN THE DRAWER IS FULLY CLOSED. IF THE DRAWER IS NOT FULLY CLOSED WHEN THE OPERATOR PUSHES THE PRESS BUTTONS, THE PRESS HEAD WILL NOT DESCEND.

REMOVING & REPLACING THE TEFLON BELT



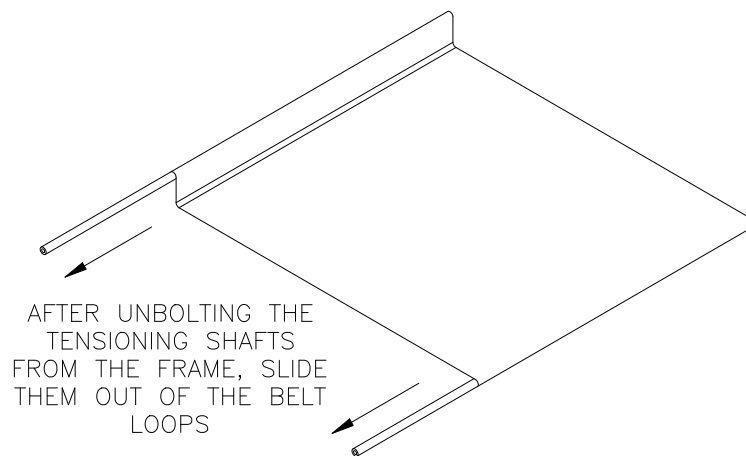
THE TEFLON BELT THAT MAKES UP THE BASE OF THE DRAWER MUST BE CLEANED REGULARLY – AND WILL WEAR OUT OVER TIME. TO REMOVE THE BELT TO CLEAN OR REPLACE IT, FOLLOW THE STEPS LISTED BELOW:



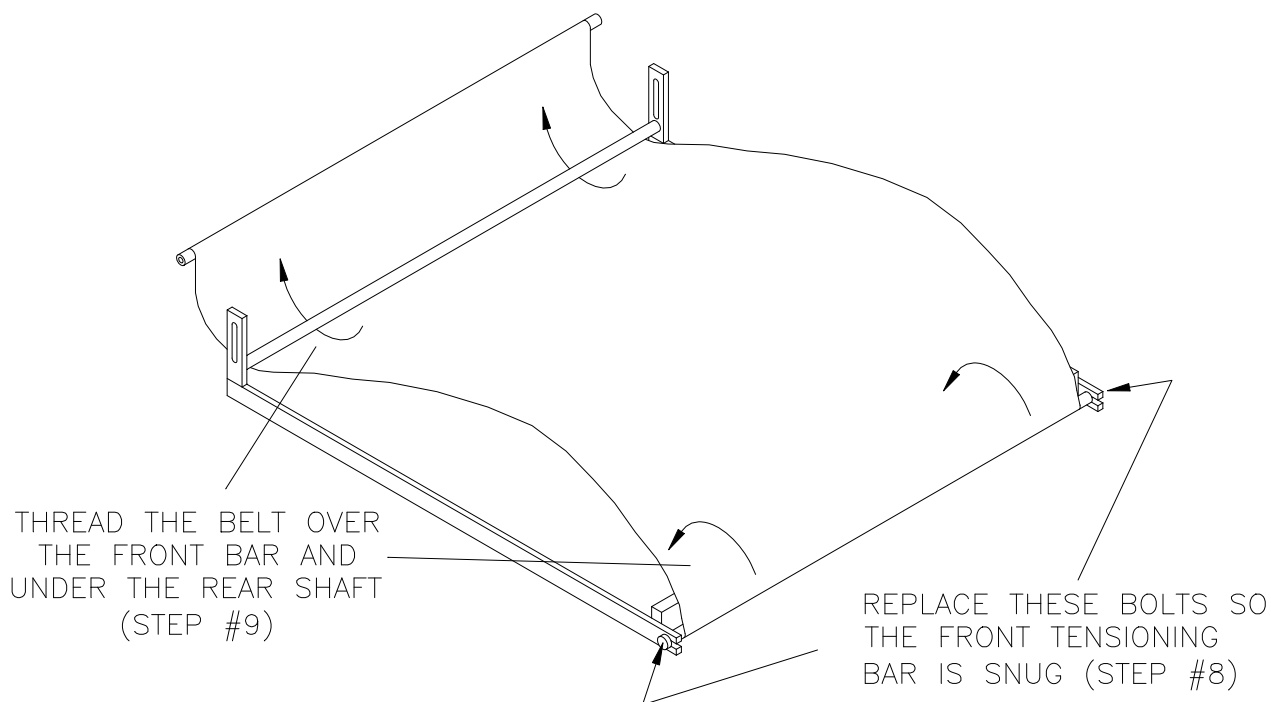
WARNING

MAKE CERTAIN THAT THE POWER SWITCH IS TURNED TO THE **OFF** POSITION, THE MACHINE CORD IS UNPLUGGED FROM THE WALL, AND THE PRESS PLATENS ARE SUFFICIENTLY COOL BEFORE ATTEMPTING TO REMOVE THE DRAWER BELT OF YOUR LITTLE TORO MACHINE.

- 1) LIFT OFF THE PLASTIC GUARD IN FRONT OF THE PRESS AREA AND LAY IT ASIDE.
- 2) USING A 7/16 WRENCH, REMOVE THE THREE BOLTS THAT HOLD THE DRAWER'S FACE PLATE IN POSITION.
- 3) USING THE SAME WRENCH, REMOVE THE TWO BOLTS FROM EACH OF THE TWO BELT TENSIONING SHAFTS. THESE BOLTS HOLD THE DRAWER IN PLACE OVER THE FRAME.

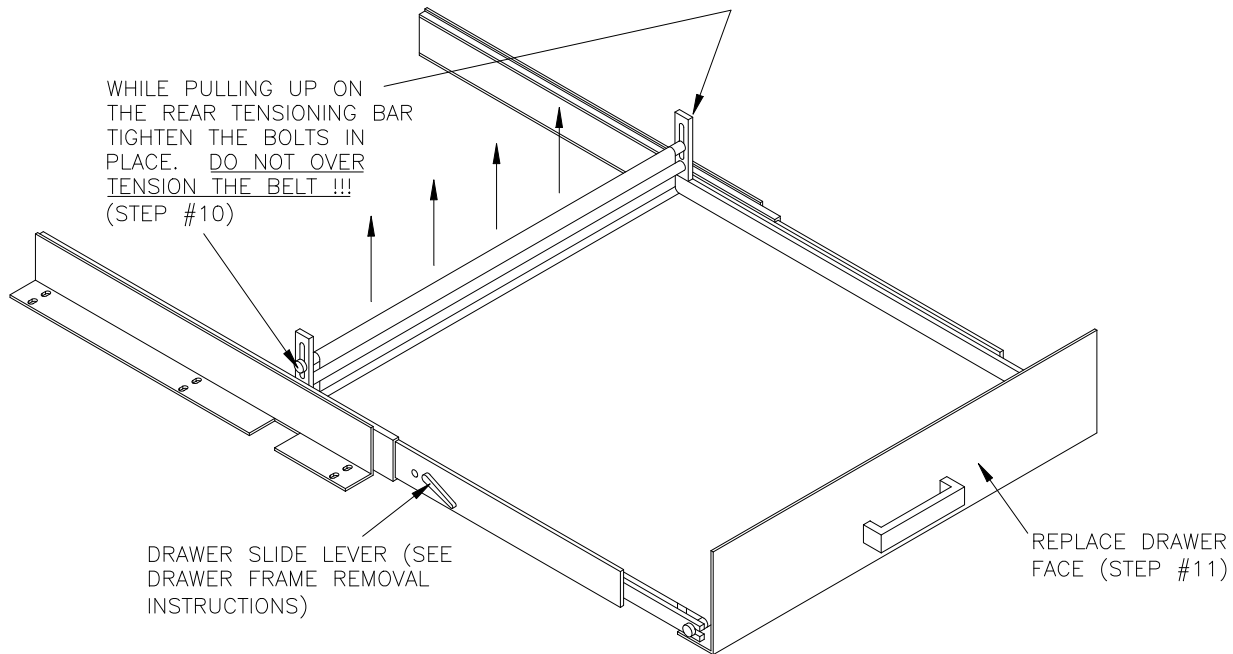


- 4) THE BELT AND BELT TENSIONING SHAFTS CAN NOW BE LIFTED FROM THE DRAWER FRAME. NOW, SIMPLY SLIDE THE SHAFTS FROM THE LOOPS OF THE BELT.
- 5) NOW THAT THE BELT IS FREE, IT CAN BE CLEANED WITH A SOFT SPONGE AND SOAP AND WARM WATER OR A MILD DETERGENT. **DO NOT USE ABRASIVE PADS OR HARSH CHEMICAL CLEASERS !!! THEY WILL DAMAGE THE BELT.**
- 6) BE SURE TO CLEAN THE TENSIONING BARS AND DRAWER FRAME THOROUGHLY BEFORE RE-INSTALLING THE CLEANED (OR NEW) BELT (ABRASIVE PADS AND STRONGER CLEASERS CAN BE USED ON THESE MORE DURABLE PARTS).
- 7) TO REPLACE THE BELT (OR INSTALL A NEW ONE), BEGIN BY SLIDING THE TENSIONING BARS INTO THE BELT LOOPS. THE BARS SHOULD GO ALL THE WAY THROUGH AND HAVE ABOUT 1 ½ INCHES STICKING OUT ON BOTH SIDES.
- 8) INSERT THE BELT AND BARS INTO THE FRAME. USING A 7/16 WRENCH, TIGHTEN THE SCREWS AT THE FRONT OF THE FRAME INTO ONE OF THE TENSIONING BARS UNTIL THEY ARE SNUG.



- 9) THREAD THE BELT OVER THE FRONT SUPPORT BAR AND UNDER THE REAR SHAFT (SEE DIAGRAM ABOVE).
- 10) USE A 7/16 WRENCH TO INSERT THE BOLTS INTO THE REAR TENSIONING BAR. LEAVE THE NUTS LOOSE UNTIL BOTH ARE IN PLACE. THEN, WHILE APPLYING TENSION TO THE BELT, TIGHTEN THE BOLTS FIRMLY IN PLACE. DO NOT OVERTIGHTEN THE BELT. IT SHOULD STILL BE VERY SLIGHTLY SLACK AFTER IT HAS BEEN BOLTED IN POSITION.
- 11) USE THE 7/16 WRENCH TO REPLACE THE FACE PLATE TO THE FRONT OF THE DRAWER.

- 12) SLIDE THE DRAWER BACK INTO POSITION AND REPLACE THE CLEAR PLASTIC GUARD ON THE FRONT OF THE MACHINE.



REMOVAL OF THE DRAWER FRAME

IN THE PREVIOUS SECTION, INSTRUCTIONS WERE GIVEN ON REMOVING THE TEFLON BELT FROM THE DRAWER FRAME. SOME INSTANCES MIGHT ARISE, HOWEVER, WHEN THE OPERATOR DESIRES TO REMOVE THE ENTIRE DRAWER FRAME FROM THE MACHINE.



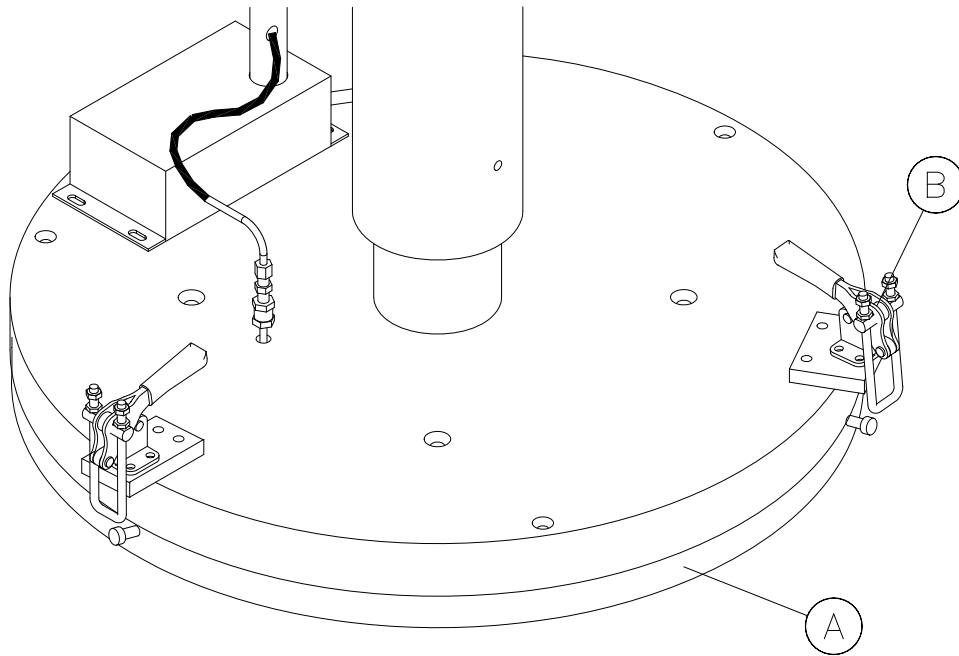
WARNING

MAKE CERTAIN THAT THE POWER SWITCH IS TURNED TO THE OFF POSITION, THE MACHINE CORD IS UNPLUGGED FROM THE WALL, AND THE PRESS PLATENS ARE SUFFICIENTLY COOL BEFORE ATTEMPTING TO REMOVE THE DRAWER FRAME OF YOUR LITTLE TORO MACHINE.

TO REMOVE THE FRAME, FIRST LIFT OFF THE PLASTIC GUARD IN FRONT OF THE PRESS AREA AND LAY IT ASIDE.

THE SLIDES THAT GOVERN THE TRAVEL OF THE DRAWER ARE FITTED WITH RELEASE LEVERS. WHEN THE DRAWER IS FULLY OPEN, THESE LEVERS CAN BE OBSERVED IN THE MIDDLE OF THE SLIDES - POINTED UP ON ONE SLIDE AND DOWN ON THE OTHER. LIGHTLY PULL UP OR DOWN ON THESE LEVERS TO FREE THE SLIDE FROM THE HOLDER. THE ENTIRE DRAWER CAN NOW BE PULLED FROM THE MACHINE. TO REPLACE THE DRAWER, CAREFULLY LINE UP THE TWO SLIDE RAILS AND GENTLY PUSH THE DRAWER BACK INTO PLACE. THE LEVERS WILL RE-ALIGN AUTOMATICALLY WHEN THE DRAWER IS CLOSED. **BE SURE TO REPLACE THE PLASTIC GUARD WHEN FINISHED.**

3. THE PRESS MECHANISM



THE PRESS MECHANISM UTILIZES A HYDRAULIC CYLINDER TO FORCE THE DIE AGAINST THE DOUGH BALL – FORMING IT INTO A CRUST OR TORTILLA. AFTER THE PRESS IS COMPLETED, THE CYLINDER THEN RAISES THE DIE SAFELY OUT OF THE WAY SO THE CRUST CAN BE REMOVED AND A NEW DOUGH BALL PUT IN ITS PLACE. SEVERAL COMPONENTS MAKE UP THE COMPLETE PRESS MECHANISM – BUT ONLY TWO ARE USED BY THE OPERATOR ON A REGULAR BASIS.

A. THE PRESS DIE

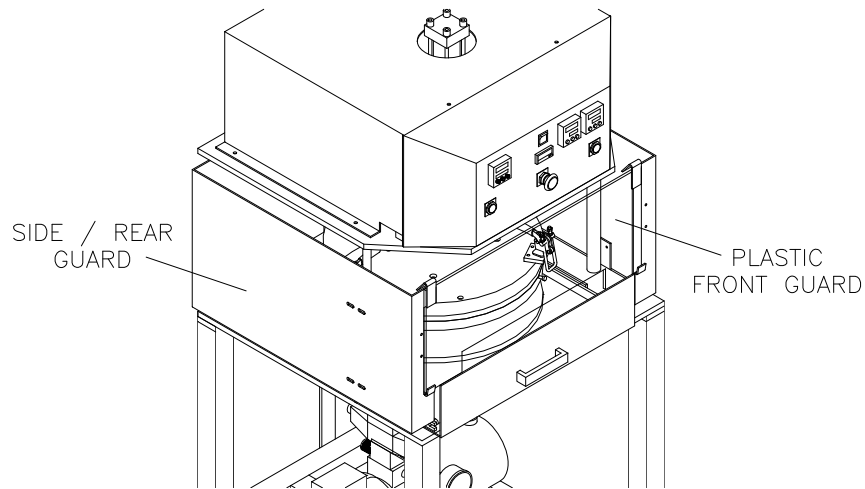
THE DIE IS THE ITEM THAT ACTUALLY TOUCHES THE DOUGH DURING PRODUCTION. CUSTOM-MACHINED TO ACCOMMODATE THE CUSTOMER'S DESIRES AND COATED TO ENSURE THAT EVEN SOFT DOUGHS WILL RELEASE EASILY, THE DIE - WITH PROPER CARE AND MAINTENANCE – WILL PRODUCE CONSISTENT, QUALITY PRODUCT TIME AFTER TIME.

B. QUICK-RELEASE CLAMPS

THE PRESS DIE IS CLAMPED AGAINST THE MACHINE'S HEATING ELEMENT BY A SET OF THREE QUICK-RELEASE CLAMPS. AFTER ALLOWING THE MACHINE TO COOL, THE DIE PLATE CAN BE EASILY REMOVED SIMPLY BY PULLING UP ON THE RED HANDLES OF THESE DEVICES – THEN LIFT THE U-BOLTS OF THE CLAMPS FROM THE BOLTS ON THE DIE PLATE. ONCE REMOVED, THE DIE CAN BE RE-INSTALLED (OR REPLACED BY A SECOND DIE) JUST AS EASILY.

(FOR COMPLETE DIE REMOVAL / REPLACEMENT INSTRUCTIONS, SEE PAGES 20 & 21 OF THIS MANUAL)

4. THE PRESS GUARDING



TO ENSURE THE SAFETY OF THE OPERATOR DURING PRODUCTION, THE PRESS AREA HAS BEEN SURROUNDED WITH GUARDING. THE SIDE / REAR GUARD IS MADE OF POLISHED STAINLESS STEEL AND IS SECURELY FASTENED WITH 10 BOLTS.

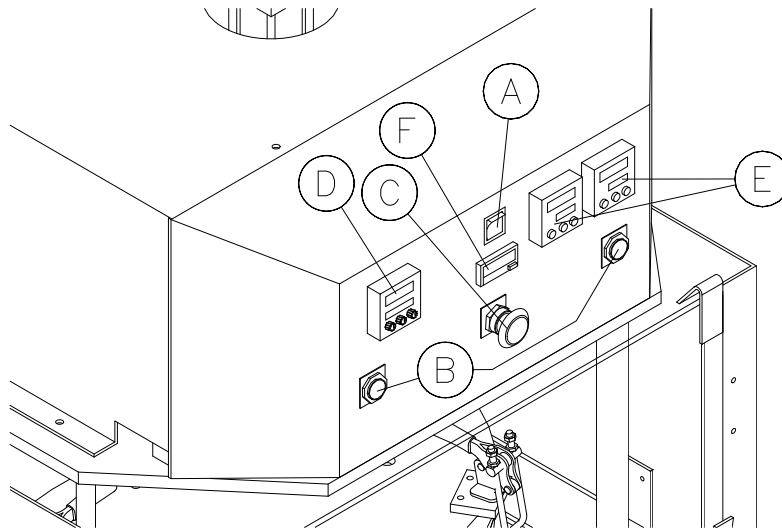
IN ORDER TO MAKE CLEANING AND MAINTENANCE MORE CONVENIENT, THE FRONT PLASTIC GUARD CAN BE REMOVED BY MERELY LIFTING IT UP AND OUT OF THE WAY. IN ORDER TO MAKE CERTAIN THE GUARD IS NOT IMPROPERLY REMOVED OR DISCARDED, IT HAS BEEN FITTED WITH A POSITION SENSOR THAT MUST ALIGN WITH A MATING PIECE ON THE SIDE/REAR GUARD. THE MACHINE WILL NOT FUNCTION UNLESS BOTH GUARDS ARE PROPERLY IN PLACE.



WARNING:

NEVER ATTEMPT TO OPERATE YOUR LITTLE TORO 1800BH PRESS BEFORE MAKING CERTAIN THAT THESE GUARDS ARE IN PLACE. IF YOU HAVE ANY QUESTION ABOUT THE PROPER ALIGNMENT OR POSITION OF ANY GUARD, CONTACT AM MANUFACTURING AT 800-342-6744.

5. THE MACHINE HOOD



IN ADDITION TO HOUSING THE HYDRULIC PRESS CYLINDER AND ELECTRICAL COMPONENTS, THE PRESS HOOD ALSO CONTAINS MANY DEVICES THAT ACTIVATE OR CONTROL MACHINE PERFORMANCE. THE SPECIFIC FUNCTIONS OF EACH OF THESE DEVICES ARE EXPLAINED BELOW:

A. THE ON / OFF SWITCH

AFTER THE POWER CORD HAS BEEN PLUGGED INTO AN APPROVED ELECTRICAL OUTLET, THE MACHINE'S POWER IS ACTIVATED BY PRESSING THIS SWITCH TO THE *ON* POSITION (UPWARD). THE ENTIRE SWITCH ILLUMINATES WHEN POWER IS ACTIVATED, SO A SIMPLE GLANCE LET'S THE OPERATOR KNOW WHETHER THE MACHINE IS *ON* OR *OFF*. TO DE-ACTIVATE THE MACHINE'S POWER, SIMPLY FLIP THE SWITCH DOWNWARD TO ITS *OFF* POSITION.



WARNING

IF AN EMERGENCY SITUATION EXISTS AND SOMETHING BECOMES TRAPPED BENEATH THE DIE WHILE THE MACHINE IS PRESSING, **DO NOT DE-ACTIVATE THE MACHINE'S POWER!** DOING SO WILL "FREEZE" THE DIE IN POSITION AND THE OBJECT BENEATH THE DIE WILL REMAIN TRAPPED. INSTEAD, DEPRESS THE *EMERGENCY RAISE* BUTTON (SEE *ITEM C* OF THIS SECTION) AND THE PLATEN WILL IMMEDIATELY RISE SAFELY OUT OF THE WAY.

B. THE PLATEN START BUTTONS

DURING PRODUCTION, THE PRESS MECHANISM IS ACTIVATED BY DEPRESSING THESE BUTTONS SIMULTANEOUSLY. WHEN BOTH BUTTONS ARE DEPRESSED, THE HYDRAULIC PRESS MECHANISM WILL BE ACTIVATED AND PRESS THE DIE AGAINST THE DOUGH BALL ATOP THE LOWER PLATEN. AS SOON AS THE DIE BEGINS ITS DESCENT, THE PRESS *DWELL TIMER* (SEE *ITEM D* OF THIS SECTION) WILL BEGIN COUNTING.

C. THE EMERGENCY RAISE BUTTON

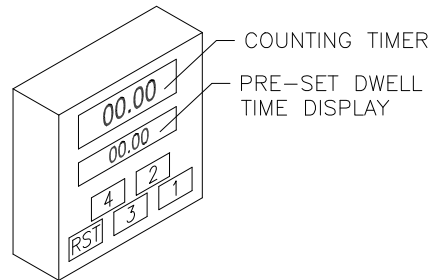
TO ENSURE OPERATOR SAFETY AND TO PROTECT THE PRESS DIE AND OTHER MACHINE COMPONENTS, THE PRESS AREA HAS BEEN SHIELDED WITH GUARDING. IN THE EVENT THAT SOME OBJECT SHOULD SOMEHOW GET PASSED THIS GUARDING AND BECOME TRAPPED BENEATH THE DIE, HOWEVER, THIS EMERGENCY DEVICE HAS BEEN ADDED TO IMMEDIATELY RAISE THE PRESS TO A SAFE LOCATION.



WARNING

IF AN EMERGENCY CONDITION EXISTS AND SOMETHING BECOMES TRAPPED BENEATH THE DIE, **PRESS THIS RED BUTTON TO RAISE THE DIE SAFELY OUT OF THE WAY. DO NOT DE-ACTIVATE THE MACHINE'S POWER. DOING SO WILL "FREEZE" THE PLATEN IN POSTION AND THE OBJECT WILL REMAIN TRAPPED.**

D. THE DWELL TIMER



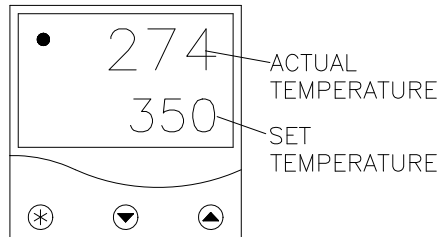
WHEN THE OPERATOR DEPRESSES THE TWO *PLATEN START BUTTONS* (ITEM B OF THIS SECTION), THE PRESS DIE WILL DESCEND UNTIL IT IS APPLYING THE AMOUNT OF PRESSURE SET BY THE OPERATOR (SEE *PART 1 – THE MACHINE BASE* FOR MORE INFORMATION) TO THE DOUGH BALL - OR UNTIL IT HAS EXTENDED TO THE END OF ITS STROKE. WHEN THIS CONDITION IS REACHED, THE DIE WILL CONTINUE PRESSING FOR A PRE-SET TIME TO ALLOW THE CRUST OR TORTILLA TO FULLY FORM. THE DURATION OF THAT "DWELL TIME" IS SET ON THIS DEVICE. TO SET THE DWELL TIMER, USE THE 4 BUTTONS (LABELED 1, 2, 3, AND 4) BENEATH THE NUMERICAL DISPLAY. PRESSING THE "1" BUTTON ONCE INCREASES THE SET TIME BY ONE TENTH OF A SECOND. PRESSING IT AGAIN, INCREASES IT BY ANOTHER TENTH – AND SO ON UNTIL IT RESETS BACK TO ZERO AFTER BEING PRESSED TEN TIMES. SIMILARLY, PRESSING THE 2 BUTTON WILL INCREASE THE SINGLE SECONDS DIGIT, AND THE NUMBER 3 BUTTON THE TENS OF SECONDS DIGIT.

SO, IF THE NUMBER 3 BUTTON WAS PRESSED ONCE, THE NUMBER 2 BUTTON THREE TIMES AND THE NUMBER 1 BUTTON FIVE TIMES, THE TOTAL DWELL TIME WOULD BE: (1 X 10 SECONDS) + (3 X 1 SECOND) + (5 X 0.1 SECONDS) – OR 13.5 SECONDS.

NOTE: THE DWELL TIME SHOULD NEVER EXCEED 20 SECONDS, SO THE NUMBER 4 BUTTON (WHICH SETS 100 SECOND INCREMENTS) SHOULD NEVER BE USED.

AS SOON AS BOTH START BUTTONS HAVE BEEN PUSHED AND THE DIE BEGINS ITS DOWNWARD TRAVEL, AN ELECTRONIC CLOCK WILL COUNT UPWARDS FROM ZERO. WHEN THE VALUE OF THIS CLOCK MATCHES THE PRE-SET VALUE SET ON THE DIALS, THE DWELL HAS FINISHED – THE CYLINDER RE-ACTIVATES AND RAISES THE DIE BACK TO ITS *UP* POSITION.

E. THE THERMOSTAT



THE LITTLE TORO 1800BH PRESS HAS UPPER AND LOWER HEATING PLATES THAT CAN BE SET UP TO 450° FAHRENHEIT (232° CENTIGRADE). THE TEMPERATURES ARE SET BY THE OPERATOR ON THESE THERMOSTATS – AND REGULATED BY PRECISION THERMOCOUPLES THAT MEASURE THE TEMPERATURE OF THE FORMING PLATES.

TO SET THE PRESS TEMPERATURE, DEPRESS THE * BUTTON ON THE FAR LEFT. THEN, *WHILE HOLDING THIS BUTTON*, DEPRESS EITHER THE ↑ OR ↓ BUTTON TO RAISE OR LOWER THE TEMPERATURE RESPECTIVELY. THE HEATING ELEMENTS WILL EITHER ACTIVATE OR DE-ACTIVATE TO ADJUST TO THE NEW SET TEMPERATURE – AND THE ACTUAL TEMPERATURE READING WILL SLOWLY CHANGE UNTIL THE SET TEMPERATURE IS MET.

F. THE CRUST COUNTER

TO ASSIST THE OPERATOR IN KEEPING TRACK OF PRODUCTION RATES – AND TO ALERT PERSONNEL OF MAINTENANCE REQUIREMENTS - THE LITTLE TORO HAS BEEN EQUIPPED WITH AN ELECTRONIC COUNTER. THIS COUNTER REGISTERS EVERY DOWNSTROKE MADE BY THE PRESS MECHANISM, AS SOON AS BOTH START BUTTONS ARE DEPRESSED AND THE PRESS BEGINS ITS DESCENT, THE NUMBER SHOWN ON THE LCD SCREEN WILL INCREASE BY ONE.



NOTE

THE CRUST COUNTER IS EQUIPPED WITH A *RESET* BUTTON. TO KEEP AN ACCURATE NUMBER OF TOTAL PRESSES FOR THE LIFE OF THE MACHINE, HOWEVER, AM MANUFACTURING INCAPACITATES THIS RESET FUNCTION BEFORE SHIPPING EACH MACHINE.

INITIAL CURING OF THE PRESS DIE

AFTER THE MACHINE HAS BEEN INSTALLED, IT IS IMPORTANT THAT THE PRESS DIE BE PROPERLY BROKEN IN BEFORE BEGINNING GENERAL PRODUCTION. THIS PROCESS – CALLED DIE “CURING” – ENSURES THAT ANY MICROSCOPIC PORES ON THE DIE FACE ARE FILLED – THUS PREVENTING ANY POSSIBILITY OF POOR PRODUCT RELEASE. TO CURE THE DIE, FOLLOW THE INSTRUCTIONS BELOW.

- 1) AFTER MAKING CERTAIN THAT THE PRESS AREA GUARDS ARE SECURELY IN PLACE, PLUG THE MACHINE’S POWER CORD INTO AN APPROVED ELECTRICAL OUTLET.
- 2) ACTIVATE THE MACHINE’S POWER BY DEPRESSING THE RED *ON/OFF SWITCH (ITEM 5A OF THE MACHINE COMPONENTS SECTION)* UPWARD. WHEN ACTIVATED, THIS SWITCH WILL ILLUMINATE.
- 3) SET THE TEMPERATURES OF BOTH THE UPPER AND LOWER PRESS PLATENS (*ITEM 5E OF THE MACHINE COMPONENTS SECTION*) TO 250 °F AND ALLOW THE PRESS TO HEAT UP TO THAT TEMPERATURE.
- 4) WHILE THE MACHINE IS HEATING UP, SET THE DWELL TIMER (*ITEM 5D OF THE MACHINE COMPONENTS SECTION*) TO 5 SECONDS AND THE PRESSURE REGULATOR (*SEE PART 1 OF THE COMPONENTS SECTION*) TO 300 PSI.
- 5) ONCE THE MACHINE TEMPERATURE HAS REACHED 250 DEGREES, PULL THE DRAWER OUT FROM UNDER THE PRESS AREA AND PLACE A GENEROUS COATING OF VEGETABLE OIL ACROSS THE TEFLON BELT (AT LEAST WHERE THE DIE AND RING WILL IMPACT IT).
- 6) CLOSE THE DRAWER TO THE PRESSING POSITION AND DEPRESS THE TWO GREEN *START* BUTTONS. THE HYDRAULIC CYLINDER WILL ACTIVATE AND THE DIE WILL DESCEND TO THE LOWER PLATEN.



NOTE:

IF THE DRAWER IS NOT PUSHED IN ALL THE WAY, THE CYLINDER WILL NOT ACTIVATE.

- 7) AFTER 5 SECONDS, THE PRESS DIE WILL RETURN TO ITS “UP” POSITION. WHEN IT HAS COMPLETED ITS TRAVEL, PULL THE DRAWER OUT AGAIN AND COAT ITS SURFACE WITH ANOTHER LAYER OF OIL.
- 8) CLOSE THE DRAWER TO THE PRESSING POSITION AND PRESS THE OILED BELT A SECOND TIME.
- 9) REPEAT THIS PROCEDURE OF OIL COATING AND PRESSING ANOTHER 4 TIMES.
- 10) COVER 10 DOUGH BALLS WITH A GENEROUS SUPPLY OF OIL. TAKE ONE OF THE BALLS AND PLACE IT ON THE CENTER OF THE TEFLON BELT ON THE DRAWER.
- 11) RETURN THE DRAWER TO THE PRESS AREA AND PRESS THE BALL INTO A CRUST OR TORTILLA (DO NOT WORRY IF THE CRUST IS NOT FORMED ACCORDING TO YOUR SPECIFICATIONS – THESE 10 DOUGH BALLS ONLY SERVE TO CURE THE DIE.
- 12) PRESS TWO MORE WELL-OILED DOUGH BALLS INTO CRUSTS – FOLLOWING THE SAME PROCEDURES.
- 13) INCREASE THE TEMPERATURE TO 350 °F AND PRESS OUT THREE MORE DOUGH BALLS. THEN, INCREASE THE TEMPERATURE AGAIN TO 450 °F AND PRESS THE FINAL FOUR.

Your die is now ready for general production.

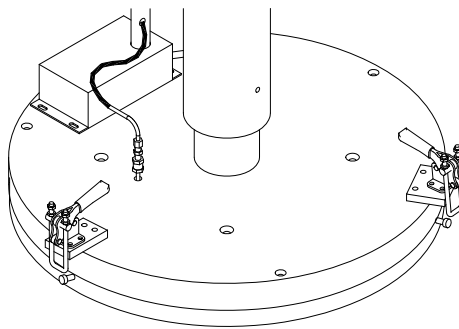
DIE CLEANING



MACHINE DIES SHOULD BE CLEANED ONCE A WEEK USING SOAP AND WATER OR A MILD CAUSTIC AGENT. DO NOT USE A SCRAPER, ABRASIVE PADS, OR HARSH CHEMICALS TO CLEAN THE DIES.

- 1) STOP MACHINE AND DISCONNECT POWER.
- 2) ALLOW THE DIE SET TO COOL TO A WORKABLE TEMPERATURE.
- 3) FOLLOW THE INSTRUCTIONS BELOW FOR PROPER REMOVAL OF THE DIE PLATE.
- 4) USING AN APPROVED DIE CLEANING AGENT, WIPE OR PRESSURE WASH THE DIE SET. DO NOT USE A SCRAPER OR AN ABRASIVE PAD TO CLEAN THE DIES OR THE DIE RINGS AS HARSH SCRUBBING MAY SCRATCH OR CHIP THE COATING FROM THE DIE (OR RING) SURFACE.
- 5) MAKE CERTAIN ALL CLEANING AGENTS ARE COMPLETELY RINSED FROM THE DIE SET. ALLOW THE SET TO DRY OR DRY THE SET WITH A TOWEL OR AIR HOSE.
- 6) RE-INSTALL THE DIE PLATE ACCORDING TO THE INSTRUCTIONS ON THE FOLLOWING PAGE.

REMOVAL OF THE DIE PLATE



THE RED-HANDLED “QUICK RELEASE” CLAMPS OF THE LITTLE TORO ALLOW THE OPERATOR TO REMOVE THE PRESS DIE PLATE SWIFTLY AND EASILY ACCORDING TO THE FOLLOWING PROCEDURE.



WARNING

MAKE CERTAIN THAT THE POWER SWITCH IS TURNED TO THE OFF POSITION, THE MACHINE CORD IS UNPLUGGED FROM THE WALL, AND THE PRESS PLATENS ARE SUFFICIENTLY COOL BEFORE PERFORMING ANY MAINTENANCE PROCEDURES.

- 1) IF THE MACHINE HAS BEEN OPERATING, SET THE UPPER AND LOWER HEATER CONTROLLERS TO 70°F AND ALLOW THE PRESS DIE TO COOL SO THE OPERATOR CAN HOLD IT IN HIS HANDS COMFORTABLY.
- 2) MAKE CERTAIN THE MACHINE IS TURNED ON, ALL GUARDING IS IN PLACE, AND ALL FUNCTIONS ARE WORKING PROPERLY.
- 3) WITH THE DRAWER CLOSED, PRESS THE TWO GREEN START BUTTONS, TO INITIATE MOVEMENT OF THE PRESS MECHANISM. WHEN THE DIE HAS DESCENDED TO ABOUT ½ INCH ABOVE THE DRAWER’S BELT SURFACE, TURN THE MACHINE’S POWER SWITCH TO THE OFF POSITION. THE DIE WILL REMAIN IN POSITION JUST ABOVE THE BELT.
- 4) UNPLUG THE POWER CORD FROM THE WALL TO ENSURE OPERATOR SAFETY WHILE WORKING IN THE PRESS AREA.
- 5) LIFT THE PLASTIC GUARD OFF THE FRONT OF THE MACHINE. THEN, LIFT THE 3 RED-HANDLES OF THE CLAMPS HOLDING THE DIE PLATE IN POSITION. THE DIE WILL DESCEND AND REST ON THE SURFACE OF THE BELT.

- 6) REMOVE THE U-LATCHES FROM THE BOLTS ON THE DIE PLATE.
- 7) AFTER MAKING CERTAIN THAT THE LATCHES ARE CLEAR OF THE BOLTS, REPLACE THE FRONT PLASTIC GUARD, PLUG THE MACHINE'S POWER CORD BACK IN AND FLIP THE POWER SWITCH BACK TO THE *ON* POSITION. UPON DOING SO, THE PRESS MECHANISM WILL RISE – LEAVING THE DIE RESTING ON THE BELT.
- 8) FLIP THE POWER SWITCH BACK TO THE *OFF* POSITION. ONCE AGAIN, UNPLUG THE CORD FROM THE WALL TO ENSURE OPERATOR SAFETY.
- 9) LIFT THE PLASTIC GUARD OFF THE FRONT OF THE MACHINE AND SLOWLY PULL THE DRAWER HALFWAY OUT. THE DIE WILL MOVE WITH THE DRAWER – BUT **DO NOT PULL THE DRAWER OUT SO FAR THAT IT LOSES CONTACT WITH THE LOWER PLATEN SURFACE!**
- 10) ONCE YOU HAVE PULLED THE DIE TO AN ACCESSIBLE POSITION, LIFT IT FREE OF THE MACHINE.

REPLACEMENT OF THE DIE PLATE

THE FOLLOWING INSTRUCTIONS EXPLAIN THE INSTALLING OF NEW DIE PLATE – OR REPLACING A PLATE THAT WAS RECENTLY REMOVED FOR CLEANING AND/OR MAINTENANCE.



WARNING

MAKE CERTAIN THAT THE POWER SWITCH IS TURNED TO THE OFF POSITION, THE MACHINE CORD IS UNPLUGGED FROM THE WALL, AND THE PRESS PLATENS ARE SUFFICIENTLY COOL BEFORE PERFORMING ANY MAINTENANCE PROCEDURES.

- 1) WITH THE MACHINE OFF, CORD UNPLUGGED FROM THE WALL AND FRONT PLASTIC GUARD REMOVED, PUSH THE DRAWER IN ABOUT HALFWAY. THEN, REST THE DIE ON THE SURFACE OF THE BELT SO ITS WEIGHT IS SUPPORTED BY THE LOWER PLATEN.
- 2) PUSH THE DRAWER ALL THE WAY IN SO THE DIE RESTS DIRECTLY UNDER THE PRESS. ROTATE THE DIE SO THE BOLTS IN THE DIE PLATE LINE-UP WITH THE RED-HANDLED CLAMPING DEVICES.
- 3) REPLACE THE FRONT PLASTIC GUARD, PLUG THE CORD INTO THE WALL, AND TURN THE POWER SWITCH TO THE *ON* POSITION.
- 4) AFTER MAKING CERTAIN THAT THE LATCHES OF THE RED-HANDLED CLAMPS ARE SAFELY OUT OF THE WAY, DEPRESS THE TWO GREEN START BUTTONS, TO INITIATE MOVEMENT OF THE PRESS MECHANISM. WHEN THE DIE HAS DESCENDED TO ABOUT ½ INCH ABOVE THE DIE PLATE, TURN THE MACHINE'S POWER SWITCH TO THE *OFF* POSITION. THE PRESS MECHANISM WILL FREEZE IN POSITION ABOVE THE DIE PLATE.
- 5) UNPLUG THE POWER CORD FROM THE WALL TO ENSURE OPERATOR SAFETY WHILE WORKING IN THE PRESS AREA. REMOVE THE PLASTIC GUARD OFF THE FRONT OF THE MACHINE.
- 6) SECURE THE LATCHES OF THE RED-HANDLED CLAMPS AROUND THE THREE BOLTS OF THE DIE PLATE. AFTER PLACING ALL THREE LATCHES AROUND THE BOLTS, SNAP THE LATCHES CLOSED – THUS LOCKING THE PLATE IN PLACE.
- 7) AFTER MAKING CERTAIN THAT ALL THREE LATCHES ARE SECURE, REPLACE THE FRONT PLASTIC GUARD, PLUG THE MACHINE'S POWER CORD BACK IN, AND FLIP THE POWER SWITCH BACK TO THE *ON* POSITION. UPON DOING SO, THE PRESS MECHANISM WILL RISE – LIFTING THE DIE FROM THE DRAWER SURFACE.

GUIDELINES FOR GENERAL PRODUCTION

ONCE THE DIE HAS BEEN BROKEN IN, IT WILL – IF PROPERLY CLEANED AND MAINTAINED – PROVIDE YEARS OF TROUBLE-FREE USAGE. IN ORDER TO UTILIZE IT FOR YOUR PARTICULAR OPERATION HOWEVER, THE CORRECT MACHINE SETTINGS MUST BE FOUND.

THE CRUST OR TORTILLA THAT IS FORMED BY THE LITTLE TORO IS INFLUENCED BY THE DIE AND LOWER PLATEN TEMPERATURES THAT PRESS IT AS WELL AS THE PRESSURE AND DURATION OF THAT PRESS. TO OPTIMIZE THESE SETTINGS FOR YOUR PRODUCT, IT WILL BE NECESSARY TO SET TIME ASIDE FOR EXPERIMENTATION. A GOOD STARTING POINT FOR PIZZA CRUSTS IS A 6 SECOND DWELL TIME WITH THE LOWER PLATEN AT 325 °F, THE UPPER PRESS PLATE AT 275 °F, AND THE PRESSURE SWITCH SET AT 400 PSI. A SUGGESTED STARTING POINT FOR TORTILLAS IS A 2.5 SECOND DWELL TIME WITH THE LOWER PLATEN SET AT 375 °F, THE PRESS PLATE AT 325 °F, AND THE PRESSURE DIAL SET AT 400 PSI. BEYOND THAT, THIS MANUAL CAN ONLY OFFER THE FOLLOWING GENERAL GUIDELINES:

- INCREASING THE PRESS TEMPERATURES CAUSES A MORE DEFINED “SKIN” ATOP THE CRUST OR TORTILLA. A GREATER PERCENTAGE OF ACTIVE INGREDIENTS WILL BECOME INACTIVE, BUT THE SHAPE OF THE CRUST WILL BE MORE CONSISTENT. THE AMOUNT OF SHRINKAGE OR “SNAP BACK” THAT OCCURS AFTER THE PRESS IS COMPLETED WILL ALSO BE DECREASED.
- DECREASING THE PRESS TEMPERATURE PRODUCES A LESS DEFINED SHAPE – BUT A GREATER PERCENTAGE OF ACTIVE INGREDIENTS IN THE DOUGH REMAIN ACTIVE. THE “SNAP BACK,” WILL BE INCREASED.
- INCREASING THE PRESS DWELL TIME DECREASES THE OVERALL RATE OF PRODUCTION OF THE MACHINE, BUT IT PRODUCES THE SAME EFFECTS OF RAISING THE PRESS TEMPERATURE WITH LESS DRASTIC SEARING OF THE DOUGH’S SURFACE.
- DECREASING THE PRESS DWELL TIME WILL INCREASE THE MACHINE’S RATE OF PRODUCTION, BUT THE CRUST WILL HAVE A GREATER TENDENCY TO “SNAP BACK” AND WILL BE LESS DEFINED.
- INCREASING THE PRESSURE THE PRESS MECHANISM APPLIES WILL HELP FILL THE DOUGH CAVITY (IF THE REMAINS UNFILLED WHEN THE PRESSURE IS SET TO 100%, A LONGER DWELL TIME AND/OR LARGER DOUGH BALL MUST BE USED), BUT A GREATER PERCENTAGE OF ACTIVE GASES WITHIN THE DOUGH BALL WILL BE RELEASED. “SNAP BACK” WILL BE REDUCED.
- DECREASING THE PRESS PRESSURE WILL DECREASE THE PERCENTAGE OF GASES LOST, BUT THERE WILL BE GREATER “SNAP BACK” – AND IF THE PRESSURE IS TOO LOW, THE CRUST WILL NOT FULLY FORM.

ONCE THE PROPER TEMPERATURE, PRESSURE, AND DWELL SETTINGS ARE FOUND, CRUSTS CAN BE MADE CONTINUOUSLY – DAY AFTER DAY – FOLLOWING THE SAME BASIC PRESSING PROCEDURES DESCRIBED IN THE DIE CURING SECTION (THE AMOUNT OF OIL PLACED ON EACH DOUGH BALL CAN BE SIGNIFICANTLY REDUCED).

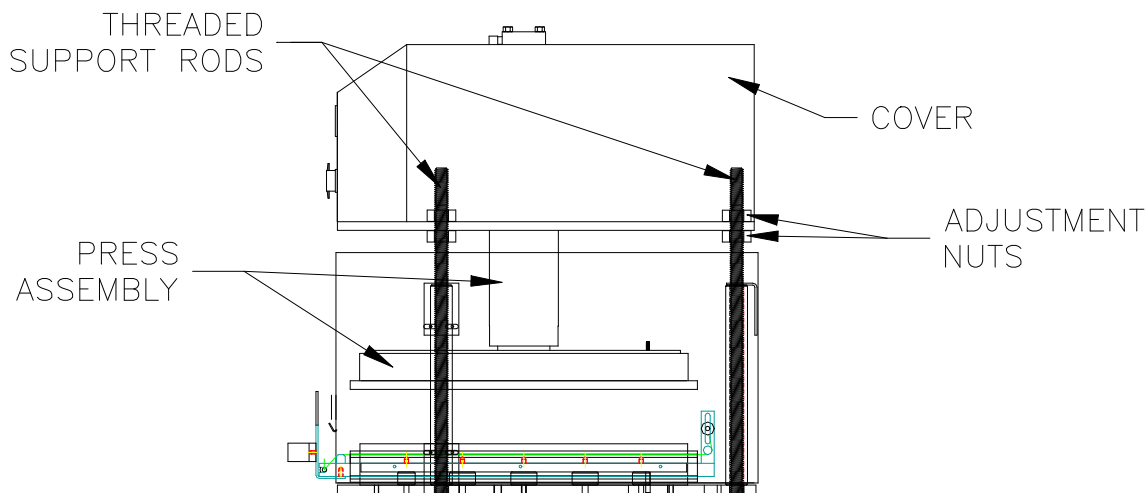
RAISING OF THE LITTLE TORO PRESS ASSEMBLY

YOUR LITTLE TORO WAS ADJUSTED SO THE UPPER PRESS PLATE WOULD DESCEND ALL THE WAY DOWN DURING PRESSING. IN SOME INSTANCES, HOWEVER, IT MAY BE NECESSARY TO RAISE THE PRESS ASSEMBLY SO THE UPPER PLATE WILL STOP BEFORE IT REACHES THE BOTTOM.



WARNING

MAKE CERTAIN THAT THE POWER SWITCH IS TURNED TO THE OFF POSITION, THE MACHINE CORD IS UNPLUGGED FROM THE WALL, AND THE PRESS PLATENS ARE SUFFICIENTLY COOL BEFORE ATTEMPTING TO RAISE THE PRESS ASSEMBLY OF YOUR LITTLE TORO DEVICE.



PERFORM THE FOLLOWING STEPS TO RAISE THE PRESS ASSEMBLY:

- 1) TURN THE MACHINE OFF AND REMOVE THE POWER CORD FROM THE ELECTRICAL OUTLET.**
- 2) REMOVE THE COVER FROM THE TOP OF THE MACHINE. LIFT OFF THE CLEAR PLASTIC GUARD FROM THE FRONT OF THE MACHINE.
- 3) THE PRESS ASSEMBLY IS SUPPORTED BY THREE THREADED SUPPORT RODS. TO RAISE THE ASSEMBLY, FIRST LOOSEN THE NUTS ON TOP OF THE UPPER SUPPORT PLATE, THEN RAISE THE NUTS BENEATH THE PLATE. THE NUTS WILL LIFT THE PLATE AS THEY ARE RAISED.

- 4) AS YOU RAISE THE UPPER SUPPORT PLATE, THE PRESS PLATEN WILL BE LIFTED FROM THE LOWER PLATE. CONTINUE TO RAISE THE PRESS UNTIL THE DISTANCE BETWEEN THE PLATENS IS THE THICKNESS YOU DESIRE YOUR CRUST TO BE.
- 5) WHEN YOU HAVE FINISHED RAISING THE ASSEMBLY, MAKE CERTAIN THAT THE PLATENS ARE LEVEL WITH ONE ANOTHER. THIS IS ACCOMPLISHED BY TAKING A TAPE MEASURE AND MEASURING THE DISTANCE FROM THE TOP OF THE LOWER PLATE TO THE BOTTOM OF THE UPPER PLATE AT THREE DIFFERENT POINTS. ALL OF THESE MEASUREMENTS SHOULD BE EQUAL. IF THEY ARE NOT, RAISE OR LOWER ONE OF THE THREE NUTS AS REQUIRED.
- 6) WHEN THE PLATEN IS RAISED AND LEVEL, REPLACE THE HOOD AND THE PLASTIC FRONT GUARD ONTO THE MACHINE.
- 7) PLUG THE ELECTRICAL CORD BACK INTO THE OUTLET AND TURN THE ON/OFF SWITCH BACK TO THE ON POSITION. AT THIS TIME, THE PRESS WILL AUTOMATICALLY RAISE.
- 8) DEPRESS THE TWO GREEN START BUTTONS. THE PRESS HEAD WILL DESCEND. VISUALLY CONFIRM THAT THE PRESS PLATE STOPS AT THE RIGHT POSITION. ALSO CONFIRM THAT THE UPPER PLATE IS LEVEL TO THE LOWER ONE.
- 9) RESET THE HEATER TEMPERATURES AND DWELL TIMER TO THE DESIRED SETTINGS.

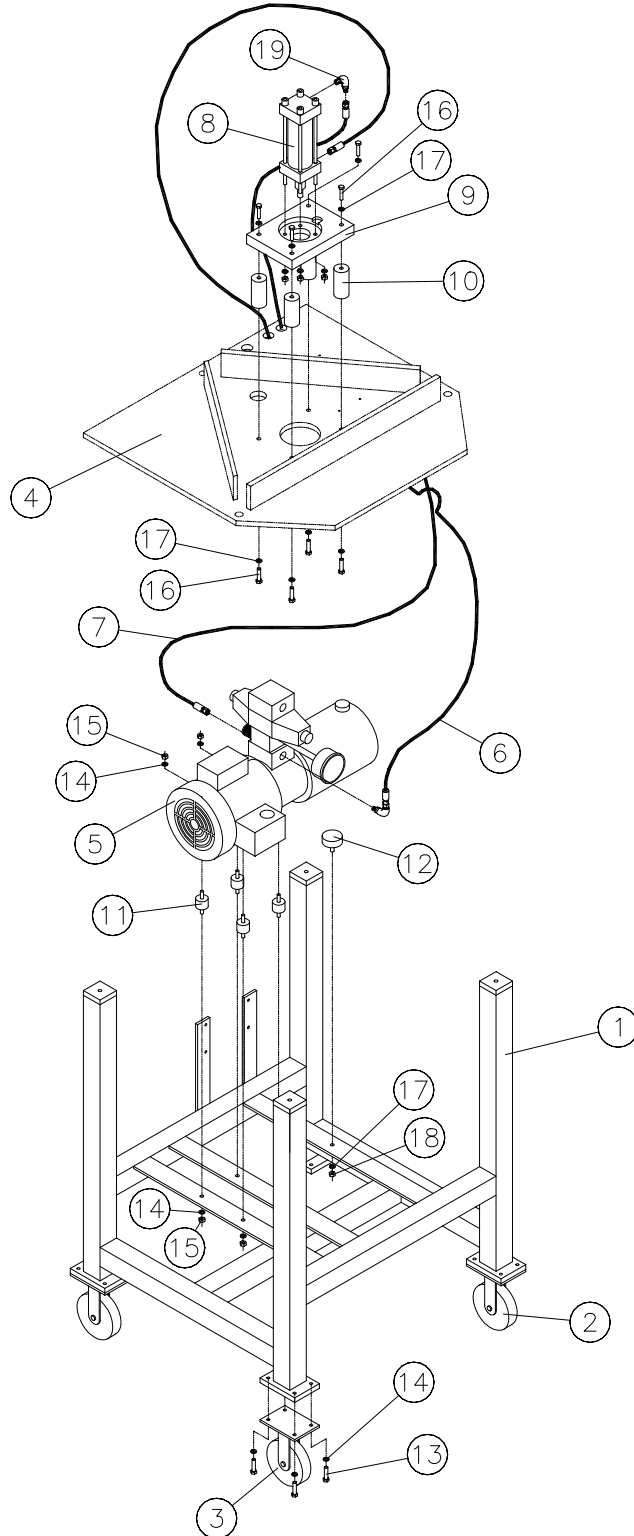
YOU ARE NOW READY TO RUN THICKER PRODUCT ON YOUR LITTLE TORO PRESS

PARTS
CATALOGUE

&

ELECTRICAL
INFORMATION

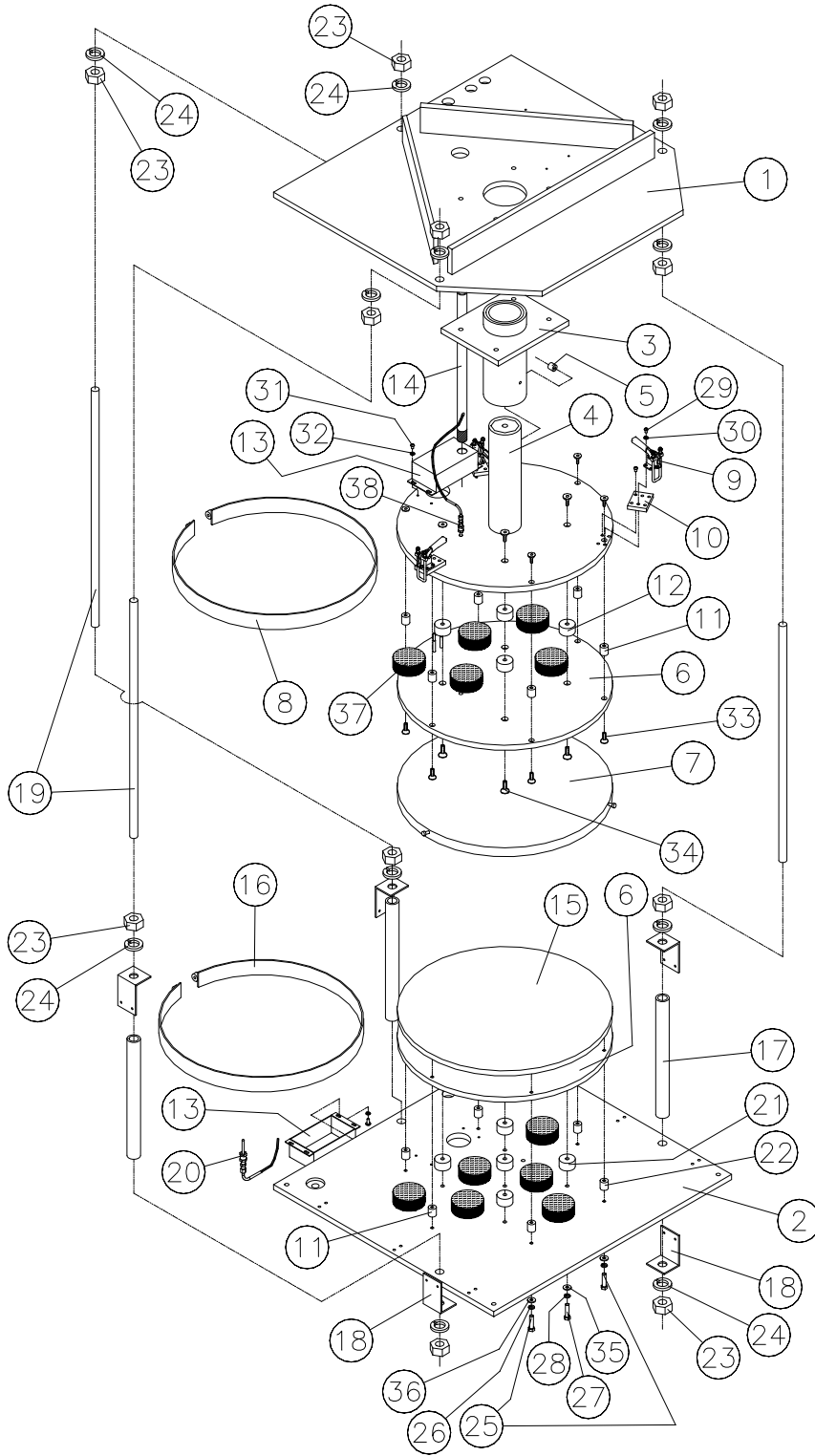
SUPPORT FRAME & HYDRAULIC ASSEMBLY



SUPPORT FRAME & HYDRAULIC ASSEMBLY

<u>ITEM</u>	<u>PART NO.</u>	<u>DESCRIPTION</u>	<u>NO. REQ'D</u>
1	12417	MACHINE FRAME	1
2	621CA1	LOCKING CASTER	2
3	621CA2	REGULAR CASTER	2
4	12422	UPPER SUPPORT PLATE	*
5	11817	HYDRAULIC UNIT / TANK	1
6	11813	PLATEN "UP" HOSE	1
7	11814	PLATEN "DOWN" HOSE	1
8	11812	HYDRAULIC CYLINDER	1
9	11846	HYDRAULIC CYLINDER MOUNTING PLATE	1
10	11861	HYDRAULIC CYLINDER MOUNTING PLATE SPACER	4
11	11822	HYDRAULIC UNIT SUPPORT PAD	4
12	11665	HYDRAULIC UNIT REAR SUPPORT PAD	1
13	F0504HH	HEX-HEAD BOLT	16
14	F0500LW	LOCK WASHER	24
15	F0500CN	NUT	8
16	F0608HH	HEX-HEAD BOLT	4
17	F0600LW	LOCK WASHER	5
18	F0600CN	NUT	1
19	11815	90° FITTING	1

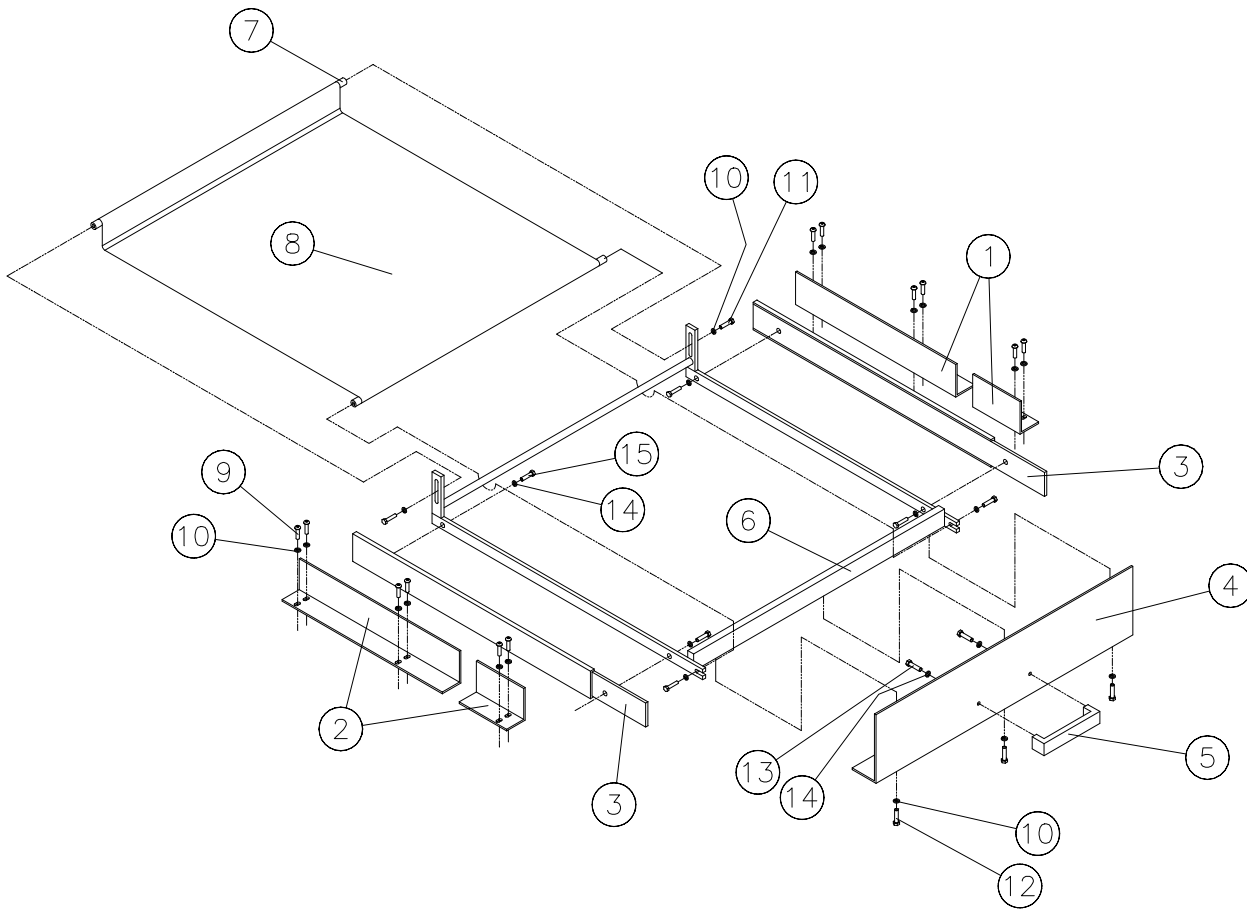
PRESS ASSEMBLY



PRESS ASSEMBLY

<u>ITEM</u>	<u>PART NO.</u>	<u>DESCRIPTION</u>	<u>NO. REQ'D</u>
1	12422	UPPER SUPPORT PLATE	1
2	12421	LOWER SUPPORT PLATE	1
3	11864	PRESS GUIDE TUBE / PLATE ASSEMBLY	1
4	12740	PRESS FLANGE / INNER TUBE ASSEMBLY	1
5	642SC	INNER TUBE GUIDE SPACER	1
6	11806	HEATER PLATE	2
7	* SEE BELOW	PRODUCT FORMING DIE	1
8	11790	UPPER PLATEN CONTAINMENT BAND	1
9	10046	FORMING DIE CLAMP	3
10	13056	DIE CLAMP EXTENSION PLATE	3
11	11802	UPPER PLATEN SPACER – SMALL	6
12	11801	UPPER PLATEN SPACER – LARGE	4
13	11788	HEATER PLATEN TERMINAL COVER	2
14	11784	UPPER PLATEN CONDUIT TUBE	1
15	12423	LOWER PLATEN	1
16	12937	LOWER PLATEN CONTAINMENT BAND	1
17	12435	SUPPORT ROD SLEEVE	3
18	12678	REAR / SIDE GUARD SUPPORT BRACKET	5
19	12434	MACHINE SUPPORT POST	3
20	EL-0643	LOWER PLATEN THERMOCOUPLE	1
21	12930	LOWER PLATEN LARGE SPACER	5
22	12931	LOWER PLATEN SMALL SPACER	6
23	F1200CN	NUT	12
24	F1200LW	LOCK WASHER	12
25	F0409HH	HEX-HEAD BOLT	6
26	F0400LW	LOCK WASHER	6
27	F0509HH	HEX-HEAD BOLT	5
28	F0500LW	LOCK WASHER	5
29	F0405HH	HEX-HEAD BOLT	4
30	F0400LW	LOCK WASHER	12
31	F9902BH	BUTTON-HEAD BOLT	8
32	F9900LW	LOCK WASHER	8
33	F0403FSH	FLAT-HEAD SCREW	12
34	F0503FSH	FLAT-HEAD SCREW	8
35	F0500FW	FLAT WASHER	5
36	F0400FW	FLAT WASHER	6
37	11862	INSULATION MATERIAL	*
38	EL-0642	UPPER PLATEN THERMOCOUPLE	1

DRAWER ASSEMBLY



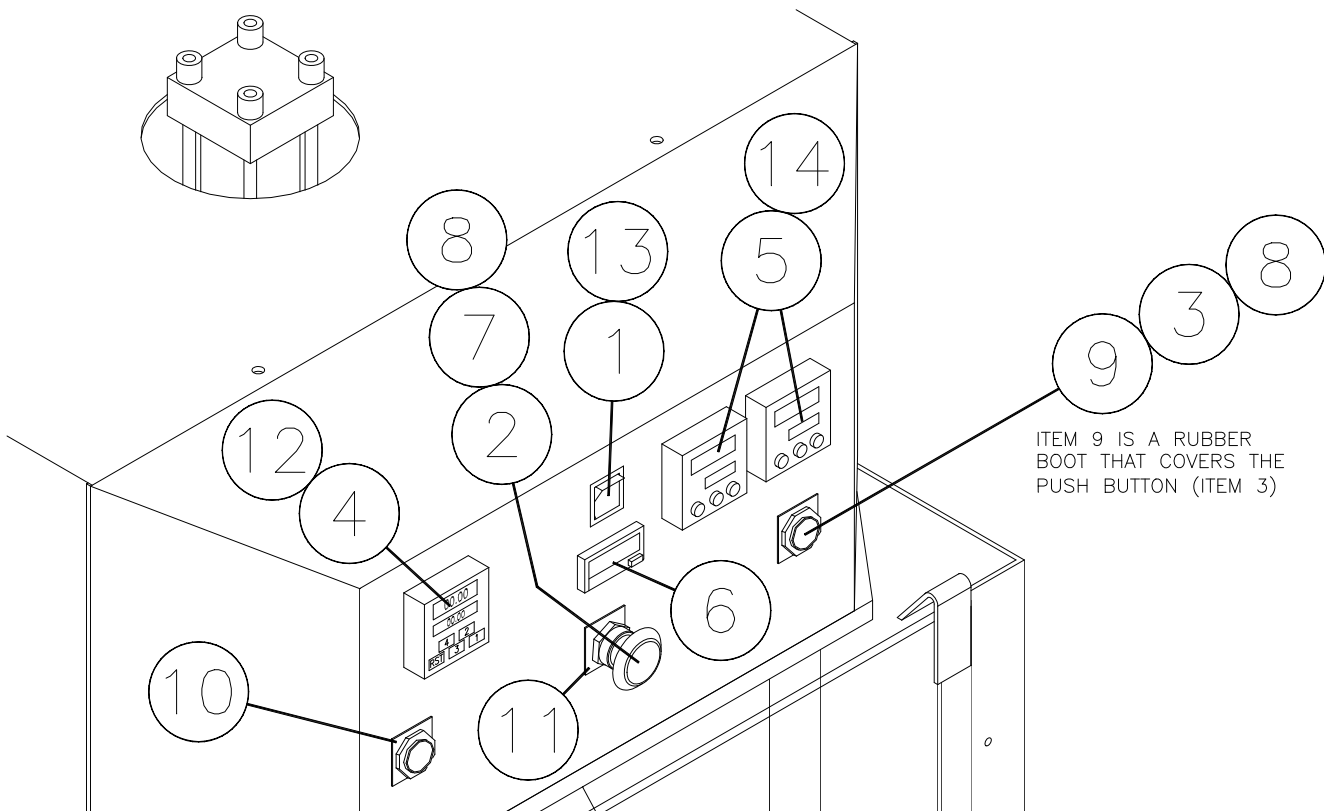
DRAWER ASSEMBLY

<u>ITEM</u>	<u>PART NO.</u>	<u>DESCRIPTION</u>	<u>NO. REQ'D</u>
1	14292 / 14293	DRAWER SLIDE SUPPORT BRACKET – LEFT SIDE	1
2	14294 / 14295	DRAWER SLIDE SUPPORT BRACKET – RIGHT SIDE	1
3	14244	DRAWER SLIDE	1 (SET)
4	12430	FACE PLATE	1
5	12432	PULL HANDLE	1
6	12424	DRAWER FRAME	1
7	12427	BELT TENSIONING BAR	2
8	12431	TEFLON BELT	1
9	F0402BH	BUTTON-HEAD BOLT	12
10	F0400LW	LOCK WASHER	19
11	F0404BH	BUTTON-HEAD BOLT	4
12	F0403HH	HEX-HEAD BOLT	3
13	F9906HH	HEX-HEAD BOLT	2
14	F9900LW	LOCK WASHER	6
15	F9902BH	BUTTON-HEAD BOLT	4

MACHINE SENSORS & GUARDING

<u>ITEM</u>	<u>PART NO.</u>	<u>DESCRIPTION</u>	<u>NO. REQ'D</u>
1	12417	MACHINE FRAME	*
2	12422	UPPER SUPPORT PLATE	*
3	12677	REAR / SIDE GUARD	1
4	12750	PLASTIC FRONT GUARD	1
5	12811	FRONT GUARD MOUNTING CLIP	2
6	12866	CONTROL PANEL	1
7	12696	MACHINE HOOD	1
8	12865	ELECTRICAL CORD BRACKET	1
9	EL-0429	PLATEN POSITION SENSOR	1
10	11844	PLATEN POSITION SENSOR BRACKET	1
11	EL-0430	DRAWER POSITION SENSOR	1
12	EL-0253	FRONT GUARD POSITION SENSOR (2 PIECES)	1 (SET)
13	F9902FH	FLAT-HEAD BOLT	4
14	F9900LW	LOCK WASHER	6
15	F9900CN	NUT	4
16	F9703BH	BUTTON-HEAD BOLT	8
17	F9700LW	LOCK WASHER	10
18	F9700CN	NUT	10
19	F0402BH	BUTTON-HEAD BOLT	10
20	F0400LW	LOCK WASHER	10
21	F9902BH	BUTTON-HEAD BOLT	2
22	F9702BH	BUTTON-HEAD BOLT	2
23	14485	DRAWER POSITION SENSOR BRACKET	1

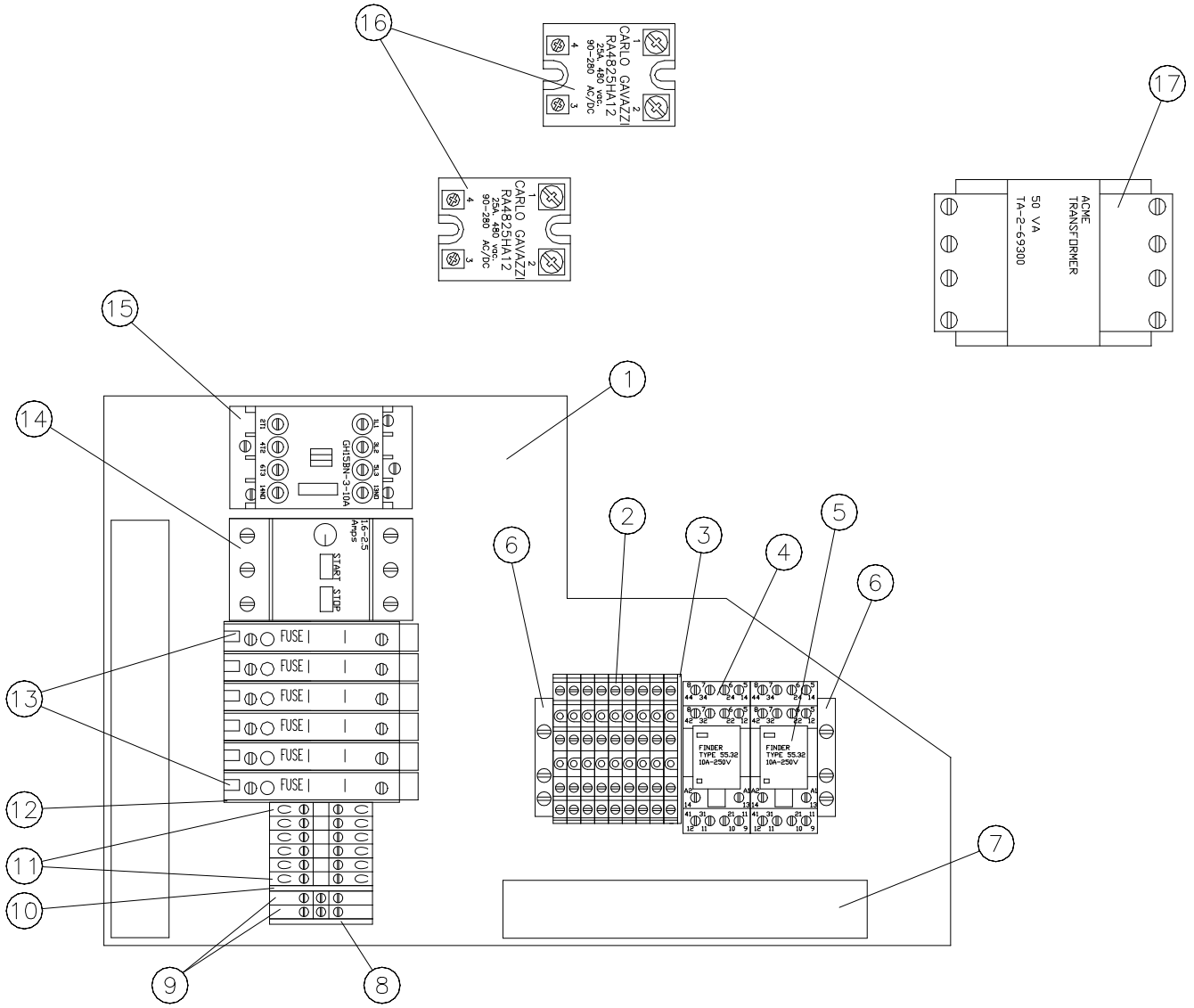
ELECTRICAL COMPONENTS (PART 1)



ELECTRICAL COMPONENTS (PART 1)

<u>ITEM</u>	<u>PART NO.</u>	<u>DESCRIPTION</u>	<u>NO. REQ'D</u>
1	EL-0433	ON/OFF SWITCH	1
2	EL-0435	EMERGENCY RAISE BUTTON	1
3	EL-0333	START BUTTON	2
4	EL-0726	DWELL TIMER	1
5	EL-0335	TEMPERATURE CONTROLLER	2
6	EL-0425	COUNTER	1
7	EL-0545	N.C. CONTACT BLOCK	1
8	EL-0544	N.O. CONTACT BLOCK	3
9	EL-0420	PUSH-BUTTON "BOOT" COVERING	2
10	EL-0445	PRESS NAMEPLATE	2
11	EL-0444	EMERGENCY RAISE NAMEPLATE	1
12	AMTAG #63	PRESS DWELL TIMER NAMEPLATE	1
13	AMTAG #55	POWER CONTROL NAMEPLATE	1
14	AMTAG #61	UPPER PLATEN TEMPERATURE CONTROLLER NAMEPLATE	1
15	AMTAG #62	LOWER PLATEN TEMPERATURE CONTROLLER NAMEPLATE	1

ELECTRICAL COMPONENTS (PART 2)

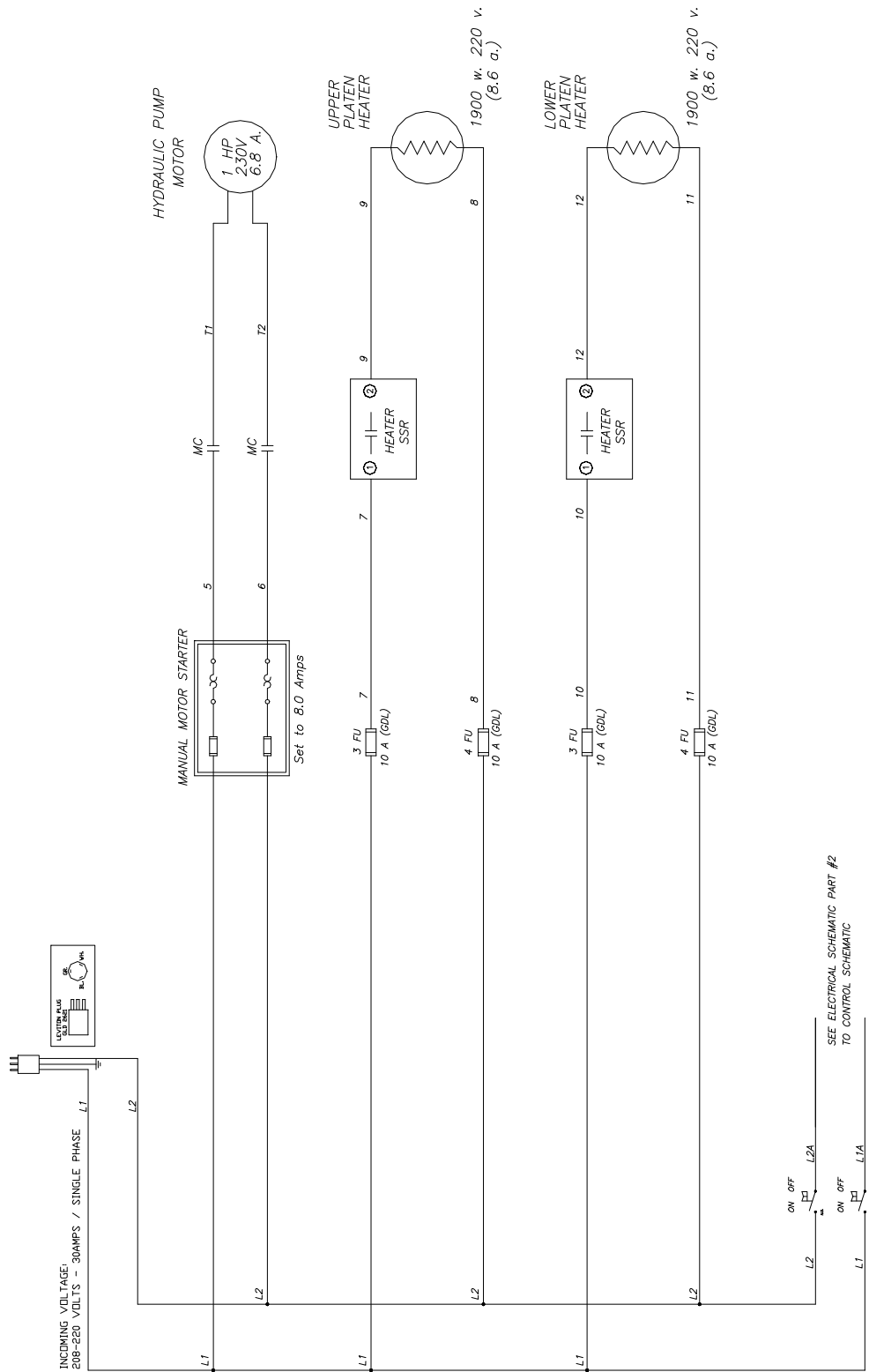


(PARTS SHOWN ARE LOCATED INSIDE THE MACHINE HOOD)

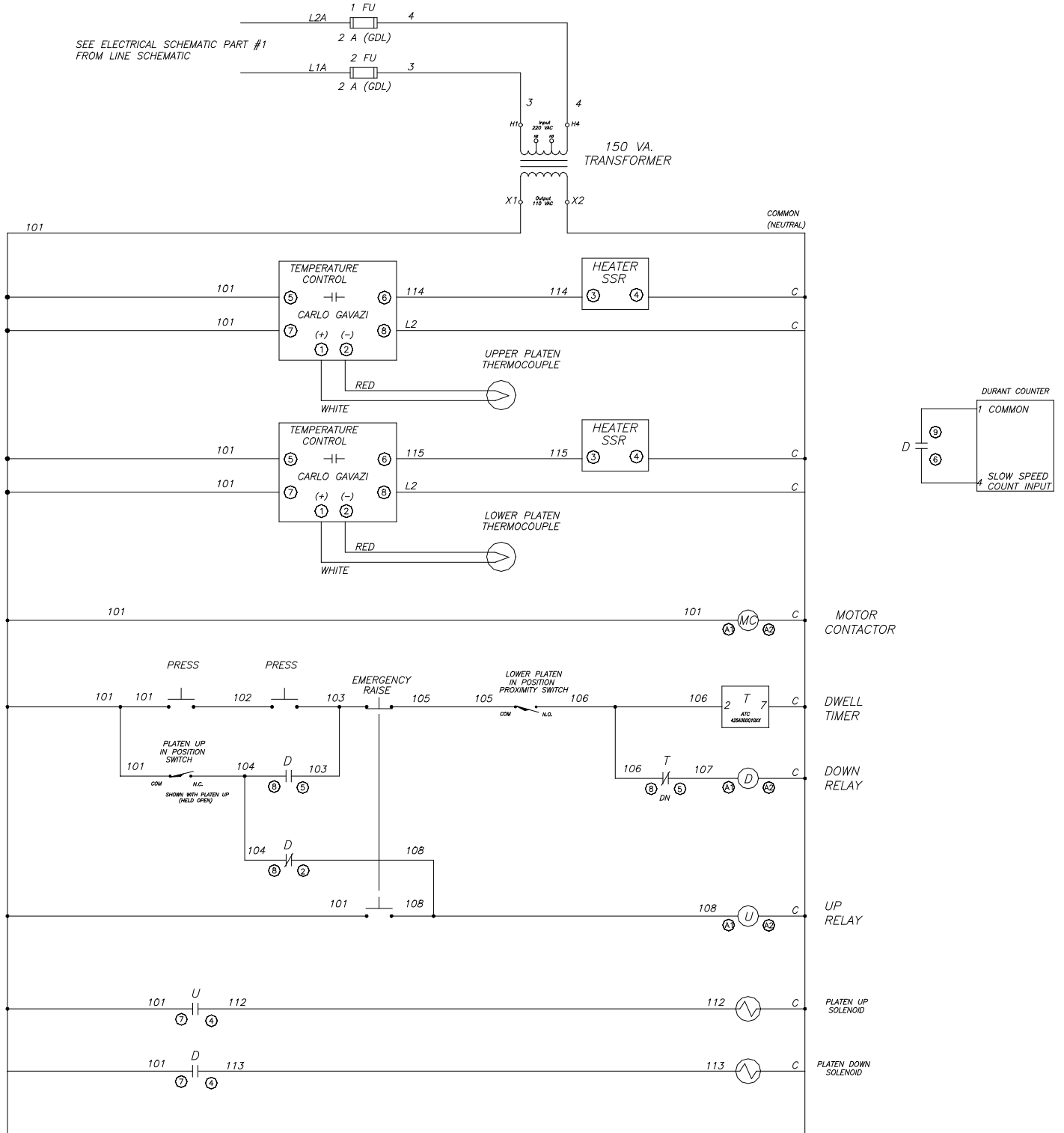
ELECTRICAL COMPONENTS (PART 2)

<u>ITEM</u>	<u>PART NO.</u>	<u>DESCRIPTION</u>	<u>NO. REQ'D</u>
1	12839	ELECTRICAL PANEL	1
2	EL-0426	DOUBLE DECK TERMINAL BLOCKS	9
3	EL-0427	DOUBLE DECK TERMINAL BLOCK END BARRIER	1
4	EL-0332	3 POLE RELAY SOCKET	2
5	EL-0331	3 POLE RELAY	2
6	EL-0396	TERMINAL BLOCK END STOP	2
7	SS181	WIRE DUCT	2
8	EL-0436	GROUNDING TERMINAL BLOCK END BARRIER	1
9	EL-0394	GROUNDING TERMINAL BLOCKS	2
10	EL-0397	TERMINAL BLOCK END BARRIER	1
11	EL-0393	TERMINAL BLOCK	6
12	EL-0419	FUSED TERMINAL BLOCK END BARRIER	1
13	EL-0418	FUSED TERMINAL BLOCK	6
14	SS175	MANUAL MOTOR STARTER	1
15	SS169	MOTOR CONTACTOR	1
16	EL-0244	SOLID STATE RELAY	2
17	SS176	TRANSFORMER	1
18	SS182	WIRE DUCT COVER	2

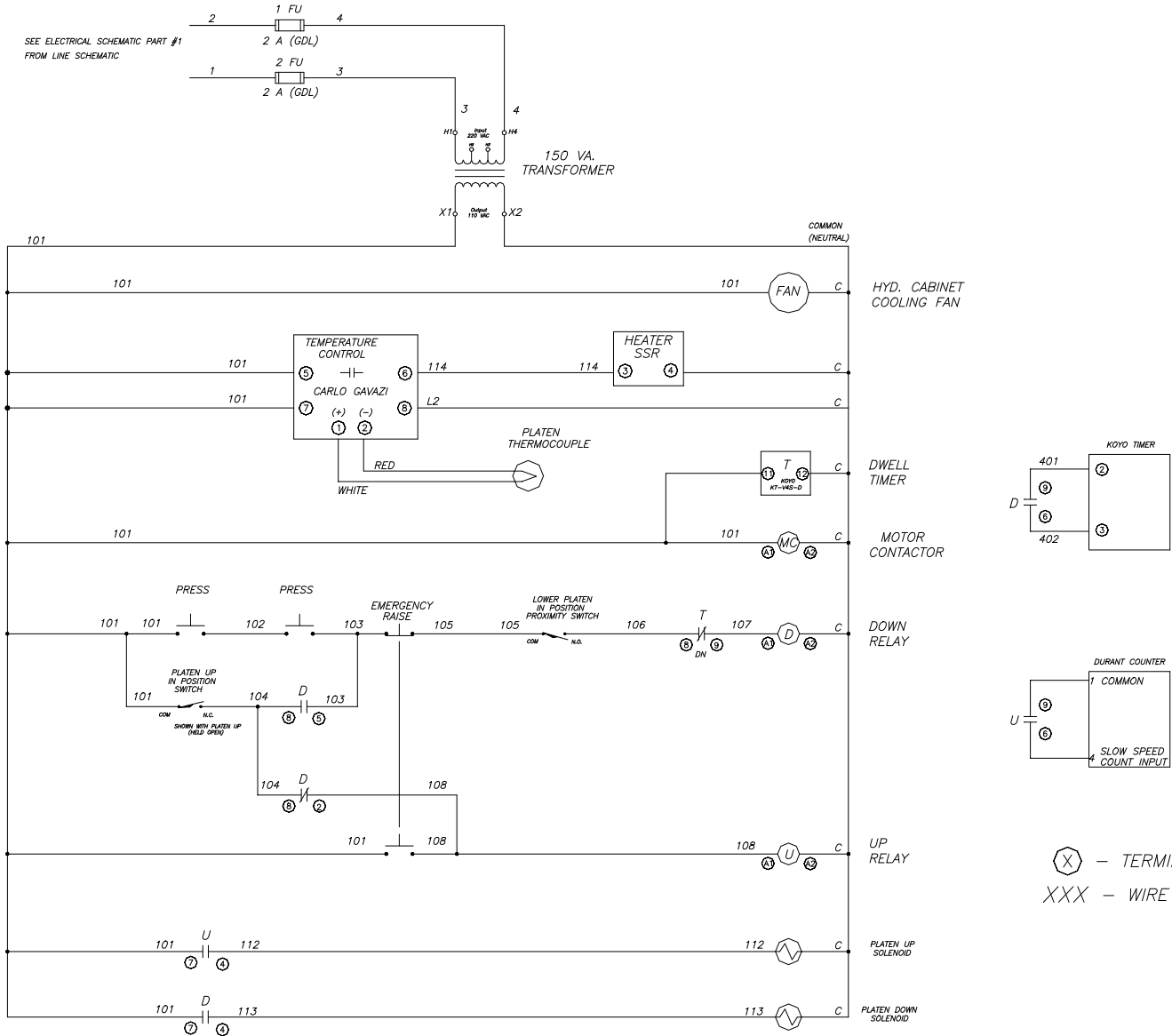
ELECTRICAL SCHEMATIC (LINE SCHEMATIC)



ELECTRICAL SCHEMATIC (CONTROL SCHEMATIC)



ELECTRICAL SCHEMATIC (CONTROL SCHEMATIC)



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.

