



MANUFACTURING
COMPANY

-SINCE 1961-



RK2201 W/ 3-1/4" DRUM
DOUGH KNIFE DIVIDER
OPERATIONS & SAFETY MANUAL

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Cautions

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⚠ 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.

NOTE: PICTURES AND DIAGRAMS MAY BE 3D REPRESENTATIONS AND MAY NOT DIRECTLY REPRESENT YOUR MACHINE.

Owners Responsibility



NOTE:

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

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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, AND THAT THEY KNOW HOW TO OPERATE THE UNIT AND ARE PROPERLY SUPERVISED SAFELY AND CORRECTLY.

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.

Table of Contents

<p>Cautions 1</p> <p>Owners Responsibility 2</p> <p>Table of Contents 3</p> <p>Introduction 4</p> <p>Specifications 5</p> <p>Installation Instructions for Location..... 6</p> <p>Safety Rules..... 7</p> <p>Safety Signal Words 8</p> <p>Warning Label Locations 9</p> <p>Warning Labels Typically Found on the RK2201..... 10</p> <p>Operating Instructions..... 11</p> <p style="padding-left: 20px;">Start-up Procedures 11</p> <p style="padding-left: 20px;">Operation Procedures 11</p> <p style="padding-left: 40px;">Adjusting the Knife and Drum speeds 11</p> <p style="padding-left: 20px;">Dough Dividing 11</p> <p>General Overview of the RK2201..... 12</p> <p style="padding-left: 20px;">General Components 12</p> <p style="padding-left: 40px;">The Drum 13</p> <p style="padding-left: 20px;">Knife and Knife Shaft 13</p> <p style="padding-left: 20px;">Infeed Conveyor Assembly 13</p> <p style="padding-left: 20px;">Discharge Conveyor Assembly..... 13</p> <p style="padding-left: 20px;">Connecting Bars 13</p> <p style="padding-left: 20px;">Knife Speed 13</p> <p style="padding-left: 20px;">Drum Speed 13</p> <p style="padding-left: 20px;">Emergency Stop 13</p> <p>General Cleaning Instructions 14</p> <p style="padding-left: 20px;">General Cleaning..... 14</p> <p>General Maintenance 15</p>	<p>Grease Points..... 16</p> <p>Belt Replacement and Tension 17</p> <p style="padding-left: 20px;">Removing the Belt 17</p> <p style="padding-left: 20px;">Belt Installation 17</p> <p>Basic Trouble Shooting Guide 18</p> <p>AM Manufacturing Service Department Contact Information 18</p> <p>Parts Catalogue..... 19</p> <p style="padding-left: 20px;">Frame & Guarding Parts Breakdown 20</p> <p style="padding-left: 40px;">Frame & Guarding Parts List..... 21</p> <p style="padding-left: 20px;">Right Side Machine Breakdown 22</p> <p style="padding-left: 40px;">Right Side Machine Parts List 23</p> <p style="padding-left: 20px;">Left Side Machine Breakdown 24</p> <p style="padding-left: 40px;">Left Side Machine Parts List..... 25</p> <p style="padding-left: 20px;">Middle Machine Parts Breakdown..... 26</p> <p style="padding-left: 40px;">Middle Machine Parts List 27</p> <p style="padding-left: 20px;">Infeed Conveyor Parts Breakdown 28</p> <p style="padding-left: 40px;">Infeed Conveyor Parts List 28</p> <p style="padding-left: 20px;">Discharge Conveyor Parts Breakdown 29</p> <p style="padding-left: 40px;">Main Drive Gear Parts List 29</p> <p style="padding-left: 20px;">Actuator Arm Assembly Parts Breakdown 30</p> <p style="padding-left: 40px;">Main Frame Assembly Parts List..... 30</p> <p style="padding-left: 20px;">380V Electrical Panel Parts Breakdown 31</p> <p>Electrical Schematics 32</p> <p style="padding-left: 20px;">208Vac-230Vac 3PH Schematics 33</p> <p style="padding-left: 20px;">Control & Pushbuttons Station Schematics 34</p> <p style="padding-left: 20px;">Clutch & Rectifier Block Schematics 35</p> <p>Ordering replacement parts..... 36</p>
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Introduction

READ AND FAMILIARIZE YOURSELF WITH THIS MANUAL BEFORE OPERATING THIS MACHINE.

FOLLOW ALL THE INSTRUCTIONS BEFORE USE.

The model RK2201, from A.M. Manufacturing, is a single bank, rotating Knife Divider. The machine can achieve output speeds of up to 4,800 dough pieces per hour, depending on the size. This capacity allows for greater bagel production while being versatile, simple, and effectively saving labor. Study this operations and safety manual for beneficial knowledge on this machine.

CAUTION:

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

IMPORTANT:

AM MANUFACTURING COMPANY RESERVES THE RIGHT TO MAKE CHANGES IN DESIGN, SPECIFICATIONS OR MANUFACTURING TO IMPROVE THEIR PRODUCTS WITHOUT NOTICE AND WITHOUT OBLIGATION TO CHANGE OR IMPROVE PREVIOUSLY BUILT PRODUCTS, INCLUDING MANUALS AND CATALOGS.

DIAGRAMS AND FIGURES WITHIN THIS MANUAL ARE OFTEN 3D REPRESENTATIONS AND MAY NOT REPRESENT YOUR MACHINE IN IT'S ENTIRETY.

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.

WARNING:

THIS MANUAL CONTAINS CRITICAL SAFETY INSTRUCTIONS. READ AND FOLLOW THEM CAREFULLY. FAILURE TO FOLLOW WARNINGS 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 AM MANUFACTURING: (800) 342-6744

Specifications

All dimensions below are approximate.

LENGTH	6'- $\frac{1}{4}$ "
WIDTH	1'-9 $\frac{1}{2}$ "
HEIGHT	5'-1 $\frac{3}{4}$ "
DRUM WIDTH	3 - $\frac{1}{4}$ "

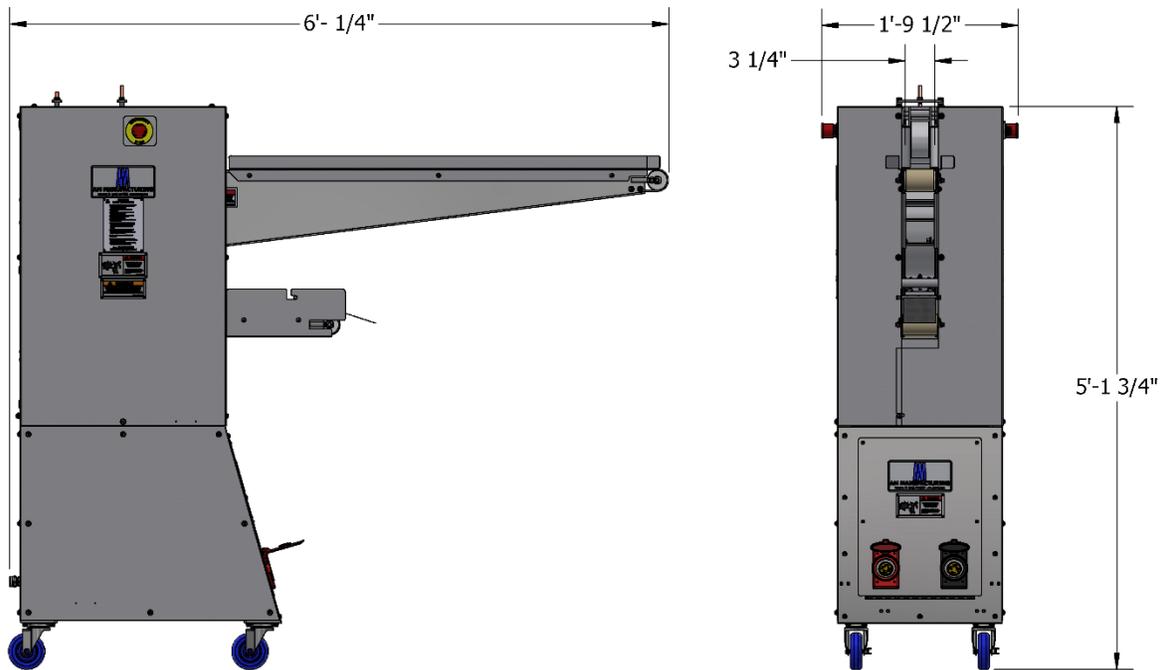


Figure 1: Specifications

Installation Instructions for 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, easy to clean, and should be free of oil, grease, etc.

CAUTION:

PROPER UNIT INSTALLATION IS NECESSARY FOR SAFE AND EFFICIENT OPERATION. PROPER INSTALLATION ALSO HELPS PROTECT THE UNIT FROM DAMAGE AND MAKES SERVICE EASIER. ALL MOVING PARTS, WITH EXCEPTION OF NECESSARY CONVEYING SURFACES, SHOULD BE COVERED AND GUARDED WHEN THE MACHINE IS IN OPERATION.

1. Open the crate and remove all packing materials, packing slips, documents, and other loose materials. Make certain to remove all manuals and schematics from the crate.
2. Move the unit to the desired location.
3. Lock the bottom two locking casters using their levers.

Safety Rules



- 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 THE 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 AM MANUFACTURING CO. TOLL FREE: (800) 342-6744**

Safety Signal Words

THIS MACHINE IS DESIGNED TO PROVIDE SAFE OPERATION 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 AND IT WILL ALSO APPEAR IN THIS MANUAL WHEREVER SAFETY MESSAGES ARE GIVEN.

GET FAMILIAR WITH SIGNAL WORDS:

- **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 Label Locations

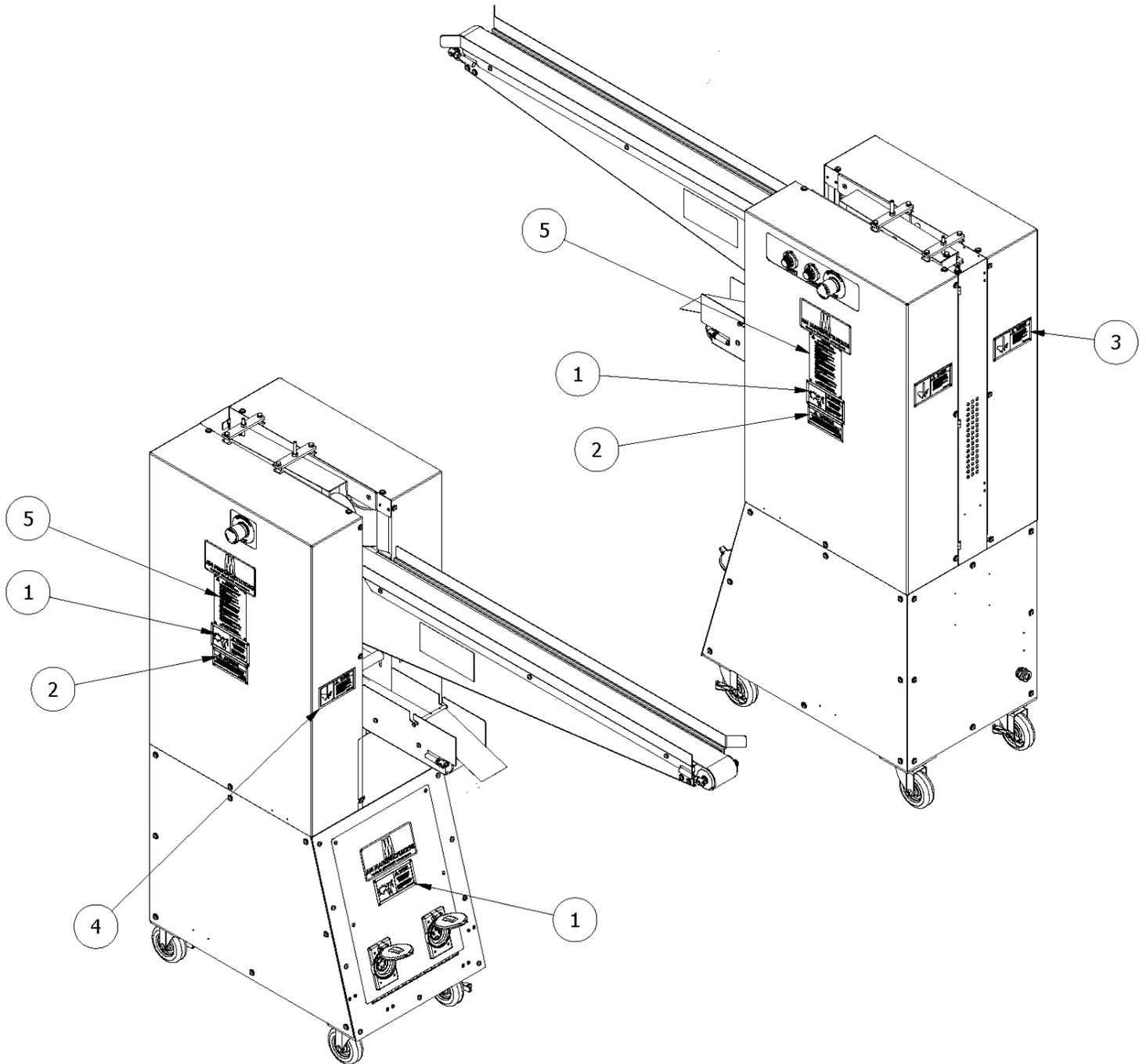


Figure 2: Warning Label Locations

Warning Labels Typically Found on the RK2201

1) TAG10AM:

LOCATED ON LEFT AND RIGHT PANEL, ELECTRICAL BOX.



2) TAG11M:

LOCATED ON BOTH SIDES OF CABINET.



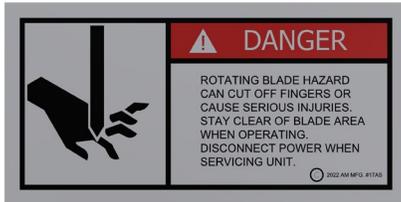
3) TAG17AM:

LOCATED ON BACK PANELS.



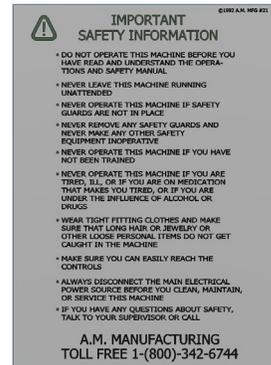
4) TAG17AS:

LOCATED ON FRONT PANELS.



5) TAG21S:

LOCATED ON BOTH SIDES OF CABINET.



Operating Instructions

WARNING:

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

IMPORTANT:

BEFORE BEGINNING START-UP, READ ALL THE INSTRUCTIONS AND FAMILIARIZE YOURSELF WITH THE LOCATIONS OF ALL CONTROLS. KNOW HOW TO SHUT DOWN THE UNIT IMMEDIATELY IN CASE OF TROUBLE. MAKE CERTAIN ALL PERSONNEL NOT INVOLVED IN THE START-UP ARE SAFELY AWAY FROM THE MACHINE BEFORE ANY SYSTEMS ARE STARTED.

The RK2201 is almost always part of the RK2200, or the Bagel Former & Knife Divider combination machine. The following section covers the start-up and operations of the knife divider.

Start-up Procedures

1. Start the Bagel Former first with the green Bagel-Former start push button on the former.
2. Start the Knife Divider with the green Bagel Divider Start button on the former.

Note: Some knife dividers, if sold as stand-alone, have a separate green start button on the side of the machine.

Operation Procedures

The RK2201 Knife-Divider has its knife and drum speed typically set during testing of the machine at AM Manufacturing. If having to readjust the knife and drum speed settings, follow step 1 below.

Adjusting the Knife and Drum speeds

1. Using the knife speed dial on the side of the machine, slowly adjust it.
 - a. If trying to achieve a heavier bagel, slow the knife speed down.
 - b. If trying to achieve a smaller bagel, speed the knife speed up.
2. Adjust the drum speed when running the machine if any issues arise in the dough.

Dough Dividing

1. Place the dough on the infeed conveyor in long log shapes in sizes no more than an inch above the side rails of the infeed conveyor.
 - a. Use fresh dough that has not formed a surface skin, this helps the dough to properly travel through the machine.
 - b. The dough should not be any longer than the infeed conveyor.
 - c. Ensure that the dough is not touching the sides of the infeed conveyor.
2. Taper the end first feeding into the knife divider so that it smoothly enters the drum area of the machine.
 - a. If using two sections of dough, overlap the last section with the first by tapering each end to allow a better transition with the machine.
3. The clicking of the actuator arm means it is working properly.

General Overview of the RK2201

The RK2201 machine has various components that are important to familiarize yourself with to effectively operate, maintain, and clean your machine.

General Components

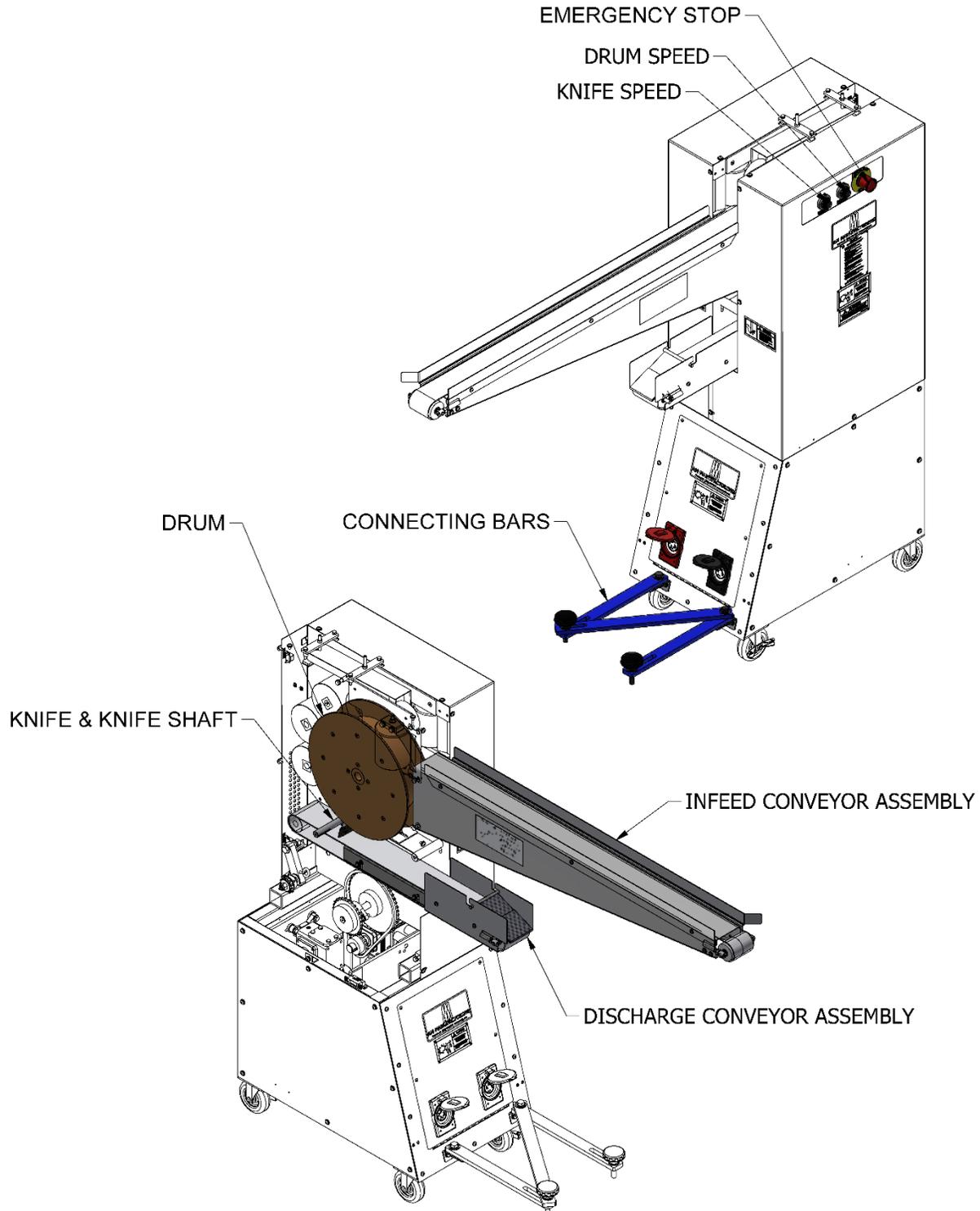


Figure 3: Overview

The Drum

- The Drum is the main component that the dough travels on as the dough moves through the machine.

Knife and Knife Shaft

- The knife rotates as the dough moves through the machine.
- This knife cuts the dough and is the responsible part for the dividing portion of the machine.
- The knife speed is adjusted with the knife speed dial, which can cause smaller or large cuts.

Infeed Conveyor Assembly

- The area in which the dough is placed.
- Uses a conveyor belts to bring dough into the machine.

Discharge Conveyor Assembly

- The area in which the divided dough exits the machine and travels on to the bagel former.
- After the knife divides the dough, it drops the divided piece onto the conveyor belt which travels out.

Connecting Bars

- The components that tie the bars to the bagel former.

Knife Speed

- Changes the speed in which the knife rotates and divides dough.
- Slower speeds allow for larger cuts, while faster speeds allow for smaller cuts.

Drum Speed

- The weight control
- The Drum speed works together with the knife speed to adjust the dough piece being cut.
- Once the knife speed is cutting the right size dough piece, adjust the drum speed to fine tune the weight until the desired size is achieved.

Emergency Stop

- The emergency stop shuts off the entire machine.
- Twist it to release it back out.
- Found on both sides of the Knife Divider

General Cleaning Instructions

⚠ WARNING: Before attempting to clean the RK2201, make certain that the machine has been properly powered down and the plug has been removed from the power source. Failure to do so could result in serious injury.

All AM Manufacturing machines are tested with dough during the quality audit procedure. Although the machine has been cleaned, some evidence of dough may be detected, this is normal.

All parts in contact with dough should be washed thoroughly after operation with a mild soap and water solution. Disassembly of this machine for cleaning is outlined and illustrated for your convenience.

Cleaning the AM Manufacturing RK2201 is essential to ensure sanitary conditions and proper machine function. Regular cleaning will extend the life of various components within the machine.

General Cleaning

- Using a mild soap solution, wipe down the outside of the cabinet to expose all warning labels to alert all employees of any hazards.
- Continue to wipe down both conveyors entirely.
 - This is to remove any dough build-up that occurs under the belts and on the interior walls of the conveyors.
 - This also helps prevent belt slippage that may occur and improve longevity of the belts.
- Open the rear inspection door.
 - Using a soap solution, wipe down the drum scraper and knife from the excess dough build-up that occurs.
 - You may have to carefully scrape any dough from the drum scraper and knife by hand to thoroughly clean these components.

General Maintenance

Read and follow the maintenance instructions below to keep the unit in good operating condition. Regular inspections and maintenance are essential to help prevent accidents and injuries.

⚠ WARNING: Before attempting maintenance on the RK2201, make certain that the machine has been properly powered down and the plug has been removed from the power source. Failure to do so could result in shock or injury.

Before making any inspection, adjustment, or repair, be certain power source is disconnected, and all moving parts are blocked out to prevent injury. Wear protective clothing.

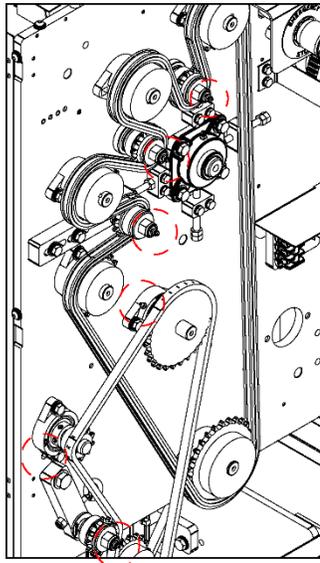
- All working surfaces should be cleaned regularly.
- The cabinet and other working surfaces should be cleaned regularly.
- Make sure that all fasteners are tightened securely.
- Make certain that all guards and covers are in place.
- Check for worn, damaged or missing parts including belts, safety guards, and protective covers.
- Inspect the unit and check to be certain that all systems are operating normally daily.

⚠ CAUTION: Replace any damaged or missing safety labels. These are available from the manufacturer.

Maintenance for the RK2201 Knife Divider always begins with keeping the machine clean. Proper cleaning procedures start on pages 14 of this manual. Standard long-term maintenance consists of lubricating main wear points of the machine with an all-purpose synthetic base grease. A grease gun with a flexible hose is needed.

Grease Points

There are various grease points around the machine that should be regularly lubricated on a bi-weekly basis for optimum bearing life. The grease points are shown in the following figures.



- Circled in red are an example of grease points located on the right side of the machine.
 - Besides the ones circled, every bearing on both sides of the machine have grease fittings.

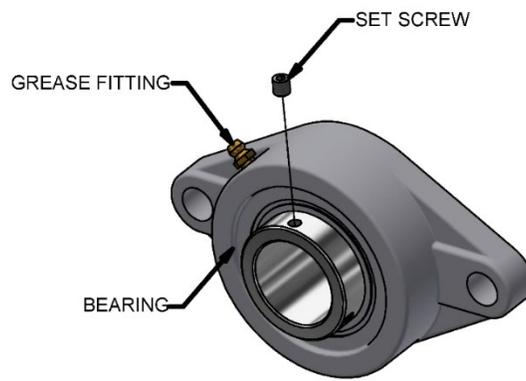
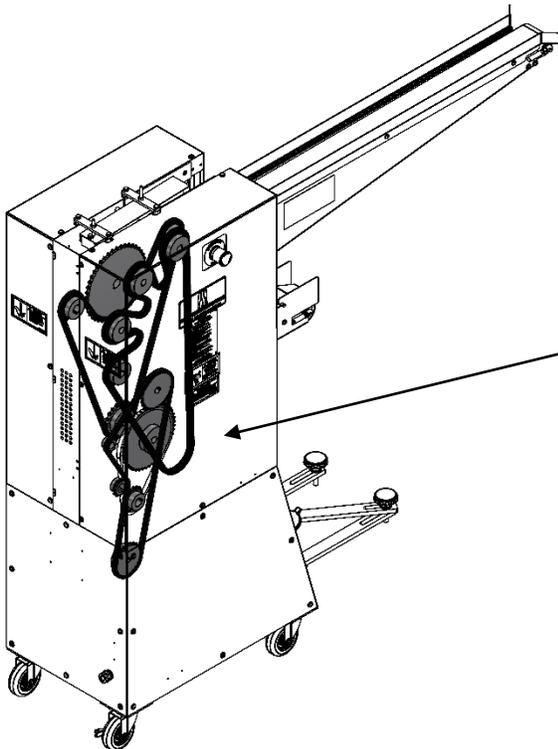


Figure 4: Grease Points



The RK2201 has four drive chains located on the machine that should be regularly lubricated.

- 1 chain on the right side of the machine driving the rollers.
- 1 chain on the left side of the machine driving the drum.
- 1 chain centered on the machine that drives the drive chain sprocket tied to the drum chain.
- 1 chain that drives the knife.

Note: Chain condition and tension should be checked every 60 days or more frequently if excess noise or vibration is noticed.

Belt Replacement and Tension

⚠ WARNING: CONVEYOR MAINTENANCE SHALL BE PERFORMED ONLY WHEN THE POWER SUPPLY HAS BEEN DISCONNECTED AND THE CONVEYOR HAS STOPPED.

At times, the infeed conveyor belt (Top belt) or discharge conveyor belt (Bottom belt) may need to be replaced. The process is the same for both belts.

Removing the Belt

1. Start with the teeth of the belt, where the pin holds the belt together, exposed.
2. Loosen the tension of the belt all the way with the adjusting nuts on the roller supports.
3. Using pliers, pull the pin on the belt out to separate the belt.
4. Pull the belt through the machine and out.

Belt Installation

1. Feed the belt through the machine.
2. Line up the teeth of each end of the belt evenly and insert the pin through the teeth.
3. Properly tension the belt and ensure the belt is tracking straight.
 - a. Loosen and tighten the nuts on the roller supports as needed to adjust tension.

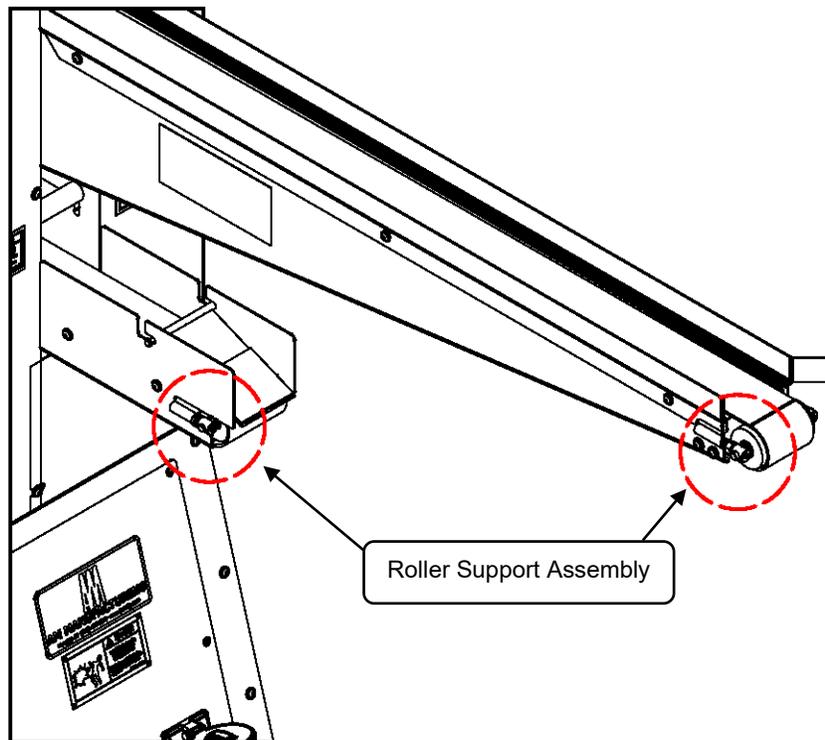


Figure 5: Roller Supports

Basic Trouble Shooting Guide

Issue	Probable Cause	Possible Solutions
Pushbutton not working	Pushbutton is broken, contact blocks need replaced	Order a new push button and contact blocks.
Belts Not Running	Fuses	Replace fuses
Speed Not Adjusting	Speed Pot	Test the speed pot, replace as needed.
Speed Not Adjusting	DC Drive	Test the DC Drive, replace as needed.
Machine Not Running	Safety trip	Ensure doors and Guards are in place.
Infeed Conveyor Running Constantly While Dough is Feeding	Limit Switch, Switch Adjustment, Clutch	Verify Limit Switch is activating. If not activating, adjust the limit switch. If the switch is activating and problem persist, call AM Service.

AM Manufacturing Service Department Contact Information

Monday through Friday, 7AM to 3:30PM (CST)

Phone: [219-472-6417](tel:219-472-6417)

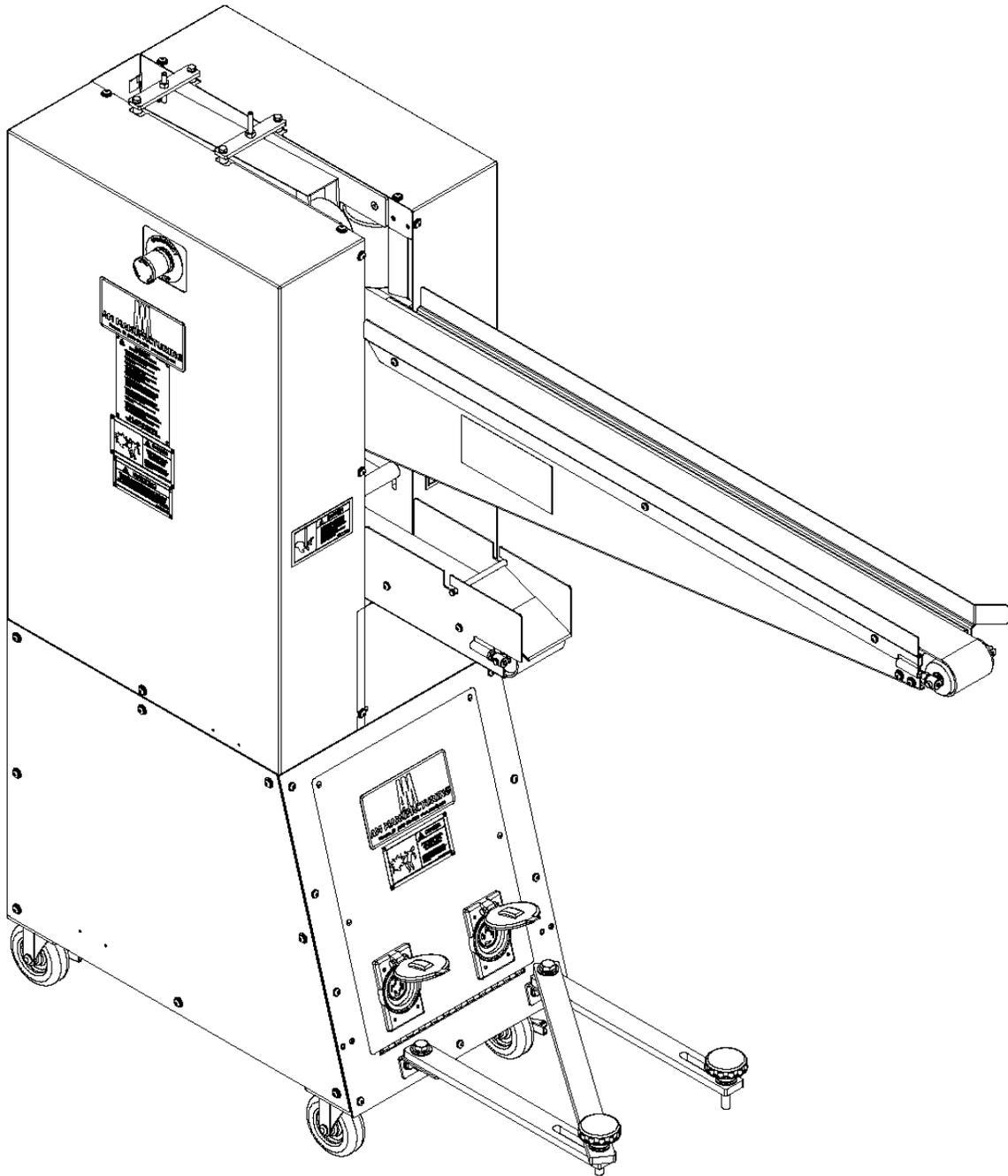
Monday through Friday, 3:30PM to 7AM (CST)

and Saturday or Sunday

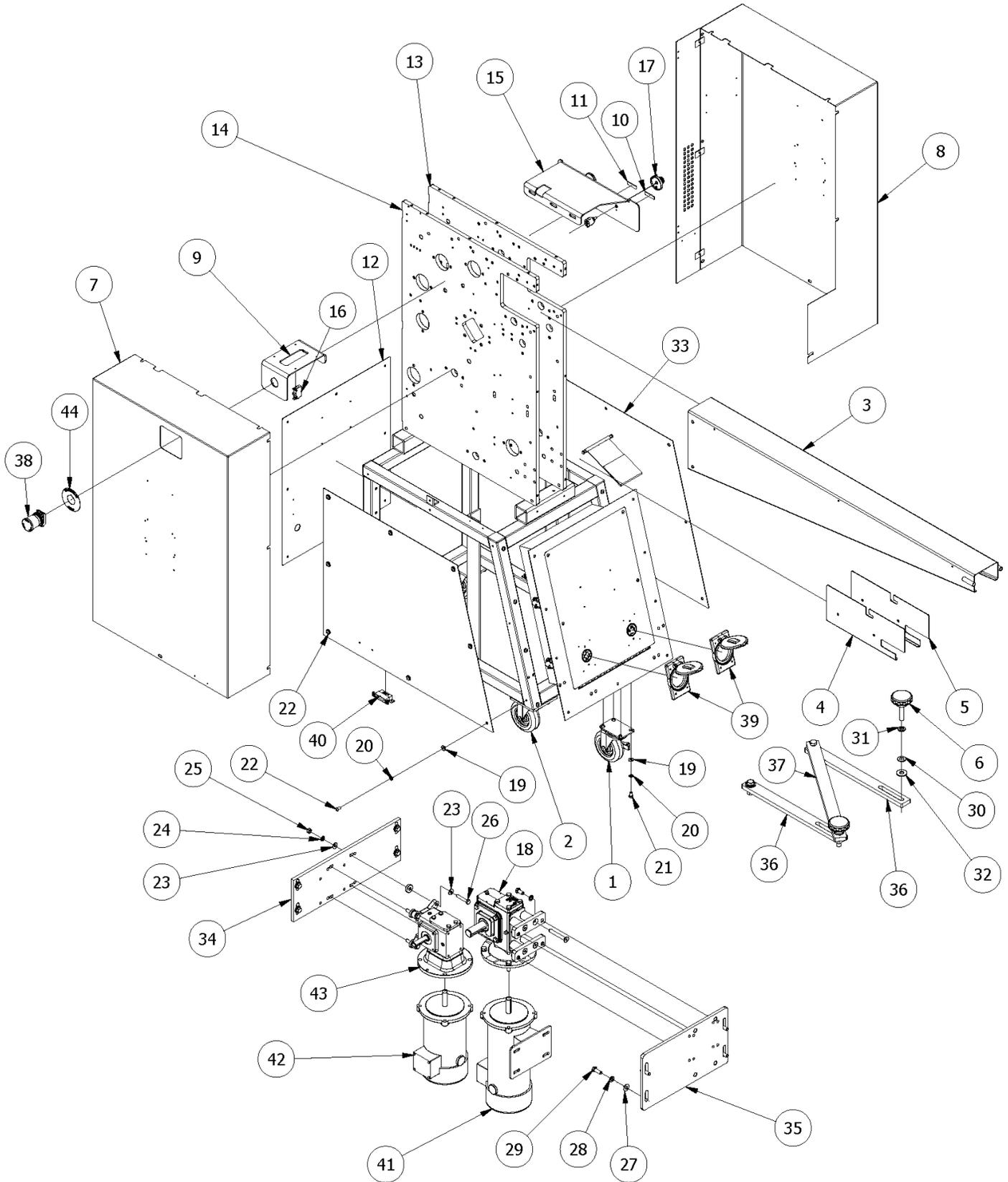
Phone: [708-328-3400](tel:708-328-3400)

support@ammfg.com

Parts Catalogue



Frame & Guarding Parts Breakdown



Frame & Guarding Parts List

ITEM	PART NO	DESCRIPTION	QTY
1	621CA1	CASTER, LOCKING 4" DIA	2
2	621CA2	CASTER, SWIVEL 4" DIA	2
3	14508	INFEED CONVEYOR BODY ASSEM.	1
4	20386	DISCHARGE CONVEYOR SIDE PLATE-RS	1
5	20387	DISCHARGE CONVEYOR SIDE PLATE-LS	1
6	21449	MACHINE LOCK KNOB / STUD ASSEMBLY	2
7	33313	MACHINE SIDE COVER-RS	1
8	33314	MACHINE SIDE COVER ASSEMBLY-LS	1
9	33316	PUSHBUTTON BRACKET - E-STOP	1
10	33317	KNIFE SPEED TAG	1
11	33318	DRUM SPEED TAG	1
12	34914	FRAME BACK PANEL	1
13	35137	RIGHT SIDE PLATE	1
14	35138	LEFT SIDE PLATE	1
15	35139	PUSHBUTTON BRACKET	1
16	400038	CONTACT BLOCKS, 1 N.C.	3
17	400091	10 TURN SPEED POT KNOB	2
18	EL-2074-A	*SEE NOTES*	1
19	F0400FW	FLAT WASHER, 1/4"	46
20	F0400LW	LOCK WASHER, 1/4"	55
21	F0402HHCS	HEX HEAD CAP SCREW, 1/4-20X1/2" LG.	16
22	F0402SB	BUTTON HEAD, SOCKET 1/4-20 X 1/2" L	33

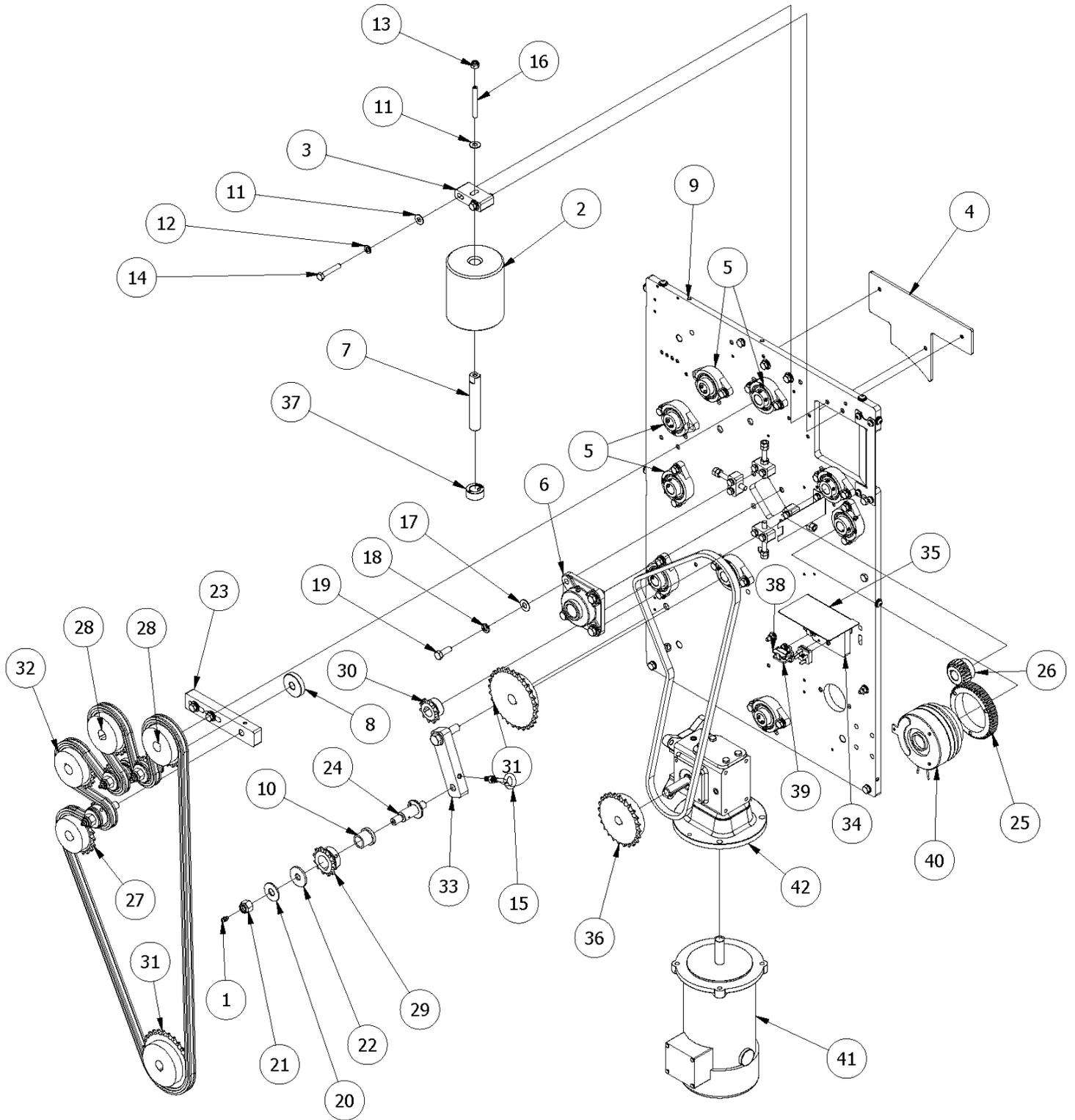
ITEM	PART NO	DESCRIPTION	QTY
23	F0500FW	FLAT WASHER, 5/16"	8
24	F0500LW	LOCK WASHER, 5/16"	4
25	F0500NC	NUT COURSE, 5/16-18	4
26	F0507HHCS	HEX HEAD CAP SCREW 5/16-18 X 1-3/4"	4
27	F0600FW	FLAT WASHER 3/8"	8
28	F0600LW	LOCK WASHER 3/8"	20
29	F0604HHCS	HEX HEAD CAP SCREW 3/8-16 X 1"	12
30	F0800FW	FLAT WASHER 1/2"	6
31	F0800LW	LOCK WASHER 1/2"	4
32	F0800NW	1/2"ID X 1-1/4"OD NYLON FLAT WASHER	4
33	K605C-L	LOWER FRAME SIDE COVER (LEFT)	1
34	K606C	DISCH.CONV. MOTOR MOUNT PLATE	1
35	K607C	MAIN DRIVE MOTOR MOUNT PLATE	1
36	K622C	RK2200 CONN. BAR, SHORT	2
37	K623C	DIVIDER/FORMER CONN. BAR, LONG	1
38	SS185	E-STOP	2
39	SS235	ALUM. WALL PLATE	2
40	SS240	MAGNETIC REED SWITCH	3
41	SS259	MAIN DRIVE MOTOR 1 H.P. RK2100	2
42	SS383	1/4 H.P. MOTOR (RK2200 KNIFE MOTOR)	1
43	SS410	GEAR REDUCER 15:1	1
44	SS425	EMERGENCY STOP NAMEPLATE	2

NOTES:

The EL-2074-A, or Drum Gear Reducer kit, is the newest gear reducer on the RK2201. The prior one, AM# SS258, is obsolete. The notes below describe what is needed.

- Machines serialized prior to 11/21/24 must order AM PART #EL-2074-A and K607C for the new style gear reducer to be compatible.
 - If ordering parts for a machine serialized **after** this date, the Gear Reducer part number is just EL-2074 and no kit is needed.
 - If the number printed on the gear reducer nameplate starts WITH 920MWT, EL-2074-A will be required along with K607C.

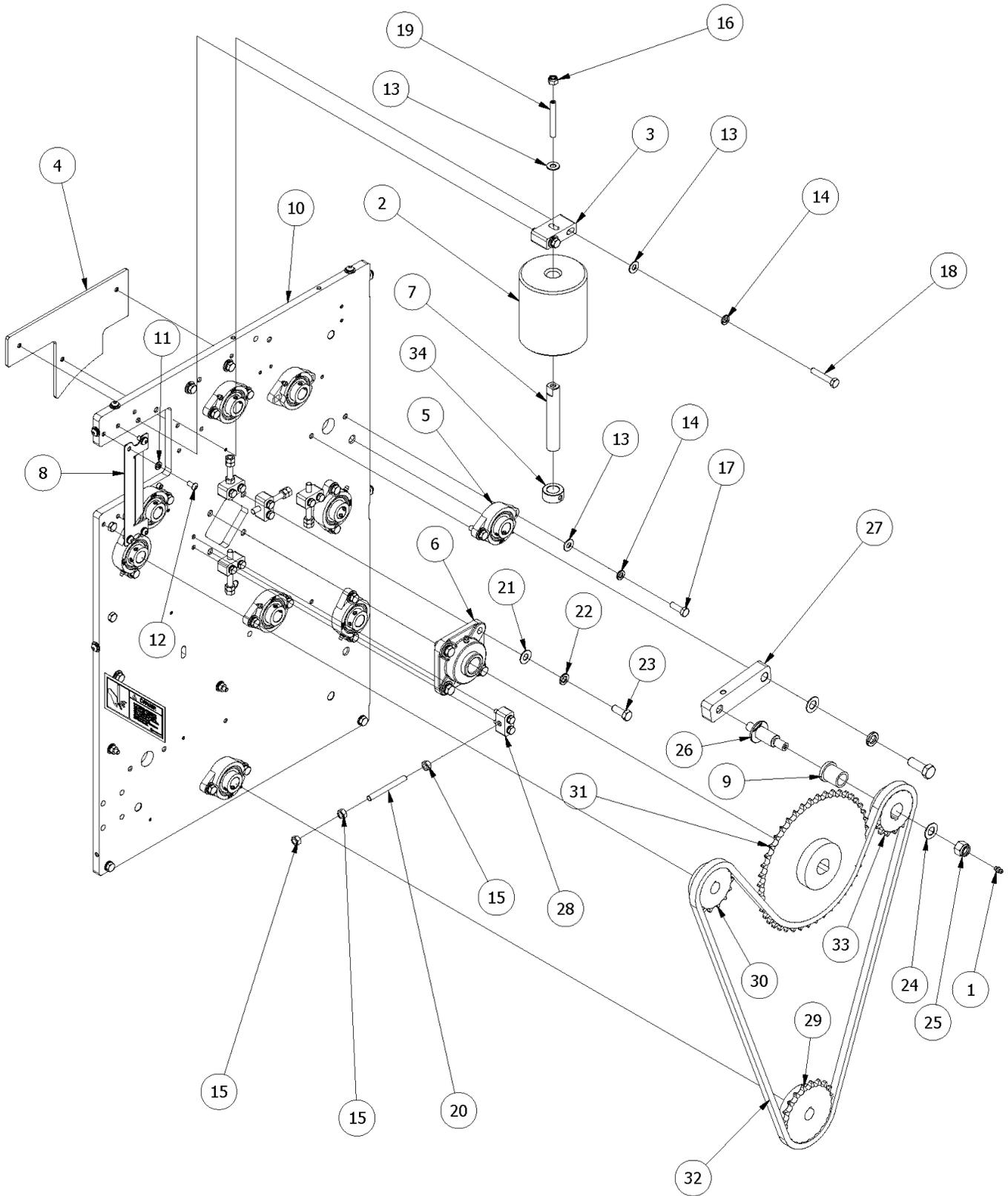
Right Side Machine Breakdown



Right Side Machine Parts List

ITEM	PART NO	DESCRIPTION	QTY
1	3038-B	1/4-28 UNF STRAIGHT GREASE FITTING	4
2	14023	VERTICAL DOUGH GUIDE ROLLERS	1
3	14509	VERTICAL ROLLER SUPPORT BLOCKS	1
4	14514	INFEED AREA PLASTIC DOUGH GUIDE, LS	1
5	14770	3/4" 2 BOLT FLANGED BEARING - SSBSL	9
6	18422	4-BOLT FLANGED BEARING, 1" DIA SHAFT, S.S.	1
7	20407	INFEED AREA GUIDE ROLLER SHAFT	1
8	25337	SPACER - 1.75 OD X 3/8 LG X 17/32 ID, SS	2
9	35138	LEFT SIDE PLATE	1
10	BBT15	BRONZE BUSHING	4
11	F0500FW	FLAT WASHER, 5/16"	23
12	F0500LW	LOCK WASHER, 5/16"	25
13	F0500NLN	NUT, NYLOCK 5/16"	2
14	F0507HHCS	HEX HEAD CAP SCREW 5/16-18 X 1-3/4"	2
15	F0508EB	5/16-18X2" LG, EYEBOLT	1
16	F0510SS	SET SCREW, 5/16-18 X 2-1/2" LG, S.S.	1
17	F0600FW	FLAT WASHER 3/8"	4
18	F0600LW	LOCK WASHER 3/8"	8
19	F0604HHCS	HEX HEAD CAP SCREW 3/8-16 X 1"	4
20	F0800FW LARGE	FLAT WASHER 1/2" (S.S., THICK, LARGE)	4
21	F0800NLN	NUT-NYLOCK 1/2"	4
22	F0800NW-THICK	NYLONG WASHER (1.507"ODX.503"IDX.125" THK)	4
23	K104LS-1	TENSION SPROCKET PLATE	1
24	K104LS1A	SPROCKET TENSION MOUNT SHAFT	4
25	K108LS	CLUTCH DRIVER GEAR	1
26	K109LS	FOLLOWER GEAR (CLUTCH ASSEMBLY)	1
27	K111LS	SIZING ROLLER SPROCKET	1
28	K112LS	SIZING ROLLER SPROCKET	2
29	K113LS	TENSION SPROCKET	4
30	K115LS	DISCHARGE CONVEYOR SPROCKET	1
31	K116LS	COUNTER / KNIFE SPROCKET	2
32	K117LS	SIZING ROLLER SPROCKET	1
33	K203RS-1	TENSION BAR	1
34	K322ES	BRIDGE RECTIFIER BLOCK	1
35	K533ES	RECTIFIER BLOCK GUARD	1
36	K617C	MAIN DRIVE MOTOR SPROCKET	1
37	R147RA	SHAFT COLLAR	1
38	SS144	TERMINAL BLOCK	4
39	SS145	TERMINAL BLOCK END SEGMENT	1
40	SS238	CLUTCH	1
41	SS383	1/4 H.P. MOTOR (RK2200 KNIFE MOTOR)	1
42	SS410	GEAR REDUCER 15:1	1

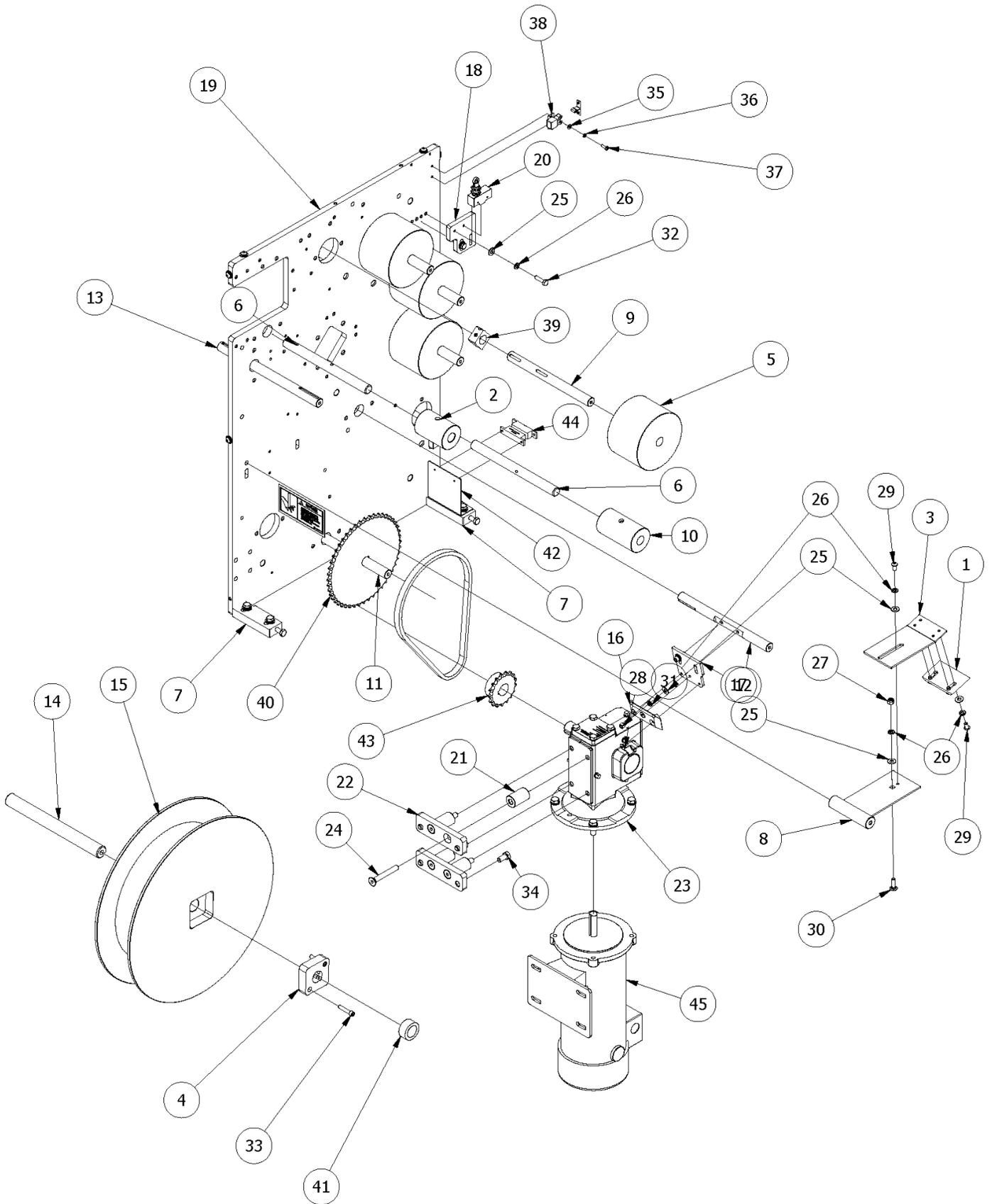
Left Side Machine Breakdown



Left Side Machine Parts List

ITEM	PART NO	DESCRIPTION	QTY
1	3038-B	1/4-28 UNF STRAIGHT GREASE FITTING	1
2	14023	VERTICAL DOUGH GUIDE ROLLERS	1
3	14509	VERTICAL ROLLER SUPPORT BLOCKS	1
4	14515	INFEED AREA PLASTIC DOUGH GUIDE, RS	1
5	14770	3/4" 2 BOLT FLANGED BEARING - SSB SL	9
6	18422	4-BOLT FLANGED BEARING, 1" DIA SHAFT, S.S.	1
7	20407	INFEED AREA DOUGH GUIDE ROLLER SHAFT	1
8	33824	VERTICAL INFEED ROLLER SCRAPER	1
9	34146	BUSHING. 1-1/4"OD FLNGX1"ODX1-1/4"	1
10	35137	RIGHT SIDE PLATE	1
11	F0400LW	LOCK WASHER, 1/4"	24
12	F0402SB	BUTTON HEAD, SOCKET 1/4-20 X 1/2" L	10
13	F0500FW	FLAT WASHER, 5/16"	22
14	F0500LW	LOCK WASHER, 5/16"	23
15	F0500NC	NUT COURSE, 5/16-18	15
16	F0500NLN	NUT, NYLOCK 5/16"	1
17	F0504HHCS	HEX HEAD CAP SCREW 5/16-18 X 1" LG.	16
18	F0507HHCS	HEX HEAD CAP SCREW 5/16-18 X 1-3/4"	2
19	F0510SS	SET SCREW, 5/16-18 X 2-1/2" LG, S.S.	1
20	F0512SD	THREADED ROD, 5/16-18 X 3" LG, S.S.	5
21	F0600FW	FLAT WASHER 3/8"	4
22	F0600LW	LOCK WASHER 3/8"	8
23	F0604HHCS	HEX HEAD CAP SCREW 3/8-16 X 1"	4
24	F0800FW-GR8	FLAT WASHER-1/2"-GR 8 ZINC PLATED	1
25	F0800NLN	NUT-NYLOCK 1/2"	1
26	K104LS1A	SPROCKET TENSION MOUNT SHAFT	1
27	K203RS-1	TENSION BAR	1
28	K204RS	TENSION ADJUSTMENT BLOCK	5
29	K206RS	INFEED CONVEYOR SPROCKET	1
30	K207RS	COUNTER SPROCKET	1
31	K208RS	INFEED CONVEYOR SPROCKET	1
32	K209RS	INFEED DRIVE CHAIN (#50 CHAIN, 58 LINKS + 1 MASTER LINK)	1
33	K213RS	TENSION SHAFT SPROCKET	1
34	R147RA	SHAFT COLLAR	1

Middle Machine Parts Breakdown



Middle Machine Parts List

ITEM	PART NO	DESCRIPTION	QTY
1	13999	DRUM SCRAPER BLADE	1
2	14000	INFEED CONVEYOR DRIVE ROLLER w/ 3.25" DRUM	1
3	14004	DRUM SCRAPER EXTENSION	1
4	14022	DRIVER PLUG FOR DRUM	1
5	14024	SIZING ROLLER *SEE NOTE*	4
6	14210	DRIVE SHAFT (INFEED & DISCHARGE CONVEYOR)	2
7	14216	SPACER BLOCK BETWEEN MAIN SIDE PLATES	2
8	14219	DRUM SCRAPER BASE ASSEMBLY	1
9	14220	SIZING ROLLER SHAFT	4
10	14517	DISCHARGE CONVEYOR DRIVE ROLLER w/ 3.25" DRUM	1
11	14519	COUNTER SHAFT, SHAFT ON BOTTOM w/ LARGE SPROCKET	1
12	14520	KNIFE SHAFT	1
13	14521	CLUTCH SHAFT	1
14	14523	DRUM SHAFT	1
15	20391	DRUM ROLLER ASSEMBLY	1
16	22669	Knife Blade	1
17	22670	Knife Backing Plate	1
18	34917	LIMIT SWITCH MOUNTING PLATE	1
19	35138	LEFT SIDE PLATE	1
20	EL-0430	*SEE NOTE*	1
21	34910	SPACER-1"ODX1-19/32"LG x 13/32"THRU, SS	4
22	34911	GEAR REDUCER MOUNT BLOCKS	2

ITEM	PART NO	DESCRIPTION	QTY
23	EL-2074	*SEE NOTES*	1
24	F0611FSH	FLAT SOCKET HEAD 3/8 X 2-3/4" LG	4
25	F0400FW	FLAT WASHER, 1/4"	18
26	F0400LW	LOCK WASHER, 1/4"	18
27	F0400NLN	NUT, NYLOCK 1/4"	1
28	F0402FSH	1/4: 20 X 1/2 SOCKET FLAT HEAD	3
29	F0402SB	BUTTON HEAD, SOCKET 1/4-20 X 1/2" L	11
30	F0403CB	1/4-20 X 3/4" LONG CARRAIGE BOLT	1
31	F0403SH	SCREW, SOCKET HEAD 1/4-20 X 3/4"LG	2
32	F0404HHCS	HEX HEAD CAP SCREW 1/4-20 X 1"	2
33	F0405SH	SOCKET HEAD, 1/4-20 X 1-1/4" LG	2
34	F0603HHCS	HEX HEAD CAP SCREW 3/8-16 X 3/4"	8
35	F9700FW	8-32 FLAT WASHER	2
36	F9700LW	LOCK WASHER #8	2
37	F9702PHS	Pan Head, Slotted, 8-32 UNC x 3/4	2
38	K122LS	DOOR HINGE ASSEMBLY	2
39	K315RA	DRIVER PLUG (SIZING ROLLER)	4
40	K327RA	INFEED CONVEYOR SPROCKET	1
41	K331RA	SPACER - 1-1/2 OD X 0.687 LG X 1 ID, CR STEEL	2
42	K619C	MAGNETIC REED SWITCH ANGLE BRACKET	1
43	K620C	INFEED CONVEYOR SPROCKET	2
44	SS240	MAGNETIC REED SWITCH	1
45	SS259	MAIN DRIVE MOTOR 1 H.P. RK2100	2

NOTES:

The EL-2074-A, or Drum Gear Reducer kit, is the newest gear reducer on the RK2201. The prior one, AM# SS258, is obsolete. The notes below describe what is needed.

- Machines serialized prior to 11/21/24 must order AM PART #EL-2074-A and K607C for the new style gear reducer to be compatible.
 - If ordering parts for a machine serialized after this date, the Gear Reducer part number is just EL-2074 and no kit is needed.
 - If the number printed on the gear reducer nameplate starts WITH 920MWT, EL-2074-A will be required along with K607C.

Older machines had only 3 of the 14024 Sizing Rollers. The fourth roller replaced the location of the sizing roller guard, 14221.

- 14221 can still be ordered from AM Manufacturing Co.

There are two versions of the actuator arm switch, Item 20.

- Machines prior to 2025 will have the lever toggle switch version, Part Number SS281.
- Machines 2025 and later will have the plunger toggle switch, Part Number EL-0430



Figure 6: SS281

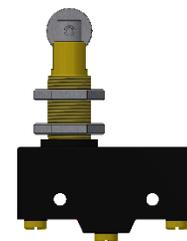
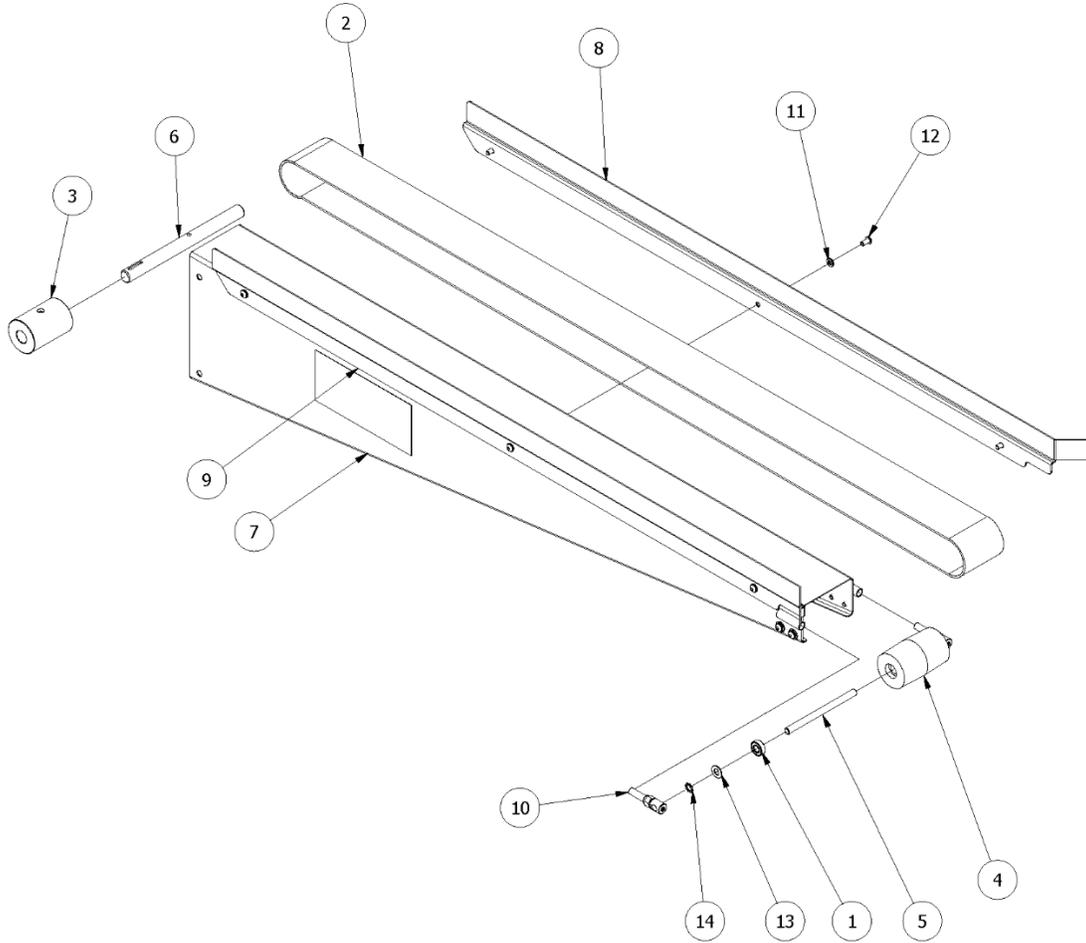


Figure 7: EL-0430

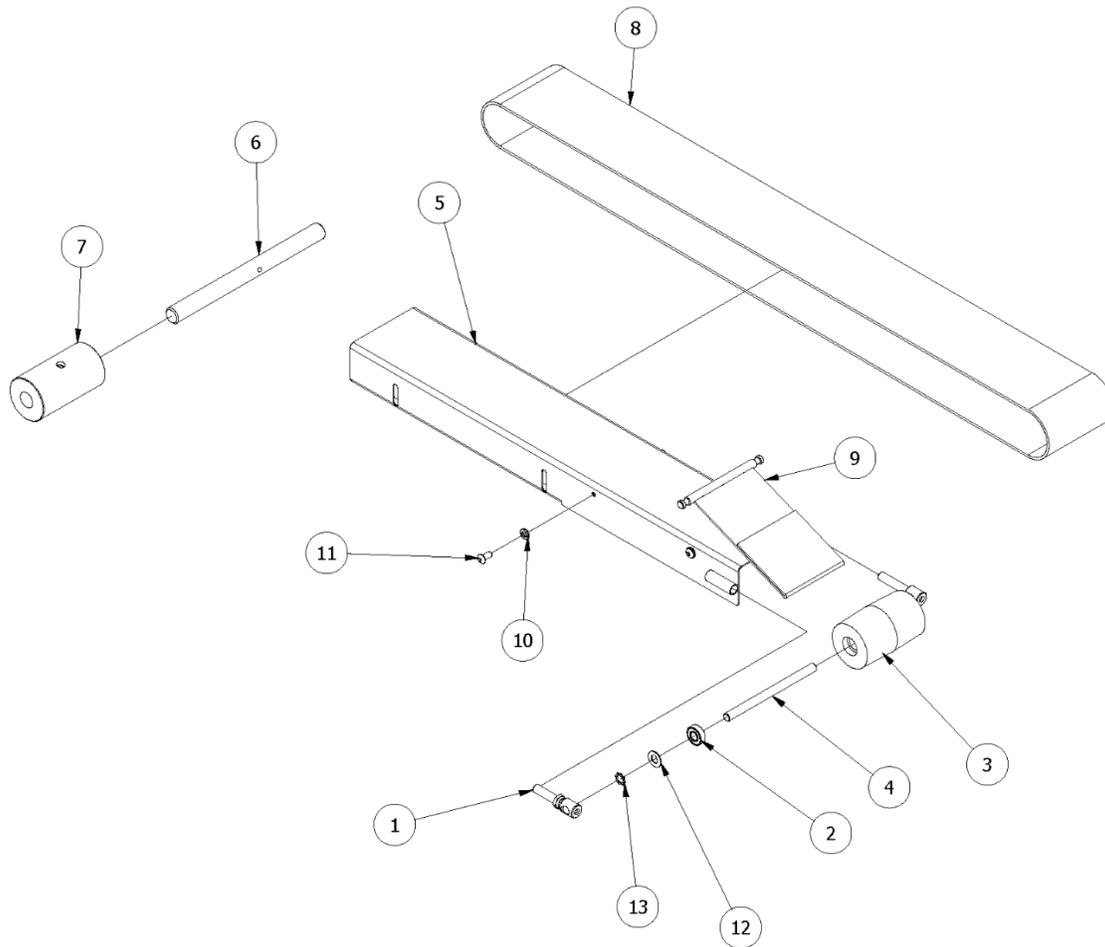
Infeed Conveyor Parts Breakdown



Infeed Conveyor Parts List

ITEM	PART NO	DESCRIPTION	QTY
1	603SCA	BALL BRNG, 3/8"ID X 7/8"OD, DP GROV	2
2	12748	INFEEED CONVEYOR BELT POLY FLAKE / #7 S.S. LACE	1
3	14000	INFEEED CONVEYOR DRIVE ROLLER w/ 3.25" DRUM	1
4	14003-1	INFEEED CONVEYOR IDLER ROLLER	1
5	14021	INFEEED / OUTFEEED IDLER ROLLER SHAFT	1
6	14210	DRIVE SHAFT (INFEEED & DISCHARGE CONVEYOR)	1
7	14508	INFEEED CONVEYOR BODY ASSEM.	1
8	20405	LEFT - SIDE INFEEED RAIL	1
9	20406	RIGHT - SIDE INFEEED RAIL	1
10	A600SC	ROLLER SUPPORT ASSEMBLY	2
11	F0400LW	LOCK WASHER, 1/4"	12
12	F0402SB	BUTTON HEAD, SOCKET 1/4-20 X 1/2" L	6
13	F0600NW	3/8" WHITE NYLON FLAT WASHER	2
14	F0600RW	3/8" RETAINING WASHER	2

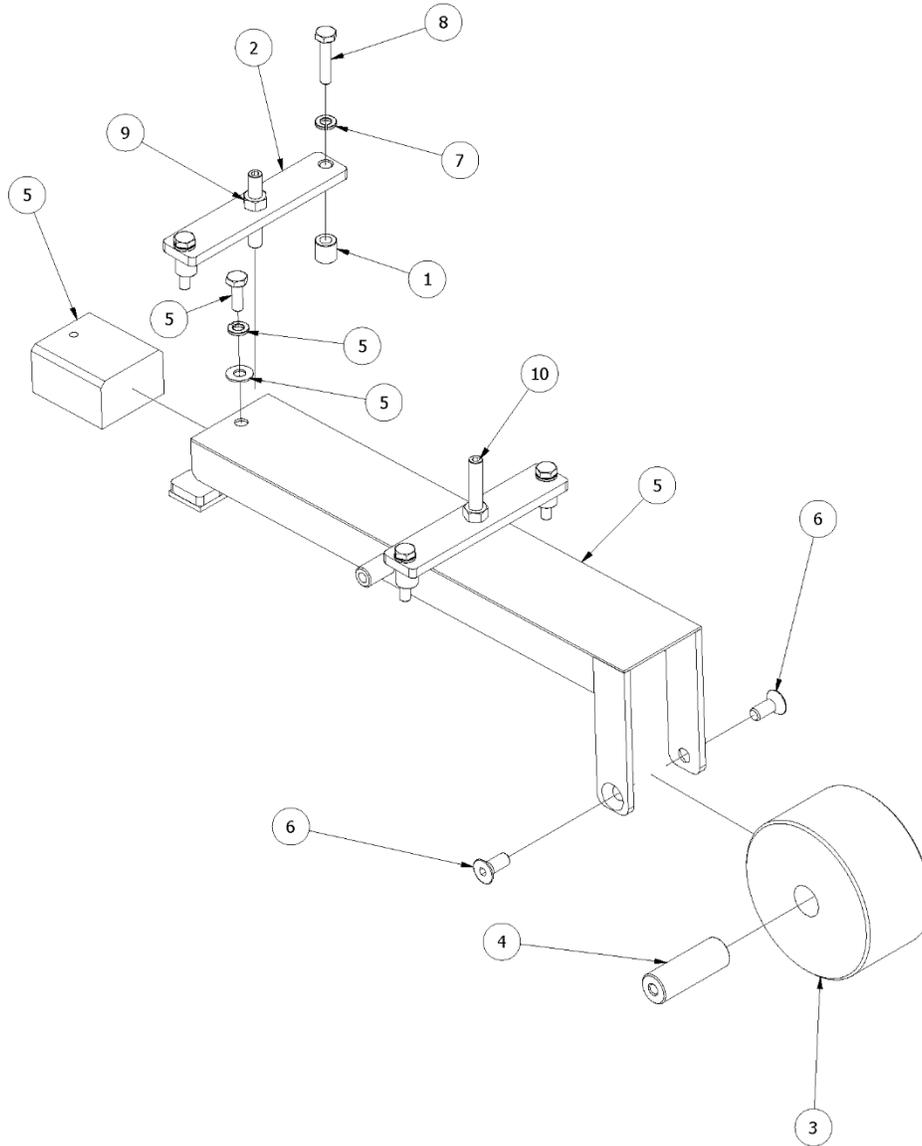
Discharge Conveyor Parts Breakdown



Main Drive Gear Parts List

ITEM	PART NO	DESCRIPTION	QTY
1	600SC	ROLLER SUPPORT BOLT	2
2	603SCA	BALL BRNG, 3/8"ID X 7/8"OD, DP GROV	2
3	14003-1	INFEED CONVEYOR IDLER ROLLER	1
4	14021	INFEED / OUTFEED IDLER ROLLER SHAFT	1
5	14209	DISCHARGE CONV. MAIN FRAME ASSEMBLY	1
6	14210	DRIVE SHAFT (INFEED & DISCHARGE CONVEYOR)	1
7	14517	DISCHARGE CONVEYOR DRIVE ROLLER	1
8	14524	INFEED CONVEYOR BELT	1
9	35224	MESH BELT ASSY. RK2201 3-1/2"W	1
10	F0400LW	LOCK WASHER, 1/4"	6
11	F0402SB	BUTTON HEAD, SOCKET 1/4-20 X 1/2" L	4
12	F0600NW	3/8" WHITE NYLON FLAT WASHER	2
13	F0600RW	3/8" RETAINING WASHER	2

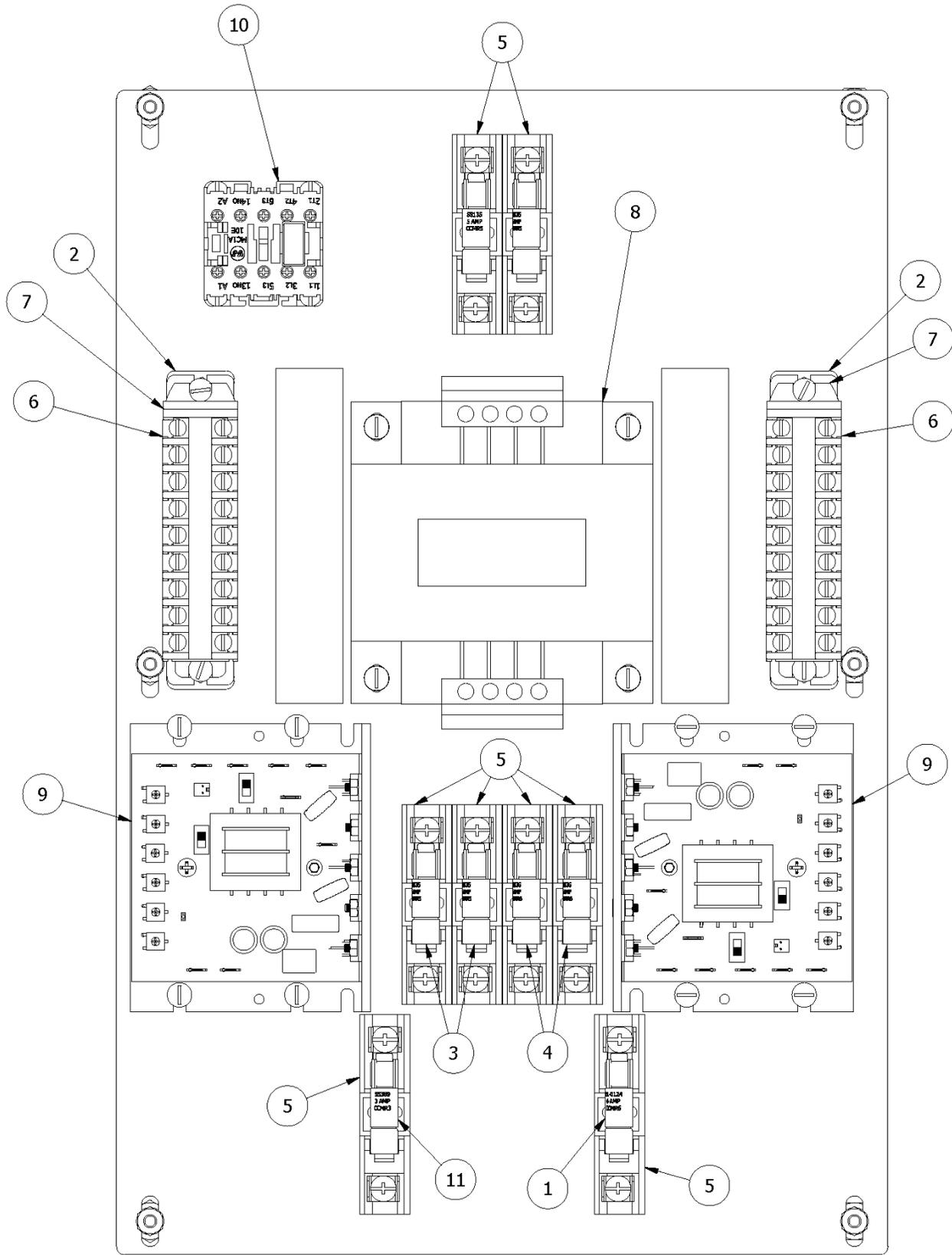
Actuator Arm Assembly Parts Breakdown



Main Frame Assembly Parts List

ITEM	PART NO	DESCRIPTION	QTY
1	642SC	SPACER - 1/2 OD X 1/2 LG X 9/32 ID, ALUM	4
2	14222	ACTUATOR ARM RESTRICTION BAR	2
3	14060	WEIGHT CONTROL ACTUATOR ARM ROLLER	1
4	14224	WEIGHT CONTROL ARM ROLLER SHAFT	1
5	20408-W	ACTUATOR ARM ASSEMBLY WELDMENT	1
6	F0503FSH	FLAT SOCKET HEAD 5/16 X 3/4" LG.	2
7	F0400LW	LOCK WASHER, 1/4"	6
8	F0405HHCS	HEX HEAD CAP SCREW 1/4-20 X 1-1/4"	4
9	F0500NC	NUT COURSE, 5/16-18	2
10	F0508SS	SET SCREW, 5/16-18 X 2" LG, S.S.	2

380V Electrical Panel Parts Breakdown



Electrical Schematics

The following schematics include diagrams on a 208Vac-230Vac 3PH machine. If your machine is not listed or you have any questions, do not hesitate to contact A.M. Manufacturing's Service department at:

Monday through Friday, 7AM to 3:30PM (CST)

Phone: [219-472-6417](tel:219-472-6417)

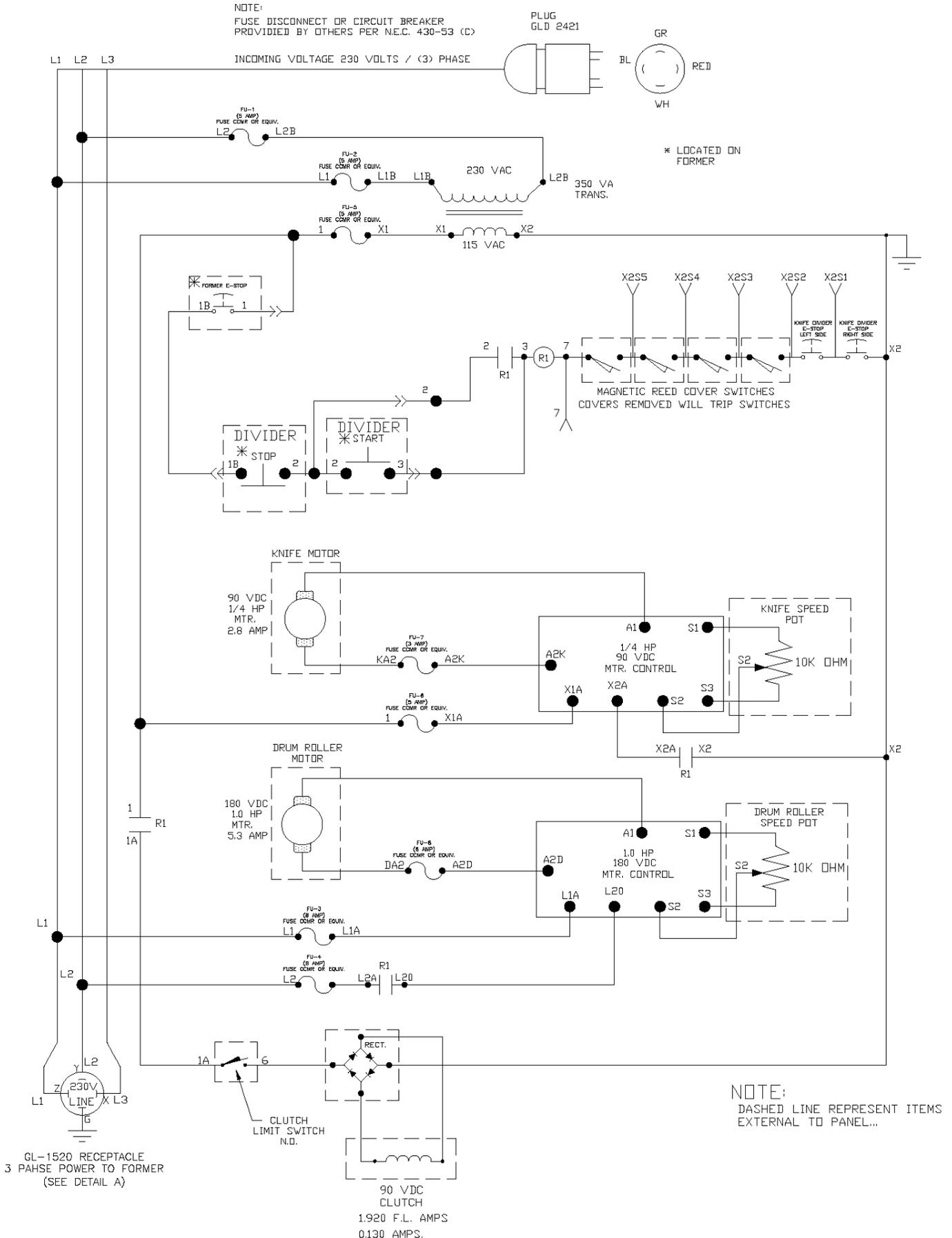
Monday through Friday, 3:30PM to 7AM (CST)

and Saturday or Sunday

Phone: [708-328-3400](tel:708-328-3400)

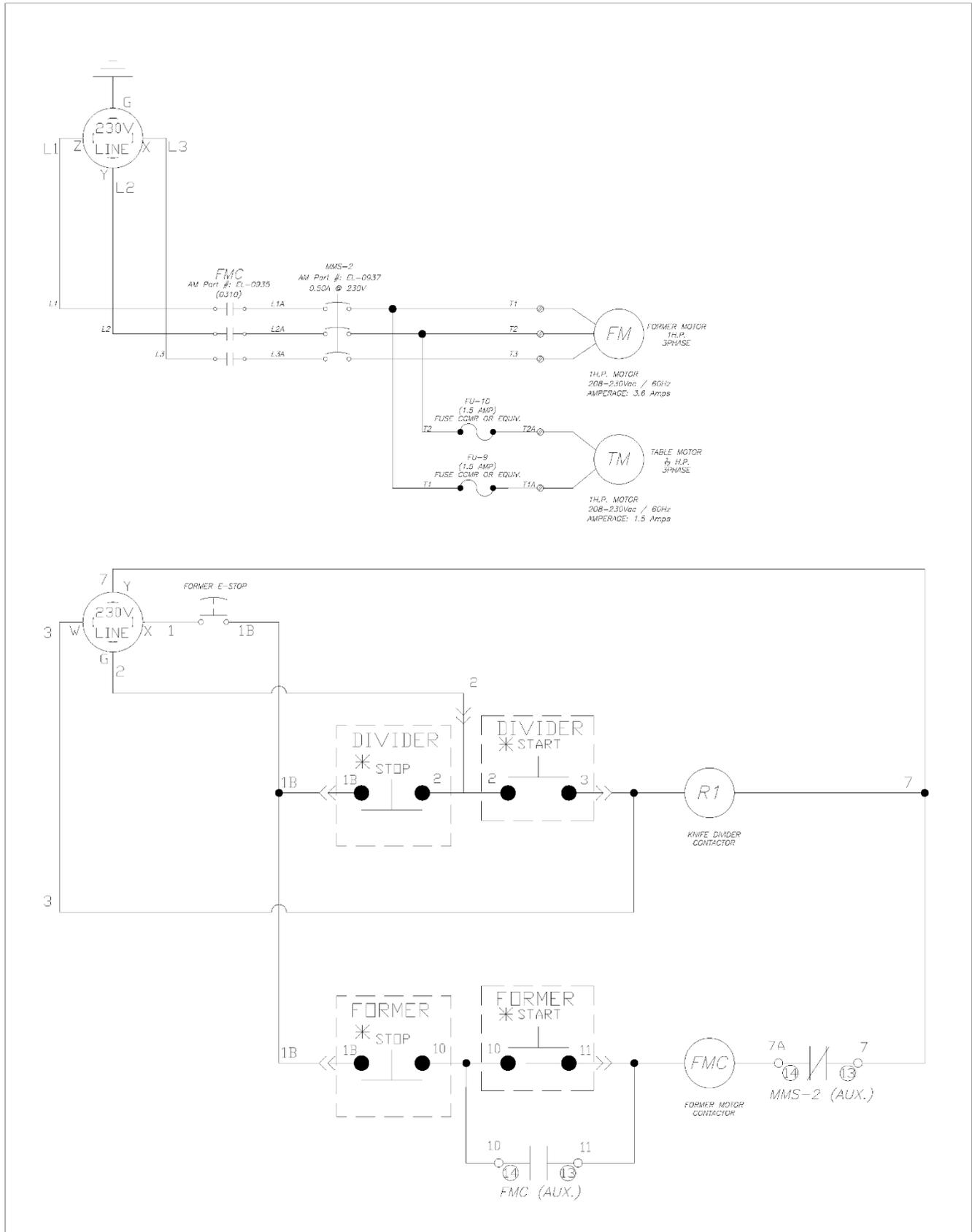
support@ammfg.com

208Vac-230Vac 3PH Schematics



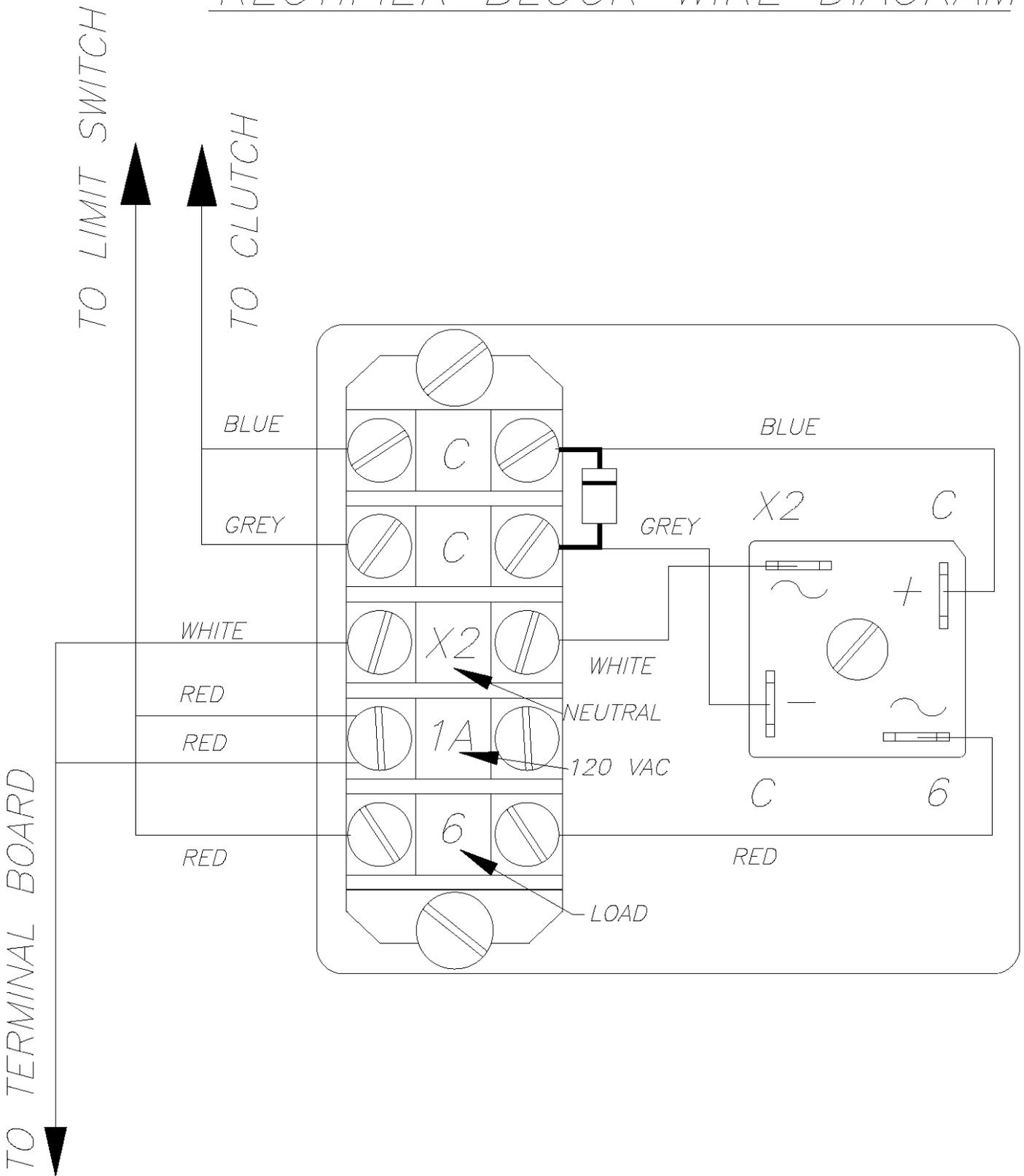
Control & Pushbuttons Station Schematics

DETAIL "A"



Clutch & Rectifier Block Schematics

RECTIFIER BLOCK WIRE DIAGRAM



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 manufacturer's 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 (219) 472-7273 and provide all the information noted above to expedite order processing and help reduce shipping costs.
5. Provide complete details for (ship to) and (bill to) information. To assist prompt delivery, specify the type of carrier speed for shipment.

AM Manufacturing accepts Visa, Mastercard, and American Express.

