



MANUFACTURING
COMPANY

-SINCE 1961-



SAB802

**DOUGH DIVIDER AND BAGEL
FORMER**

OPERATIONS & SAFETY MANUAL

FOR MACHINES BUILT AFTER 2022

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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.

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Introduction

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

FOLLOW ALL THE INSTRUCTIONS BEFORE USE.

The Scale-O-Matic dough divider and bagel former, model SAB802, is designed to give you optimum time and labor-saving service with a speed of approximately 2000 pieces per hour. The SAB802 can accurately scale from 1 oz. To 32 ± ¼ oz depending on the proper attachments. New and current employees can be taught to operate this machine efficiently and safely in a short period of time. We urge you to study this operation and safety manual for full benefits.

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.

DIVIDER	
LENGTH	3'-2 1/8"
WIDTH	2'-4 1/4"
HEIGHT	5'-8 1/2"
HEIGHT (STANDARD HOPPER – LID OPEN)	6'-4 1/4"
HEIGHT (EXTENDED HOPPER – LID OPEN)	7'-4 3/4"

FORMER	
LENGTH	8'-9"
WIDTH	2'-7 7/8"
HEIGHT	4'-1 5/8"

VOLTAGES:

- 3 PHASE, 208 - 230 VOLTS (STANDARD)
- 3 PHASE, 380 – 480 VOLTS

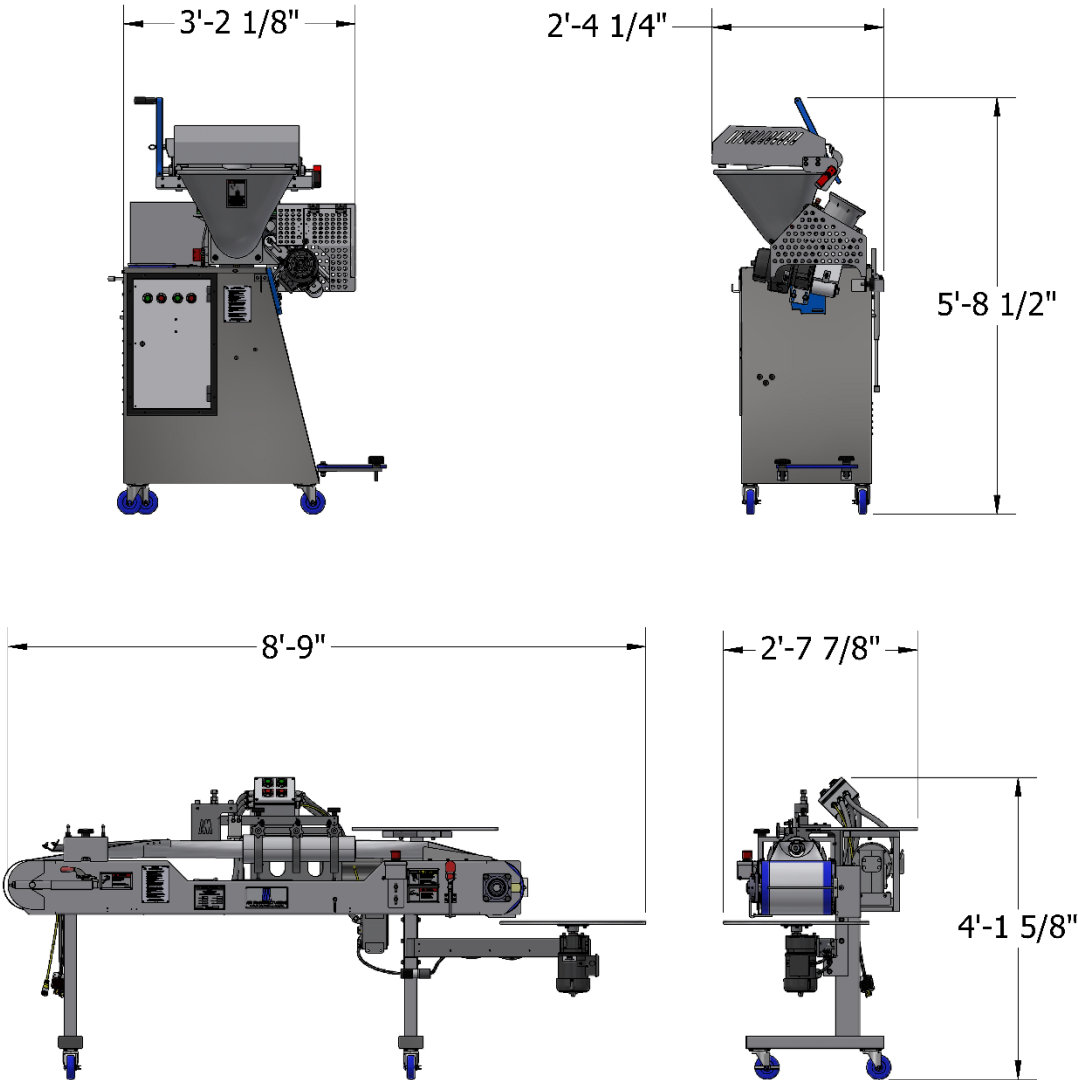


Figure 1: Specifications

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 – Divider

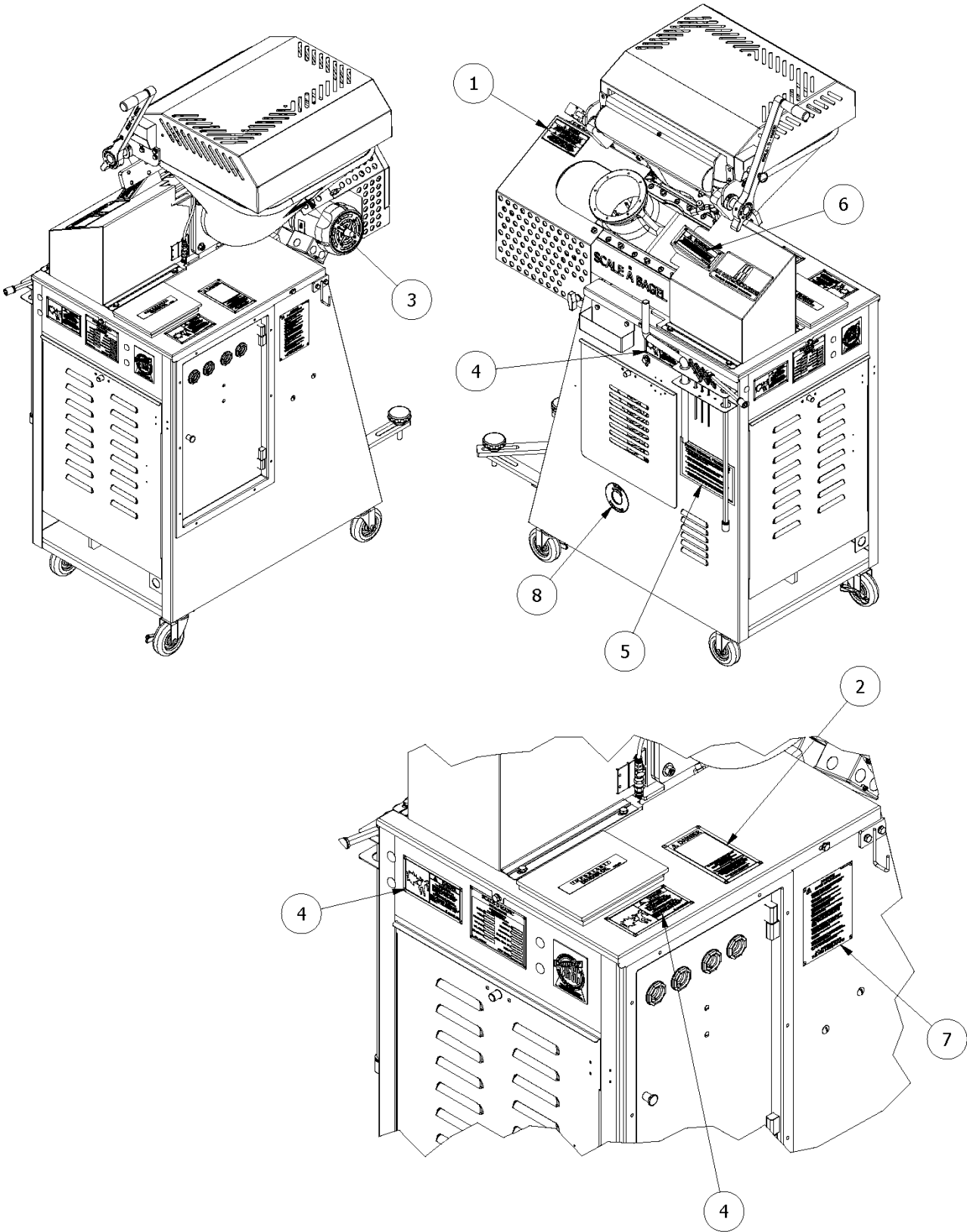
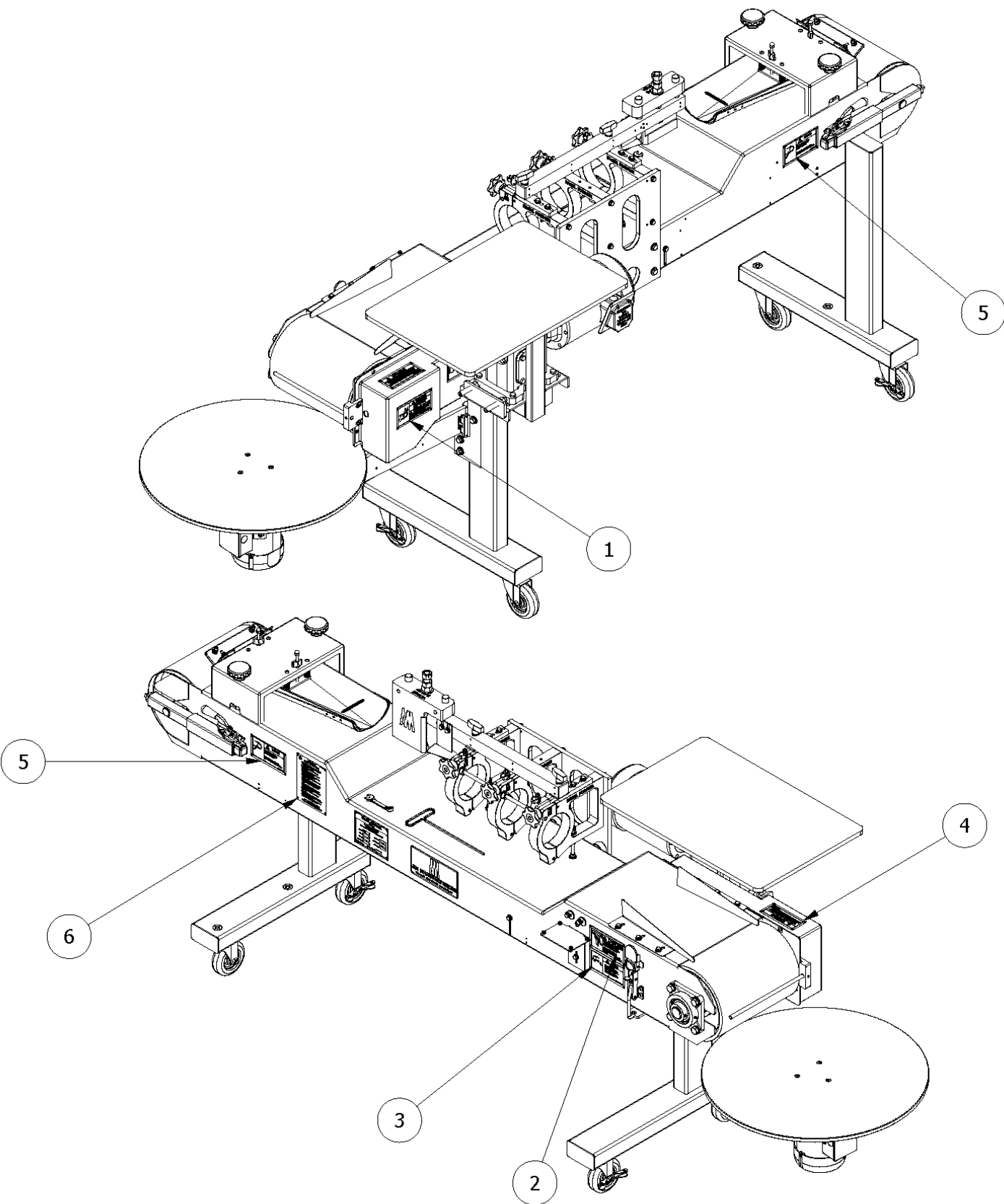


Figure 2: Warning Label Locations

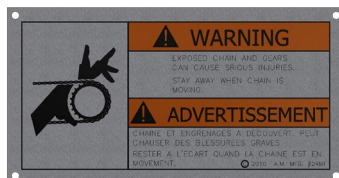
Warning Label Locations - Former



Warning Labels on the SAB802 Former

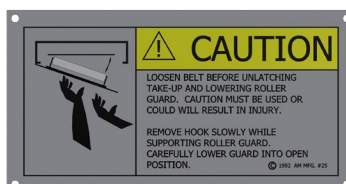
1) AMTAG24MF:

LOCATED ON CHAIN
GUARD COVER AND
BEHIND CHAIN GUARD
COVER



2) TAG #25:

LOCATED NEAR SWING
PLATE



3) TAG9BM:

LOCATED NEAR SWING
PLATE



4) TAG11M:

LOCATED ON TOP OF
CHAIN GUARD COVER



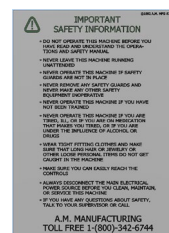
5) TAG14M:

LOCATED ON BOTH
SIDES OF CABINETS
NEAR TENSIONERS



6) TAG21M:

LOCATED ON ONE
SIDE



Divider 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.

Start-up Procedures

1. Ensure the machine and its components are clear of packing material, packing slips, documents, and other obstructions.
2. Position the SAB802 divider into the desired location and lock the two locking casters with their levers.
3. Position the bagel former in front of the divider and lock it to the divider with the connecting bars after positioning.
4. Connect the proper cables to the former and divider and ensure that the former's table motor is connected.
5. Plug the power cord from the divider into the proper outlet.
6. Push the green Bagel Former Start Push-button to turn the machine on **FIRST**.
7. Push the green Bagel Divider Start Push-button after starting the former.
8. Check rotation of the divider by looking through small inspection door. The large gear should be turning clockwise.

NOTE: If the Machine is turning counterclockwise, contact a professionally trained electrician.

Operation Procedures

1. Fill the oil reservoir with lightweight mineral oil. Make sure to clean any oil spilled around machine. These surfaces become slippery.
2. With the squirt bottle supplied, apply a small amount of mineral oil to the inside sides of the dough hopper. The hopper should be oiled every time you place new dough in it.
3. Open the valve located on the top gib bar approximately 1/8 of a turn.
4. Fill the hopper with dough by loading with pieces not exceeding 20 pounds. Dough pieces above 20 pounds could cause serious lower back injury.
5. Close the hopper cover, pull the spring pin, and set the hopper paddle on top of the dough.
6. Press the Divider Button

Dough Dividing

1. Dough is portioned by the measuring cup, which is bolted to the divider slide.
2. To adjust the weight, stop machine. Turning the measuring cup handle in a counterclockwise motion causes the dough weight to increase. Turning the handle in a clockwise motion decreases the dough weight.
3. Find your desired dough weight by weighing the dough piece.
4. Once you have achieved this, adjust the locking star knob (529ms-2d) to the top of the measuring cup to keep scaling accurate.
5. Note the number position on the star knob stud. This can be referenced in the future when setting back up for the same dough weight.

NOTE: When the former is not in use, it is recommended to release tension from the belt by dropping the swing plate and lifting the tension clamps. See the instructions on page 19.

General Overview of the SAB Divider

The SAB802 divider has various components that are important to familiarize yourself with to effectively operate, maintain, and clean your machine.

General Components

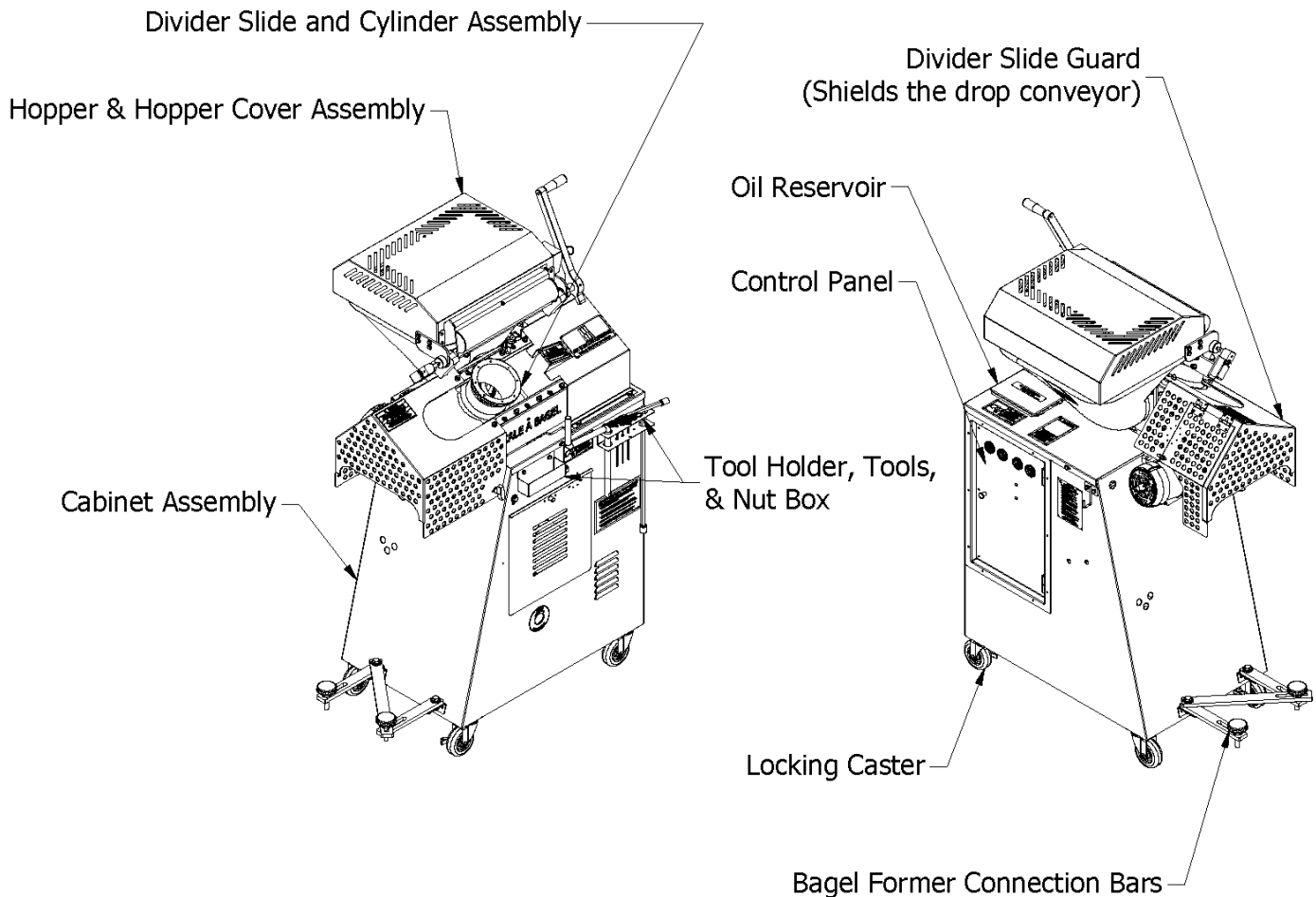


Figure 3: SAB Divider Overview

Divider Slide and Cylinder Assemblies

- The divider slide and Cylinder Assemblies are the core components of the SAB802 that allows the machine to scale.
- The Divider Cylinder has a metal scraper ring and O-Ring which sits on top where the divider slide rides.
 - These two rings are wearable components that are vital to machine scaling and suction.
- Within the cylinder is the piston assembly. This helps to create suction and push the dough up towards the measuring cup.
 - The piston contains a piston cup and O-ring, which is vital to the machine's scaling and suction.

Hopper & Hopper Cover Assembly

- This is the assembly where dough chunks are fed and pushed down towards the cylinder.

Cabinet Assembly

- Includes the doors and accessible areas for maintaining, cleaning, and accessing various components in the machine.

- Equipped with safety sensors to allow for machine shut off in the event a door or guard is removed during operation.

Tool Holder, Tools, & Nut Box

- The divider comes with various T-handle Allen wrenches, a T shaped socket assembly, and a crank handle.
- The nut box allows for easy storage of nuts and bolts removed during disassembly for cleaning or maintenance.

Divider Slide Guard

- Guards the area around the divider slide to prevent injury.
- This guard covers the drop conveyor assembly.
 - This drop conveyor assembly drops the divided dough onto the bagel former

Measuring Cup

- Allows for adjustment of dough weight.

Oil Reservoir

- Where oil is added and distributed by an oil pump to the machine.

Locking Casters

- These casters lock in place so the machine cannot roll away.

The Emergency Stop

- Located on the front of the control panel is the Emergency Stop button.
- This button allows for a quick stop of the machine in case of emergency.

General Cleaning Instructions

⚠ WARNING: Before attempting to clean the Divider, 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 divider is essential to ensure sanitary conditions and proper machine function. Regular cleaning will extend the life of various components within the machine.

General Cleaning

- The drip pan below the machine should be emptied and cleaned off daily.
- The front of the cylinder has a Scale-O-Matic name plate that allows excess oil to drain to the drip pan.
 - This plate can be removed by loosening the small Allen head bolt in the center of the plate.
 - Regularly clean out the channels on this plate and ensure it is free of any sediment so oil can continue to drain properly.
- Wipe excess dough from the inside of the dough hopper.
 - **NOTE: Never use a metal edges scraper for cleaning any part. These tools can result in damage to coatings and parts.**
- The inside of the divider should be cleaned out occasionally.
 - Remove any buildup around the main drive gear (Part # S0113CD) inside the machine.
 - Remove any build up around the bronze shoe (Part # 448CD) that the main drive gear sits inside of.

Divider Cleaning and Disassembly

1. **Shut off and disconnect all power to the machine.**
2. Remove the cover over the drive end of the slide above the rocker arm. Slide back to remove it.

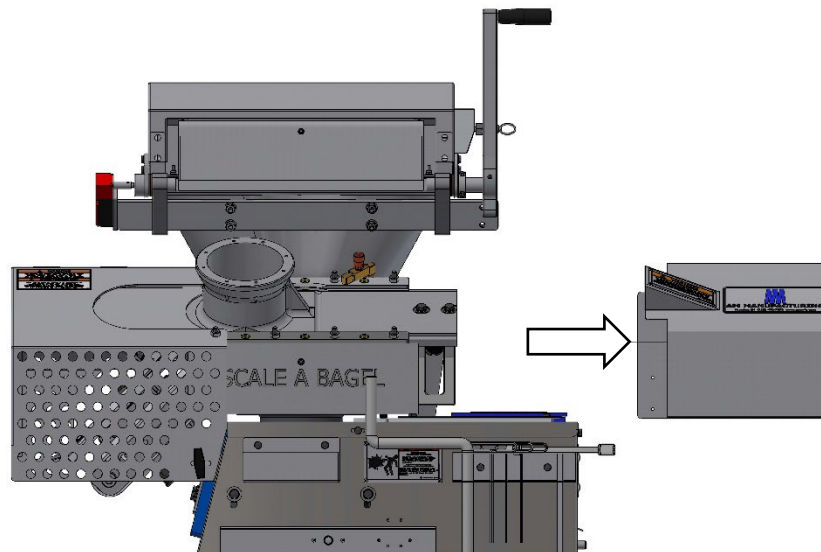


Figure 4: Rocker Arm Cover Removal

3. Break loose the 4 socket screws at the top of the measuring cup on the divider slide. Twist and pull to remove the cup.

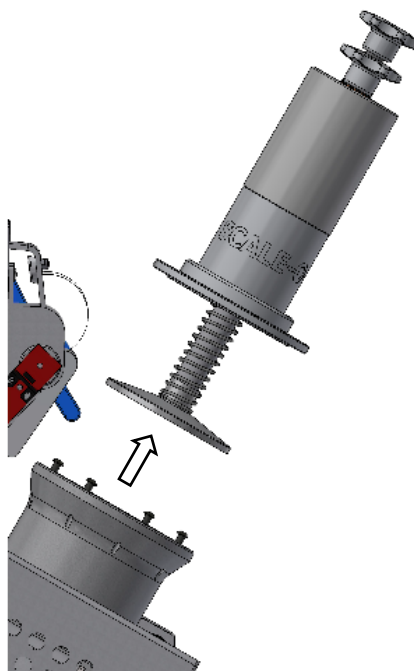


Figure 5: Measuring Cup Removal

4. Remove the measuring cup and clean.
5. Remove and clean the measuring cup insert, if the plunger at the bottom of the measuring cup is 5" in diameter, there will be no insert to remove.
6. Loosen the 8 hex head nuts at the top of the gib bars (the bars on the top and bottom of the slide which the divider slide rides against). Two of the nuts are holding the divider slide guard.
7. Remove the divider slide guard that is above the drop conveyor by removing the wing nut and lifting it up and out.
8. Remove the gib bar assemblies by lifting them off the cylinder studs. Clean any dough residue from them.
9. Remove the divider slide by lifting it up and out. Clean thoroughly.

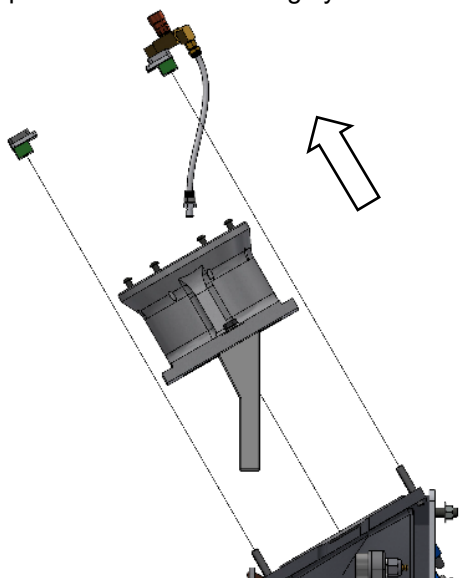


Figure 6: Divider Slide Removal

10. Remove the side door on the left-hand side of the machine when facing the rear of the machine. This uncovers the hole where the crank handle enters.

Removing the Piston

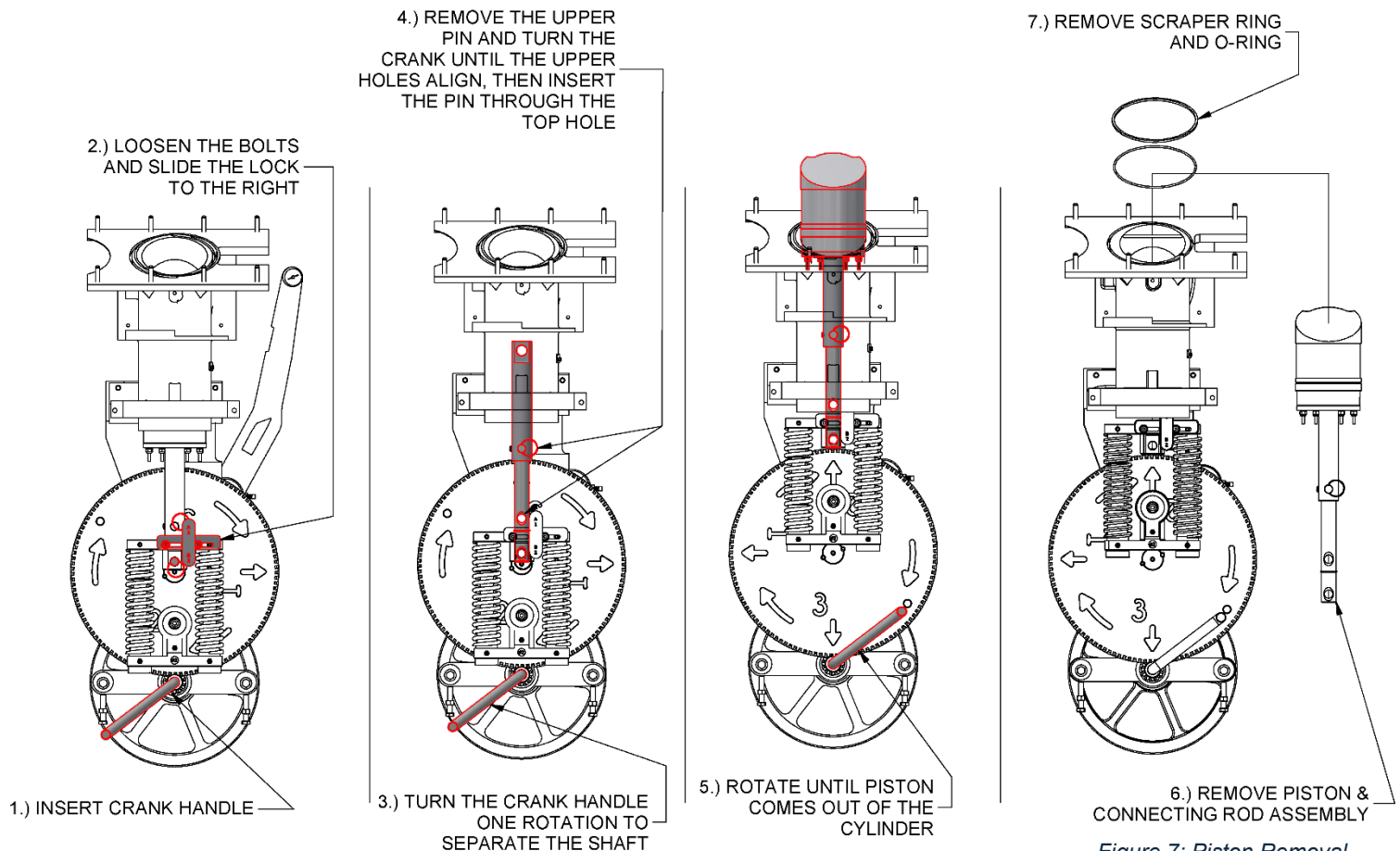


Figure 7: Piston Removal

NOTE: The above steps are only to be done after following the steps on the previous page.

The steps above highlight the procedure to remove the piston for cleaning and maintenance.

- Ensure that any excess dough is removed from face of the cylinder and that the scraper ring and O-ring that were removed in Step 7 (Figure 7 above) have been cleaned.
- Ensure that any dough residue has been cleaned from the inside and outside of the dough cylinder.
 - Make sure to clean out the hole where the oil valve feeds inside the cylinder.
- Clean all surfaces around the piston from dough.

Reinstalling the Piston

1. Replace the piston.
 - a. Ensure the piston is in an extended position with the pin in the upper hole.
 - b. Put the piston into the cylinder, guiding the shaft into the spring assembly.
 - ⚠ WARNING: ENSURE THAT THE PISTONS ANGLED FACE IS FACING YOU, PUTTING THE PISTON IN BACKWARDS WILL DAMAGE IT WHEN THE MACHINE IS IN OPERATION.**
 - c. Take the other pin and put it in the lower hole through the spring assembly.
 - d. Rotate the crank until the upper pin is visible and remove it.
 - e. Turn the crank until the shaft collapses and the two upper holes meet, then insert the pin.
 - f. Push the “plus sign” shaped pin lock slide over and tighten the 2 socket head bolts.
 - g. **Verify that the piston collapses by making one full rotation with the crank and note that the piston does not come above the upper cylinder. If the piston is backwards, it could be destroyed during operation.**
2. Place the divider slide back on top and bolt the cam arm slide back to the divider slide.
3. Reinstall the Gib Bars with the 8 hex nuts.
4. Reinsert the measuring cup and cup insert (if applicable). Turn the cup and tighten the 4 bolts to lock in place.
 - ⚠ WARNING: Failure to reinstall the insert on measuring cups where it is required will result in damage.**
5. Remove the hand crank.

Bagel-former Belt Removal & Cleaning

⚠ WARNING: Before attempting to clean the former, 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 former is essential to ensure sanitary conditions and proper machine function. Regular cleaning will extend the life of various components within the machine.

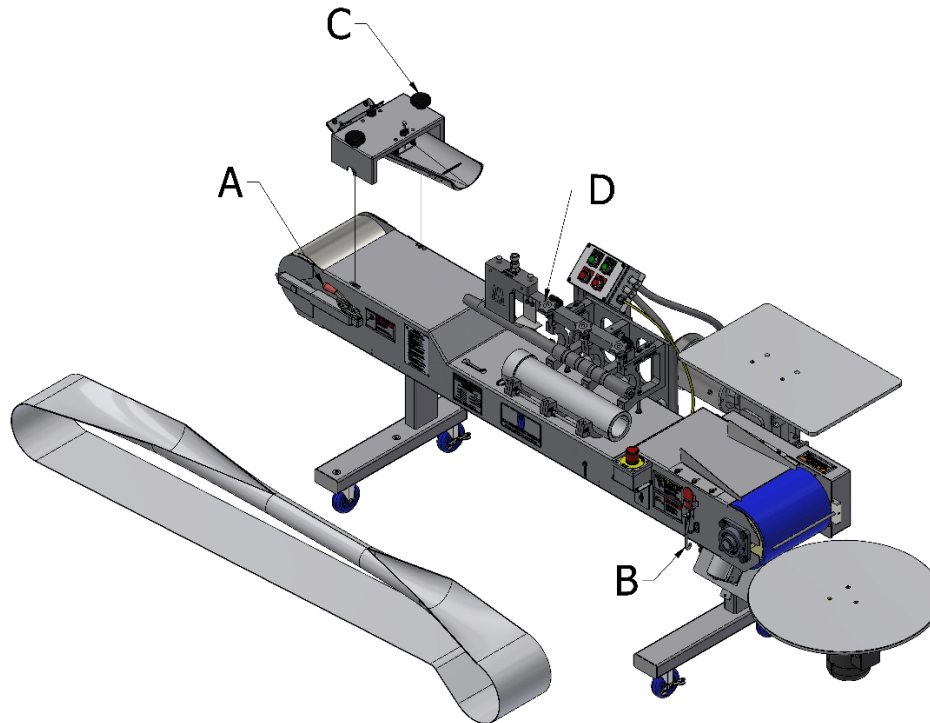


Figure 8: Belt Removal

Removing the Bagel Belt

- A. Lift the two red handled clamps (Figure 8, A.) on the drive roller end and push the drive roller inwards.
- B. Locate the red handled swing plate latch on the opposite end (Figure 8, B).
 - a. Push in the small red lever and pull the larger red handle away to disengage the swing plate assembly.
- C. Locate the two black knobs on top of the pressure plate bridge (Figure 8, C).
 - a. Loosen both knobs until the bridge and pressure plate assembly can be removed from the machine.
- D. Locate the three (3) star knobs on the mandrel support area (Figure 8, D).
 - a. Loosen two of the knob until the rods that the knobs are threaded onto can lift into their latches.
 - b. Loosen the last knob, ensuring that the clamps are supported by hand, so they do not fall.
 - c. Remove the forming tubes and the belt.

Tensioning and Aligning the Bagel Belt

The bagel belt must be properly installed, aligned, and tensioned for the belt to track in the center of the rollers and to prevent premature wear. If reinstalling the bagel belt, perform the previous section for Figure 8 in reverse.

1. The hex nuts found at the very end of the lifting clamps in Figure 8, A are used to adjust the tension.
 - a. The hex nuts must be turned clockwise to loosen the belt and counterclockwise to tighten it.
 - b. Never adjust one nut independently of the other for more than five rotations.
2. During the tightening or loosening process, alternate from the right side to the left side for equal adjustment.

Cleaning the Bagel Former

1. Loosen and remove the forming belt, cleaning off any built-up dough residue.
 - a. Follow the instructions in the **Removing the Bagel Belt** section to remove the belt.
2. Remove the forming tubes from the machine and gently wash with soap and water, using a nonabrasive cloth.
3. Clean the swing plate tensioner below the machine of any excess dough buildup. (Figure 9).
4. Clean any dough built up along the dough scraper below the bagel former. (Figure 9).

NOTE: THE BAGEL FORMING BELTS SHOULD REMAIN LOOSE WHEN MACHINE IS NOT IN USE TO AVOID STRETCHING.

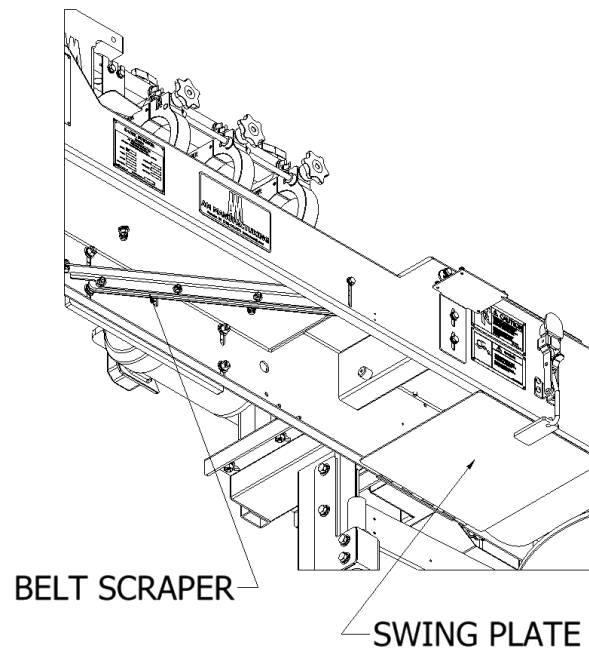


Figure 9: Scraper & Swing Plate

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 this machine, 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.

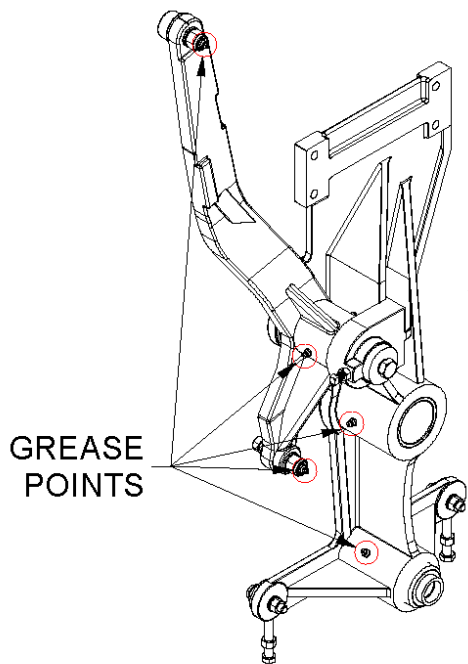
- All working surfaces should be cleaned regularly.
- The cabinet and other working surfaces should be cleaned regularly.
- Make sure that all fasteners are tightened securely.
- Make certain that all guards and covers are in place.
- Check for worn, damaged or missing parts including belts, safety guards, 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 this equipment always begins with keeping the machine clean. Proper cleaning procedures start on pages 16 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.



There are 5 grease fittings located on the rocker arm and divider frame:

- 1 on the cam roller at the top of the rocker arm.
- 1 on the cam shoe bolt at the bottom of the rocker arm.
- 3 total on the bronze bearing locations on the rocker arm and main frame.

The piston and spring load assembly, pictured on the right, have a total of 4 grease fittings.

- Three of these fittings are found on the lower casting of the spring load.
 - Apply a small amount of grease to these fittings once a week.
- The same procedure should be followed for the grease fitting under the piston at the top of the figure on the right.
 - This fitting will require a flexible hose grease gun or removal of the piston to access.

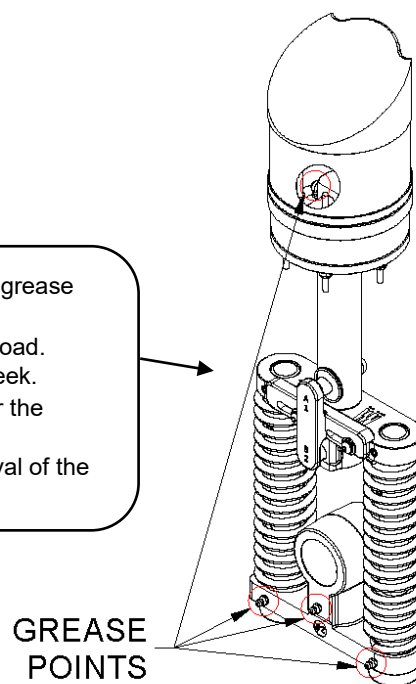
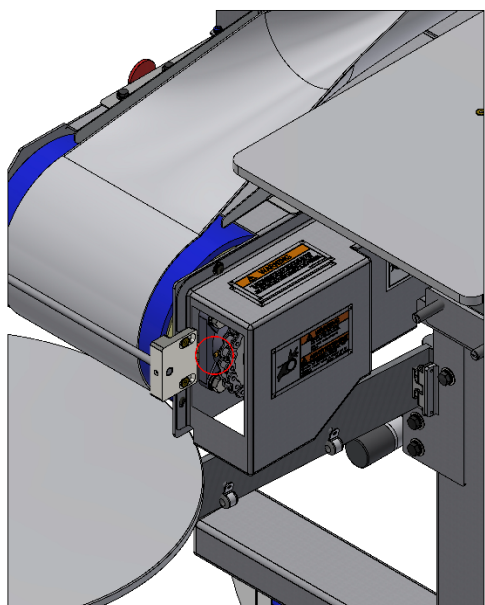


Figure 10: Grease Points



The bagel former has a grease point on the two bearings on each side of the discharge end.

- Ensure these bearings are regularly greased along with the chains and sprockets behind the chain guard.

Adjusting the Measuring Cup Depth

Following any disassembly of the Measuring Cup assembly, the measuring cup must be properly set. Setting the measuring cup means adjusting the distance of the bottom of the plunger base. Setting the Measuring Cup allows for the Cup and the Divider Slide to slide freely. **The depth of the measuring cup will need to be adjusted any time the cup is disassembled, or a component is replaced.**

⚠ CAUTION: Failure to properly set the Measuring Cup will result in damaged components!

The instructions below are assuming the cup is already partially disassembled.

To adjust the depth of the plunger on the Measuring Cup Assembly:

1. Set the measuring cup components on a flat surface.
2. Remove the divider slide and place it on a flat surface with the other components.
3. Loosen the $\frac{3}{4}$ " long socket head bolt from the slot nut on the measuring cup.
4. Place the measuring cup on the divider slide.
5. Turn the slot nut to the right to bring the plunger base up, or to the left to bring it down.
6. Feel beneath the divider slide and adjust until there is about a $\frac{1}{16}$ " inch space from the bottom of the slide to the bottom of the plunger base inside the slide.
 - The gap allows it to avoid wear or damage when the slide is traveling.
7. After the slot nut is adjusted to where there is adequate depth, reinstall the $\frac{3}{4}$ " long socket head bolt.
- Apply blue thread locker to the bolt and tighten down all the way so the slot nut can lock onto the thread.
8. Reassemble the Measuring Cup Assembly.

NOTES:

- The diagram shown is for a 5" diameter plunger base, which does not use a divider cylinder insert.
- For measuring cups 1-1/2" (Part # AMS1), 2" (Part # AMS2), and 3-1/4" (Part # AMS3):
 - Adjust the plunger to be flush with the bottom of the divider cylinder insert (Figure 11) that sits inside the divider slide.
 - **The divider cylinder insert must be placed into the divider slide before operation.**

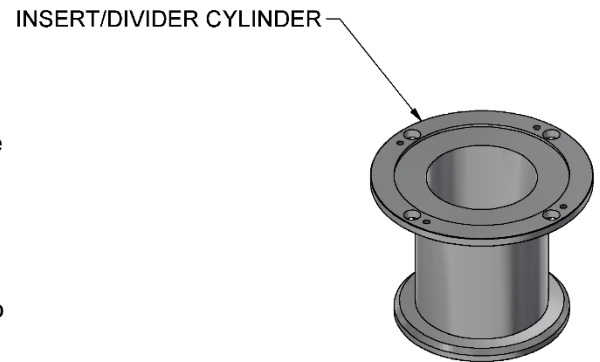


Figure 11: Insert/Divider Cylinder

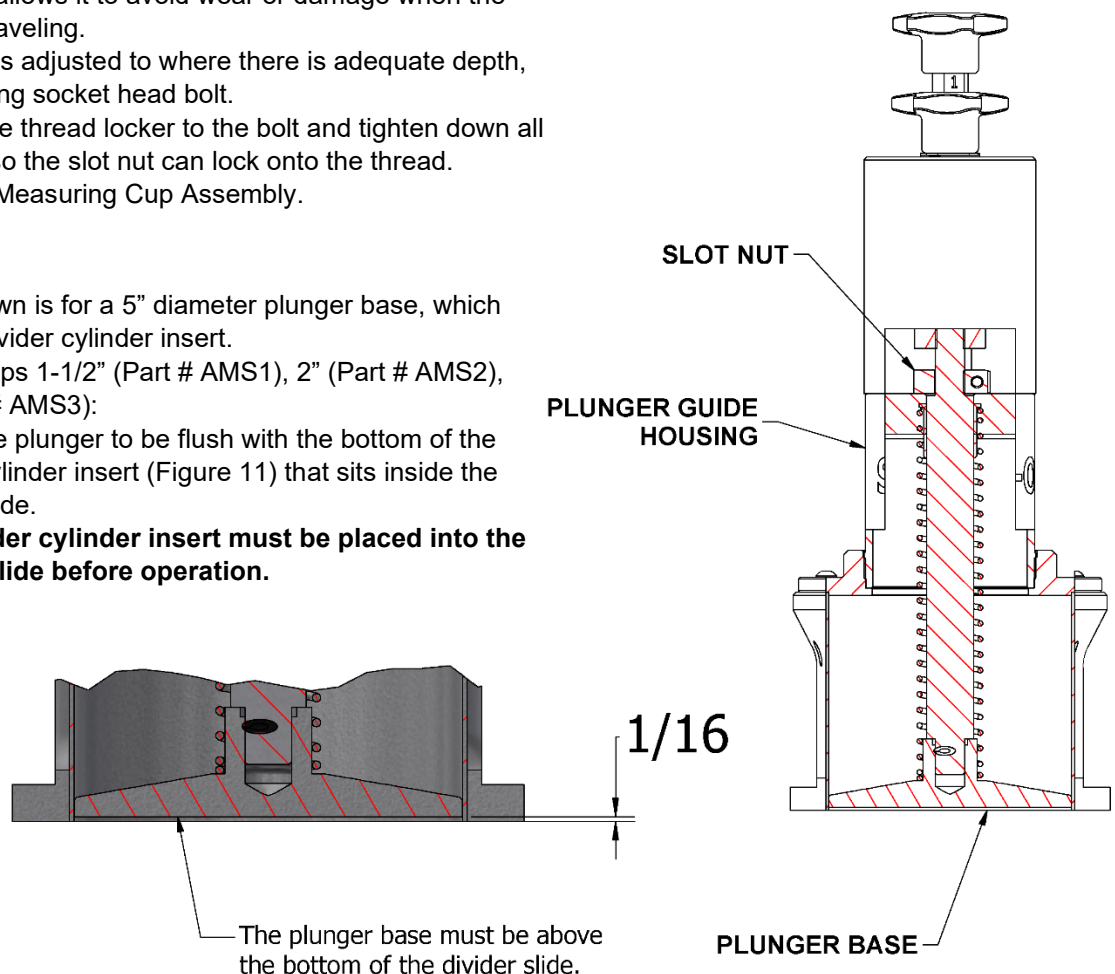


Figure 12: Measuring Cup Depth

Basic Trouble Shooting Guide

Issue	Probable Cause	Solution
Loss of suction.	Wear within the scaling area of the divider.	Replace the Cylinder Scraper Ring, Cylinder O-Ring, Piston Cup, Piston O-Ring. If problem persists, contact manufacturer. *See notes below*
Machine Not Powering On	Main Power to machine, safety circuit.	Check the safety circuit on all guards. Open the panel, check for power light on safety relay. If light is off, check the fuses.
Individual motor does not run	Bad circuit breakers, bad motor.	Check the circuit breakers. Replace motor if necessary.
Former motor does not run	Broken connection, parts, or bad motor	Check the overloads, replace the motor as needed.
Table motor does not run	Broken connection, parts, or bad motor	Check the fuses, replace the motor as needed.
Both former motors not running	Power disconnected, bad contactor.	Verify connections and check the contactor. Ensure the E-stop is not activated.
Bagels not tying	Excess dough weight, pressure plate needing adjustment, or incorrect bagel setup sizes.	Check that infeed dough is of the expected weight. Adjust the black plastic wing nuts on the pressure plate assembly to push down or lighten up as needed.
Bagels are lop-sided	The mandrel mount bar holding the mandrel bar and sleeve is off center with the forming tubes.	Adjust the mandrel bar's position from side to side, centering it as needed.

Note: The following items may cause suction problems after excessive wear or incorrect adjustment.

- The Cylinder Scraper Ring, Cylinder O-Ring, Piston Cup, Piston O-Ring.
- The wear strips and components that make up the gib bars that sit on the divider slide. These are held on by the eight cylinder studs.
- The measuring cup plunger.

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

Bagel Forming Belt Setups

On the AM Manufacturing Bagel Former, there are various optional sized parts that allow for different raw bagel weight ranges. The chart below shows the standard sizes of these bagel forming set-ups, which are guidelines to reach specific weight ranges. Some of these parts can be changed to achieve more custom bagels, but not all will be guaranteed to form correctly. Pushing too much dough through a smaller setup may cause issues tying the bagels together, and dough weights may change if using a smaller mandrel bar and sleeve but a much larger forming tube and belt..

- The mandrel bar and mandrel sleeve play a direct role in how the hole of the bagel will look after it is formed.
- The forming tube affects the outer shape of the bagel.
- Keeping the right amount of dough balanced to satisfy the sizes of the setup is key to forming a bagel.
- **The bagel belt size much match its corresponding set-up size so the belt can fit the forming tube correctly.**
 - For example, a 9-3/4" BDP22 belt will not fit inside a standard BFM21 forming tube, the belt will overlap. If used with a larger tube, the belt will not fully meet inside the forming tubes. The BFM21 forming tube will only work with an 8-7/8" wide belt.

The chart below shows the setups along with the components that make up with them. The weight column on the right shoes the weight ranges for those setups, but these can vary if parts are mixed and matched.

SETUP	SET UP SIZE	TUBE #	TUBE ID	BELT#	BELT WIDTH	MANDREL BAR PART#	MANDREL BAR DIA	MANDREL SLEEVE PART#	MANDREL SLEEVE DIA	WEIGHTS OZ
MICRO	5"	BFM54	1.625"	BDP27	5"	BFM37D	3/4"	N/A	N/A	1/2-3/4 OZ
COCKTAIL	6"	BFM40	1.91"	BDP23	6"	BFM37E	1-1/8"	N/A	N/A	3/4-1-1/2 OZ
MINI	7"	BFM50	2.33"	BDP25	7"	BFM37F	1-1/4"	N/A	N/A	1-1/2-2 OZ
BLACK	8"	BFM51	2.646"	BDP26	8-3/8"	BFM23	1-1/2"	BFM34	1-1/2"	2-3 OZ
STANDARD	9"	BFM21	2.866"	BDP21	8-7/8"	BFM55	1-3/4"	BFM35	1-7/8"	3-3.8 OZ
BULL	10"	BFM41	3.182"	BDP22	9-3/4"	BFM55	1-3/4"	BFM37	2"	4-5 OZ
MAXI	11"	BFM53	3.615"	BDP24	11"	BFM56	2"	BFM37-B	2-1/4"	5-6 OZ

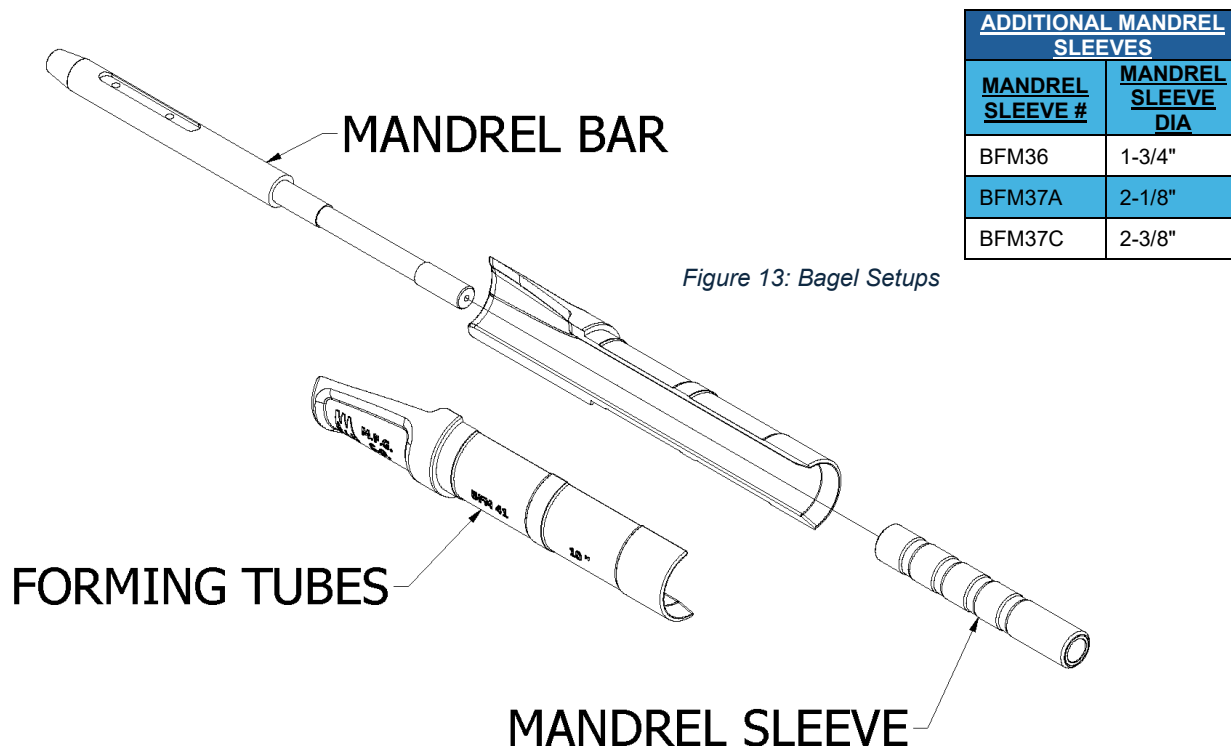
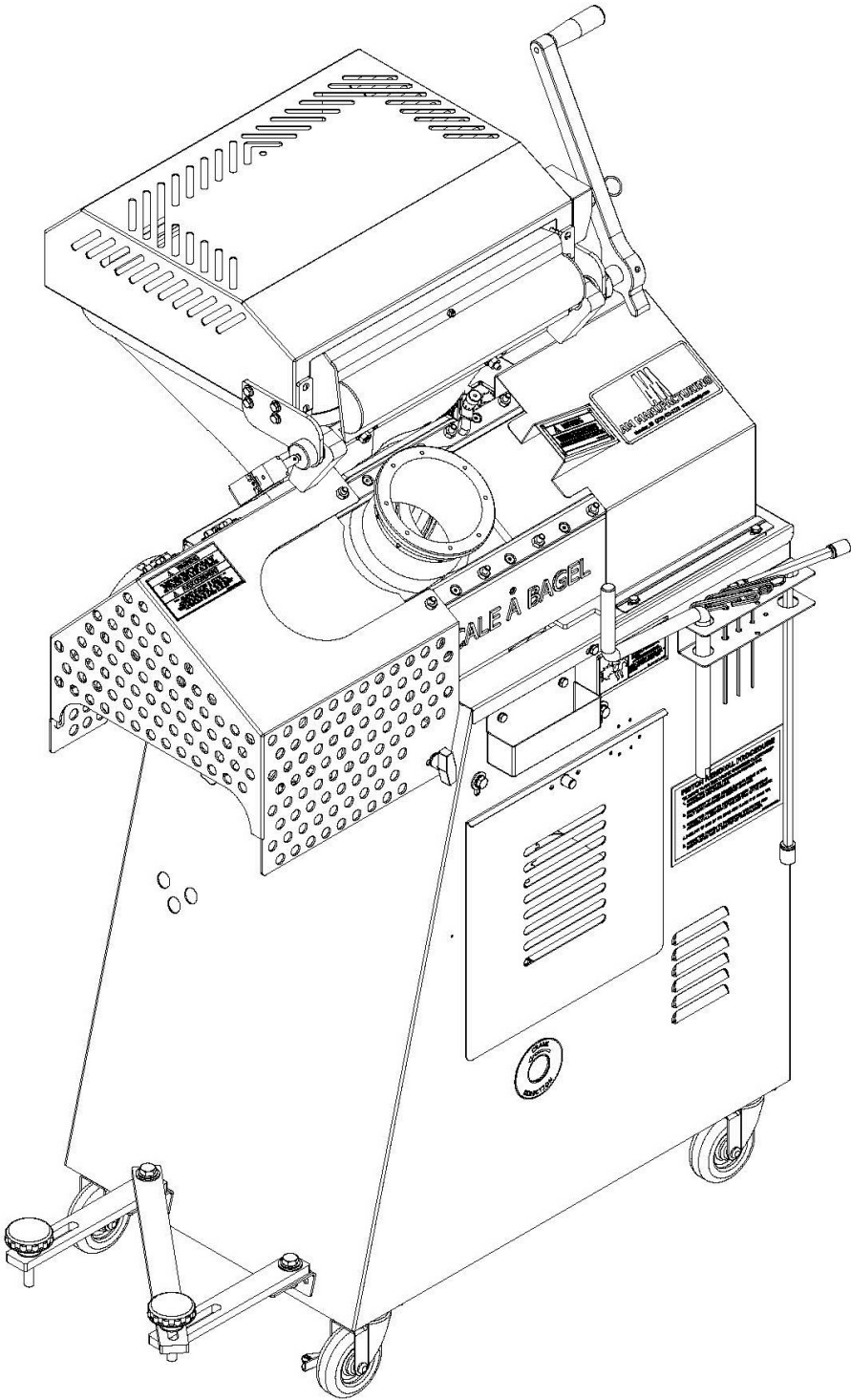
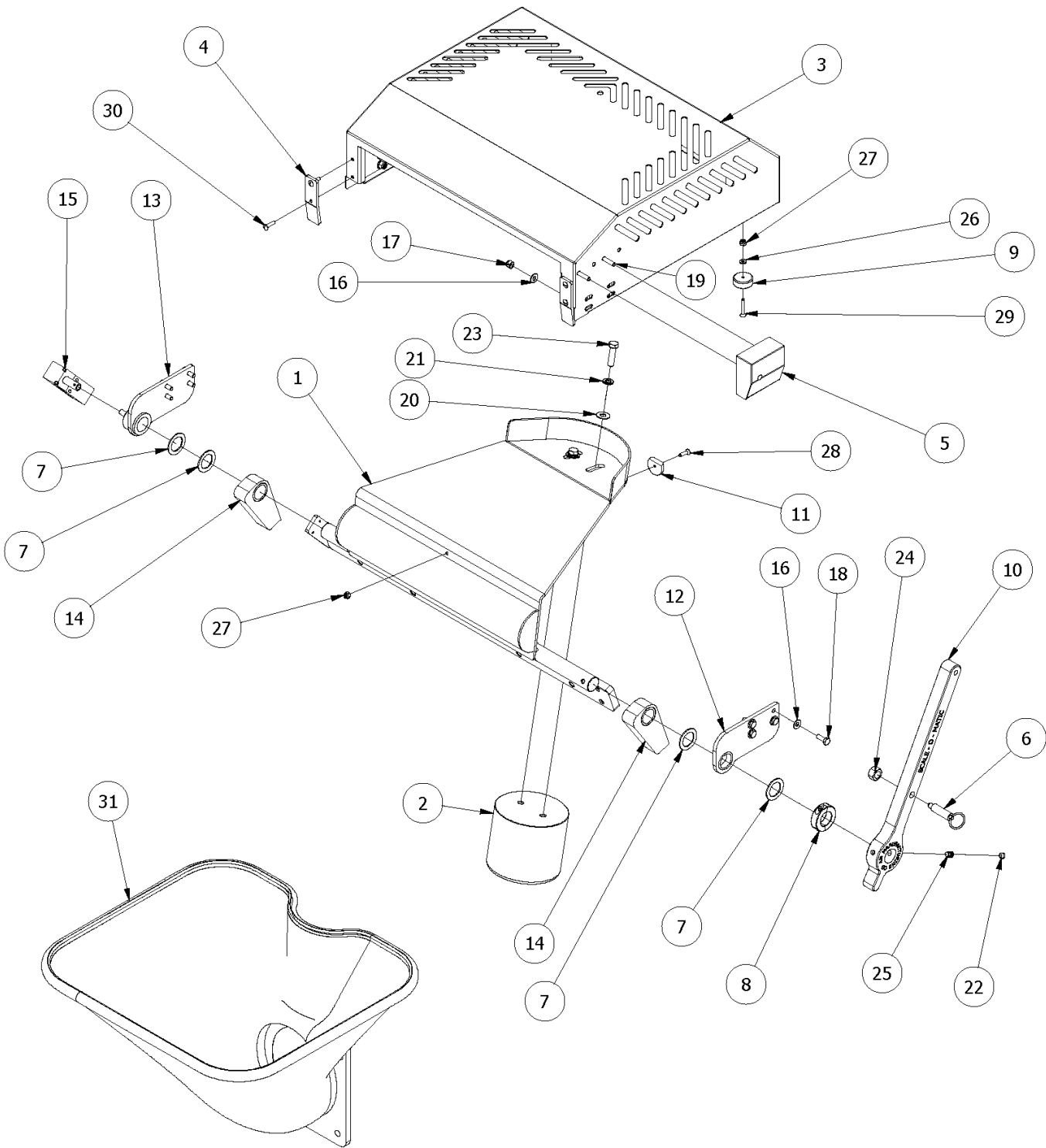


Figure 13: Bagel Setups

Divider Parts Catalogue



Standard Hopper Cover Assembly Parts Breakdown



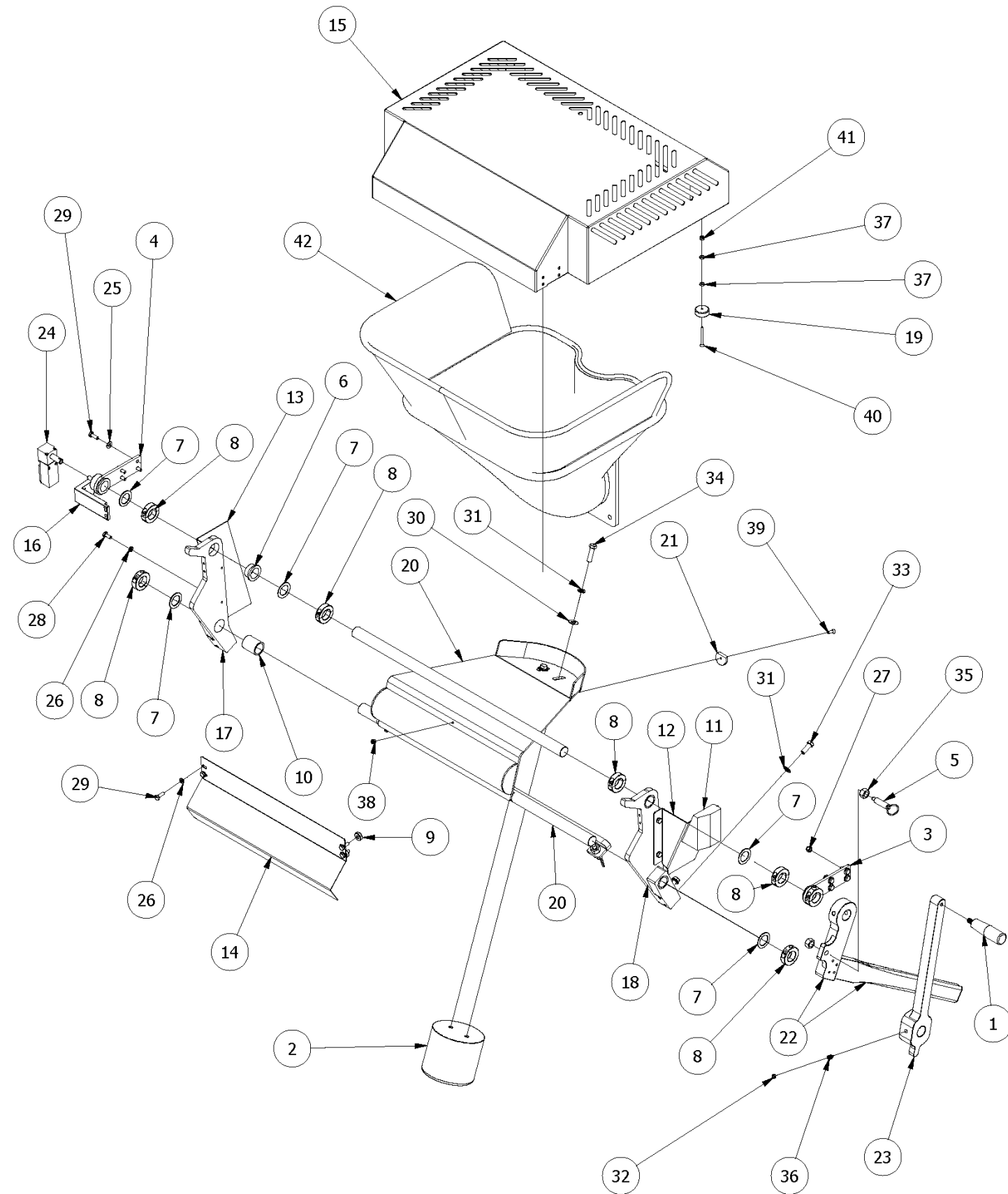
Standard Hopper Cover Assembly Parts List

ITEM	PART NO	DESCRIPTION	QTY
1	17827	DOUGH FEED PLATE ASSEMBLY	1
2	17833B	SAFETY COVER PLASTIC DOUGH PLUNGER	1
3	17834	HOPPER SAFETY COVER	1
4	17834-4	HOPPER SAFETY COVER STOP	2
5	19475	SAFETY COVER PIVOT LOCK BLOCK	1
6	20432	SPRING PLUNGER (1/2-13) S.S.	1
7	20615	NYLON WASHER	4
8	20616	1" S.S. SPLIT SHAFT COLLAR (2 PIECE)	1
9	20671	HOPPER COVER BUMPER	2
10	22850	SAFETY COVER & DOUGH PADDLE HANDLE	1
11	27061	DOUGH FEED PLATE BUMPER	1
12	34530-L	*SEE NOTE*	1
13	34530-R	*SEE NOTE*	1
14	A17828	HOPPER HINGE ASSEMBLY W/ BUSHING	2
15	EL-1320	SAFETY SWITCH - ROTARY HINGE - 2NC	1
16	F0400FW	FLAT WASHER, 1/4"	16
17	F0400NLN	NUT, NYLOCK 1/4"	8
18	F0403HHCS	HEX HEAD CAP SCREW 1/4-20 X 3/4"	8
19	F0404SB	BUTTON HEAD, SOCKET 1/4-20 X 1" LG	2
20	F0600FW	FLAT WASHER 3/8"	2
21	F0600LW	LOCK WASHER 3/8"	2
22	F0601SS	3/8-16 S.S. SET SCREW 1/4" LONG	2
23	F0605.5HHCS	HEX HEAD CAP SCREW 3/8-16 X 1-3/8"	2
24	F0800NC	NUT COURSE, 1/2-13	1
25	F0802DPSS	SET SCREW (3/8-16 X 1/2" LONG) w/ DOGPOINT	2
26	F9800FW	FLAT WASHER #10	2
27	F9800NLN	NYLOCK NUT, #10 (10-24)	3
28	F9803FSH	10-24 X3/4" LONG FLAT SOCK HEAD SCR	1
29	F9804FSH	10-24X1LG FLAT SOCKET HEAD	2
30	F9903TH	10-32 X 3/4" LONG TRUSS HEAD	4
31	445CD	STANDARD HOPPER	1

NOTES:

- When ordering 34530-L and 34530-R, the hopper cover hinges, check the style used on the machine, 34530-L and 34530-R were introduced in machines starting in January of 2024.
 - If the dimensions are 1-1/2" wide on the rectangular side, order:
 - 17842-L, Hopper Safety Cover Hinge, Left Side.
 - 17842-R, Hopper Safety Cover Hinge, Right side.
 - If the dimensions are 2-1/2" wide on the rectangular side, order:
 - 34530-L, Hopper Safety Cover Hinge, Left Side.
 - 34530-R, Hopper Safety Cover Hinge, Right Side.

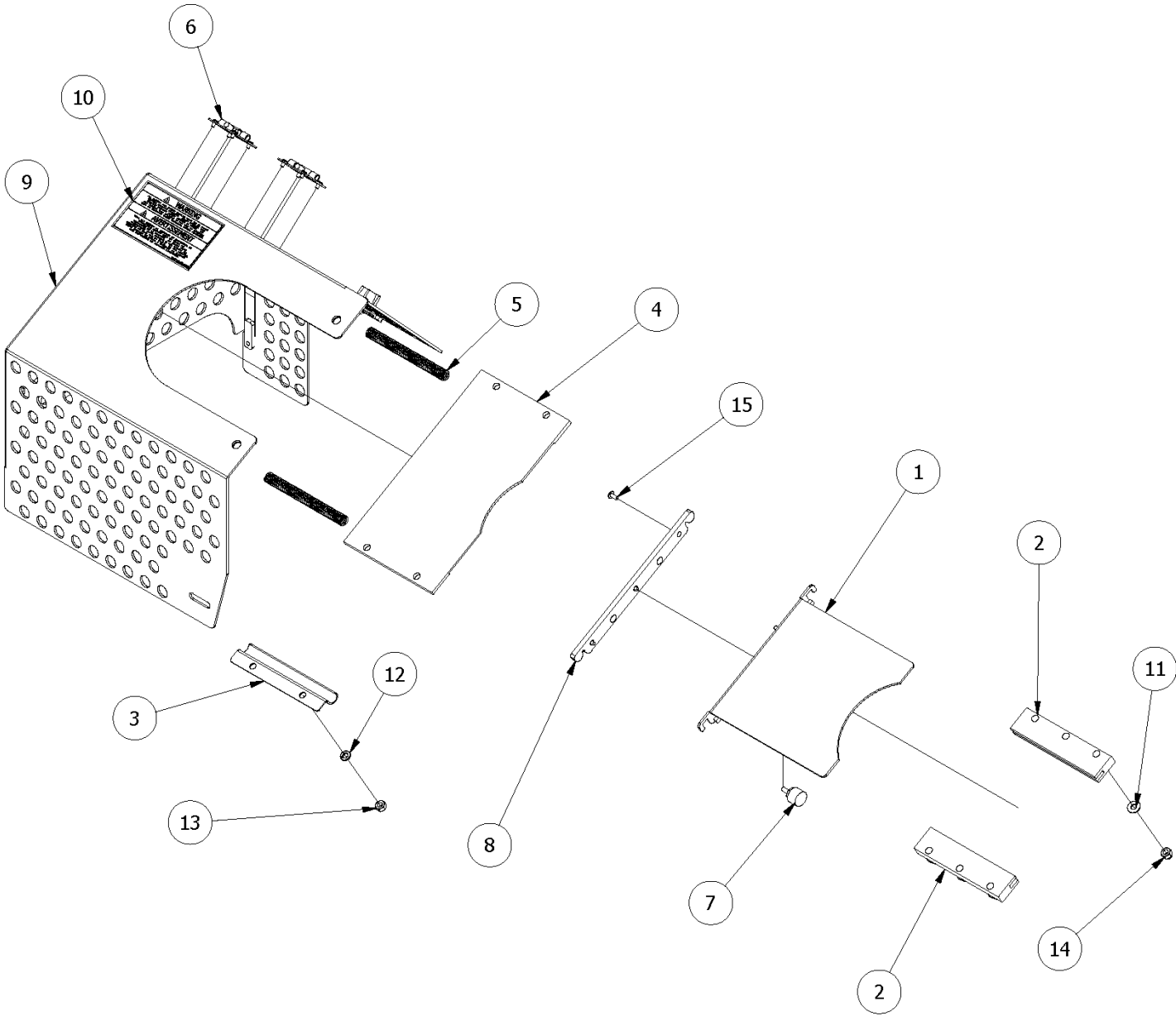
Extended Hopper Cover Parts Breakdown



Extended Hopper Assembly Parts List

ITEM	PART NO	DESCRIPTION	QTY
1	11467	Easy-Turn Revolving Handle 3/8"-16	1
2	17833B	SAFETY COVER PLASTIC DOUGH PLUNGER	1
3	17842-L	HOPPER SAFETY COVER HINGE LS-EXTENDED	1
4	17842-R	HOPPER SAFETY COVER HINGE RS-EXTENDED	1
5	20432	SPRING PLUNGER (1/2-13) S.S.	2
6	20453	FLANGE BUSHING - 1"IDX1.253"ODX3/4"	2
7	20615	NYLON WASHER	6
8	20616	1" S.S. SPLIT SHAFT COLLAR (2 PIECE)	6
9	20645	SPACER - 3/4 OD X 1/4 LG X 9/32 ID	2
10	20649	SLEEVE BUSHING (1.002 ID X 1.253 OD X 1.5" LONG)	2
11	20650	SPRING PIN LOCK BLOCK	1
12	20657	HOPPER GUARD (LEFT SIDE)	1
13	20658	HOPPER GUARD (RIGHT SIDE)	1
14	20661	HOPPER BACK GUARD	1
15	20665	EXTENDED HOPPER SAFETY COVER ASSEMB	1
16	20666	INTERLOCK SWITCH MOUNT BRACKET	1
17	20669	SAFETY COVER HINGE BAR (RIGHT SIDE)	1
18	20670	SAFETY COVER HINGE BAR (LEFT SIDE)	1
19	20671	HOPPER COVER BUMPER	2
20	20810	DOUGH FEED PLATE & SHAFT ASSEMBLY	1
21	27061	DOUGH FEED PLATE BUMPER	1
22	27251	SAFETY COVER HANDLE ASSY.	1
23	28324	SAFETY COVER & PADDLE HANDLE, EXT'D HOPPER	1
24	EL-1320	SAFETY SWITCH - ROTARY HINGE - 2NC	1
25	F0400FW	FLAT WASHER, 1/4"	16
26	F0400LW	LOCK WASHER, 1/4"	8
27	F0400NLN	NUT, NYLOCK 1/4"	8
28	F0402.5HHCS	HEX HEAD CAP SCREW 1/4-20 X 5/8"	4
29	F0403HHCS	HEX HEAD CAP SCREW 1/4-20 X 3/4"	12
30	F0600FW	FLAT WASHER 3/8"	2
31	F0600LW	LOCK WASHER 3/8"	6
32	F0601SS	3/8-16 S.S. SET SCREW 1/4" LONG	2
33	F0604HHCS	HEX HEAD CAP SCREW 3/8-16 X 1"	4
34	F0605.5HHCS	HEX HEAD CAP SCREW 3/8-16 X 1-3/8"	2
35	F0800NC	NUT COURSE, 1/2-13	4
36	F0802DPSS	SET SCREW (3/8-16 X 1/2" LONG) w/ DOGPOINT	2
37	F9800NC	NUT COURSE, #10-24	4
38	F9800NLN	NYLOCK NUT, #10 (10-24)	1
39	F9803FSH	10-24 X3/4" LONG FLAT SOCK HEAD SCR	1
40	F9808FSH	10-24 X 2" LONG FLAT SOCK HEAD SCREW	2
41	F9900NLN	NYLOCK NUT, #10-32	2
42	445CDE	EXTENDED HOPPER	1

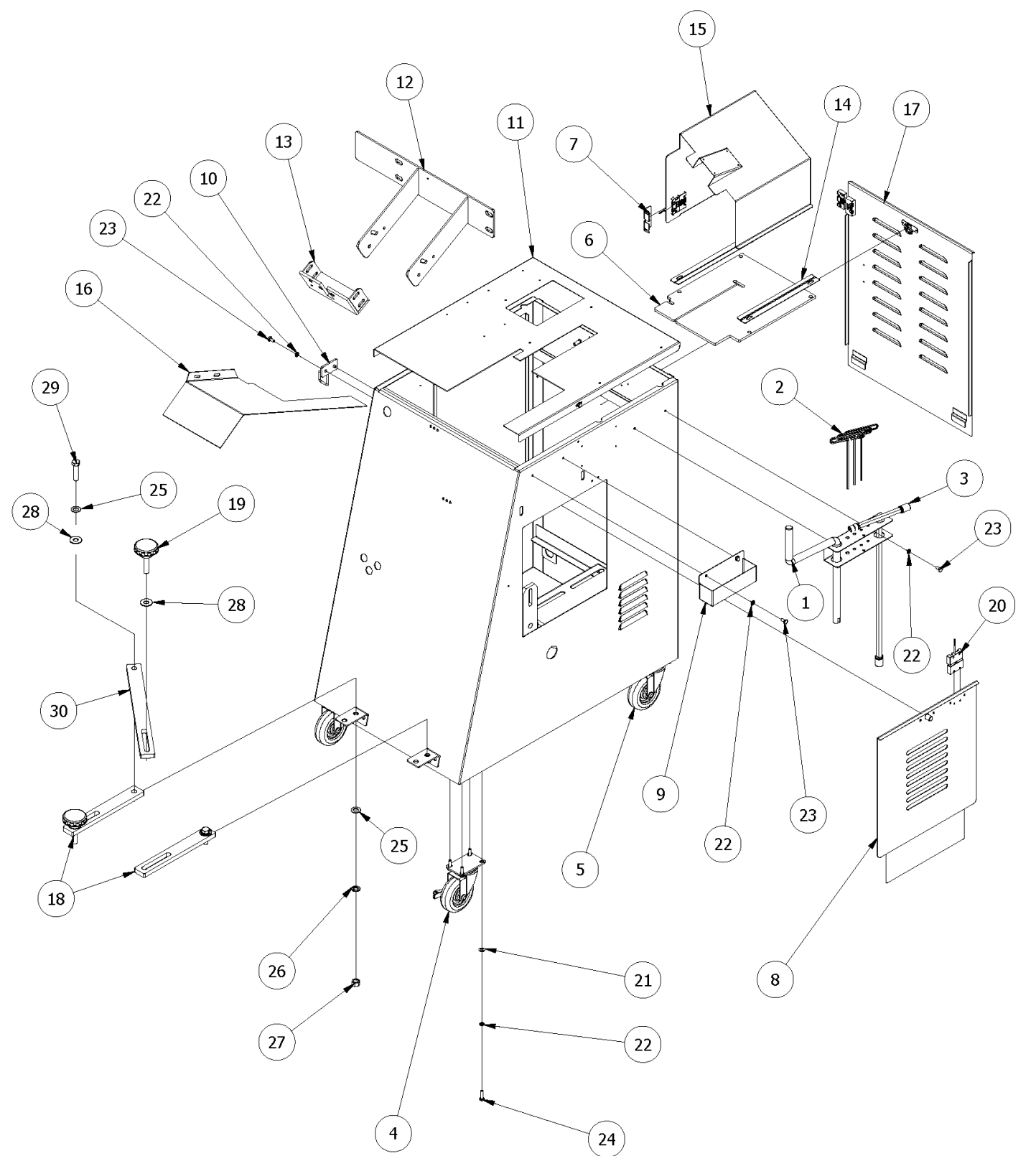
Divider Slide Guard Breakdown



Divider Slide Guard Parts List

ITEM	PART NO	DESCRIPTION	QTY
1	11823	GUARD SLIDE ASSEMBLY	1
2	11824	GUARD SLIDE TRACK	2
3	11825	SPRING RETAINER	2
4	11826	SLIDE SPACER	1
5	11830	SPRING 1/2" OD X 5" LG	2
6	11831	HINGES, SS, CONCEALED SPRING SET	1
7	11832	BUMPER, THREADED STUD W/HEX SHOULDE	2
8	12114	GUARD SLIDE ADAPTER	1
9	21029	GUARD MAIN BODY ASSEMBLY	1
10	AMTAG11SF	STICKER, GUARD WARNING LABEL (ENGLISH & CANADIAN FRENCH)	1
11	F0400FW	FLAT WASHER, 1/4"	6
12	F0400LW	LOCK WASHER, 1/4"	4
13	F0400NC	NUT COURSE, 1/4-20	4
14	F0400NLN	NUT, NYLOCK 1/4"	6
15	F9701.5TH	8-32 X 3/8" LONG TRUSS HEAD	3

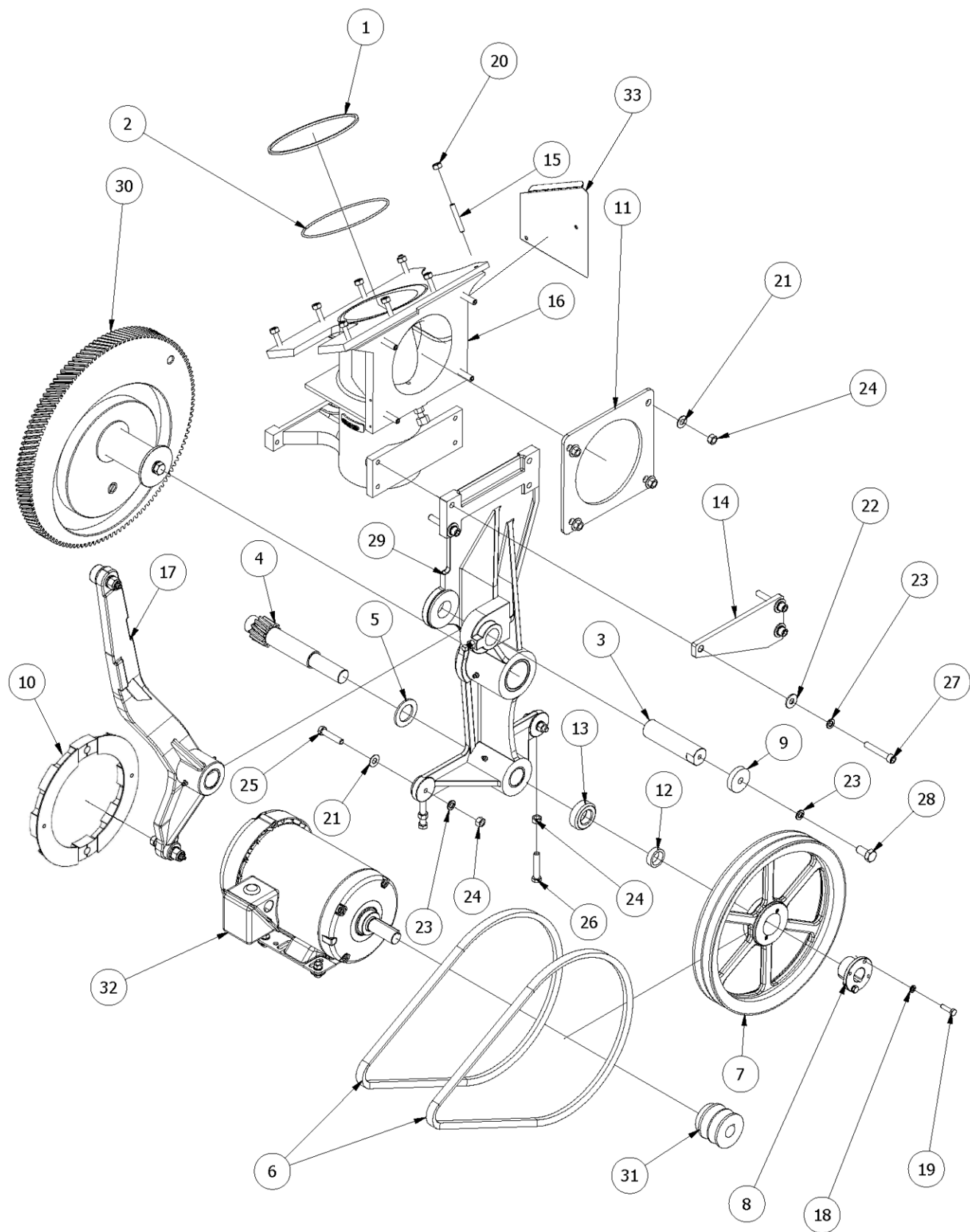
Cabinet Assembly Parts Breakdown



Divider Slide Guard Parts List

ITEM	PART NO	DESCRIPTION	QTY
1	426CD	CRANK HANDLE	1
2	530MSW	ALLEN WRENCH SET	1
3	542MSW-E	"T" HANDLE ASSY. (EXTENDED HOPPER)	1
4	621CA1	CASTER, LOCKING 4" DIA	2
5	621CA2	CASTER, SWIVEL 4" DIA	2
6	641CA1	ROCKER ARM COVER GASKET	1
7	19968	ROCKER ARM INTERLOCK SWITCH MOUNT BRACKET	1
8	11810	FRONT CABINET DOOR ASSEMBLY (NEW STYLE)	1
9	11866	NUT BOX	1
10	12167	SAFETY GURAD HOOK ASSEMB	1
11	602CA-C	CABINET TOP COVER	1
12	605CA1	LARGE PUMP BRKT. WELDMENT ASSEMBLY	1
13	605CA2	OIL PUMP BRACKET (SMALL)	1
14	640CA	ROCKET ARM COVER TRACK	2
15	641CA	ROCKER ARM COVER ASSEMBLY	1
16	643CD	V BELT GUARD	1
17	CA602A	REAR DOOR W/HARDWARE	1
18	20937	DIVIDER / FORMER CONNECTION BAR (SHORT)	2
19	21449	MACHINE LOCK KNOB / STUD ASSEMBLY	2
20	EL-1308	SAFETY SWITCH	3
21	F0400FW	FLAT WASHER, 1/4"	16
22	F0400LW	LOCK WASHER, 1/4"	25
23	F0402HHCS	HEX HEAD CAP SCREW, 1/4-20X1/2" LG.	9
24	F0404HHCS	HEX HEAD CAP SCREW 1/4-20 X 1"	16
25	F0800FW	FLAT WASHER 1/2"	4
26	F0800LW	LOCK WASHER 1/2"	2
27	F0800NC	NUT COURSE, 1/2-13	2
28	F0800NW	1/2"ID X 1-1/4"OD NYLON FLAT WASHER	4
29	F0808HHCS	HEX HEAD CAP SCREW 1/2-13 X 2"	1
30	K622C	RK2200 CONNECTION BAR (SHORT) / SAB CONNECTION BAR (LONG)	1

Main Drive Assembly Parts Breakdown

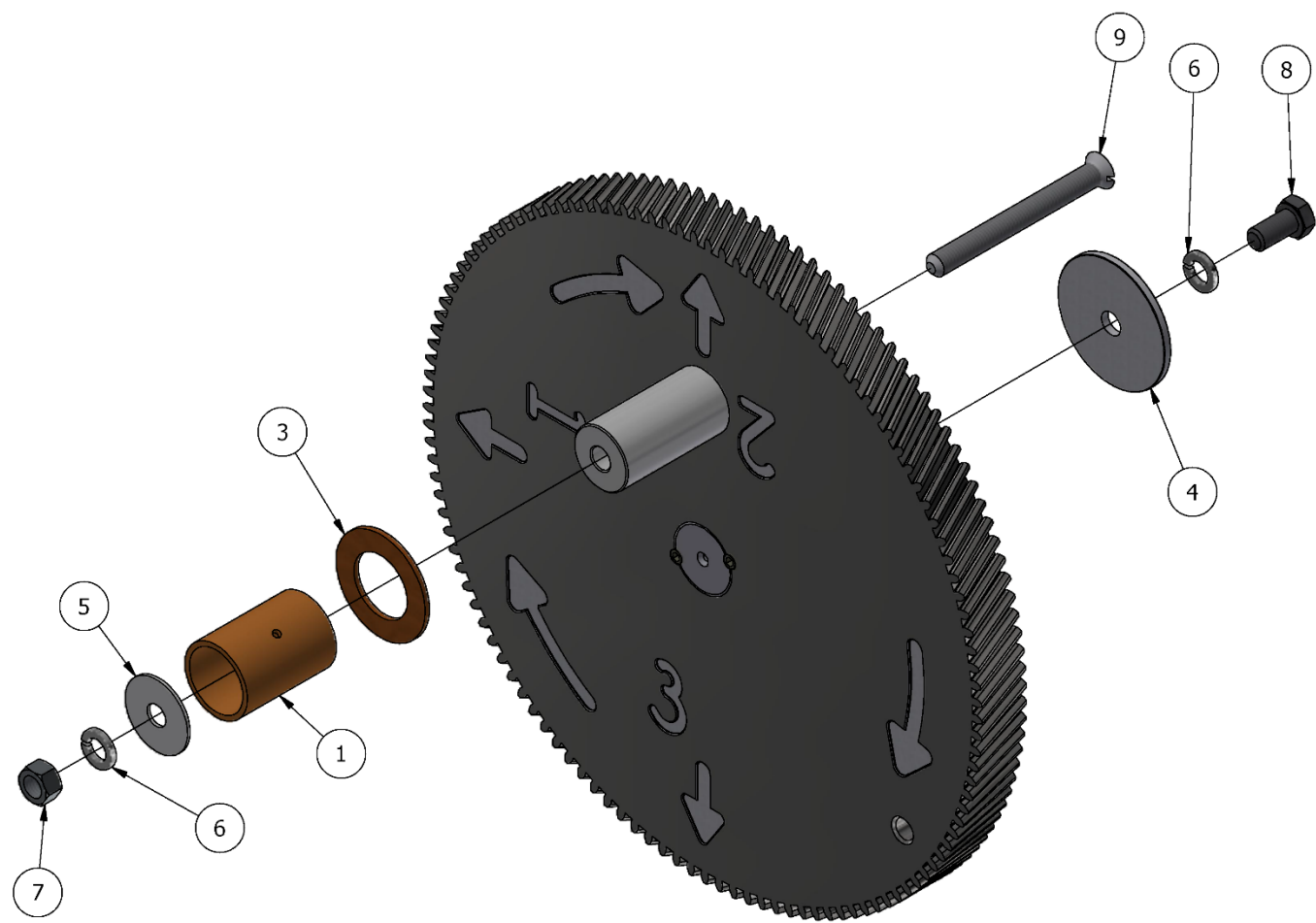


Main Drive Assembly Parts List

ITEM	PART NO	DESCRIPTION	QTY
1	401CD	SCRAPER RING	1
2	402CD	CYLINDER SLIDE "O" RING	1
3	412CD	CAM ARM PIN	1
4	415CD-H	PINION DRIVE GEAR (HELIX)	1
5	416CD	BRONZE SPACER WASHER, 1-1/4 ID	1
6	434CD49	"V" BELT 49"	2
7	435CDA	DRIVE PULLEY (DOUBLE GROOVE)	1
8	436CD	H BUSHING (1" BORE)	1
9	442CD	WASHER, STEEL, 1-3/4 X 3/8	1
10	448CDA	BRONZE SHOE, FULL	1
11	449CD	HOPPER GASKET	1
12	464CD	SPACER	1
13	465CD	THRUST BEARING	1
14	29287	MOTOR SPACER (DROP CONVEYOR)	1
15	F0508SD	5/16-18 X 2 LG THRD, S.S.	8
16	AS0107CD	CYLINDER ASSEMBLY (STUDS & NUTS INCLUDED)	1
17	AS0110CD	ROCKER ARM ASSY *SEE PAGE 39 FOR PARTS*	1
18	F0400LW	LOCK WASHER, 1/4"	26
19	F0404HHCS	HEX HEAD CAP SCREW 1/4-20 X 1"	2
20	F0500HNC	5/16" HEX NUT, HVY DUTY SS	8
21	F0600FW	FLAT WASHER 3/8"	6
22	F0600FW-Large	FLAT WASHER 3/8" (LARGE)	6
23	F0600LW	LOCK WASHER 3/8"	22
24	F0600NC	3/8-16 HEX NUT	16
25	F0607HHCS	HEX HEAD CAP SCREW 3/8-16 X 1-3/4"	2
26	F0608HHCS	HEX HEAD CAP SCREW 3/8-16 X 2" LG	4
27	F0609SH	SCREW, SOCKET HEAD 3/8-16 X 2-1/4" LG	4
28	F0804HHCS	HEX HEAD CAP SCREW 1/2-13 X 1"	1
29	S0109CD	MAIN DRIVE FRAME ASSEMBLY *PAGE 38 FOR PARTS*	
30	S0113CD	MAIN DRIVE GEAR / HELIX *SEE PAGE 37 FOR PARTS*	1
31	458CDB	DOUBLE GROOVE PULLEY	
32	MAIN DRIVE MOTOR	*SEE TABLE BELOW*	1
33	24778	DIVIDER BACKING / DELETE PLATE	1

MAIN DRIVE MOTOR TABLE			
ELECTRICAL SPECS.	PART NO	DESCRIPTION	QTY
208-220, 3PH	SS265	2HP/3PH 208-220 MAIN DRIVE MOTOR	1
208-220, 1PH	19908	2HP/1PH 208-220 MAIN DRIVE MOTOR	1
380V, 400V, 415V 50HZ	15265	2HP/3PH 50HZ 380V MAIN DRIVE MOTOR	1
380V 60HZ	19540	2HP/3PH 60HZ 380V MAIN DRIVE MOTOR	1

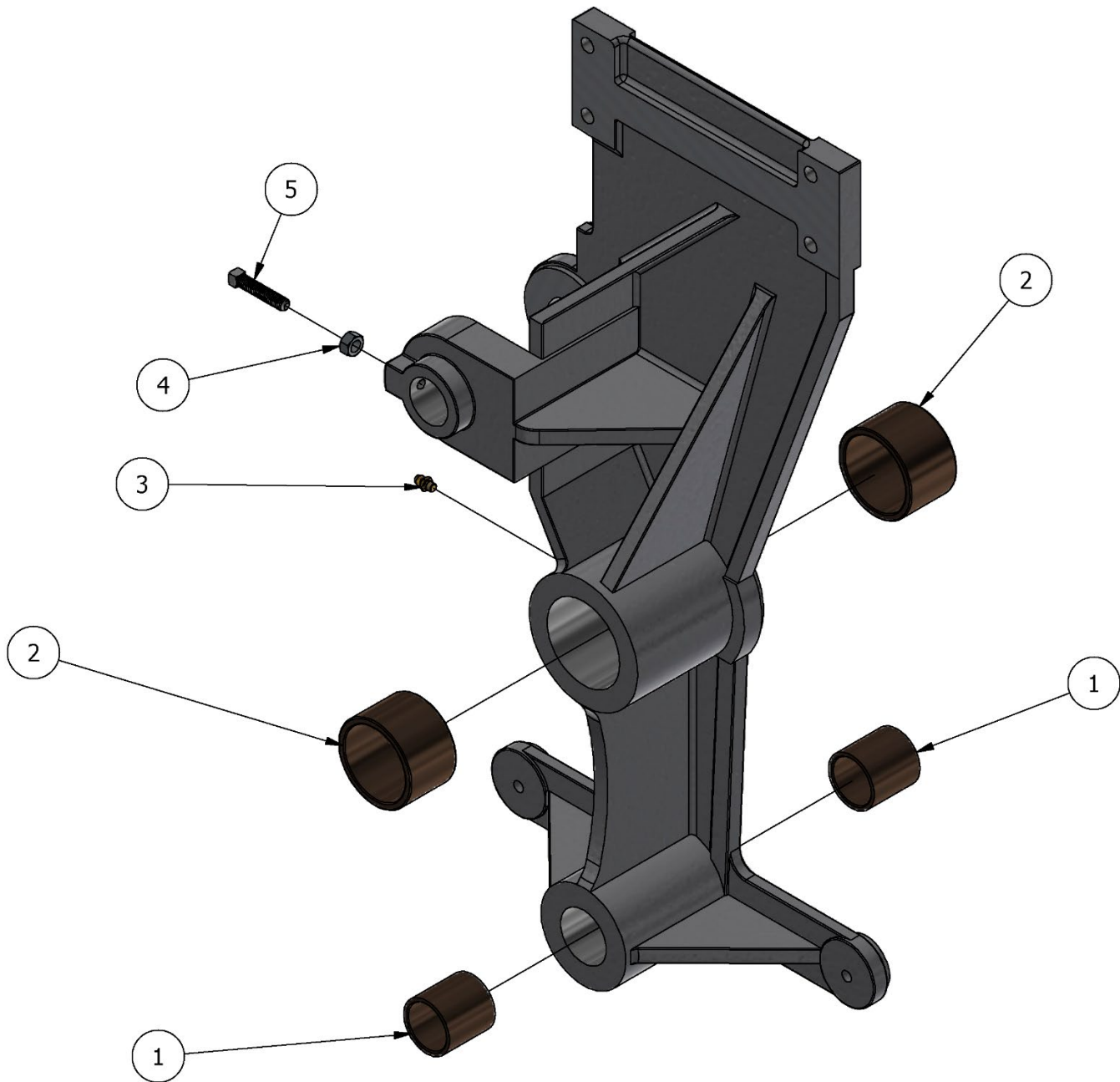
Main Drive Gear Breakdown



Main Drive Gear Parts List

ITEM	PART NO	DESCRIPTION	QTY
1	312PY	DRIVE BEARING	1
2	411CD	SPACER WASHER- 2" ID (BRONZE)	1
3	413CD	SPACER WASHER- 1-1/2" ID (BRONZE)	1
4	439CD	WASHER, 3" X 3/16" THICK	1
5	459CD	WASHER - STEEL, 1 -3/4 OD X 1/2 ID	1
6	F0800LW	LOCK WASHER 1/2"	2
7	F0800NC	NUT COURSE, 1/2-13	1
8	F0804HHCS	HEX HEAD CAP SCREW 1/2-13 X 1"	1
9	F0819FH	1/2" X 4-3/4" FLAT HEAD BOLT	1

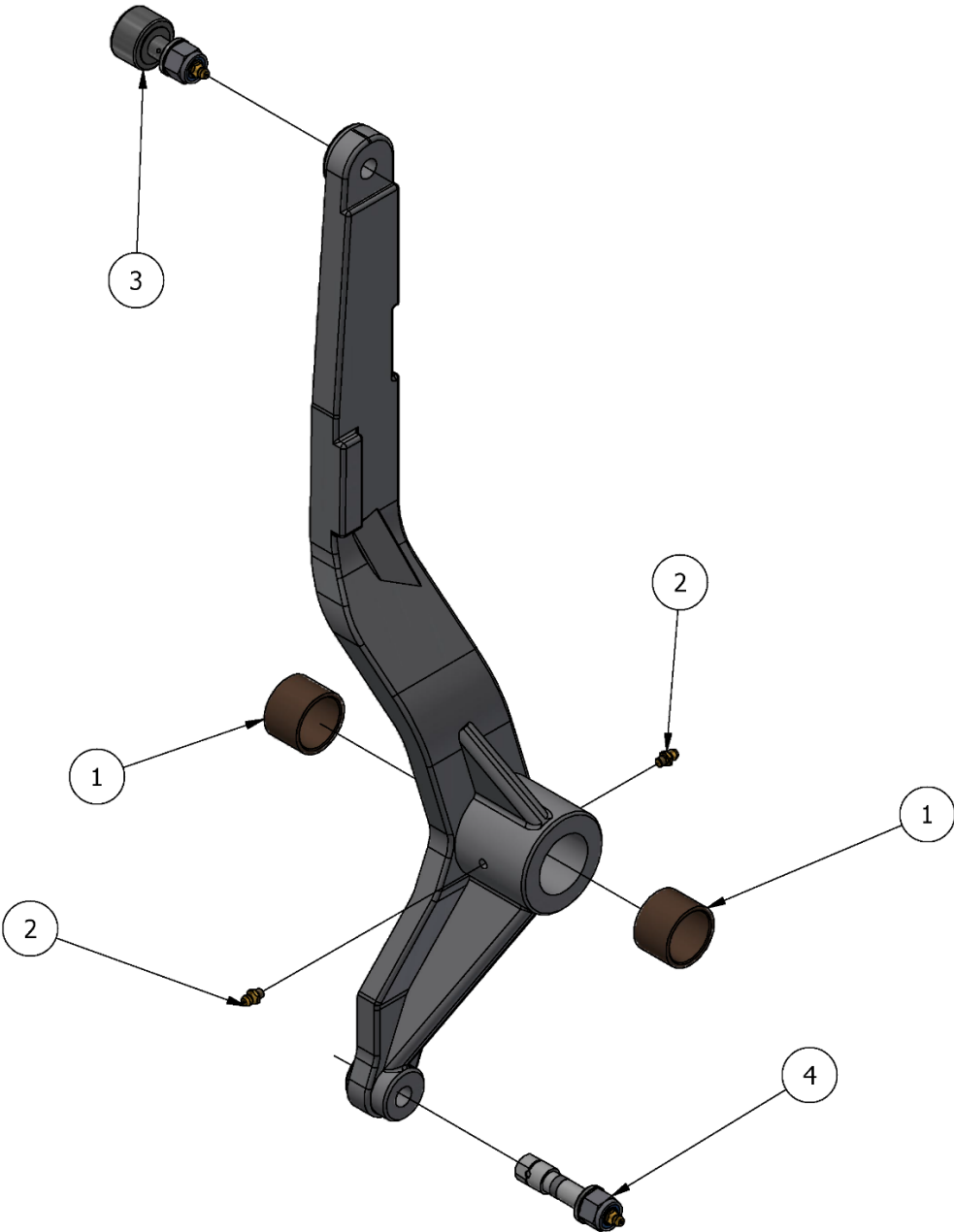
Main Frame Assembly Breakdown



Main Frame Assembly Parts List

ITEM	PART NO	DESCRIPTION	QTY
1	437CD	PINION SHAFT BEARING	2
2	440CD1	MAIN FRAME BEARING-BRONZE, 2-3/8	2
3	3038-B	1/4-28 UNF STRAIGHT GREASE FITTING	2
4	F0500NC	NUT COURSE, 5/16-18	1
5	F0506SQ	5/16 X 1-1/2" SQUARE BOLT	1

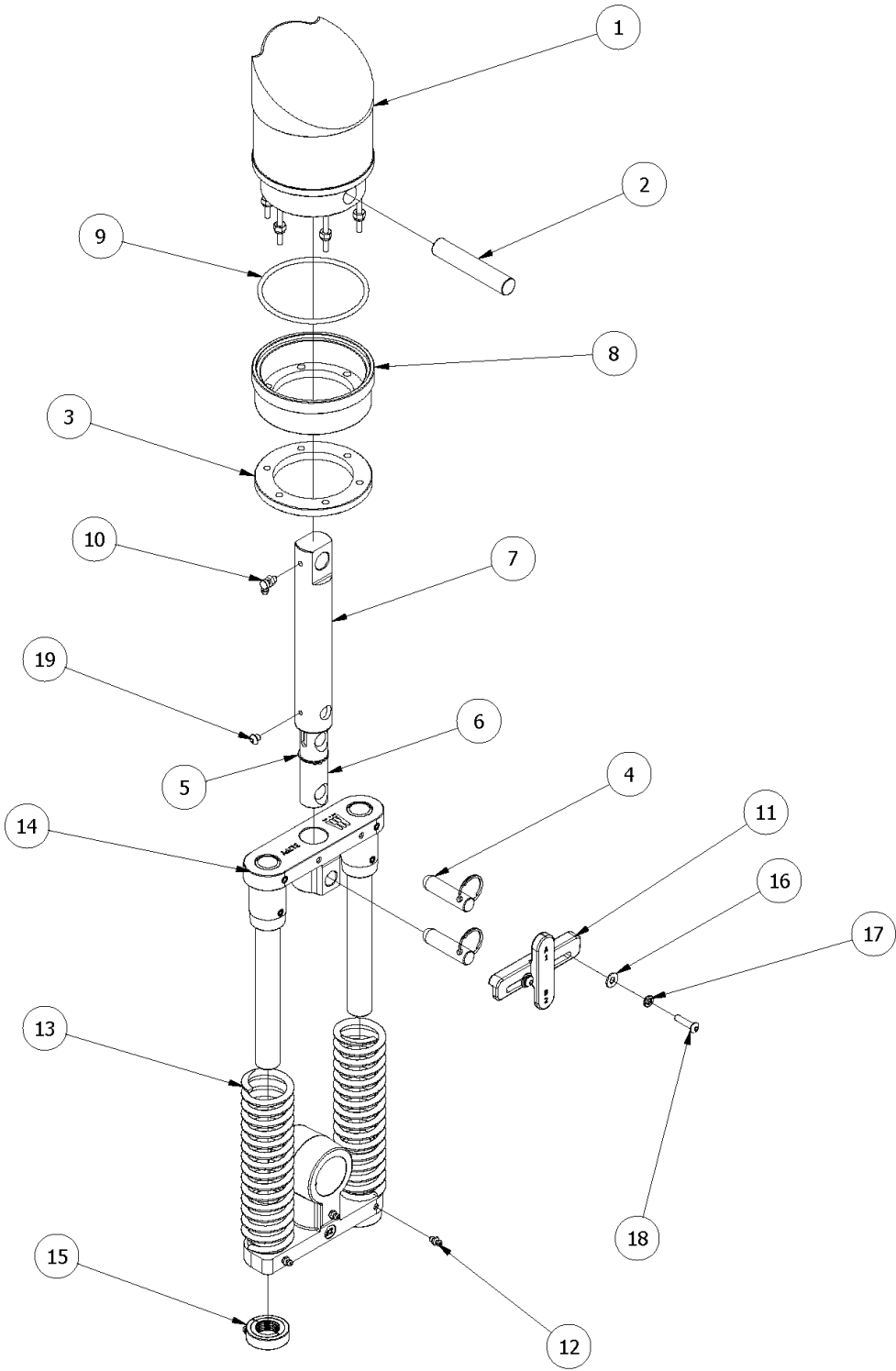
Rocker Arm Assembly Breakdown



Rocker Arm Assembly Parts List

ITEM	PART NO	DESCRIPTION	QTY
1	422CD	ROCKER ARM BEARING	2
2	3038-B	1/4-28 UNF STRAIGHT GREASE FITTING	2
3	A427CD	CAM ROLLER ASSEMBLY	1
4	A452CD	SHOE BOLT ASSEMBLY	1

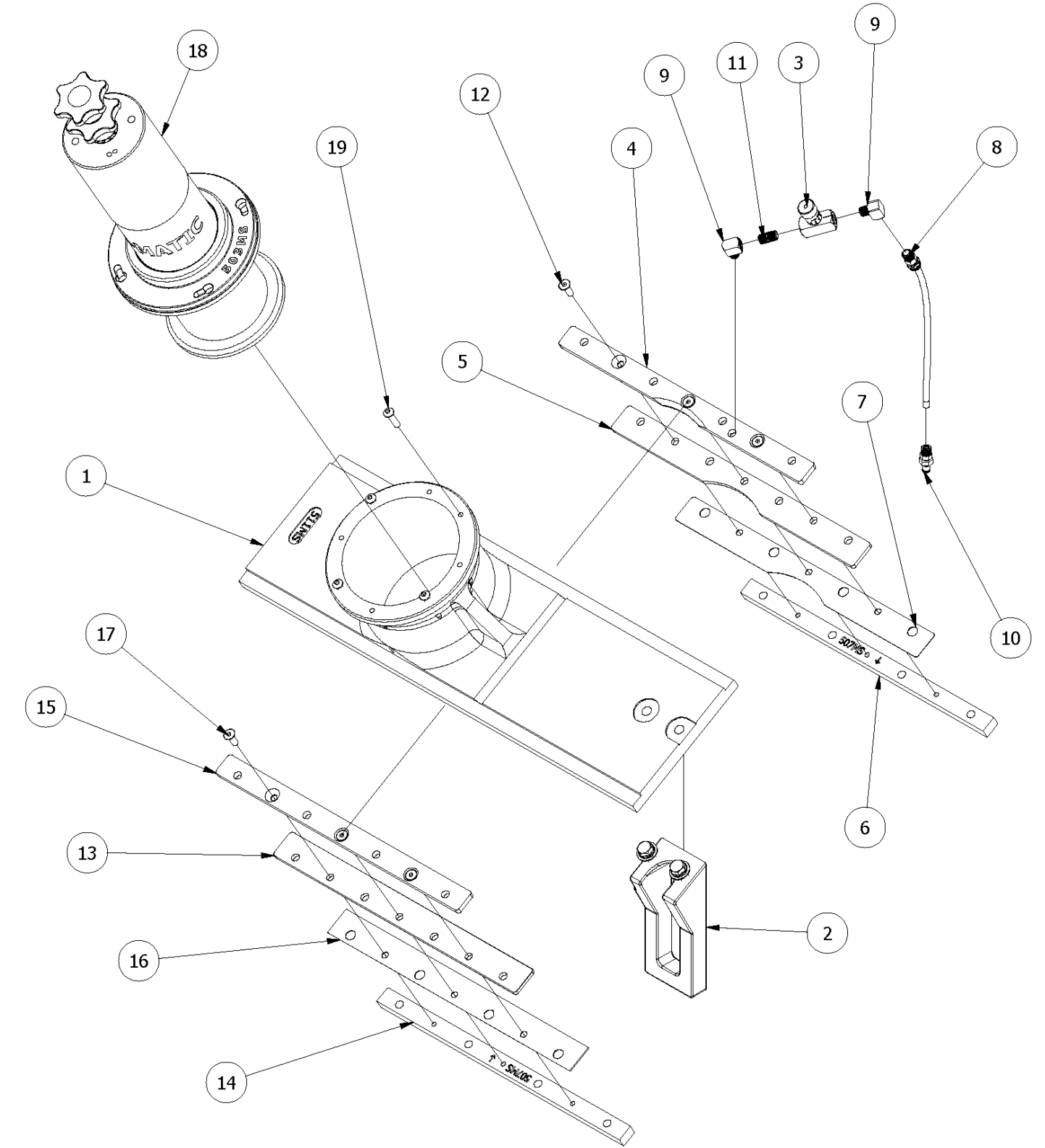
Piston and Spring Load Assembly Breakdown



Piston and Spring Load Assembly Parts List

ITEM	PART NO	DESCRIPTION	QTY
1	300PY1	PISTON ONLY W/STUDS & NUTS	1
2	301PY	WRIST PIN	1
3	302PY	PISTON RING BACKUP WASHER	1
4	304PY	CONNECTING ROD PIN W/ KEY RING	2
5	318PY	SNAP RING	1
6	319PY	CONNECTING ROD - LOWER	1
7	322PY	CONNECTING ROD - UPPER	1
8	323PY	PISTON CUP	1
9	324PY	O-RING (PISTON) 4-1/8"ID X 4-1/2"OD	1
10	23128	1/4-28 UNF 90 DEGREE GREASE FITTING	1
11	306PY	LOCK CONNECTING PIN	1
12	310PY	LOWER SPRING LOAD CAST ASSEMBLY	1
13	316PY	COMPRESSION SPRING, 10" LONG FREE L	2
14	317PY	UPPER SPRING LOAD	1
15	33799	1"-14 THRD'D SHAFT COLLAR, BLK OXIDE	2
16	F0400FW	FLAT WASHER, 1/4"	2
17	F0400LW	LOCK WASHER, 1/4"	2
18	F0404SB	BUTTON HEAD, SOCKET 1/4-20 X 1" LG	2
19	F0401SB	1/4 X 1/4" BUTTON SOCKET HEAD	1

Divider Slide Parts Breakdown



Divider Slide Parts List

ITEM	PART NO	DESCRIPTION	QTY
1	511MS	DIVIDER SLIDE	1
2	517MS	CAM SLIDE ARM ASSMB.	1
3	14393	OIL VALVE - NEEDLE	1
4	505MS	GIB BAR, TOP	1
5	506MS-T	GIBB BAR PTFE PLASTIC INSERT BOTTOM	1
6	507MS	GIBB BAR - SPACER BAR, TOP, OR BOTTOM	1
7	521MS	WEAR STRIP LINER (SET ONLY)	1
8	7220S	MALE CONNECTOR- HOSE	1
9	7240S	90 STREET ELBOW - BRASS	2
10	7260S	MALE QUICK CONNECT	1
11	7370S	NIPPLE 1/8 X CLOSE SCH 40 SST304	1
12	F0403FSH	FLAT SOCKET HEAD 1/4-20 X 3/4" LG.	3
13	506MS-B	GIBB BAR PTFE PLASTIC INSERT, BOTTOM	1
14	507MS	GIBB BAR - SPACER BAR, TOP, OR BOTTOM	1
15	520MS	GIB BAR - LOWER	1
16	521MS	WEAR STRIP LINER (SET ONLY)	1
17	F0403FSH	FLAT SOCKET HEAD 1/4-20 X 3/4" LG.	3
18	MEASURING CUP	SEE NEXT PAGE	1
19	F0404SB	BUTTON HEAD, SOCKET 1/4-20 X 1" LG	4

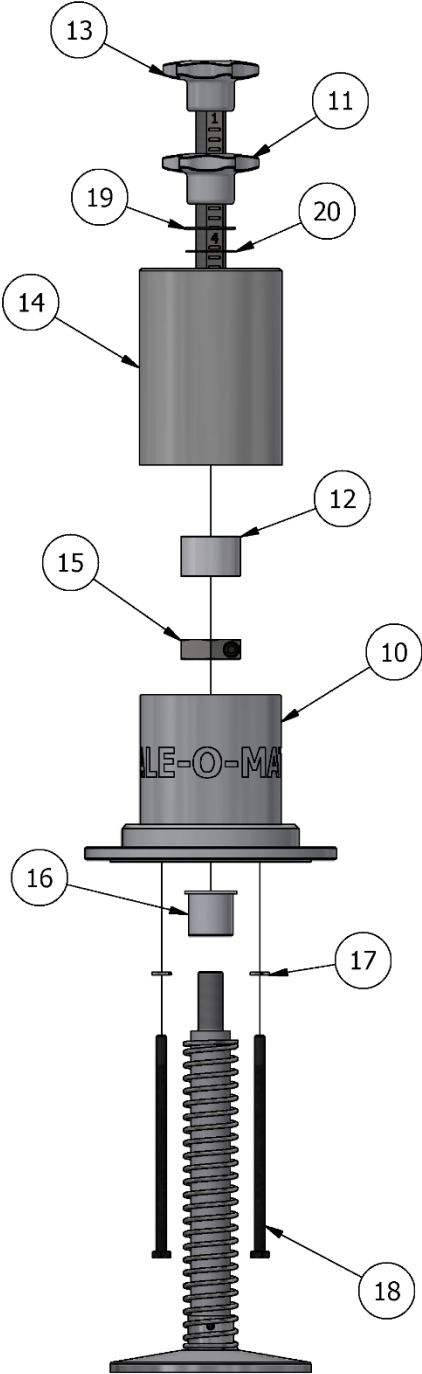
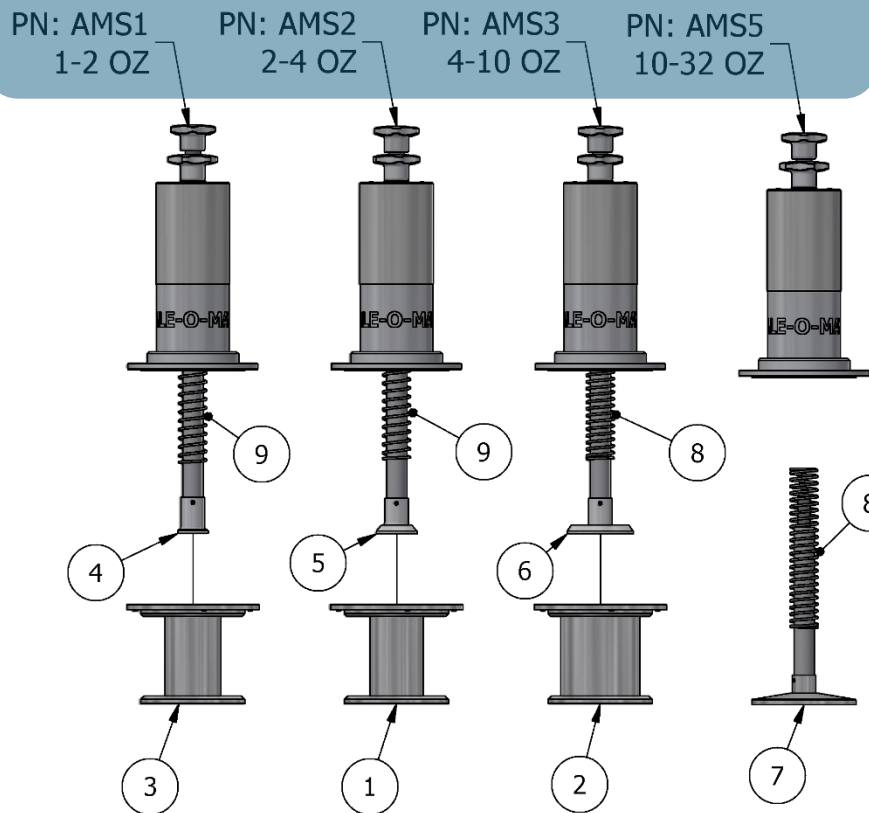
Measuring Cup Notes:

The measuring cup assemblies scale dough within certain weight ranges. The weight ranges on these measuring cups are determined by the plungers on the bottom. For the three smaller measuring cups, these plungers require an insert to fit in the divider slide.

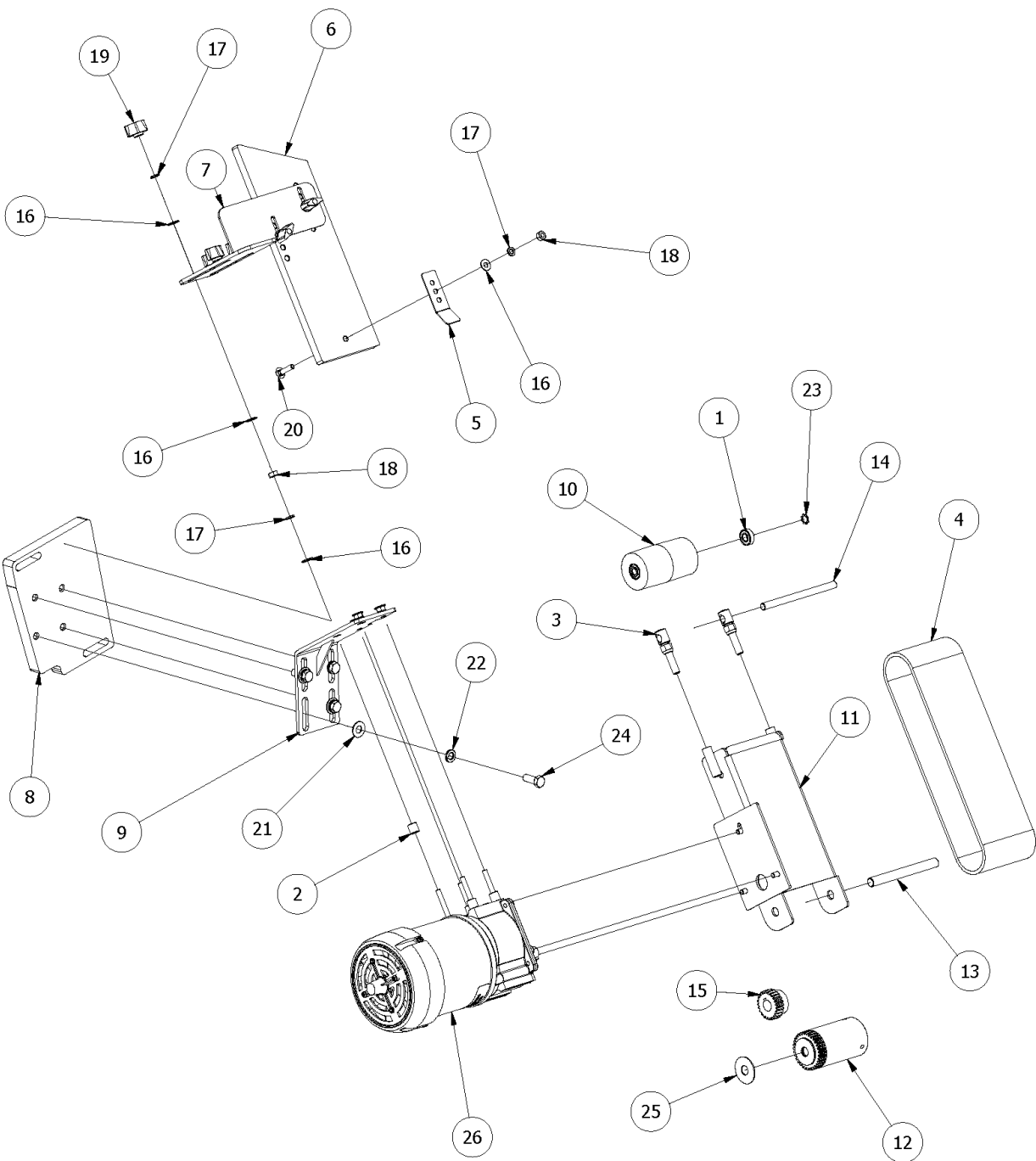
Measuring Cup Assembly Parts Breakdown

ITEM	PART NO	DESCRIPTION	QTY
1	509MS	2" INSERT, DIVIDER CYLINDER	1
2	510MS	3-1/4" INSERT, DIVIDER CYLINDER	1
3	512MS	1-1/2" INSERT, DIVIDER CYLINDER	1
4	513MS-1	1 1/2" PLUNGER & SHAFT ASSEMBLY	1
5	513MS-2	2" PLUNGER & SHAFT ASSEMBLY	1
6	513MS-3	3" PLUNGER & SHAFT ASSEMBLY	1
7	513MS-5	5" PLUNGER & SHAFT ASSEMBLY	1
8	516MSH	COMPRESSION SPRING (HEAVY)	2
9	516MSL	COMPRESSION SPRING (LIGHT)	2
10	503MS	PLUNGER GUIDE HOUSING	1
11	529MS-2D	STAR KNOB 3/4-16 THUR HOLE	1
12	529MS-2E	PLASTIC STOP PLUG	1
13	529MS-2F	ADJUSTING HANDLE & STUD ASSEMBLY	1
14	529MS-2-M	PLUNGER GUIDE EXTENSION HOUSING	1
15	531MS	NUT, SLOTTED 5/8-18	1
16	539MS-P	PLASTIC BUSHING	1
17	F0400LW	LOCK WASHER, 1/4"	2
18	F0422HHCS	HEX HEAD CAP SCREW 1/4-20 X 5-1/2"	2
19	F1200RW	3/4" RETAINING WASHER	1
20	F1200WF	FIBER WASHER (3/4" I.D X 1-1/4" O.D.)	1

Individual Measuring Cup Assembly Part Numbers and Dough Weight Ranges:

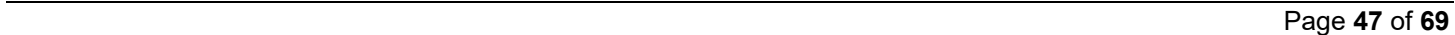


Drop Conveyor Assembly Parts Breakdown



Drop Conveyor Assembly Parts List

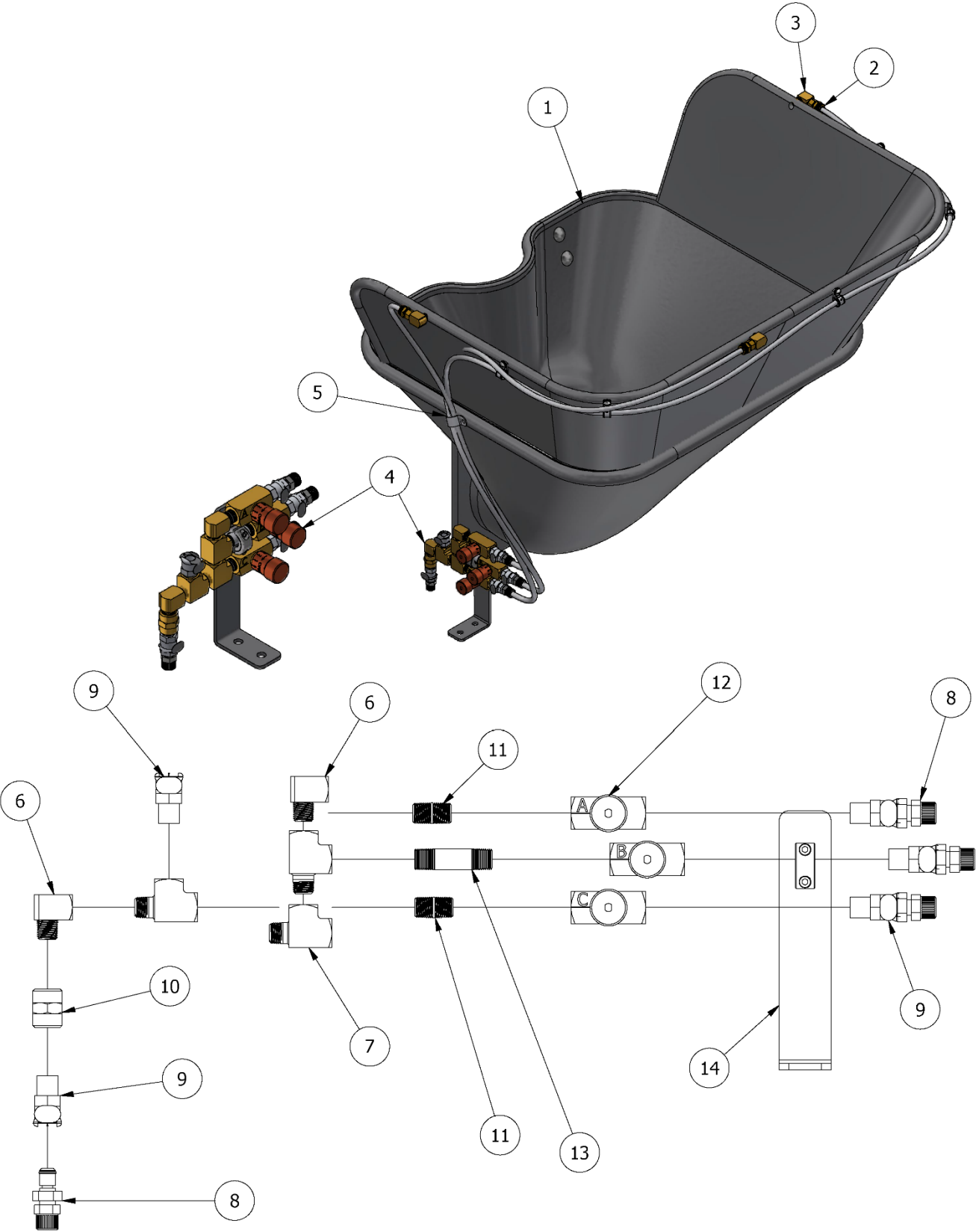
ITEM	PART NO	DESCRIPTION	QTY
1	603SCA	BALL BRNG, 3/8"ID X 7/8"OD, DP GROV	2
2	642SC	SPACER - 1/2 OD X 1/2 LG X 9/32 ID, ALUM	4
3	A600SC	ROLLER SUPPORT ASSEMBLY	2
4	BSC3-4 BELT	DROP CONVEYOR BELT	1
5	BSC62-1	METAL STRIP	1
6	BSC62B	PRESSURE PLATE	1
7	BSC63	DOUGH GUIDE SUPPORT	1
8	BSC64	MOUNTING PLATE	1
9	BSC65	SMALL CONVEYOR MOUNTING ARM	1
10	BSC66	IDLER ROLLER	1
11	BSC67	SMALL CONVEYOR FRAME	1
12	BSC68	DRIVE ROLLER ASSEMBLY	1
13	BSC70	DRIVE ROLLER SHAFT	1
14	BSC72	IDLER ROLLER SHAFT	1
15	BSC73-1	SPUR GEAR (MODIFIED)	1
16	F0400FW	FLAT WASHER, 1/4"	16
17	F0400LW	LOCK WASHER, 1/4"	13
18	F0400NC	NUT COURSE, 1/4-20	5
19	F0400PWN	1/4 PLASTIC WING NUT	6
20	F0404BB	1/4-20 X 1" LONG CARRAIGE BOLT	3
21	F0600FW	FLAT WASHER 3/8"	4
22	F0600LW	LOCK WASHER 3/8"	4
23	F0600RW	3/8" RETAINING WASHER	2
24	F0604HHCS	HEX HEAD CAP SCREW 3/8-16 X 1"	4
25	F0800NWL	FLAT NYLON WASHER	6
26	SS262	GEAR MOTOR (1/6HP, 115/230Vac, 11:1 RATIO, 161RPM)	1



Oiling System Parts List

ITEM	PART NO	DESCRIPTION	QTY
1	518MS	SCALE O MATIC OIL RETURN	1
2	604CA	COMPLETE OIL BOX	1
3	7130S	AERATOR, PLASTIC INSERT W/STRAINER	1
4	7270S	FEMALE QUICK CONNECT	1
5	7000S	OIL PUMP ASSEMBLY	1
6	7090S	PLASTIC FERRULES	3
7	7220S	MALE CONNECTOR- HOSE	4
8	7240S	90 STREET ELBOW - BRASS	2
9	7250S	STREET T 1/8" BRASS	1
10	7310S	1/8 BRASS COUPLING	1
11	7370S	NIPPLE 1/8 X CLOSE SCH 40 SST304	1
12	14393	OIL VALVE - NEEDLE	1
13	14393	OIL VALVE - NEEDLE	1
14	7220S	MALE CONNECTOR- HOSE	1
15	7240S	90 STREET ELBOW - BRASS	2
16	7260S	MALE QUICK CONNECT	1
17	F0404SH	SCREW, SOCKET HEAD 1/4-20 X 1"LG	2

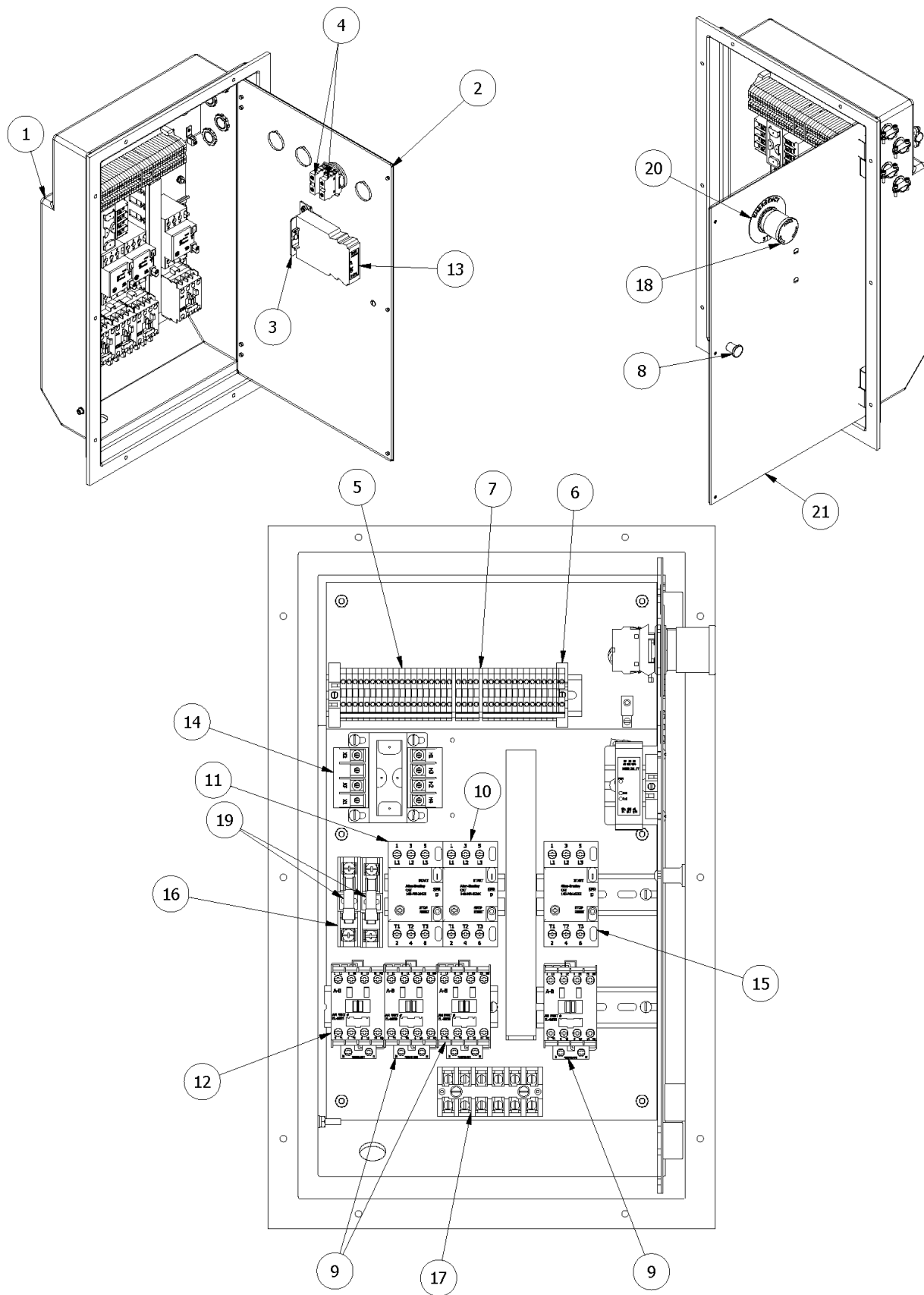
Extended Hopper Oil System Breakdown



Extended Hopper Oil System Parts List

ITEM	PART NO	DESCRIPTION	QTY
1	445CDE	DOUGH HOPPER - EXTENDED	1
2	7220S	MALE CONNECTOR- HOSE	3
3	7240S	90 STREET ELBOW - BRASS	3
4	33942	HOPPER (EXTENDED) OILING SYSTEM SET-UP	1
5	EL-2002	FIXED DIA CABLE CLAMPS - HEAVY	1
6	7240S	90 STREET ELBOW - BRASS	2
7	7250S	STREET T 1/8" BRASS	3
8	7260S	MALE QUICK CONNECT	4
9	7270S	FEMALE QUICK CONNECT	5
10	7310S	1/8 BRASS COUPLING	1
11	7370S	NIPPLE 1/8 X CLOSE SCH 40 SST304	2
12	14393	OIL VALVE - NEEDLE	3
13	17664	1/8" NPT NIPPLE X 1-1/2" LG. SS	1
14	33940	OIL VALVE MOUNT BRACKET ASSY.	1

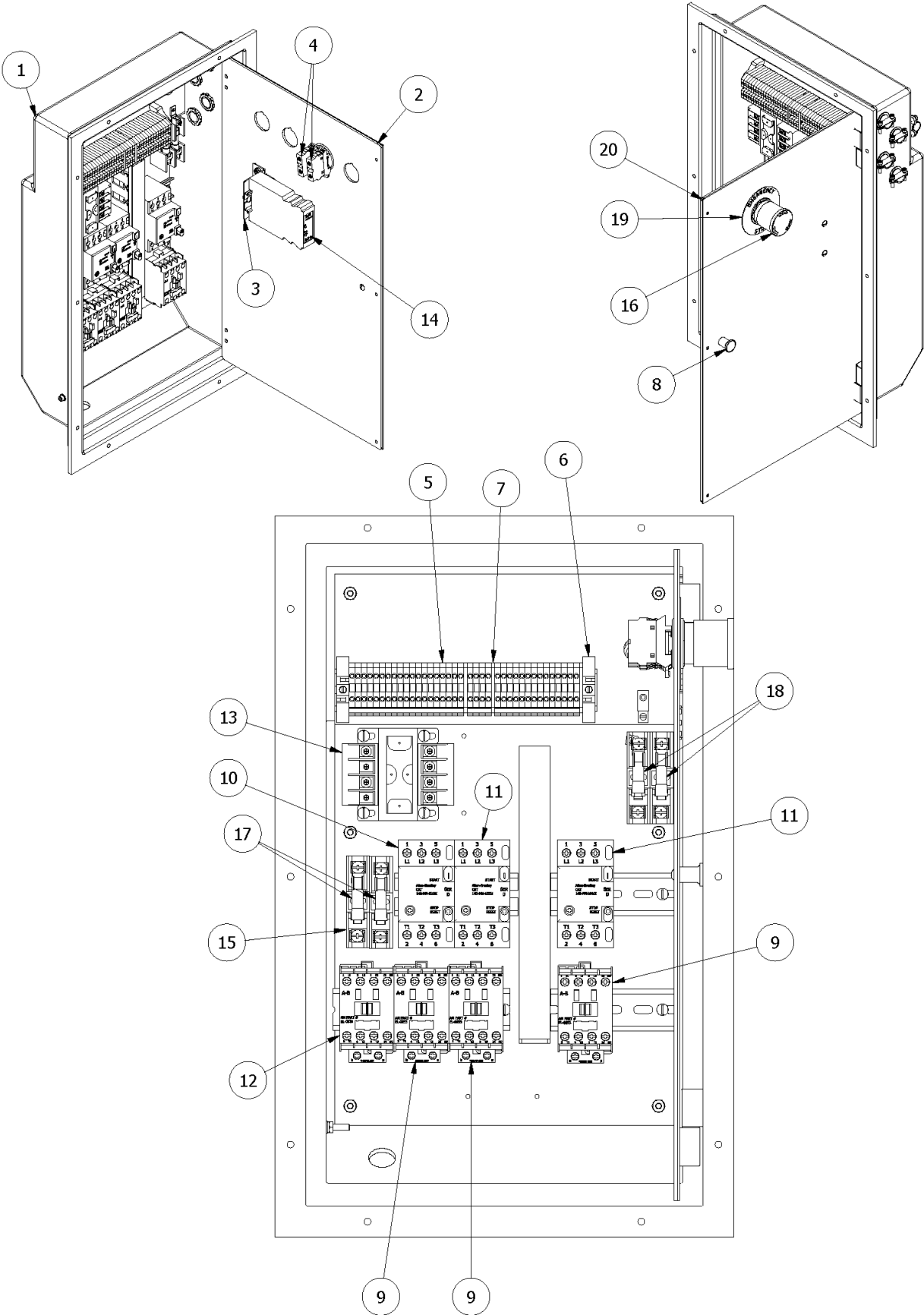
Electrical Box 208V-230V-3PH Breakdown



Electrical Box 208V-230V-3PH Parts List

ITEM	PART NO	DESCRIPTION	QTY
1	617CA6	ELECTRICAL ENCLOSURE	1
2	11423	S-300 ENCLOUSRE PANEL	1
3	20452	SAFETY RELAY MOUNT BRACKET	1
4	400038	CONTACT BLOCKS, 1 N.C.	2
5	EL-0395	TERMINAL BLOCK (TYPE MA2.5/5)	37
6	EL-0396	TERMINAL BLOCK END ANCHOR	3
7	EL-0397	END BARRIER (GRAY)	3
8	EL-0414	KNOB: PUSH, PULL, LIFT	1
9	EL-0853	IEC MOTOR CONTACTOR (9 AMP)	3
10	EL-0854	MANUAL MOTOR STARTER (2.5 - 4.0 AMP)	1
11	EL-0855	MANUAL MOTOR STARTER (4.0 - 6.3A)	1
12	EL-0935	IEC MOTOR CONTACTOR (16 AMP)	1
13	EL-1307	GUARDMASTER SAFETY RELAY	1
14	EL-1773	TRANSFORMER (50Va, 230/460Vac PRIMA	1
15	EL-1929	MANUAL MOTOR STARTER (1.0 - 1.6 AMP)	1
16	SS142	FUSE HOLDER	2
17	SS143	6 POINT TERMINAL BLOCK	1
18	SS185	MAINTAINED BUTTON - TWIST TO RELEAS	1
19	SS302	1 AMP FUSE (CLASS CC)	2
20	SS425	EMERGENCY STOP NAMEPLATE	1
21	TAG #37	ELECTRICAL ENCLOSURE DOOR LABEL	1

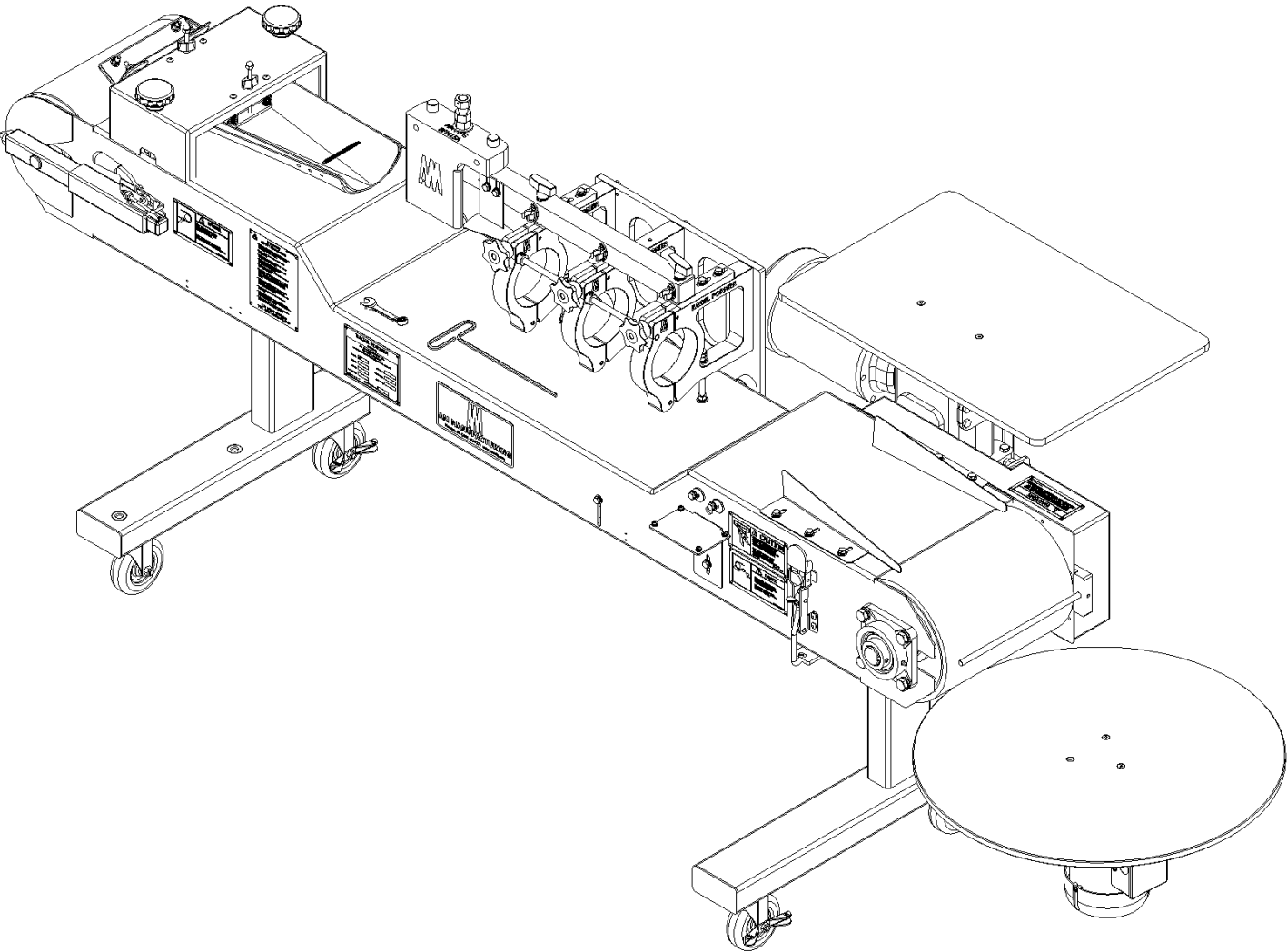
Electrical Box 380V-3PH 50HZ Breakdown



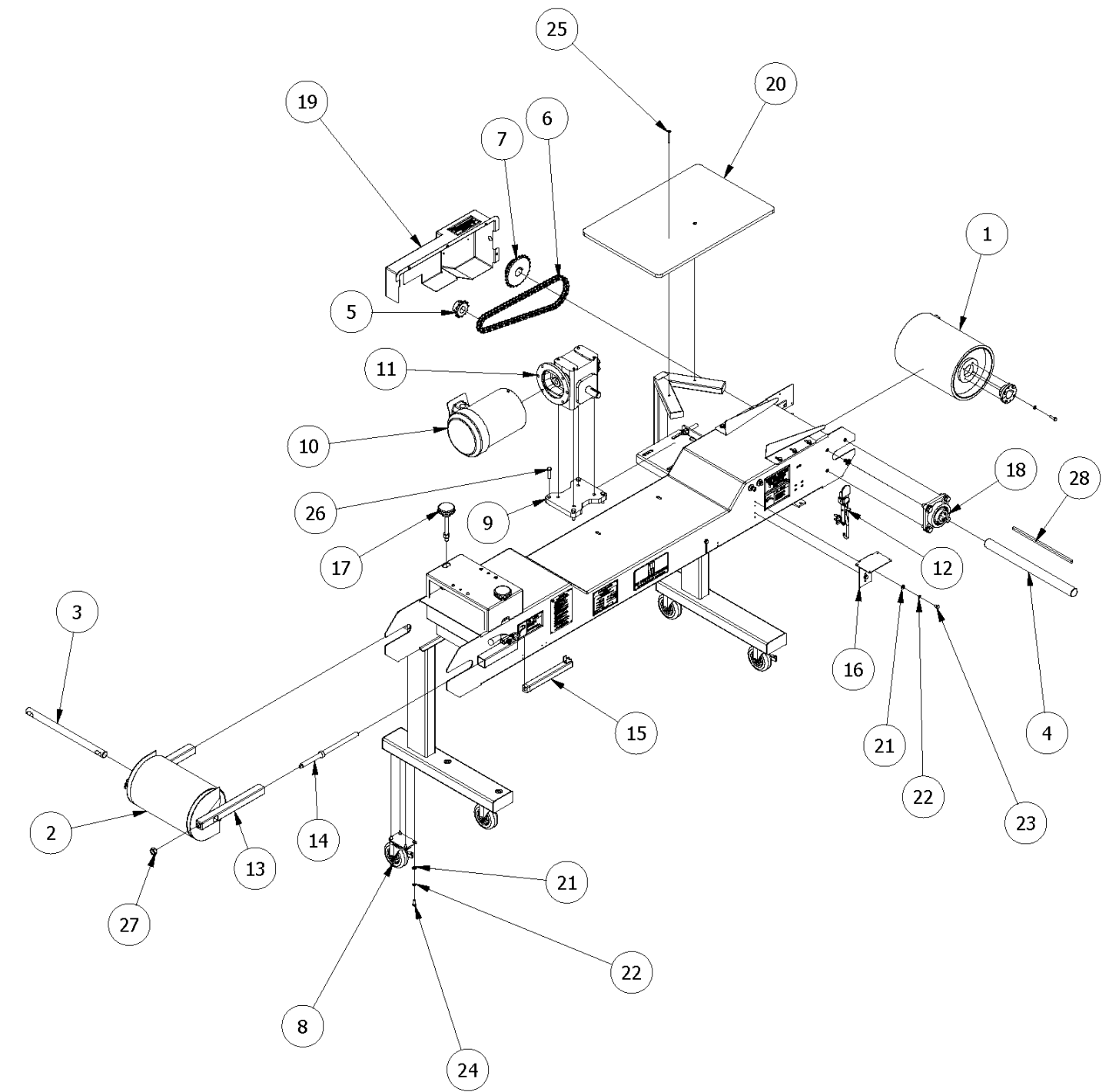
Electrical Box 380V-3PH 50HZ Parts List

ITEM	PART NO	DESCRIPTION	QTY
1	617CA6	ELECTRICAL ENCLOSURE, PLASTIC MOLD.	1
2	11423	S-300 ENCLOUSRE PANEL	1
3	20452	SAFETY RELAY MOUNT BRACKET	1
4	400038	CONTACT BLOCKS, 1 N.C.	2
5	EL-0395	TERMINAL BLOCK (TYPE MA2.5/5)	37
6	EL-0396	TERMINAL BLOCK END ANCHOR	3
7	EL-0397	END BARRIER (GRAY)	3
8	EL-0414	KNOB: PUSH, PULL, LIFT	1
9	EL-0853	IEC MOTOR CONTACTOR (9 AMP)	3
10	EL-0855	MANUAL MOTOR STARTER (4.0 - 6.3A)	1
11	EL-0858	MANUAL MOTOR STARTER (1.6 - 2.5 AMPS)	2
12	EL-0935	IEC MOTOR CONTACTOR (16 AMP)	1
13	EL-1300	TRANSFORMER - 100VA - (380/400/415)	1
14	EL-1307	GUARDMASTER SAFETY RELAY	1
15	SS142	FUSE HOLDER	4
16	SS185	MAINTAINED BUTTON - TWIST TO RELEAS	1
17	SS302	1 AMP FUSE (CLASS CC)	2
18	SS317	7 AMP FUSE (CLASS CC)	2
19	SS425	EMERGENCY STOP NAMEPLATE	1
20	TAG #37	ELECTRICAL ENCLOSURE DOOR LABEL	1

Bagel Former Parts Catalogue



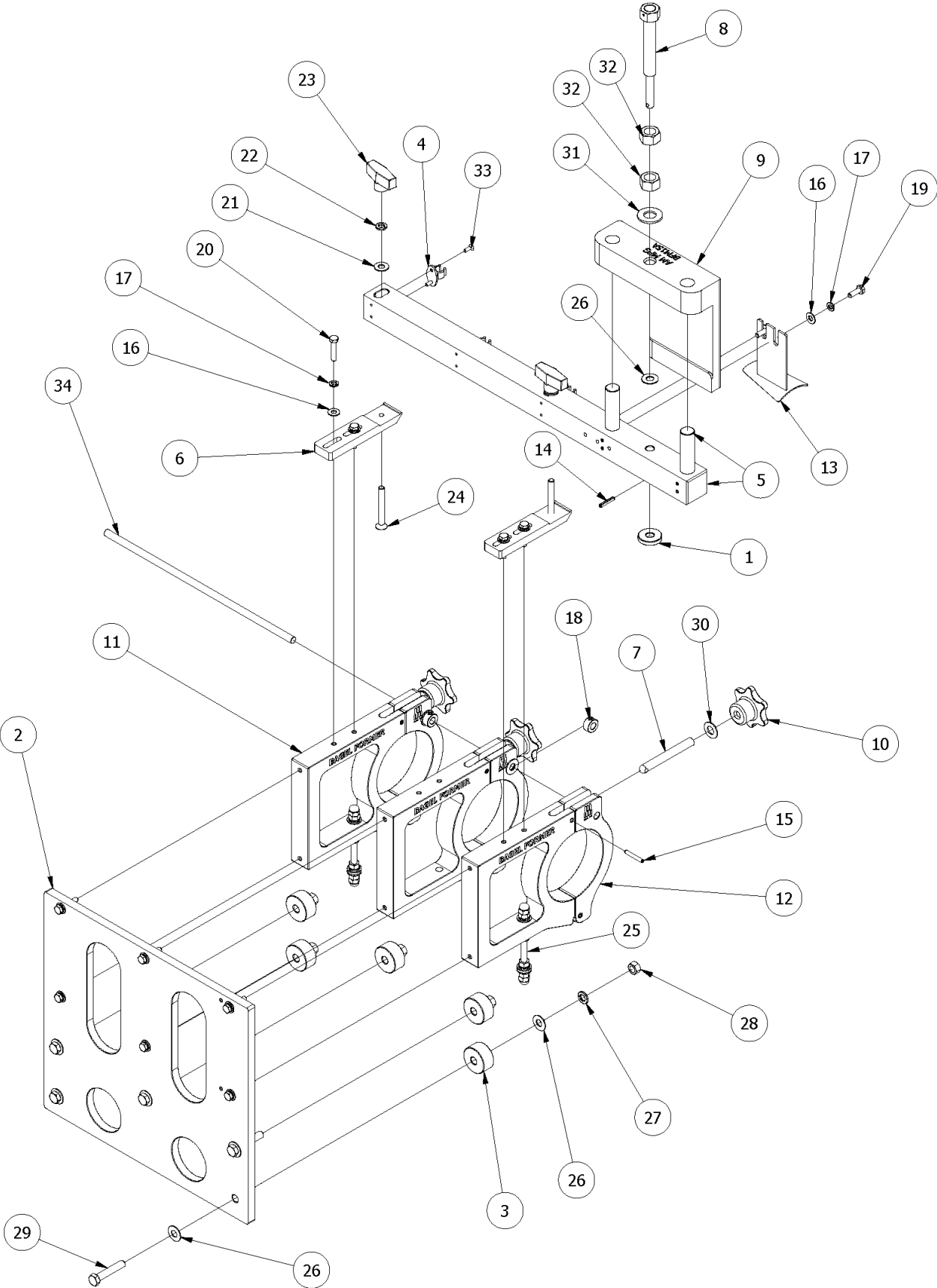
Bagel Former Body Parts Breakdown



Bagel Former Body Parts List

ITEM	PART NO	DESCRIPTION	QTY
1	100DR	ROLLER DRUM DRIVE PULLEY	1
2	100IR	IDLER ROLLER ASSEMBLY	1
3	101IR-A	TAKEUP ROLLER SHAFT	1
4	102DR	DRIVE ROLLER SHAFT	1
5	106DR	MOTOR SPROCKET (50B12X1)	1
6	107DR	#50 CUT CHAIN, 31 LINKS W/ MASTER	1
7	117DR	BAGEL FORMER DRIVE SPROCKET	1
8	621CA1	CASTER, LOCKING 4" DIA	2
9	11208	SPECIAL MOTOR MOUNT PLATE	1
10	11900	1 HP MOTOR, 1750 RPM 56C/WASHDOWN	1
11	12444	GEARBOX (25:1 RIGHT HAND)	1
12	12822	BELT TENSION SWING PLATE DESTACO CLAMP	1
13	20918-C2	ROLLER TAKE-UP MIDDLE TUBE ASSEMBLY	2
14	20918-C4	ADJUSTMENT STUD ASSEMBLY	2
15	20918-C6	ROLLER TAKE-UP INNER TUBE ASSEMBLY	2
16	33535	E-STOP MOUNT BRACE	1
17	A107IR	BRIDGE HOLEDOWN ASSEMBLY	2
18	BDP10	4 HOLE FLANGE BEARING (1-3/8" SHAFT)	2
19	BFM148-002L	CHAIN GUARD	1
20	BRT11	STATIONARY TABLE	1
21	F0400FW	FLAT WASHER, 1/4"	55
22	F0400LW	LOCK WASHER, 1/4"	51
23	F0402HHCS	HEX HEAD CAP SCREW, 1/4-20X1/2" LG.	6
24	F0403HHCS	HEX HEAD CAP SCREW 1/4-20 X 3/4"	22
25	F0408FSH	FLAT SOCKET HEAD, 1/4 X 2" LG.	2
26	F0606HHCS	HEX HEAD CAP SCREW 3/8-16 X 1-1/2"	4
27	F1000JN	NUT, JAM 5/8-11	2
28	KEY STOCK .3125SQ X 12LG	5/16" KEY STOCK (12" LONG)	1

Mandrel Support Parts Breakdown



Mandrel Support Parts List

ITEM	PART NO	DESCRIPTION	QTY
1	21375	SPACER-1-1/4ODX1/4LGX13/32ID, SS	1
2	22579	MANDREL BAR ASSEMBLY SUPPORT PLATE	1
3	22879	SPACER - 1-1/2 OD X 3/4 LG X 13/32 ID, SS	5
4	22973	TOOL HOLDER (7/16" - 9/16")	3
5	ABFM2	MANDREL SUPPORT ASSY	1
6	BFM4	HORIZONTAL ADJUSTING BLOCK	2
7	BFM6	STUD-LOCKING HINGE	3
8	BFM12	MANDREL BAR HEIGHT ADJUSTMENT SCREW ASSEMBLY	1
9	BFM15A	MANDREL SUPPORT & ADJUSTMENT	1
10	BFM19	STAR KNOB 7/16-14 THUR HOLE	3
11	BFM27	FORMING TUBE HOLDER	3
12	BFM31	CLAMP - FORMING TUBE	3
13	BFM52R	RIGHT DOUGH SHIELD	1
14	F0304RP	3/16" DIA X 1" LONG ROLL PIN	1
15	F0305RP	3/16" DIA X 1-1/4" LONG ROLL PIN	3
16	F0400FW	FLAT WASHER, 1/4"	12
17	F0400LW	LOCK WASHER, 1/4"	12
18	F0401SS	SET SCREW 1/4-20 X 1/4"LG.	4
19	F0403HHCS	HEX HEAD CAP SCREW 1/4-20 X 3/4"	2
20	F0405HHCS	HEX HEAD CAP SCREW 1/4-20 X 1-1/4"	10
21	F0500FW	FLAT WASHER, 5/16"	10
22	F0500LW	LOCK WASHER, 5/16"	10
23	F0500PWN	PLASTIC WING NUT (5/16-18)	2
24	F0510FSH	FLAT SOCKET HEAD 5/16 X 2-1/2" LG.	2
25	F0518SD	THREADED ROD (5/16-18 X 4-1/2" LONG)	2
26	F0600FW	FLAT WASHER 3/8"	16
27	F0600LW	LOCK WASHER 3/8"	5
28	F0600NC	3/8-16 HEX NUT	5
29	F0608HHCS	HEX HEAD CAP SCREW 3/8-16 X 2" LG	5
30	F0700FW	FLAT WASHER 7/16"	3
31	F1000FW	5/8" FLAT WASHER	1
32	F1000NC	5/8" HEX NUT	2
33	F9702FH	8-32 X 1/2 SLOTTED FLAT HEAD SCREW	6
34	RS .375X13.75 SS	3/8" OD ROUND STOCK X 13-3/4" LG, SS	1

Table Assembly Parts Breakdown

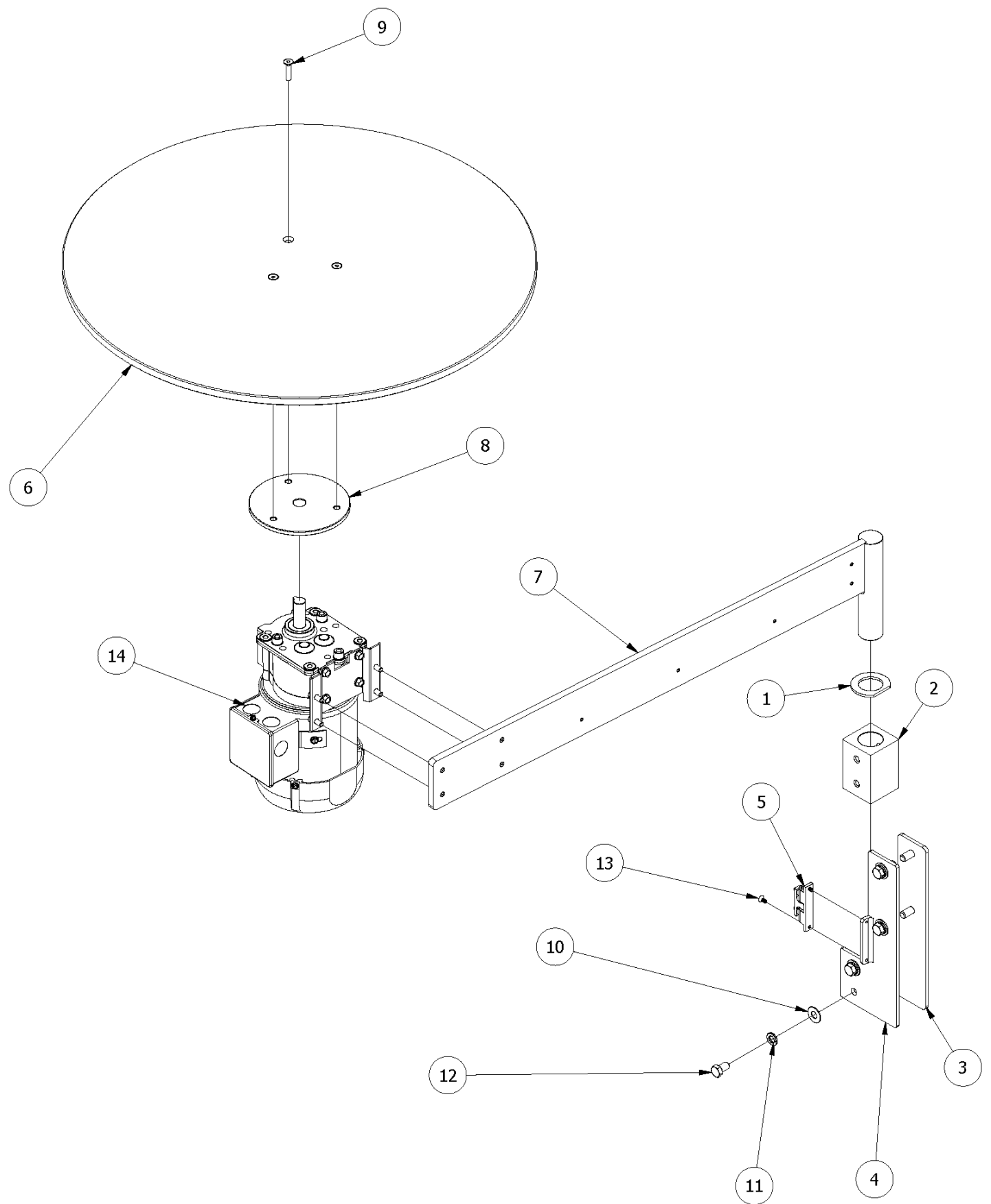
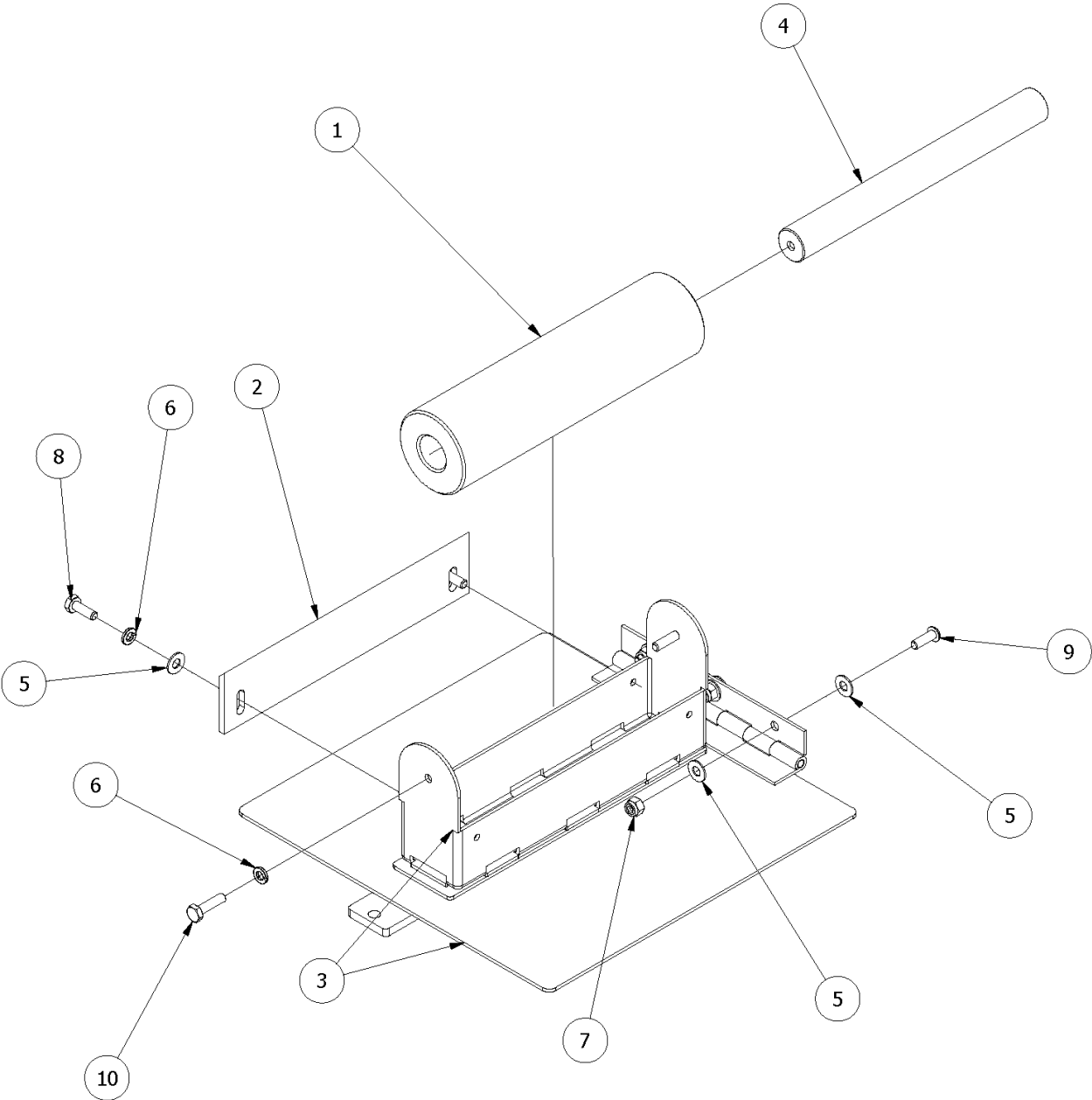


Table Assembly Parts List

ITEM	PART NO	DESCRIPTION	QTY
1	416CDF	SPACER BUSHING	1
2	32869	TABLE ARM MOUNT BRACKET	1
3	32870	TABLE ARM MOUNT BRACKET HOLDER	1
4	33329	TABLE ARM MOUNT BRACKET HOLDER (EXTEND SIDE)	1
5	33337	BALL STYLE GRAB LATCH (MULTI-DIRECT	1
6	BRT32	ROTARY TABLE	1
7	BRT34	SWING ARM MOTOR MOUNT ASSY.	1
8	BRT-36	ROTATING TABLE FLANGE	1
9	F0404.5FSH	FLAT SOCKET HEAD 1/4-20 X 1.125" LG.	3
10	F0600FW	FLAT WASHER 3/8"	8
11	F0600LW	LOCK WASHER 3/8"	8
12	F0602.5HHCS	HEX HEAD CAP SCREW 3/8-16 X 5/8"	4
13	F9701.5FH	FLAT HEAD, HEX DRIVE (8-32 X 3/8" LONG, S.S.)	4
14	SS267	GEAR MOTOR (1/12HP, 7.8RPM, 320in-lb Torque)	1

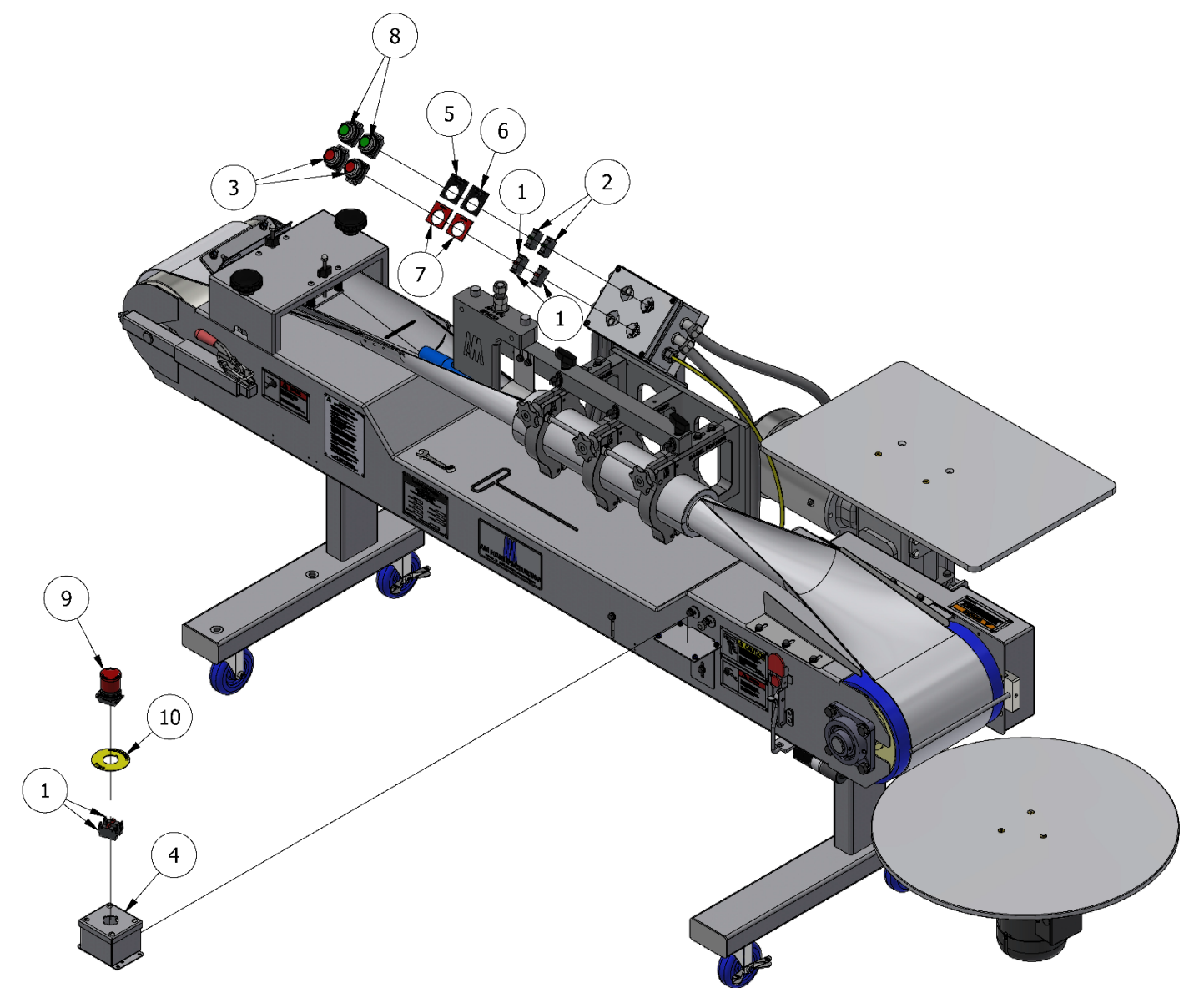
Swing Plate Assembly Parts Breakdown



Swing Plate Assembly Parts List

ITEM	PART NO	DESCRIPTION	QTY
1	110DR	BELT ROLLER	1
2	111DR	ROLLER SCRAPER (BELT TENSION ASSY.)	1
3	115DR-A	BELT TENSIONING SWING PLATE	1
4	116DR	BELT ROLLER SHAFT	1
5	F0400FW	FLAT WASHER, 1/4"	8
6	F0400LW	LOCK WASHER, 1/4"	4
7	F0400NLN	NUT, NYLOCK 1/4"	3
8	F0403HHCS	HEX HEAD CAP SCREW 1/4-20 X 3/4"	2
9	F0403SB	BUTTON HEAD, SOCKET 1/4-20 X 3/4" L	3
10	F0404HHCS	HEX HEAD CAP SCREW 1/4-20 X 1"	2

Pushbutton and E-Stop Parts Breakdown



Pushbutton and E-Stop Parts List

ITEM	PART NO	DESCRIPTION	QTY
1	400038	CONTACT BLOCKS, 1 N.C.	4
2	400039	CONTACT BLOCK 1 N.O.	2
3	EL-0409	PUSH BUTTON, RED	2
4	EL-1970-MH	PUSHBUTTON ENCLOSURE	1
5	EL-2007	NAMEPLATE, "BAGEL DIVIDER START (I)"	1
6	EL-2008	NAMEPLATE, "BAGEL FORMER START (I)"	1
7	SS122	NAMEPLATE, "STOP (O)"	2
8	SS184	START BUTTON, GREEN	2
9	SS185	MAINTAINED BUTTON - TWIST TO RELEAS	1
10	SS425	EMERGENCY STOP NAMEPLATE	1

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)

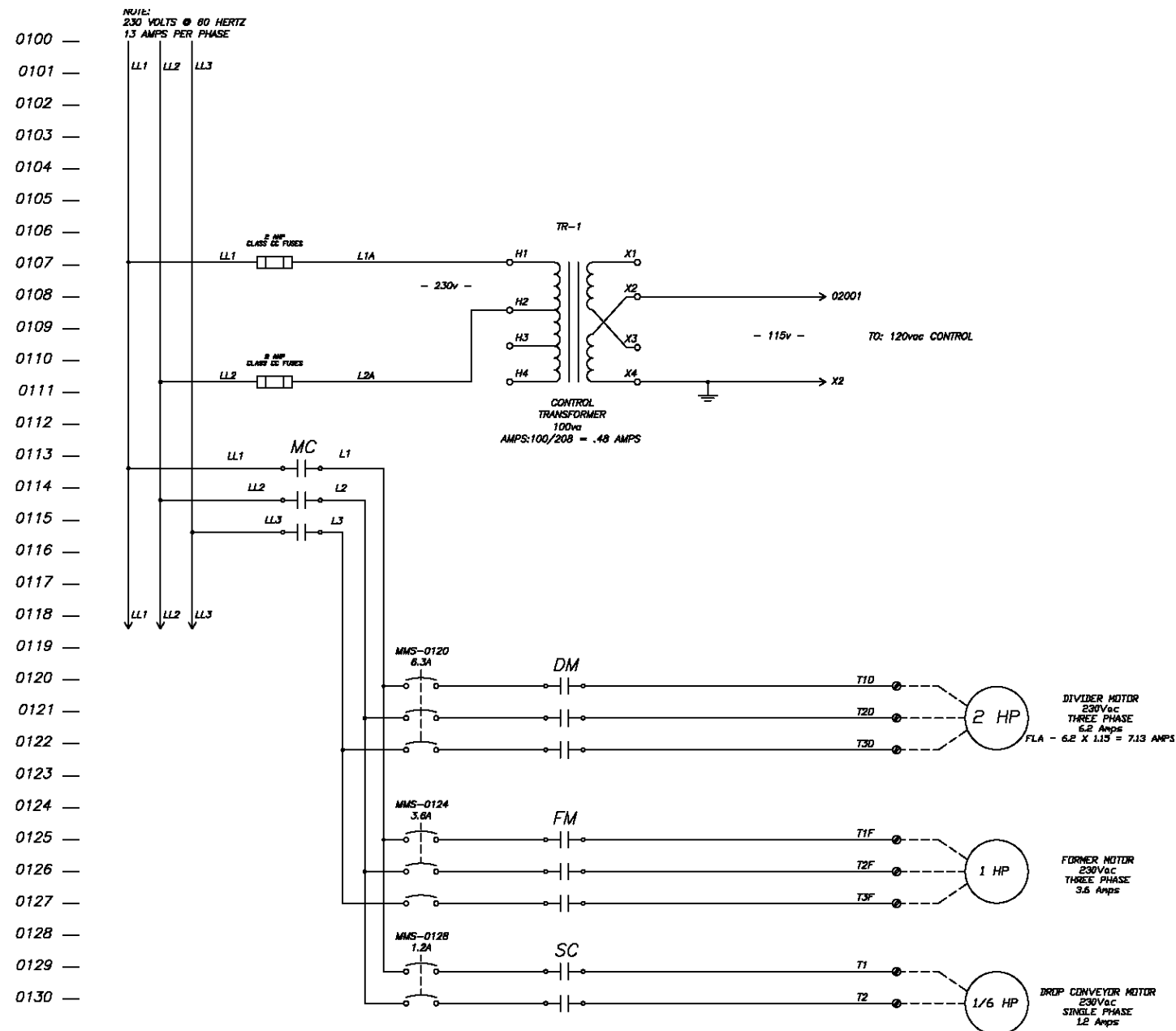
Monday through Friday, 3:30PM to 7AM (CST)

and Saturday or Sunday

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

support@ammfg.com

208Vac-230Vac 3PH Line Wiring Schematics



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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.

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