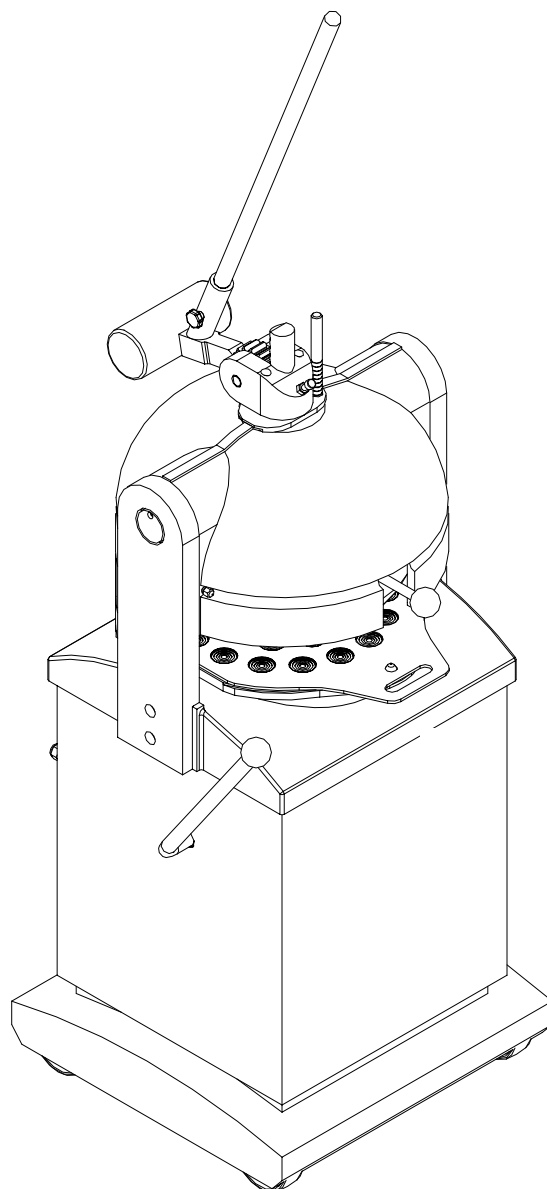


DAUB BAKERY MACHINERY B.V.

Manual
Date: 01-10-2004
Version:03

DR²

English



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1 GENERAL

It is important to read this manual and to comply with the suggestions and/or regulations when unpacking, installing, using and maintaining the machine. If the machine is sold, this manual should be handed over to the new owner.

Employees who have been instructed concerning the use of it and who have read this manual can only operate the machine.

The guarantee obligation of Daub Bakery Machinery B.V. is only valid for defects, which have occurred in spite of a good use of the machine such as described in this manual. Daub Bakery Machinery B.V. can never be held responsible for damage or injuries to persons if these are caused by an inaccurate use of the machine.

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Daub Bakery Machinery B.V. can not be held responsible for mistakes and/or misprints in this manual.

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2 PRODUCT INFORMATION

Manufacturer: Daub Bakery Machinery B.V.
Nieuwkerksedijk 10
5051 HT Goirle
P.O. Box 51
5050 AB Goirle (The Netherlands)
Tel: +31 13 5308700
Fax: +31 13 5308729

After sales service: Your supplier

Machine naming: DR²
Machine number: See machine plate
Date of manufacturing: See machine plate
Power: See machine plate
Voltage: See machine plate
Current: See machine plate
Weight: 350 kg
Sound: <65 dB(A)

Possible executions:

Type	Dividing disc	Max. dough weight	Weight range
DR ² 2/30	30-delig	2,5 kg	25-85 gram*
DR ² 3/30	30-delig	3 kg	30-100 gram*
DR ² 3/36	36-delig	3 kg	25-85 gram*
DR ² 3/52	52-delig	3 kg	16-45 gram*
DR ² 4/14	14-delig	4 kg	130-250 gram*
DR ² 4/30	30-delig	4 kg	40-130 gram*
DR ² 4/36	36-delig	4 kg	30-110 gram*

* The weight range depends on the dough consistency

Voltage: 3*400 V/50 Hz+N, 3*230 V/50 Hz, 3*440V / 60Hz+N, 3*220 V/60 Hz
Other voltages on request

Rounding plates: Plastic Trovidur
Dividing disc: Aluminium Teflon coated
Dividing knife: Stainless steel
Press ring: Iron casted Teflon coated
Rounding table: Aluminium

N.B. All parts, which could come in contact with the dough, are approved for the foods industry.

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3 NOTIONS

3.1 Warnings

The following signs warn the operator for a possible danger.



Figure 3-1

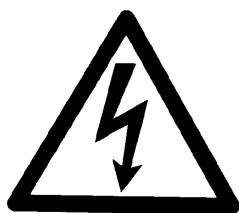


Figure 3-2

Figure 3.1 is a sticker which is used on the machine indicating the position where caution must be taken to avoid sticking into the machine.

Figure 3.2 is a sticker which is used on the machine indicating where electrical power is present.

Before taking in use the machine, you should carefully read this manual and follow the instructions.

Make sure that the warning stickers stay in good condition and, if necessary, replace them.

When you use the machine for the first time, follow the instructions in this manual carefully so that you will not be surprised.

Do not allow unqualified employees to operate the machine.



Only qualified employees may operate the machine.



Make sure the machine is switched off during cleaning, maintenance and lubrication.

After maintenance of the machine, do not forget to replace the safety guards and close the door at the backside.

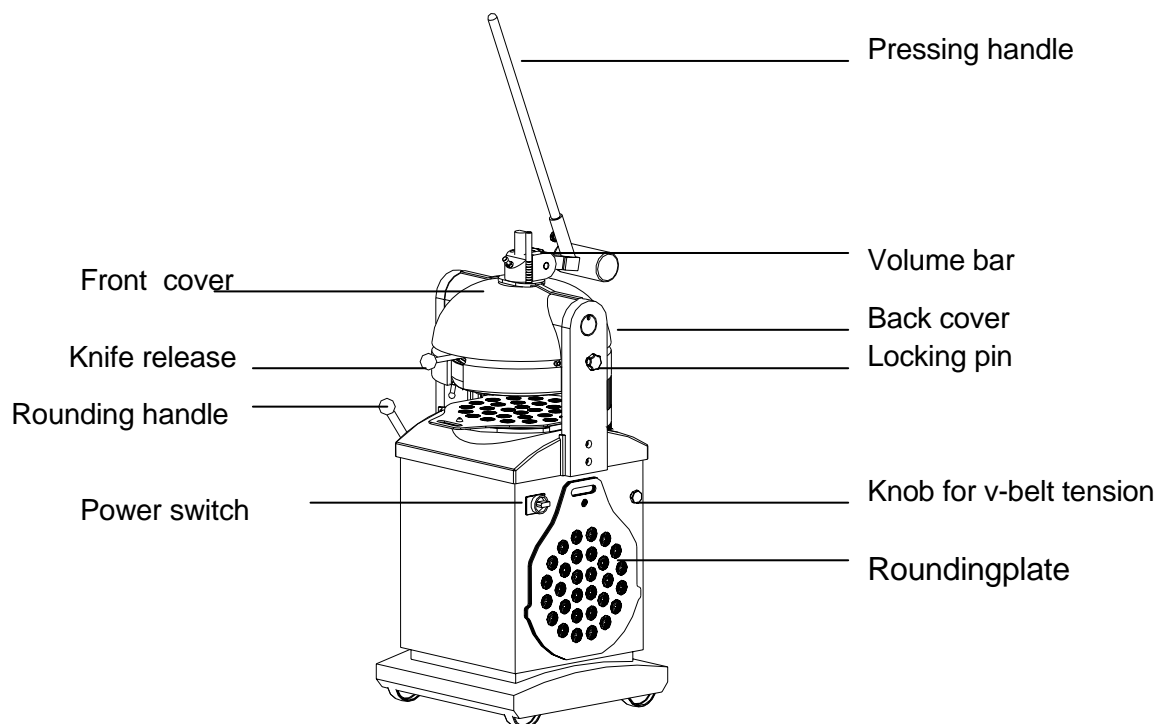
All repairs, mechanical as well as electrical, may only be done by qualified employees.

3.2 Qualified employees

We herewith mean: persons who are familiar with the installation, mounting, taking in use and working of the machine and who have the right qualifications.

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3.3 Naming of parts of the machine



Figuur 3-3

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4 DANGERS

4.1 Safety regulations



Remove plug from the power supply when cleaning and/or maintaining the machine.



Only qualified or well instructed employees can do repairs of mechanical or electrical nature.



Never put your hands in its working area when using the machine (see figure 4-1).



Only one person may use the machine.



Keep guards placed when operating the machine.

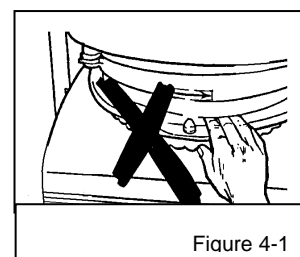


Figure 4-1

4.2 Dangers because of mechanical components



Safety guards protect all parts. Because of the manual operating order, the operator can stop his actions at all time.



When maintaining the machine and especially when removing parts without respecting standard safety regulations, you might get injured when not carefull.



Do not keep your hands at the back of the dividing disc. You might get stuck when rotating the dividing disc back (see figure 4-2) when you are ready cleaning.

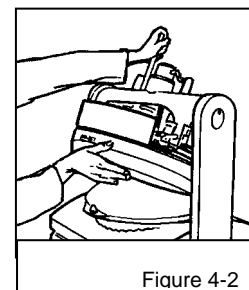


Figure 4-2

By proper use of the machine as described in chapter 8 no dangers will occur.

4.3 Dangers because of electrical components

These dangers will not occur because the electrical parts are not direct accessible. Broken or damaged cables and electrical componements should be replaced immediately by an electricien.

4.4 Dangers because of lack of hygiene

These dangers can occur if the measures such as described in chapter 9 ("Maintenance") are not followed up.

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5 TRANSPORT AND UNPACKING

5.1 Transport

The machine must be transported in its original packing. In the means of transport the packing must be secured against shoving. The machine should be moved with the right lift equipment.

Transport damage caused by not having followed above-mentioned regulations, can not be claimed. Moreover the transport of goods is always at the buyers risk, unless explicitly agreed otherwise.



Do not load anything on top of the packing.



The machine should always be transported upright.

5.2 Unpacking

Leave the packing upright and remove the box vertically.

Unpack the machine carefully and check if there are signs of transportation damages. Should you find any, please inform your transport agent immediately. We advise you to take photographs of the damage.

Remove the machine from the pallet by means of a lift truck or other lift equipment.

By shoving the arms of a lift truck under the foot of the machine, it can be taken from the pallet.



The weight of the machine is approximately 350 kgs.

Out of safety considerations it is advisable to keep enough distance when lifting the machine.

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6 INSTALLATION

6.1 Placing and maintenance



Only qualified employees are allowed to install the machine.



The machine can only be used for its purpose: to divide and round dough.



Guarantee can not be claimed if changes have been made to the machine without the manufacturers permission and/or if not-original spare parts are used. The use of not-original spare parts can damage the machine and/or harm the operator.

The machine should be placed on a solid and flat floor. The machine is very stable. In case of a very slippery floor, you can block the wheels by using wedges.

Check if the rounding plates which are delivered with the machine fit well. The hole in the plate should fall easily over the locking pin (see figure 6-1, B) of the rounding table. If not, plane the back of the plate until it does fall easily over it.

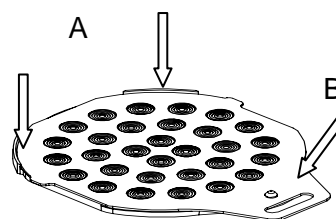


Figure 6-1

6.2 Conditions

Temperature: 15° C till 40° C
Relative humidity: 20% till 95%

6.3 Electrical connection

A qualified engineer must carry out the installation and an electrician should connect the machine to the power supply. Always check first if the voltage and the phases of the electrical connection are in accordance with those of the machine (see machine plate). If this is not the case, please contact your supplier.

Check the direction of rotation of the machine. Turn the power switch (see figure 3-3) to position 1 and press the rounding handle (see figure 6-2, B). The rounding table will make a rotation movement counterclockwise. If this is not the case, an electrician should change the two phases in the plug in order to change the direction of rotation of the motor.

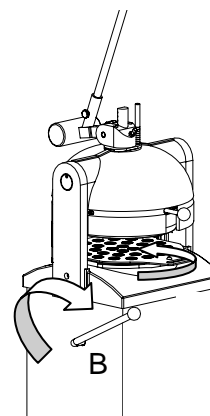


Figure 6-2

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6.4 Carrying off materials

When carrying off a complete machine, parts or only the packing, you should comply with the legal regulations. Specifications concerning the material of the parts can be asked for at the manufacturers.

6.5 Taking out of operation

Switch off the machine by turning the power switch. Then clean it and check the lubrication points as described in chapter 9 "Maintenance". Protect the machine for influences from outside and store it in a closed and dry room.

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7 PRODUCT DESCRIPTION

7.1 Purpose of the machine

The machine (dependent on the type) is meant to divide and round dough pieces of 2, 3 or 4 kgs, which have already been pre-proofed lightly. Put the undivided dough piece on the plate and flatten it by hand. In case of a sticky dough, use some flour to get a better rounding result.

All parts of the machine, which come in contact with dough, are Teflon coated, stainless steel or made of plastic which is approved for use in the foods industry.

7.2 Inadmissible use of the machine

The divider rounder is only meant for activities such as described in chapter 7.1.

The machine can only be cleaned with cleaning products, which are approved for use in the foods industry. Never use corrosive products!

Be sure the machine is placed on a flat floor.

The machine can only be used when the safety guards are placed.

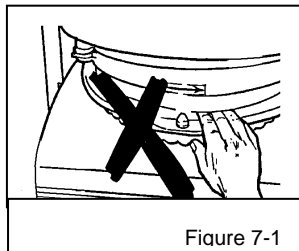


Figure 7-1

Never put your hands in its working area when using the machine (see figure 7.1).

Only use original spare parts.

Do not use dough with metals, stones or other peculiar objects inside.

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7.3 Taking in use of the machine

Check if the machine has been placed correctly, as described in chapter 6 "Installation".

Check if it is necessary to clean the machine because of possible transport dirt.

Also check if the voltage on the machine plate is in accordance with that of your main supply.

In the factory, the dividing head is lightly greased. Clean the dividing head before you start working with dough and then oil it with a little bit of edible oil (see chapter 10 "Maintenance").



Make sure the machine is placed on a solid and flat floor.

Check the direction of rotation of the machine. Turn the power switch to position 1 and press the rounding handle. The rounding table will make a rotation movement counterclockwise. If this is not the case, an electrician should change the two phases in the plug in order to change the direction of rotation of the motor.

You can now proceed with the first test.

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7.4 Working with the machine



Qualified persons older than 16 years may only operate the divider rounder.

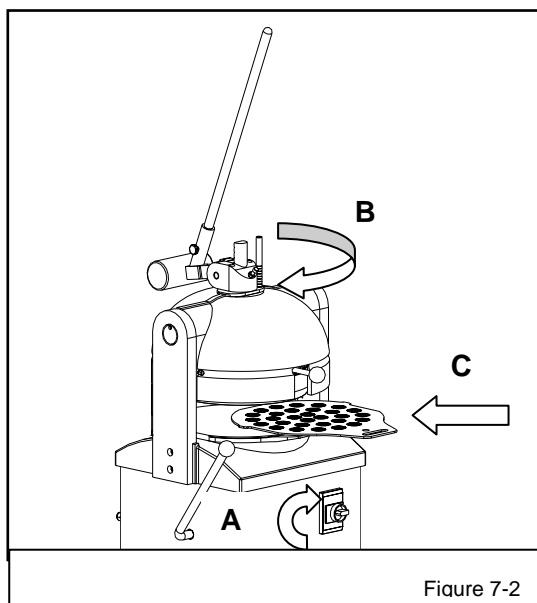


Figure 7-2

- Turn the power on
- Adjust volume control bar (Indications shown in table 1) to the position to the weight of dough
- Place the dough piece in the middle of the rounding plate and flatten it by hand.



If the dough is very stiff it is useful to flatten the dough by a dough roller.



In case of sticky dough it is advisable to flour the dough and rounding plate lightly.

- Place the plate correct onto the moulding table (see chapter 6.1)



Inserting the rounding plate improperly can cause damage to the machine.

The following table gives a rough indication of the correct position of the volume control bar, for the model up to 2, 3 as well 4 kgs dough (see chapter 2 “Product information”).

Stand	Gewicht type 2/xx	Gewicht type 3/xx	Gewicht type 4/xx
0	750 gram	900 gram	1200 gram
1	1110 gram	1320 gram	1550 gram
2	1470 gram	1740 gram	1900 gram
3	1830 gram	2160 gram	2250 gram
4	2190 gram	2580 gram	2600 gram
5	Max.	Max.	2950 gram
6			3300 gram
7			3650 gram
8			Max.

Table 1

Remarks:

The position of this bar determines how far the dividing head jumps back before rounding. In this way the volume of the rounding chambers can be determined. Therefore this position is related to the weight of the dough piece that should be divided.

As the correct setting depends on the dough consistency, it is a question of experience.

When the volume of the rounding chambers is too small, the dough pieces will be damaged. When the volume is too big, they will not be sufficiently rounded.

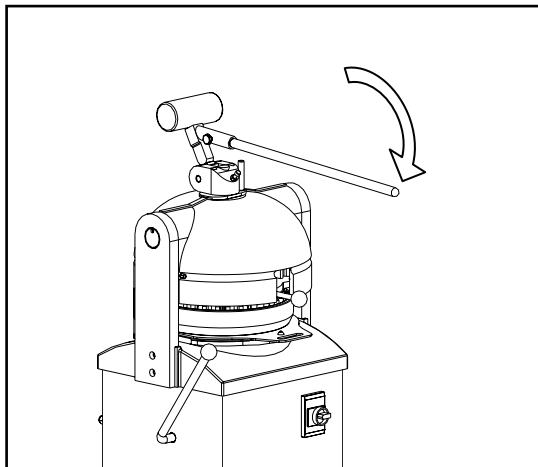


Figure 7-3

- Press the dough by rotating the press handle. The pressing ring will come down and the dough will be pressed.



In order to obtain dough pieces with equal weights, it is necessary to press as long until you see dough coming out of the ring

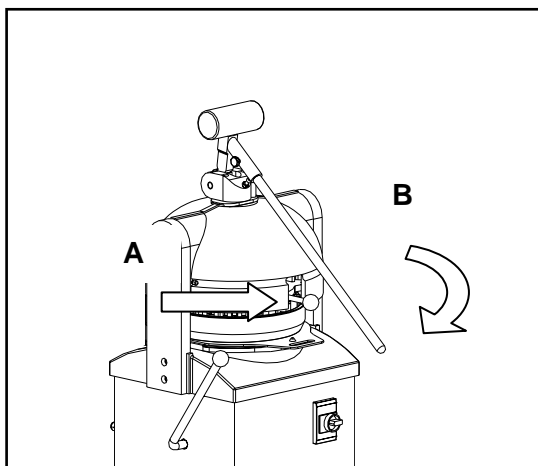


Figure 7-4

- Release the cutting lever to the right (see position A)
- Press the press handle further to cut the dough (see position B) to its end position

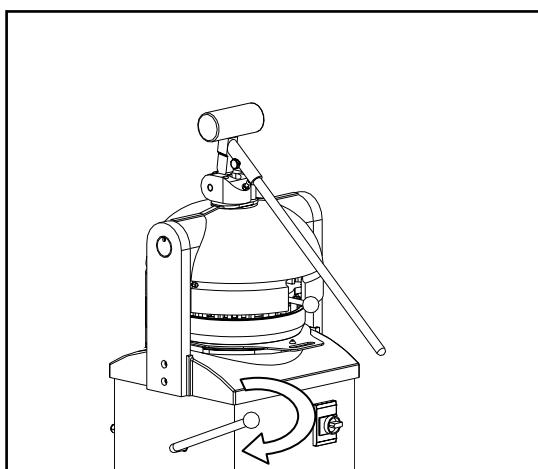


Figure 7-5

- Press the rounding handle to round the dough



Keep the press handle in its position

- After rounding you can return the rounding handle and the the press handle to its starting position to take out the dough

The next chapter will give more information about the result and how to optimize.

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8 JUDGMENT OF THE RESULT

The following information will help you to obtain the best possible result. When operating the machine, always observe the following adjustment options: volume, pressing time and rounding time.

- A) The dough pieces do not have the same weight.
- ◆ Make sure the dough piece is put exactly in the middle of the plate and flatten it a little by hand. The dough should stay inside the circles on the plate. If this is not the case, then you will see when the pressing ring comes down. The pressing ring is not flat on the rounding plate and the dough outside the circles will not be pressed and rounded.
 - ◆ Be sure that the dough has had the right pre-proofing time (dependent of the consistency of the dough, but usually 15 minutes).
 - ◆ Press the dough by pressing the handle longer in the press position. As soon as the dough appears under the pressing ring, it has been pressed long enough.

- B) The dough pieces have not been rounded enough.
- ◆ Turn the volume bar (figure 3-3) to a lower setting.
 - ◆ Round the dough more by keeping the handle longer in the rounding position.
 - ◆ Try a combination of both.

The dough will now be rounded more intensively.

- C) The dough pieces have a dot on top.
- ◆ Turn the volume bar (figure 3-3) to a higher setting.
 - ◆ Check if the weight of the dough piece is in accordance with the capacity of the machine.
- D) The dough pieces have a damaged skin.
- ◆ The dough pieces have been rounded too long. Round shorter.
- E) The machine presses the dough through the gap between the pressing ring and the rounding plate.
- ◆ The dough piece has been pressed too long. Press shorter



For a good result observe the weight range of the machine. Eventually check the machine plate. The table on page 4 mentions the weight ranges of the different types of machines.

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9 MAINTENANCE

9.1 Cleaning



Always turn the power switch to “0” and unplug the power connector before starting any kind of maintenance.



Never clean the machine with water. The use of water will cause oxidation and electrical problems.



Only qualified employees may clean the machine. Other persons should keep some distance.

Daily:

Clean all used rounding plates (do not forget to clean the bottom as well!) with cold to lukewarm water.

Do not store the rounding plates in the machine, but hang them on the bracket at the side of the machine.

Clean the topside of the rounding table.



Make sure that there are no dough rests between the rounding table and the plate, because this will cause damage to the knife crown and the rounding plate while working.

Weekly:

Clean the working area of the dividing disc, the dividing knife and the pressing ring. (see chapter 9.2)

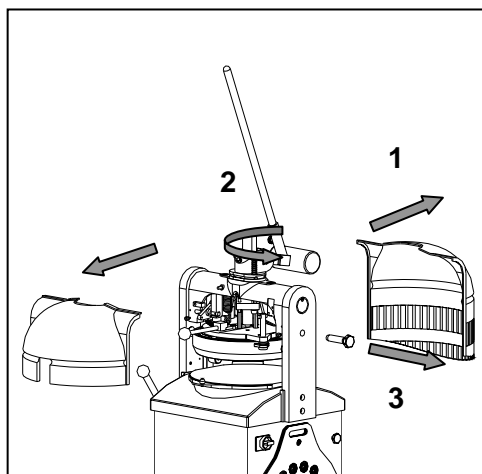
Monthly:

Grease all moving parts of the head. Pay special attention to the two support shafts (figure D1, 46) , the knife release lever (figure D1, 23) and the two brass guide blocks (figure D1, 9). After having cleaned the area below the rounding table (figure DA, 1) (see also chapter 9.3) also grease all moving parts. Pay special attention to the running surface of the rounding table, the plastic sliding ring (figure DA, 2) and the bearing of the cross bearing (figure DA, 10).

Check the tension of the V-belt and if necessary tighten it with help of the knob (figure 3-3) at the right side of the machine.

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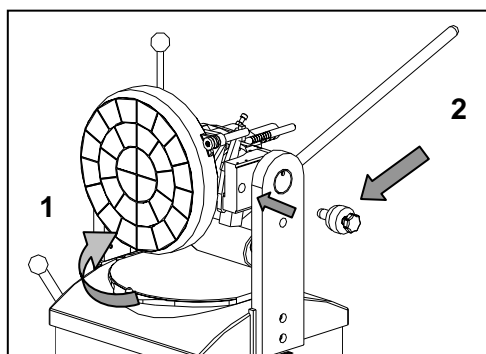
9.2 Cleaning of the dividing head and knife crown



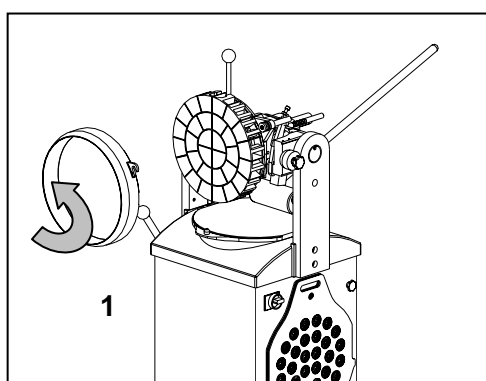
- Remove covers (see position 1)
- Turn the weight control bar to its maximum (see figure position 2)
- Remove locking pin (see position 3)



Be aware the pressing handle will rotate backwards if the dividing disc will tilt towards.

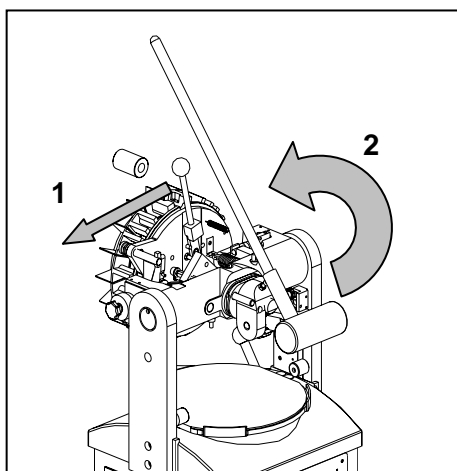


- Turn the dividing disc up by pulling up the knife release lever (see position 1)
- Put locking pin together with extra supplied rubber ring into the hole of the rotated part to keep the disc up.



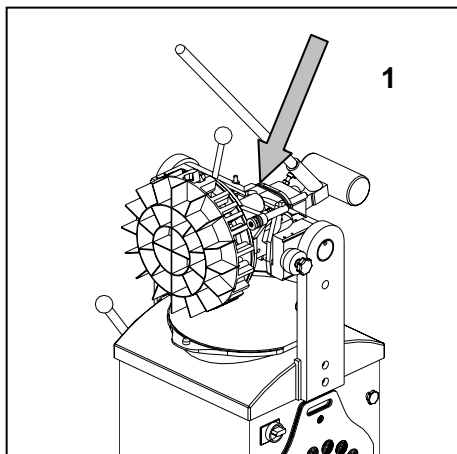
- Remove the pressing ring (see position 1)

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- Take position at the back of the machine
- Keep knife release with left hand and pressing handle with the right hand
- Move knife release to the left (see position 1) to end position
- Move pressing handle up (see position 2) to end position

Knife will come out for cleaning



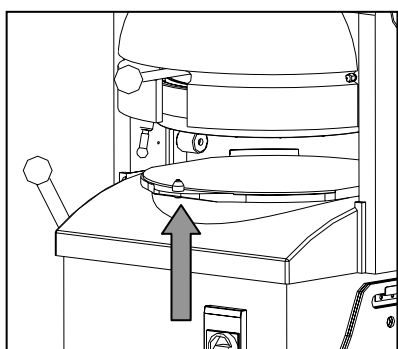
- Put supplied grey bush between knifeholder and top to keep the knife out (see position 1)
- Clean the knife with a soft brush and plastic scraper
- Lubricate knife with oil base on paraffine



Never use vegetable oil which will get hard

After cleaning you can place the machine back in opposite direction.

9.3 Cleaning of the area below the rounding table



- Remove the rounding table by giving a firm push to the bottom of the protruding post (see figure).
- Clean the area from dough and flour rests (clean without water). Grease the white cavities in the plastic sliding ring (figure DA, 2) and the running surface of the frame (DA, 5).
- Replace the rounding table and make sure that the round cavity in the middle of the rounding table fits correctly on the bearing of the cross bearing (figure DA, 10).
- Press the rounding table firmly and check if it lies flat.



The rounding table must lie flat!

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9.4 Adjusting of the knife crown



Only qualified employees can adjust the knife crown. Other persons have to keep some distance.

First of all remove the covers and the pressing ring.

Put a rounding plate upside down on the rounding table and then put three sheets of paper as big as the rounding plate on it.

Release the knife release spring (figure D1, 20)

Press the press handle down so the knife will press the paper.



Keep the press handle all the time down

Loosen the two nuts per knife bolt (figure D1, 44).

By gently knocking on the four knife bolts with a rubber hammer, you can pat the knife crown on the paper.

You can lower the knife crown by adjusting the lower nuts on the knife bolts, and heighten it by adjusting of the upper nuts.

Check if the paper moves freely under the knife crown by pulling the four corners of the paper.

If the paper moves freely, tighten the nuts.

Now you are ready, can turn back the handle and place the knife release spring and the covers again



Do not forget to put back the knife release spring again.

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10 FAULT FINDING

The knife crown and the dividing head remain disconnected.

- Check if pressing handle is returned up completely
- Check the spring on the knife release (figure D1, 20)

The rounding table does not stop its eccentric movement.

- Check the drawing springs (figure DA, 11) of the cross bearing.

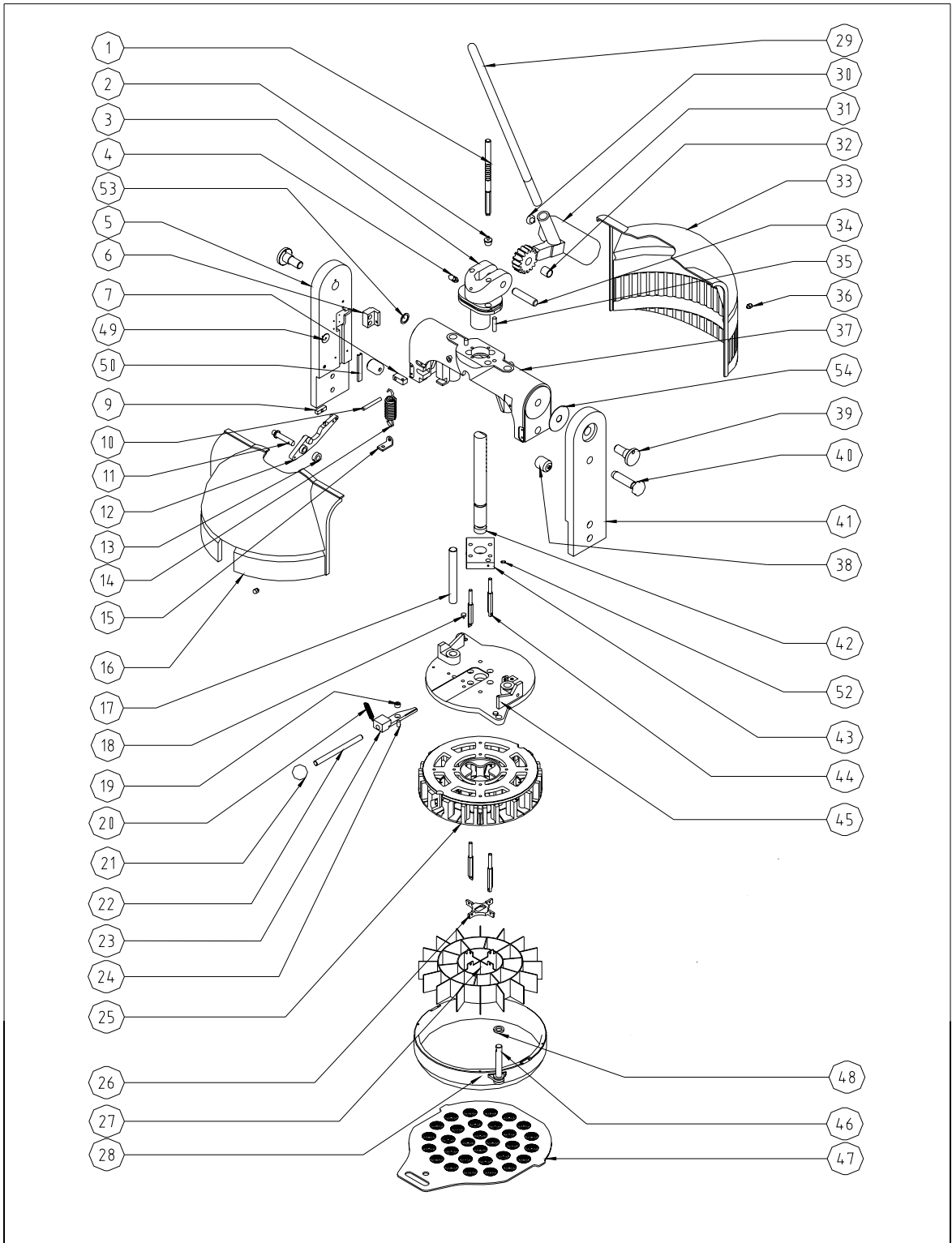
The machine does not divide the dough.

- Check if the knife release (figure D1, 23) moves out of the pressing shaft (figure D1, 42).
 - If so: The knife crown is filthy or bent
 Springs (see figure D1, 14) are broken.
 - If not: The knife release lever does not run well. Clean and grease it.

The machine does not round the dough.

- Turn the power switch on (see figure 3-3)
- Check if the pressure link (figure D2, 4) is adjusted in such a way that it does push up the cross bearing (DA, 7).
- Check the tension of the V-belt, by means of the knob (see figure 3-3).

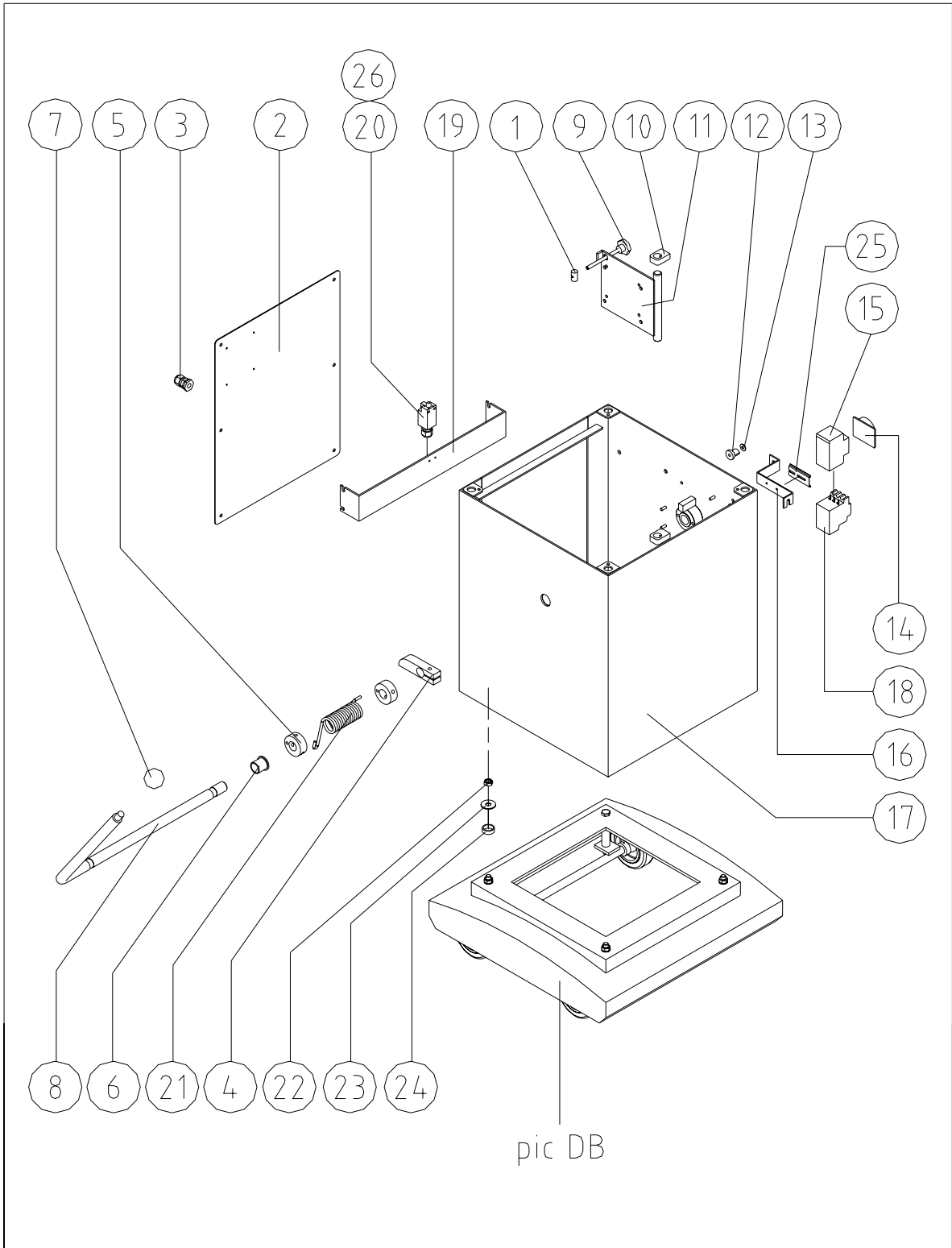
11 FIGURES AND DIAGRAMS



Picture: D1

File: D1.1_BOVENDEEL MANUEEL

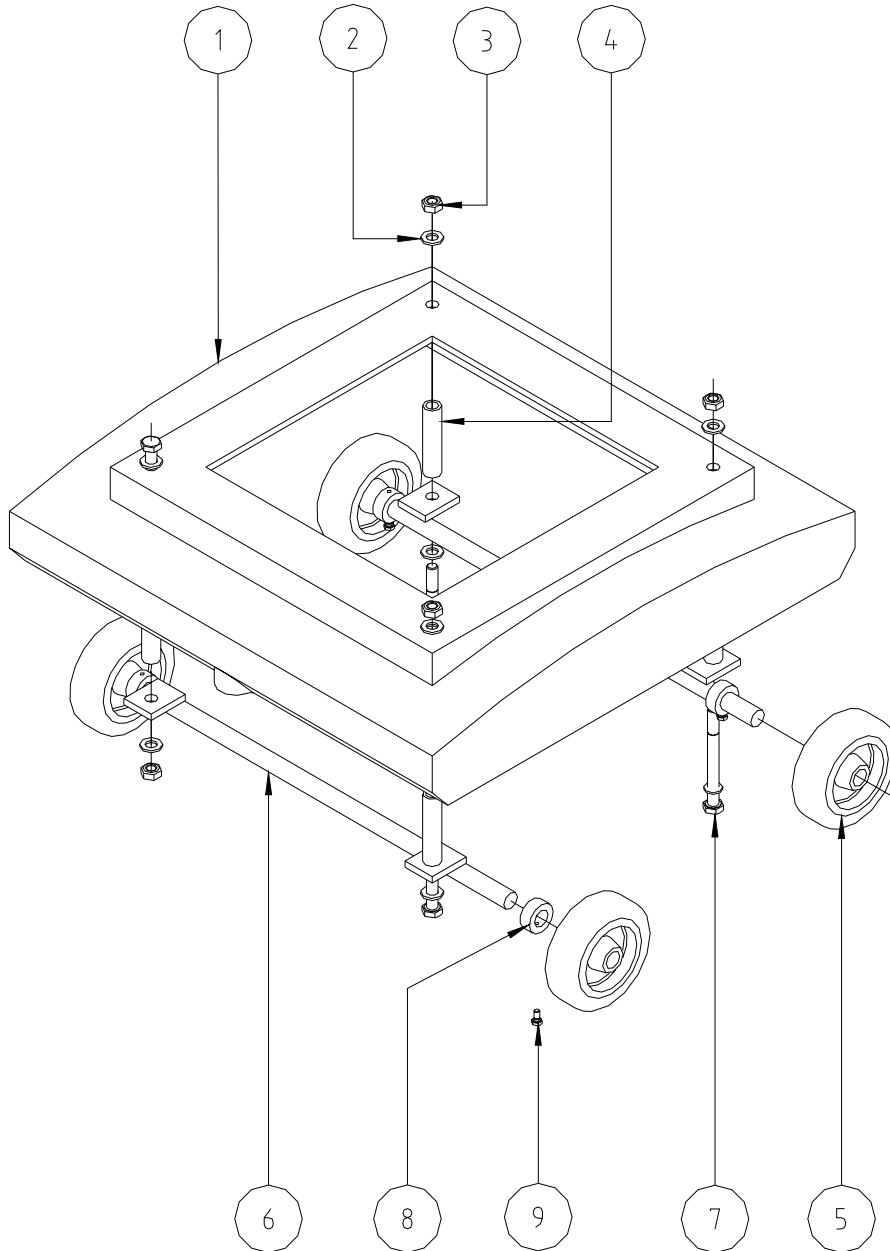
Name: TOP ASSEMBLY



Picture: D2

File: D2.2_FRAME MANUEEL

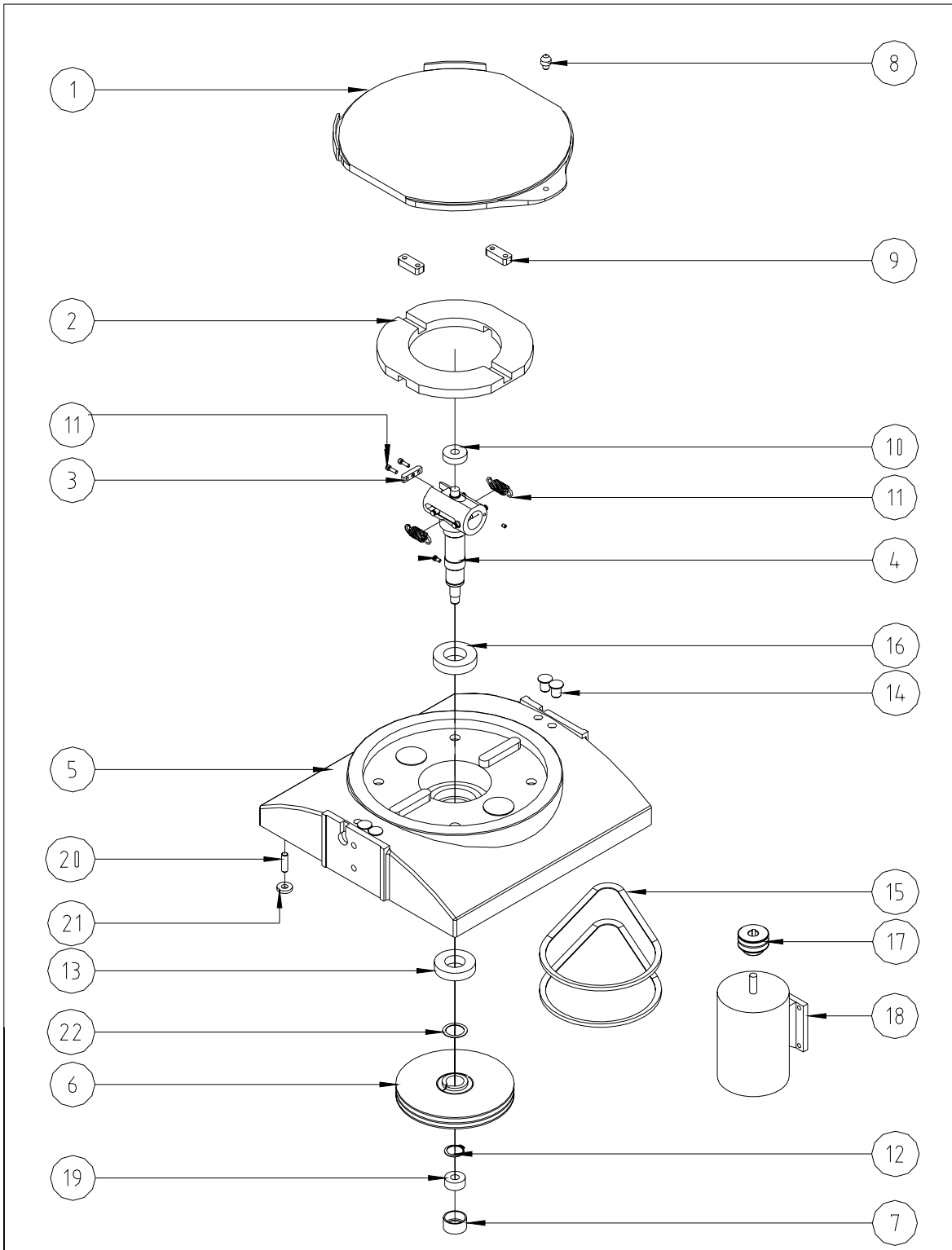
Name: FRAME MANUAL



Picture: DB

File: DB11_ONDERSTEL

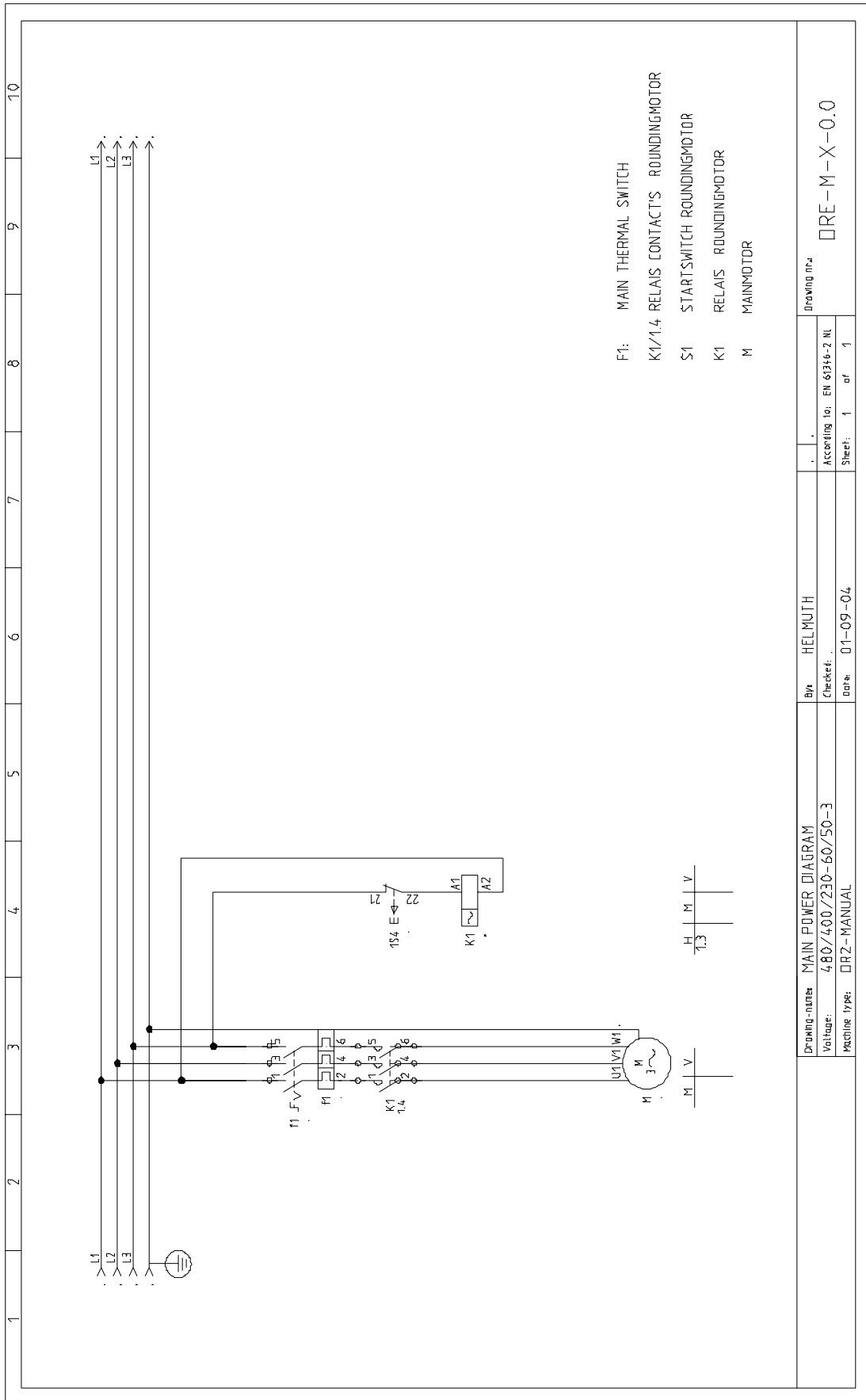
Name: BASE



Picture: DA

File: DA11_0PB0LTAFEL

Name: OSCILLATING TABLE



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12 SPARE PARTS

Pos. no.	art. no.	description	qty
D1-01	03006	Volume shaft	1
D1-02	60031-1	Stopdamper	1
D1-03	02999	Fill up tin of binder	1
D1-04	00054	Stop stud press handle M10*35	1
D1-05	03020-L	Sidepiece left	1
D1-06	02314	Adjusting block	1
D1-07	03009	Stop block of lever	2
D1-09	00396	Guide block	2 *)
D1-10	00052	Shaft of springs	2
D1-12	62263-4/36	Dividing knife 4/36	1
D1-14	62280	Tension spring divide disc	2 *)
D1-15	03023	Binder of tension spring divide disc	2
D1-16	90020-5	Frontcover DR2	1
D1-17	03014	Console shaft	2
D1-18	62203-1	Stopdamper	2
D1-19	00055	Bush (lever)	1
D1-20	60614	Draw spring ratchet	1 *)
D1-21	60008	Ball knob 50*16	1
D1-22	03013	Handle of ratchet	1
D1-23	03012	Ratchet	1
D1-24	60958	Insert notching pen S4 10*20 D1474	1
D1-25	02992-2/30	Dividing disc 2/30	1
D1-25	02992-3/30	Dividing disc 3/30	1
D1-25	02992-3/36	Dividing disc 3/36	1
D1-25	02992-3/52	Dividing disc 3/52	1
D1-25	02992-4/14	Dividing disc 4/14	1
D1-25	02992-4/30	Dividing disc 4/30	1
D1-25	02992-4/36	Dividing disc 4/36	1
D1-27	62263-2/30	Dividing knife 2/30	1
D1-27	62263-3/30	Dividing knife 3/30	1
D1-27	62263-3/36	Dividing knife 3/36	1
D1-27	62263-3/52	Dividing knife 3/52	1
D1-27	62263-4/14	Dividing knife 4/14	1
D1-27	62263-4/30	Dividing knife 4/30	1
D1-28	90104-2/XX	Pressing ring 2/XX complete	1
D1-28	90104-3/XX	Pressing ring 3/XX complete	1
D1-28	90104-4/XX	Pressing ring 4/XX complete	1
D1-29	00025	Press handle	1
D1-30	60077	Star-shaped knob black S-40 M8	1
D1-31	03019	Perss lever holder	1
D1-32	60802	Bearing self-oiling bush 22*27*28	1
D1-33	90020-6	Backcover DR2	1
D1-34	03015	Shaft perss lever holder	1
D1-36	02917	Screw for guard	4
D1-37	03000	Binder	1
D1-38	03022	Stop back cover	2
D1-39	02312	Reversing rod	2
D1-40	90-VO-02528	Lockingpin complete rond 25	1
D1-41	03020-R	Sidespiece right	1

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D1-42	03005	Press shaft	1
D1-43	03004	Knife bolt holder	1
D1-44	03003	Knife bolt of cross	4
D1-45	03001	Locking plate	1
D1-46	90101	Conduction perss-ring	2
D1-47	03017-2/30	Rounding plate 2/30	3
D1-47	03017-3/30	Rounding plate 3/30	3
D1-47	03017-3/36	Rounding plate 3/36	3
D1-47	03017-3/52	Rounding plate 3/52	3
D1-47	03017-4/14	Rounding plate 4/14	3
D1-47	03017-4/30	Rounding plate 4/30	3
D1-47	03017-4/36	Rounding plate 4/36	3
D1-48	62302	Touch pressing ring	2
D1-49	02223	Fixing pulley	2
D1-50	03040	Cover profile of electric cables	2
D1-52	60509	Adjusting screw + ball M8*16	1
D2-01	00746	Tension shaft motor bracket	1
D2-02	03028	Cover plate of frame	1
D2-03	62188-M20	Turnbuckle M20	1
D2-04	02381	Pression link	1
D2-05	00762	Adjusting ring torsion spring	2
D2-06	60042	Nylon bearing 08-25	2
D2-07	60008	Ball knob 50*16	1
D2-08	03029	Rounding lever	1
D2-09	90-DR-02308	Clampwire motor	1
D2-10	00745	Motorsupport	2
D2-11	00742	Motor bracket cpl.	1
D2-12	03050	suspension rounding plates	1
D2-13	62303	Ring M6	1
D2-14	62304	Main switch	1
D2-15	62131	Motor security switch upto 2,5 A	1
D2-15	62132	Motor security switch upto 4 A	1
D2-15	62133	Motor security switch to 6,3 A	1
D2-16	03049	Holder motorrelay	1
D2-18	62406-400	Motor security relay 400V	1
D2-19	03107	ZS Supportplate frame manual	1
D2-20	62155	Endswitch	1
D2-21	61087	Torsion spring	1
D2-22	60014	Nut ZK M12 D934	3
D2-24	02370	Mounting bush for wheel axle	3
D2-25	02894-70	Assembly rail	1
D2-26	62188-M20	Turnbuckle M20	1
DA-01	02396	Mouldingtable 4/XX	1
DA-01	90014-4/XX	Rounding table 4/XX complete	1
DA-02	01359	Sliding ring	1 *)
DA-03	02740	Limitation strip cross bearing	1
DA-04	90-VO-02386	Crossbearing assembled	1
DA-05	03016	Table	1
DA-06	90015	Pulley	1
DA-07	00019	Bearing house	1
DA-08	02532	Centring pin moulding table	1
DA-09	01363	Guide key -S-	2
DA-10	60016	Ball bearing 63032ZR 17*47*14	1
DA-11	61292	Draw spring cross bearing	2

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DA-11	62317	Draw spring cross bearing DR2	2
DA-12	60007	Retaining ring A35 D471	1
DA-13	60005	Ball bearing 6208.2ZR	1
DA-14	90043	Protection bush hydr. hose	4
DA-15	61861-1	V-belt SPZ 850	2 *)
DA-16	60004	Ball bearing 6209.2ZR	1
DA-17	03061	V-belt disc	1
DA-17	60020	Pulley 2SPZ 56	1
DA-17	61293	V-belt pulley 50 2*SPZ	1
DA-18	61232	Motor 220/380 V. 0,55 kW	1
DA-18	61587	Motor 0.55kW UL 3*208V RPM=1200	1
DA-18	62006	Motor MDE80	1
DA-19	60003	Angular contact bearing 3203BTVH	1
DA-22	60631	Screw CK MBZ RVS M6*20	2
DA-22	61931	Shim ring steel 36*48*1,0	1
DB-01	61856	Casting underframe	1
DB-02	60538	Washer M12 D125	8
DB-03	60014	Nut ZK M12 D934	4
DB-04	02369	Adjusting tube for wheel axle	4
DB-05	62014	Wheel	4
DB-06	02366	Wheel axle	2
DB-07	60526	Bolt ZK M12*130	4
DB-08	00458	Collar sheel axle	4
DB-09	60053	Hex head screw M6x10	4
DB-09	60061	Adjusting screw M6*6 D916K	4

*) recommended spare parts