SIMON FRERES

CONTISTOCK	GENERAL DATA		
ORIENTATION	The front is the butter outlet nozzle end, right and left sides for an observer facing the nozzle.		
POSITION of SERIAL NUMBER	At the rear below the filler cap of the mechanism casing		
OVER - ALL SIZE		assembled	Disassembled
	Length	2200 mm	2000 mm
	width	1350 mm	800 mm
	height	1300 mm	900 mm
ELECTRIC MOTOR	4 HP at 1500 rpm		Gear box ratio 1/17
DRIVE PULLEY	Ø 95 mm	Electro-magnetic clutch	
RECEIVING PULLEY	Ø 112 mm		
DRIVE BELTS	3 belts	18 mm x 8 mm x 780 mm	

Compressed air inlet on RH side of Km 1000

Flexible conduit with quick release connections supplied with machine.

Compressed air requirement : 0,2 m3 to 0,6 m3 (200 to 600 L/hr)

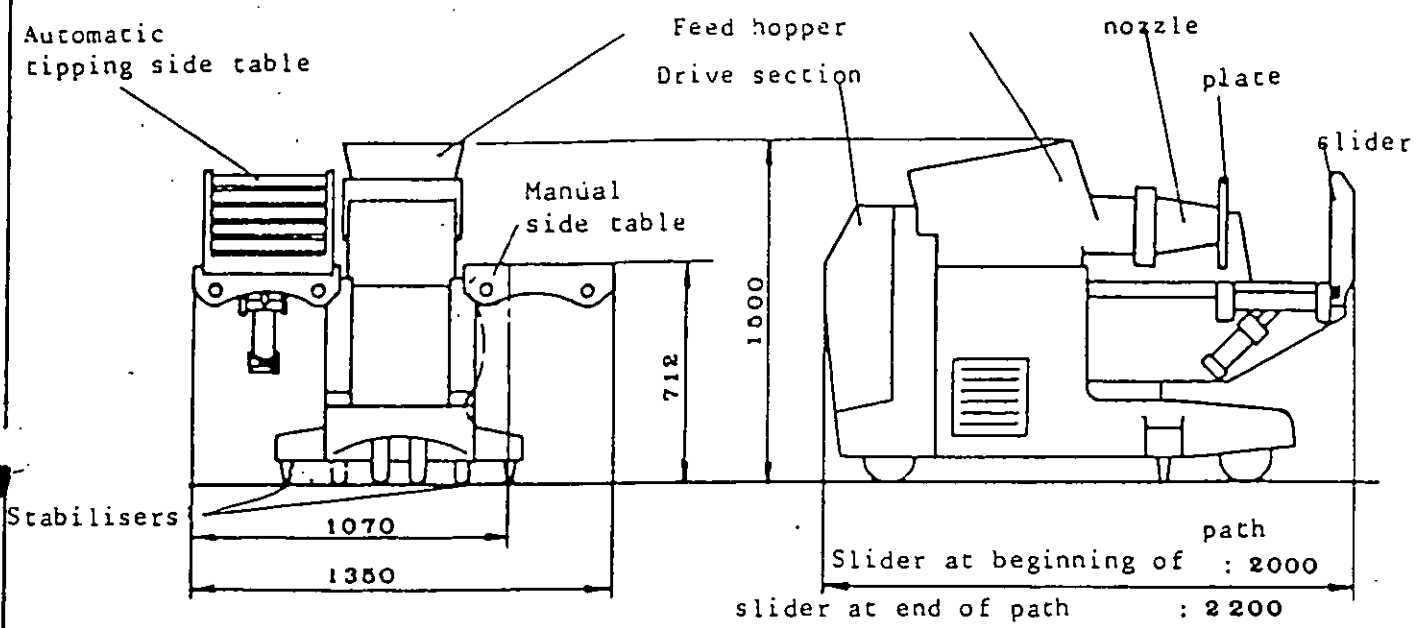
Air supply pressure : 6 to 8 kg/cm2

Tools supplied : 1 wrench 10/12 mm - 1 wrench 17/22 mm - 1 allen-key 3/5 mm

Standard filling equipment : moulding plate Ø 220 mm
moulding plate 285 mm x 285 mm

CONTISTOCK

PACKER



DIMENSIONS IN mm = LENGTH X WIDTH X HEIGHT

MAXIMUM SPACE OCCUPIED : 220 X 1350 X 1500

DIMENSIONS IN SEAWORTHY OR LAND TRANSPORT PACKING : 2200 X 1110 X 1620

VOLUME OF MACHINE CASE : about 4 m3

NET WEIGHT = 610 Kg GROSS WEIGHT : land transport = 785 Kg Seaworthy = 870 Kg

Augers screws drive motor

(Motor type J.N.S.F. - 100 L4
(Cage rotor in short circuit - direct start
(Power 4 H.P. - 1415 R.P.M. - 3 KW - shaft Ø 28
(Amperage/volatage (220 V - 380 V - 440 V - 500 V
((11,5 6,6 5,75 5

Weight motor only : 39 Kg

Clutch : Electro-magnetic type SENIOR S.F. 825

Pulleys and Drive belts

(Drive : bore 28 d.p. 112 - receiving bore 35 d.p. 95 - auger screws
(speed 70 R.P.M.
(Drive : bore 28 d.p. 95 - receiving bore 35 d.p. 112 - auger screws
(speed 50 R.P.M.
(Drive-belts - number : 3 - dimensions 13 X 8 X 780 - 13 D - 00767

Reducer of Auger screws Drive

(type LV - 5 - 63 - ratio 1/17
(In put shaft Ø 35 - output shaft Ø 45
(Principle : worm screw 3 threads - tangent wheel - modul -

Weight of reducer alone : about 46 Kg

(1 pneumatic ram for slider - type NCA 40 X 18 - AP 29 - 0,1 - 1 -
(450 KC Ø 40 - path 450
(1 pneumatic ram for automatic tipping side table - type NCA 50-18
(NA - 27 - 4 - 14 - 210 - KS - 107
(

PREPARATION AND INSTALLATION

Electrical Equipment

The complete electrical equipment of the CONTISTOCK is factory-fitted. It comprises a 4 HP 1500 rpm motor, usually 220/380 volt 3-phase, con--trolled and protected by a 3-pole contact breaker fitted with a 220 or 380 volt coil according to customer's requirements.

The starting and stopping of the auger-screws are automatic and con--trolled by the forwards and backwards movements of the carriage.

NOTE : The new models do not have a disconnecting switch inside. Outside connection.

CONTISTOCK KM-1000 mains connection

a) open the door on the LH side of the machine

b) unscrew the two butterfly nuts which hold the switch on the inner front wall of the framework. The length of the wire linking it to the motor allows it to be taken out to facilitate connection.

c) use a flexible 4-core cable of 16/10 section. Pass it through the opening provided at the bottom on the RH side of the framework and connect :

- *to the plug (male plug on CONTISTOCK side) protected by a mains connected switch ;*
- *to the CONTISTOCK contact breaker. (refer to the wiring diagram on the inside of the contact breaker cover). Connect the 3-phase wires to the terminals marked L1 - L2 - L3 "ligne triphasée". The fourth wire "earth" should be connected to the screen marked "borne de mise à la terre".*

d) Check that the coil of the contactor corresponds exactly to your mains supply voltage 220 or 380 volt

e) Position the voltage selection connection strips of the motor terminal box according to the mains voltage.

Direction of motor rotation

with the electrical connections completed, the hopper and the auger-screws removed, start the motor and check the direction of roatation of the auger drive tenons for an observer facing the front of the machine:

- *the LH tenon should turn in a clockwise direction*
- *the RH tenon should turn in an anticlockwise direction.*

Pneumatic Equipment

(2 Stabilisers pneumatic rams AX 10 H - TF 25
(Air inlet by closing connection O/ 3/8 reducing valve - III
(Distributer D.T.P. 31.210 - 2497 - microvalves MGV
(Rapid release valve - type CEA - No 4.164
(Glycerine manometer - 0 to 10 bars.

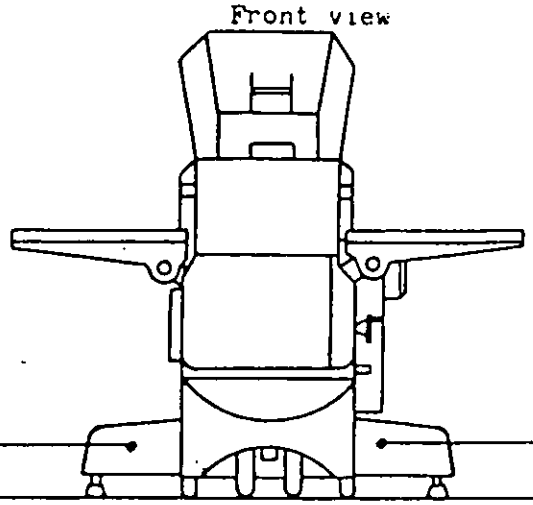
Electrical Accessories

(Stop - start switch of feed auger screws
(Roller model - type XC2 - MC 11
Disconnecting switch ND 1 - CB 520 -
Relays and fuses according to voltage.
(Compressed air requirements : pressure 7 bars - output 0,4 TO 2m3/hou
(Recommended compressor : motor 1,5 to 2 H.P. - i.e. 1,1 to 1,5 KW

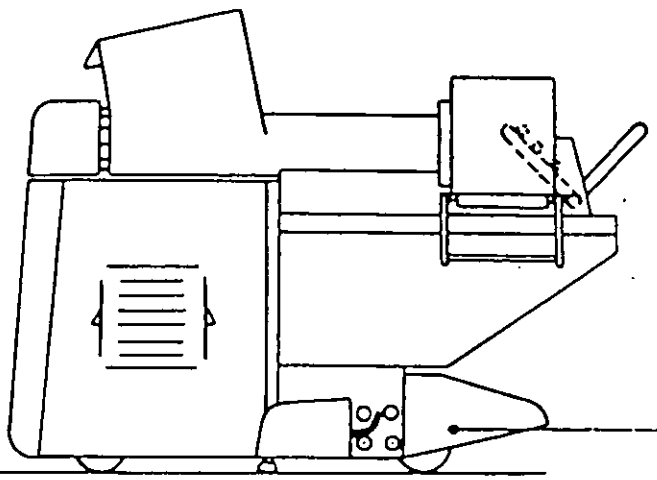
ETS SIMON FRERES

CONTISTOCK ET SUPER CONTISTOCK

Vue de face
Ansicht
Front view



Vue de côté
Seiten-Ansicht
Side view



Position des stabilisateurs montés

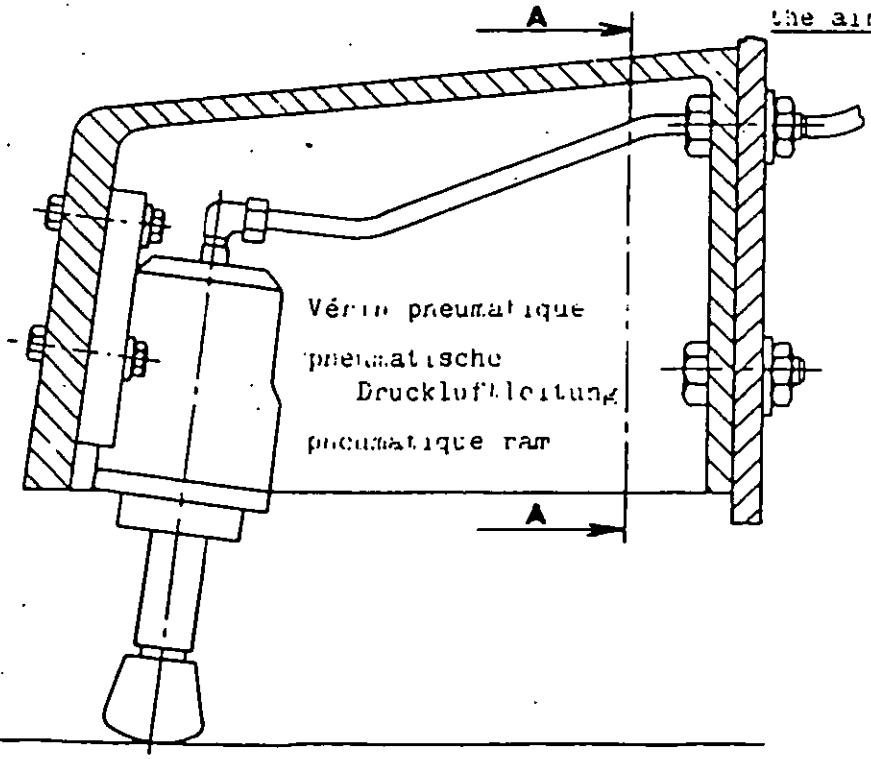
Position der montierten Stabilisatoren

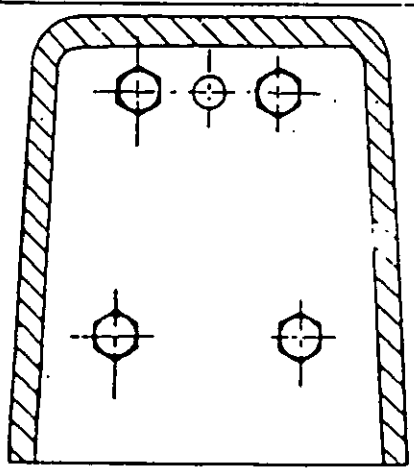
Position of the fitted stabilisers

Position des stabilisateurs dans l'emballage
(sont repliés tuyaux d'air non débranchés).

Position der Stabilisatoren in der Verpackung, wo sie umgeklappt sind, aber die Luftleitungen bleiben angeschlossen.

Position of the stabilisers in the crate where they are bent through 90°, but the air pipes remain connected.





Vue suivant A
Ansicht von A aus gesehen
seen from A

Pour fixer les stabilisateurs mettre en place et serrer les vis.
Um die Stabilisatoren zu montieren, diese richtig setzen und die Schrauben anziehen.
To fit the stabilisers, place them correctly and fix the screws.

PLAN N° 82 763.

COMPRESSED AIR SUPPLY

- 1st Possibility -

The dairy has a compressor giving a minimum pressure of 6 to 8 kg/cm2 :

The compressed air supply should be brought up to the CONTISTOCK machine by means of rigid 15/21 mm dia tube if the distance is less than 10 meters or 20/27 mm dia tube for a maximum distance of 30 meters between the compressor and the CONTISTOCK. Connect this rigid air line to the CONTISTOC by means of flexible tube able to support this pressure.

IMPORTANT - PROVIDE A CLEANING FILTER WITH A STOP VALVE ON THE AIR LINE JUST BEFORE THE CONTISTOCK BEFORE CONNECTING THE FLEXIBLE TUBE.

- 2nd Possibility -

The dairy does not possess a compressor ;

Request from us the supply of a compressor specially designed for use with the CONTISTOCK. As any compressor tends to be quite noisy when running, we advise you to place it outside the production room. Connect to the CONTISTOCK as indicated in paragraph "1st possibility". There is no inconvenience in piping the compressed air over a long distance.

PREPARATION PRIOR TO USING FOR FIRST TIME

This production is absolutely indispensable for normal working as if omitted, the butter will stick to the sides of the hopper and the turns of the augers making normal working impossible.

This preparation is carried out in two operations using the non-st: . pro- -duct SULTRIBUTY or P3Z a sample of which you will find in a plastic bag with the accessories.

- 1st Operation : CLEANING OF CONTISTOCK BEFORE EACH WORKING SESSION

Run about 100 litres of water at around 90°C into a large recipient and make a 1% solution of SULTRIBUTY. Soak the following elements in the so- -lution prepared :

- *the infeed hopper*
- *the auger screws*
- *the bearing plate*
- *the outlet nozzle*
- *the end plate*

.../...

Thoroughly brush these parts with the solution.

- 2nd operation : RINSING

The above parts should then immediately be rinsed in cold water before being mounted on the machine.

CLEANING AFTER USE

If the KM-1000 is not equipped with the system for reversing the augers, it will be necessary to dismantle the same elements as were previously removed for cleaning prior to starting up.

These parts should be degreased using hot water, thoroughly brushed down with a 1% solution of SULTRIBUTY and finally rinsed with cold water.

If the KM-1000 is equipped with the system for reversing the augers, it will only be necessary to feed hot water into the hopper while running the augers in reverse for about 10 minutes. The water can be drained off afterwards by running the augers in forwards.

Repeat this operation using a 1% SULTRIBUTY solution and finally rinse two or three times with cold water.

ASSEMBLY OF HOPPER UNIT

- Place the empty hopper across the upper part of the main support base.
- Introduce the two auger-screws through the rear of the hopper making sure that the auger with the larger drive tenon is on the left.
- Fit the bearing plate on the front of the hopper making sure it is the right way round. When the hopper augers' bearing plate and outlet nozzl are correctly fitted the "V" engraved on the top of these parts, pointi towards the front, will be completed.
- To facilitate fitting of the bearing plate, it is advisable to bring the auger-screws 2 or 3 cm further forward in the hopper.
- When the bearing plate is in place, mount the outlet nozzle flush up against it, centering by means of the 4 studs. Confirm its correct position by means of the reference numbers stamped on the top of the parts.
- Tighten up the complete assembly by means of the four (4) 23 mm lock nuts using the wrench supplied with the CONTISTOCK tools.
- Fit the end plate, corresponding to the size of box used, on to the outlet nozzle. Its 4 studs will pass through the holes drilled on the end of the nozzle. Tighten by means of the four (4) cage nuts using the 6 mm flat wrench supplied.

.../...

MOUNTING OF HOPPER UNIT

Having assembled the hopper unit as described above, take hold of the two handles and turn it through 90°, seat it firmly on the two cut-away celeron housings, at the same time guiding the auger-screws into their locations in the drive plate, and tighten down the four fasteners.

Setting in place of side roller tables

These are factory mounted. Bring them into a horizontal position by pivo--ting them downwards through 90° and then, lift them into their support lugs.

At the end of operation, fold them against the machine by lifting them slightly to clear the lugs and lower vertically.

ADJUSTMENTS TO BE CARRIED OUT BEFORE COMMENCING OPERATIONS

Adjust the height of the roller table

Before starting up, ensure that the nozzle end plate is correctly centered with respect to the packaging being employed.

This is done as follows :

- *loosen (1/2 turn) the 4 lock nuts below the front of the table and place a box (or other packaging being used) without its lining, in the carriage.*
- *Push the carriage forwards until the plate just enters the box. Using the bakelite hand-wheel below the front of the table, adjust the height of the box until the top and bottom clearances between the box and end plate are the same. Turn the hand-wheel to the right to raise the box, left to lower.*
- *Retighten the 4 lock nuts once a correct adjustment has been obtained. Do not overtighten.*

Adjustment of carriage path

Having adjusted the height of the roller table, proceed with the adjustment of the carriage path :

- *Connect up the machine electrically and adjust the air pressure to around 1 kg/cm2.*
- *Push the carriage towards the hopper.*
- *With the end plate fully engaged inside the box, you should hear air entering the cylinder and the auger-screws should begin to turn.*

.../...

- *If nothing happens, turn the milled knob, situated on the front of the carriage, lower right-hand side, in a clockwise direction until the above actions take place.*
- *Having made this adjustment, pull back the carriage and box. When the nozzle plate reaches the top of the box, you should hear the air being released from the cylinder. If not, turn the other milled knob, on the lower left hand side of the carriage front, towards the minus sign.*

Note that the auger screws only stop once the carriage has moved back a further few millimeters following the exhausting of the air cylinder.

This latter milled knob is used to adjust the weight of butter packed in the box, adjustment made according to the weight of the first few filled boxes and as per the indications on the knob.

CAREFULL

All these operations should be carried out with a low air-pressure setting in order to facilitate manual movement of the carriage.

ADJUSTMENT OF COMPRESSED AIR PRESSURE

This is set according to the consistancy of the butter to be packed and the shape of the recipient. The pressure needed for round packs is lower than for rectangular or square boxes. The following figures are rough estimates based on previous experience and given by way of an indication only.

Very soft butter advised pressure : 0,8 to 1,2 kg/cm2
Firm butter advised pressure : 1,8 to 3,5 kg/cm2

Supply pressure : 6 to 8 kg/cm2

We would point out that it is not advisable to work with soft butter as it makes filling more delicate.

The air pressure adjustment is made by means of the control knob of the air pressure valve on the right hand side above the air inlet. Check the pressure by means of the gauge on the front of the CONTISTOCK.

The air pressure is increased by turning this knob in a clockwise direction.

Pressure stability can be checked by moving the carriage backwards and forwards a few times. Note there is no danger of unscrewing the knob comple-tely. Having made this adjustment, do not forget to tighten the handle lock nut to prevent loss of setting.

.../...

- CONTISTOCK _ tous modèles

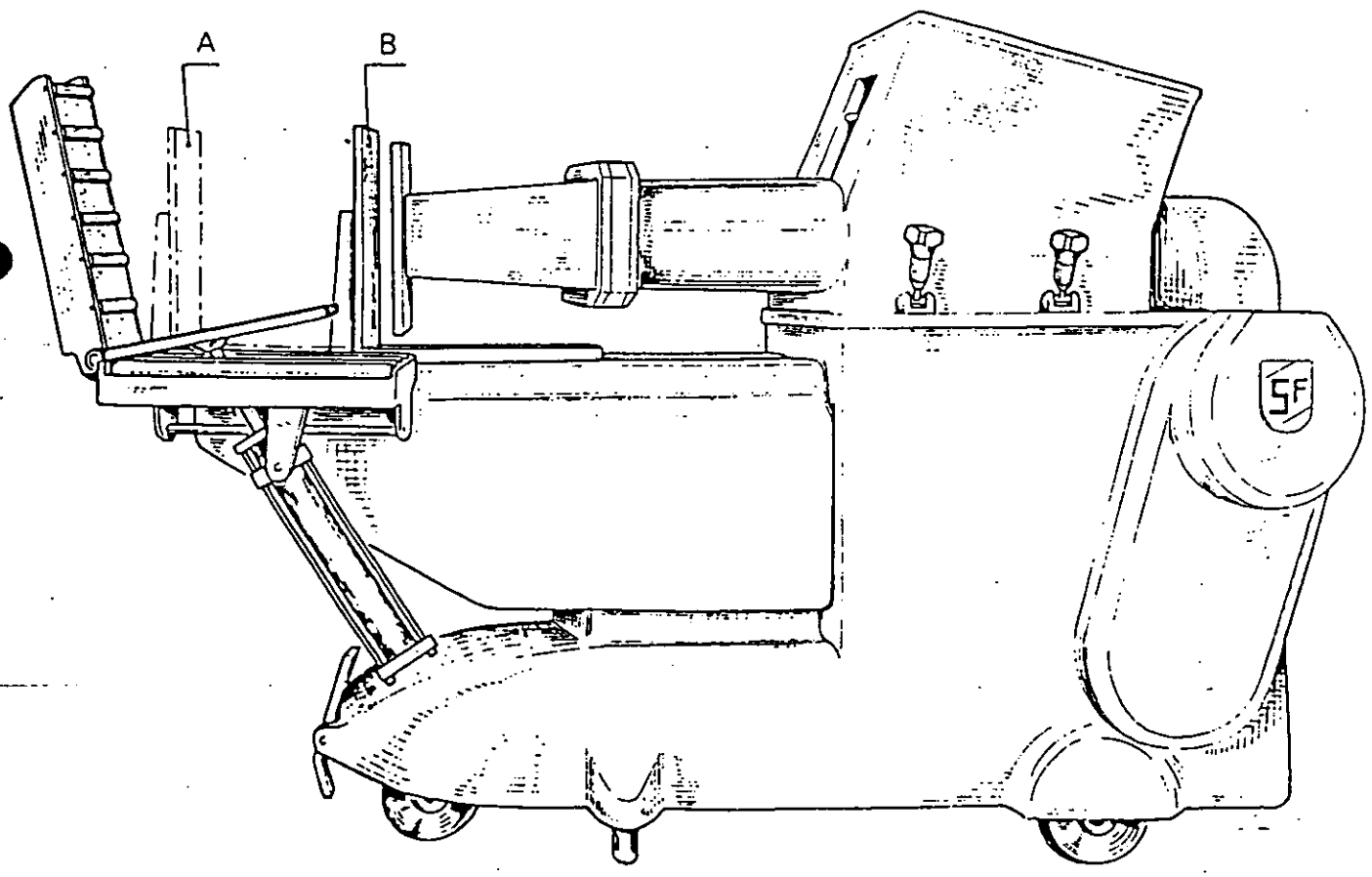
A l'arrêt du CONTISTOCK il est important de ne pas laisser le plateau du chariot poussé vers l'avant _ position A _ mais au contraire de le placer en _ position B _ poussé à fond près de la buse de sortie.

- CONTISTOCK _ all types

When the CONTISTOCK ist stopped, it is important NOT to leave the plate of the sleigh pushed towards the front (position A), but place it fully against the outlet nozzle plate (position B).

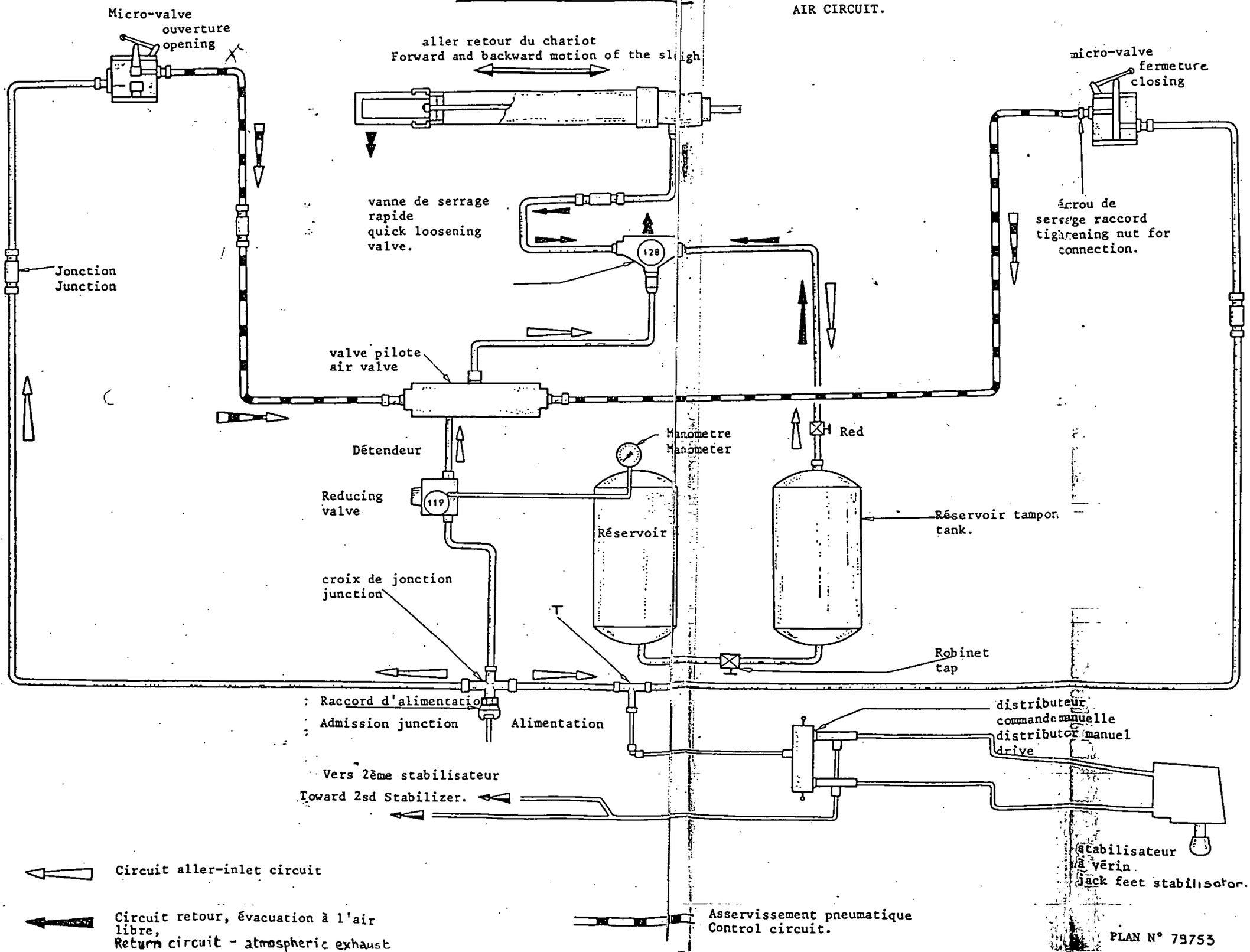
- CONTISTOCK _ alle Typen

Wenn die CONTISTOCK still steht, ist es wichtig, die Platte des Schlittens NICHT vorn stehen zu lassen (Pos. A), sondern sie ganz an die Austrittsplatte zurück zu schieben (Pos. B).



CONTISTOCK KM 100

CIRCUIT PNEUMATIQUE
AIR CIRCUIT.



PLAN N° 79753

TROUBLE SHOOTING

For pneumatic circuit, refer to circuit diagram plan n°79753.
For electrical circuit, consult the electrical drawings supplied with the machine.

A - THE AUGER-SCREWS FAIL TO TURN WHEN THE CARRIAGE IS PUSHED UP AGAINST THE OUTLET NOZZLE PLATE

1. - Check power supply connection
2. - Check operation of the disconnecting switch
3. - Check fuses, relay and coil
4. - Replace any defective elements
5. - Exceptionnally : defective relay in the reclosing system or an amperag which does not correspond to that required for the machine. In the latter case open the cover of the disconnecting switch and adjust the amperage by means of the selector by turning towards the desired ampe--rage setting.

   Conform to the setting indicated on the general data table.

   Having completed these checks, the current reaches the limit switch (rep.431 - plan n°4 - instruction n°4.067 A).

B - IF THE AUGERS STILL DO NOT BEGIN TO TURN AND THE MECHANISM IS IN GOOD CONDITION

1. - The source of the trouble could be the limit switch (rep.431) which it will be necessary to remove and repair using our repair kit or replace completely.
2. - The adjustable stop (rep.424 - plan n°4) is out of position. Re-adjust position by means of the auger control handles (rep.426 - plan n°4).

   In this case, it is the right hand stop, i.e. the side where the butte is packed.

   This stop is pushed too far back so turn the handle in a clockwise direction to bring it further forwards.

C - THE AUGERS TURN BUT EITHER TWO SLOWLY OR AT AN IRREGULAR SPEED

Check the condition of the two drive belts. If they are worn or stretched, replace them. If in good condition, but slipping, adjust the tension. If t trouble does not originate with the drive belts, check in turn :

- the variable pulley mounted onthe motor shaft
- the pulley clutch unit
- the electro-magnetic clutch.

.../...

For the latter, refer to drawing n°93838.

Note that the pulley and electro-magnetic clutch form a precision factory mounted assembly and that any necessary repairs should only be carried out by competent technical staff.

D - THE CARRIAGE BACK PRESSURE OPERATES ONLY INTERMITTANTLY OR NOT AT ALL, AND DECOMPRESSION DOES NOT TAKE PLACE

1. - Check if the air circuit pressure is correct :

0,8 to 1,2 kg/cm2 for very soft butter
3,0 to 5,0 kg/cm2 for soft butter
6,0 to 8,0 kg/cm2 for firm butter

Check the condition of the quick release valve (pos.128 - drawing n°79753) and repair, if necessary, using our repair kit or replace.

2. - Check the two opening and closing micro-valves (drawing 79.753) Following this check you will know whether one or other or both need to be replaced or whether it is possible to carry out repairs using the repair kit.

IMPORTANT : the "OPENING" and "CLOSING" micro-valves are identical, only the roller arm is differently oriented. If you only have one spare micro-valve and it does not correspond to the one you need to replace, simply remove the roller arm and adjust orientation as necessary (drawing 79.753).

E - AS IT ENTERS THE BOX, THE NOZZLE PLATE CATCHES ON THE PAPER LINER

Pull the carriage back and remove the packaging. Replace with a new lined box.

If the problem is due to the incorrect positionning of the box, it could possibly be remedied, if the paper is not too crumpled.

It should be remembered that in general a clearance of 7 to 8 mm needs to be maintained between the nozzle plate and the inside of the recipient.

IMPORTANT REMARK :

WHATEVER TYPE OF CONTISTOCK IS IN SERVICE, IT SHOULD BE ENSURED THAT THE COMPRESSOR EMPLOYED IS CAPABLE OF SUPPLYING AIR AT A SUFFICIENT PRESSURE AND FLOW RATE.

COMPRESSOR - STARTING UP AND SERVICING

THESE RECOMMENDATIONS ONLY CONCERN COMPRESSORS SUPPLIED BY SIMON FRERES.

Lubrication

The compressor gear-case is empty at the time of dispatch. Ensure that it is filled before starting up (check level by means of sight-glass).

For preference, use oil LPT 150, viscosity SAE30 or an equivalent with the following characteristics :

Example lubricant	*Characteristics specified by manufacturer*
SHELL S-2426	*- Engler viscosity at 50°C : 7,8* *- Melting point ASTM (°) : -20* *- Flow point : 30°C*

An oil with anti-corrosive qualities is recommended because of the damp operating medium.

Fill the gear-case up to the level indicated on the sight glass at the rear of the compressor seen from the handwheel side (do not exceed this level so as to avoid abnormal consumption and traces of oil in the dis-charge). IT IS IMPORTANT TO CHECK THE OIL LEVEL FREQUENTLY TO CHANGE THE OIL EVERY 100 HOURS.

AIR FILTER

Check the condition of the filter elements every week and clean or replace as necessary.

VALVES

Main reason for removal : drop in pressure due to a leak (carbon deposits on valves and valve seats). Carefully clean in soapy water, wipe dry and lightly lubricate all the surfaces with the oil used for the compressor so as to prevent corrosion.

Should it be necessary disassemble the valve assemblies, do so with care, clean and re-assemble.

The suction and discharge valves are not interchangeable so it is better to clean them one at a time.

CHANGE OF NOZZLE END PLATE

It is necessary to change the end plate during production, disconnect the power supply to the CONTISTOCK to prevent operation of the auger-screws during the necessary forwards and backwards movements of the carriage.

CONTISTOCK MAINTENANCE

Careful maintenance is the basis for correct operation and a long working life of any machine. Follow closely the following operations, especially during running in :

Element	Oil changes	Oil level	Example of lubricant characteristics	Remarks
Auger drive mechanism	1st oil change after 100 hours in service. Thereafter every 1000 hours	Gauge of filler cap. The level should always be between the two marks. Check every 50 hours	SHELL MACOMA 82 Engler viscosity at 50°C 100°C 43°C 5°C Quantity : about 1,5 L	Be careful when filling not to introduce any foreign matter

OIL CHANGE OF GEAR CASE OIL BATH

Drain off all the old oil, flush with 1/2 litre of fresh clean oil while running the CONTISTOCK for one or two minutes.

Drain off the flushing oil. Fill with one litre of fresh oil.

Access is gained to the drain plug through the door on the left hand side of the machine base. The drain plug is on the left as you look in.

NOTE :

A repeated drop in the oil level between normal oil changes may indicate a damaged seal on the pulley side. Check.

PARTS TO GREASE

1°) Using the TECALEMIT Pump

Element	Position of greaser	Example of lubrifiant Characteristics as per standard ASTM-D567 SHELL ALVANIA 2 Engler viscosity : Drop point : 190°C	Grease twice a year
Front wheels Pivot	1 greaser on the cover above the front wheels		
Transporter Wheels	1 greaser on each wheel		

2°) Using a brush

Table lifting bevel gears			Once a month
Table adjustment nuts			Once a month
Nylon carriage rollers	Remove wipe off exis--ting grease. Replace with fresh grease	Drop point 150°C	Once a year

THINGS TO AVOID

Do not start-up the CONTISTOCK before ensuring :

- that the power supply voltage corresponds to the voltage indicated on the motor plate,
- that it is correctly assembled,
- the correct position of the auger-screws
- the centering and fastening in place of the hopper
- that the end plate fitted corresponds to the recipient to be filled
- the table height adjustment
- the adjustment of the carriage path
- that the air pressure is sufficient

IMPORTANT : NEVER USE SPARE PARTS OTHER THAN THOSE SUPPLIED BY OUR COMPANY. TO ORDER, CONSULT THE LIST AT THE END OF THIS MANUAL AND IF URGENT, TELEPHONE OR TELEX YOUR LOCAL AGENT.

POSSIBILITY OF BLENDING BUTTER USING A CONTISTOCK

The CONTISTOCK can also be used to blend soft butter prior to packing in boxes.

For this purpose, we can supply, subject to a price supplement, a set of impellers and a perforated plate which can be adapted on to this machine provided it has been equipped with the corresponding auger-screws.

Fitting of this device :

- with the hopper unit assembled as usual with its auger-screws and bearing plate, fit on the perforated plate.
- Slide the two impellers on to the auger-screws shafts so that they are clush against the shoulder, ensuring that the keys coincide.

Having completed this assembly, tighten down the impellers :

- LH impeller with stainless steel nut marked G.- CAREFUL L.H. THREAD
- RH impeller with stainless steel nut marked D - CAREFUL R.H. THREAD

Then proceed as normal for the fitting of the nozzle and end plate.

NOTE :

There is no question of using this device for the re-working of hard cold store butter as with our CONTIMALAX continuous reworker.

TRANSFORMATION OF CONTISTOCK INTO CONTIVIS CONTINUOUS BUTTER MOULD

The CONTISTOCK can be transformed into a CONTIVIS by the addition of a very simple device which can be supplied if specified on the original order or requested at a later date. With such a device, it is possible to use the CONTISTOCK to produce rectangular, square or cylindrical pats.

The device is composed of the following elements :

- a roller table with cutting frame,
- a special outlet nozzle to replace the one supplied with the original machine,
- one or several different draw plates corresponding to the various shapes and sizes of pats to be produced.

FITTING OF THE MOULDING DEVICE

a) remove the carriage :

For its complete removal from the slide rails and disconnection from the cylinder, proceed as follows :

- pull the carriage as far as possible towards the front,
- using the allen-key 35, loosen the set screws securing the carriage connecting spindle on the cylinder rod,
- unscrew and completely remove the connecting spindle,
- slide off the carriage.

b) Replace the outlet nozzle :

- remove the 4 lock nuts Ø 23 mm of the outlet nozzle,
- remove the TONTISTOCK outlet nozzle and end plate,
- replace with the special draw-plate holder nozzle, supplied as part of this device which is held in place by 4 butterfly nuts. The various draw-plates can b mounted on the nozzle.

c) Mount the roller table

Having first loosened the flanges on the front :

- mount the roller table support and cutting frame onto the carriage slides so tha the hinge of the cutting frame is on the LH side.
- Engage it on the sliders, moving from the front towards the rear until the support plate is level with the outer end of the slide rails. The first roller should then be tangent to the outlet nozzle.
- Fix in position by means of the two butterfly nuts at the front, underneath the roller table.

d) Adjust the height of the roller table

Adjust the height by means of the bakelite handwheel below the roller table until the rollers are level with the lower edge of the draw-plate outlet.

e) Plug the male plug of the roller table into the socket on the CONTISTOCK below the roller table on the left hand side close to the handwheel. If this socket was not fitted on the original machine, mount the one supplied with the device in the above position and connect by means of a two care cable, to the contactor/disconnecting switch inside the machine:

- one wire to the left hand side terminal above the green push button,
- the other wire on the last terminal at the bottom left, on the base of the disconnecting switch.

f) Fill the trough below the rollers with water to prevent the butter sticking.

This water can be drained off after production by unscrewing the drain plug at the front, having previously removed the discharge rollers.

g) Adjustment of the cutting wires

- Arrange for the first wire to be as close as possible to the draw-plate, about 15 - 20 mm (for the moulding of 500 grs pats reduce, if necessary, the frame support boss in order to move the slider closer).

  The second wire should be placed at a distance which corresponds, appro-ximately, for the weight of the desired pat.

- The exact setting is obtained by trial and error. Weigh the first pat, if too heavy move the second wire a little closer to the first, if too light a little further away.

- Repeat the operation until the exact weight has been obtained.

- Carry out the same operation for the adjustment of the other wires.

  Ensure that the wires are taught. Check weight from time to time during production to ensure that the adjustment has not altered.

- To save time in adjusting the wires during subsequent start-ups, the position of the cutting wires, corresponding to the usual sizes of pat produced, can be marked on the frame.

h) Operation of the cutting frame

- Bring the frame downwards but stop an instant, once power to the augers has been cut off, to allow the butter ribbon to expand and thus, permit better weight regularity.

- Take care to produce a butter ribbon of about the same length each time, the excess needing to be as small as possible.

- Remove the formed pats

- Lift back the cutting frame as far as the stop allowing a new butter ribbon to be formed.

i) Cleaning of the cutting wires

In order to obtain a clean cutting of the butter, the wires should be thoroughly cleaned between each cutting operation. A special wiper can be supplied to order with the CONTIVIS.

j) Consistancy of the product to be moulded

To obtain well formed, well cut pats, the butter needs to be perfectly homogeneous and at a temperature of between 12 and 16°C in order to possess a normal consistancy.

TIPPING SIDE TABLE FOR KM-1000

Purpose of this accessory

To facilitate tipping of the filled recipient, saving time and reducing the physical effort required from the operator.

Description and use

A vertical roller table fixed on one or other of the side tables and which tips around 2 removeable spindles. Its rollers are identical to those of the other tables and it has bars which pass in between the horizontal rollers.

The rollers of the tipping accessory allow the box to slide sideways across the front of the CONTISTOCK.

When you will order a part.

Precise : the number of the part
the name
and the drawing number where it is shown.

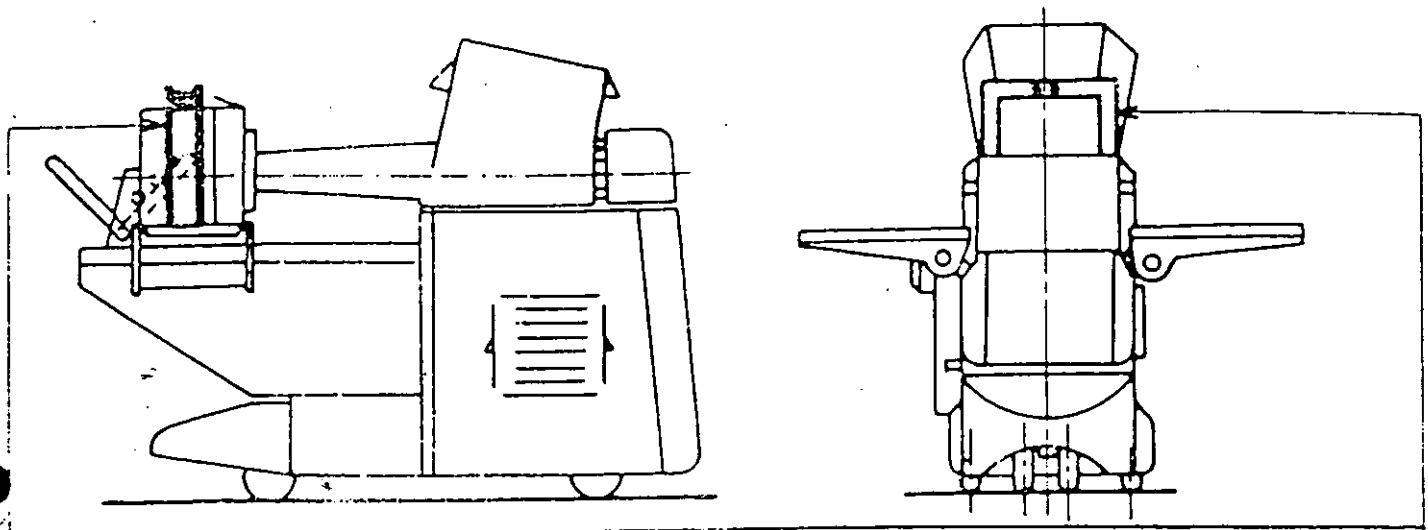
Ex : 9 - Combined bearing

Plan N° 93 837.

-o-o-o-o-

Ets SIMON FRERES

CEINTURE POUR CARTONS / Belt to maintain boxes during filling // Karton-Haltegürtel

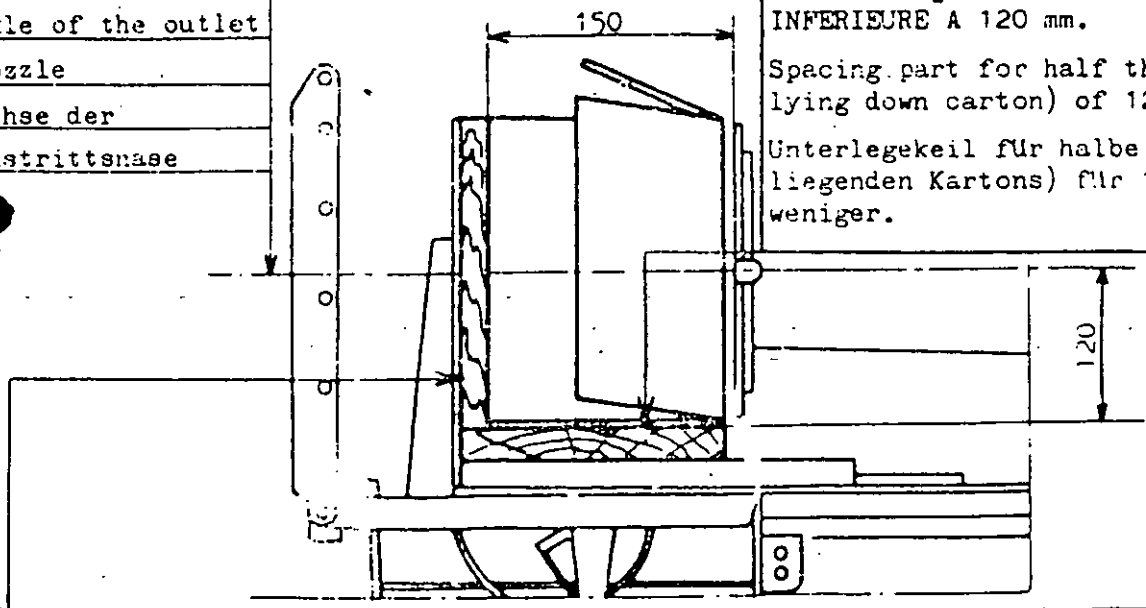


CETTE CEINTURE EST RECOMMANDEE POUR EVITER LA DEFORMATION DES CARTONS D'EMBALLAGE PENDANT LE REMPLISSAGE.

This belt is recommended to avoid that the cartons get out of shape during the filling operation.

Dieser Haltegürtel wird empfohlen, um jegliches Verformen der Kartons beim Füllen zu vermeiden.

AXE BUSE DE SORTIE
Axle of the outlet nozzle
Achse der Austrittsnase



CALE POUR ½ HAUTEUR (CARTON COUCHE) INFERIEURE A 120 mm.

Spacing part for half the height (of the lying down carton) of 120 mm or less.

Unterlegekeil für halbe Höhe (des liegenden Kartons) für 120 mm oder weniger.

CALE BOIS NECESSAIRE POUR CARTONS DE PROFONDEUR EGALE OU INFERIEURE A 150 mm.

Wooden spacing part, necessary for cartons with depth of 150 mm or less.

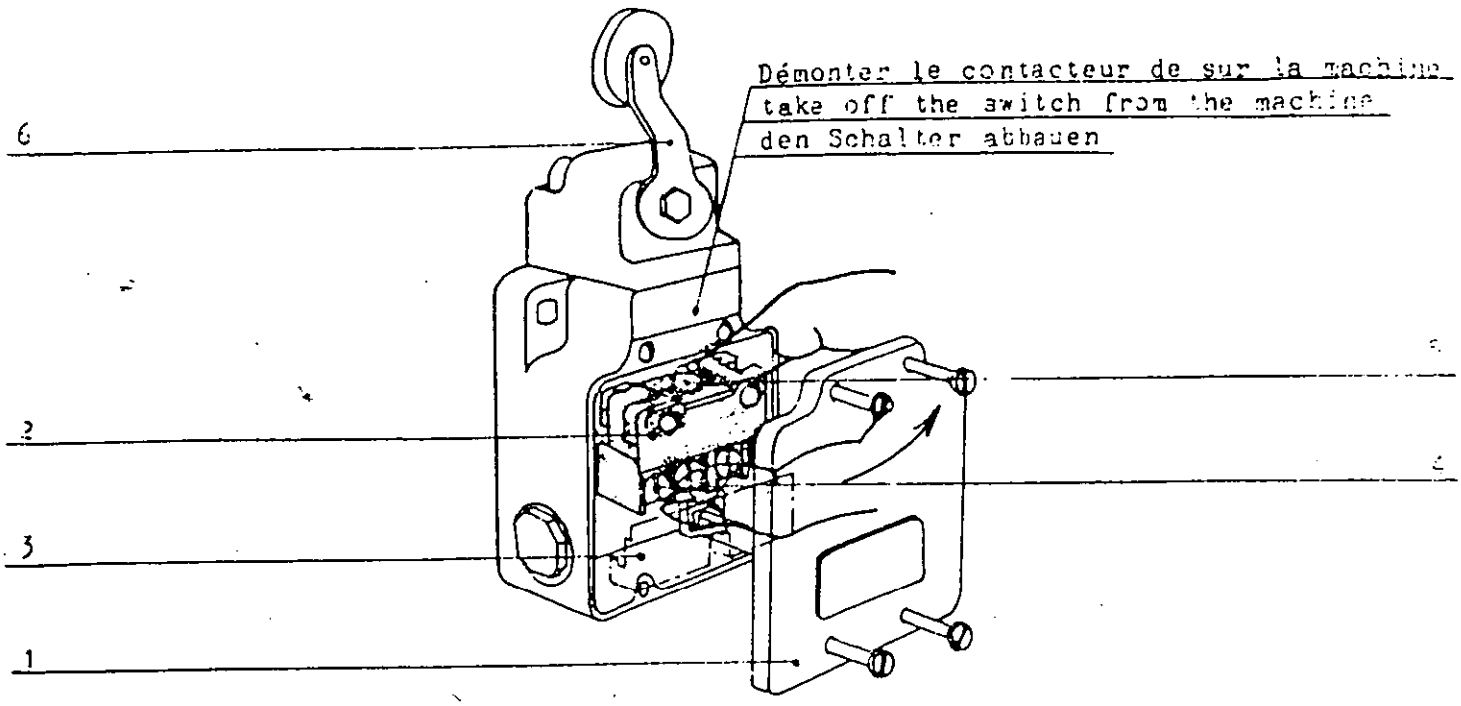
Holzkeil erforderlich für Kartons von 150 mm Tiefe oder weniger.

NOUS CONSULTER // Please ask for our advice // uns um Rat fragen.

Plan N° 79.738

CONTISTOCK - Remplacement du contact sur contacteur XC 2/MC 11
CONTISTOCK - Replacement of the Contact-Part on Switch XC 2/MC 11
CONTISTOCK - Austausch der Kontakte des Schalters XC 2/MC 11
} TELESCANIQUE

CONTACTEUR REP.431 DU PL. 4 - SWITCH No.431, DIAGRAM 4 - KONTAKTSCHALTER Nr431, PLAN 4



MODE OPERATOIRE -

a) Enlever le couvercle 1 en dévissant les 4 vis
b) Par une légère pression en-dessous, extraire le contact 2 défectueux
c) Sur le contact neuf, enlever le petit protecteur de connexion 3
d) Mettre en place le contact neuf 2
e) Brancher les fils aux connexions 4 avec les vis 4
f) S'assurer que le poussoir 5 fonctionne bien, en actionnant le levier à galet 6
g) Remonter le couvercle 1

Procede in the following way:

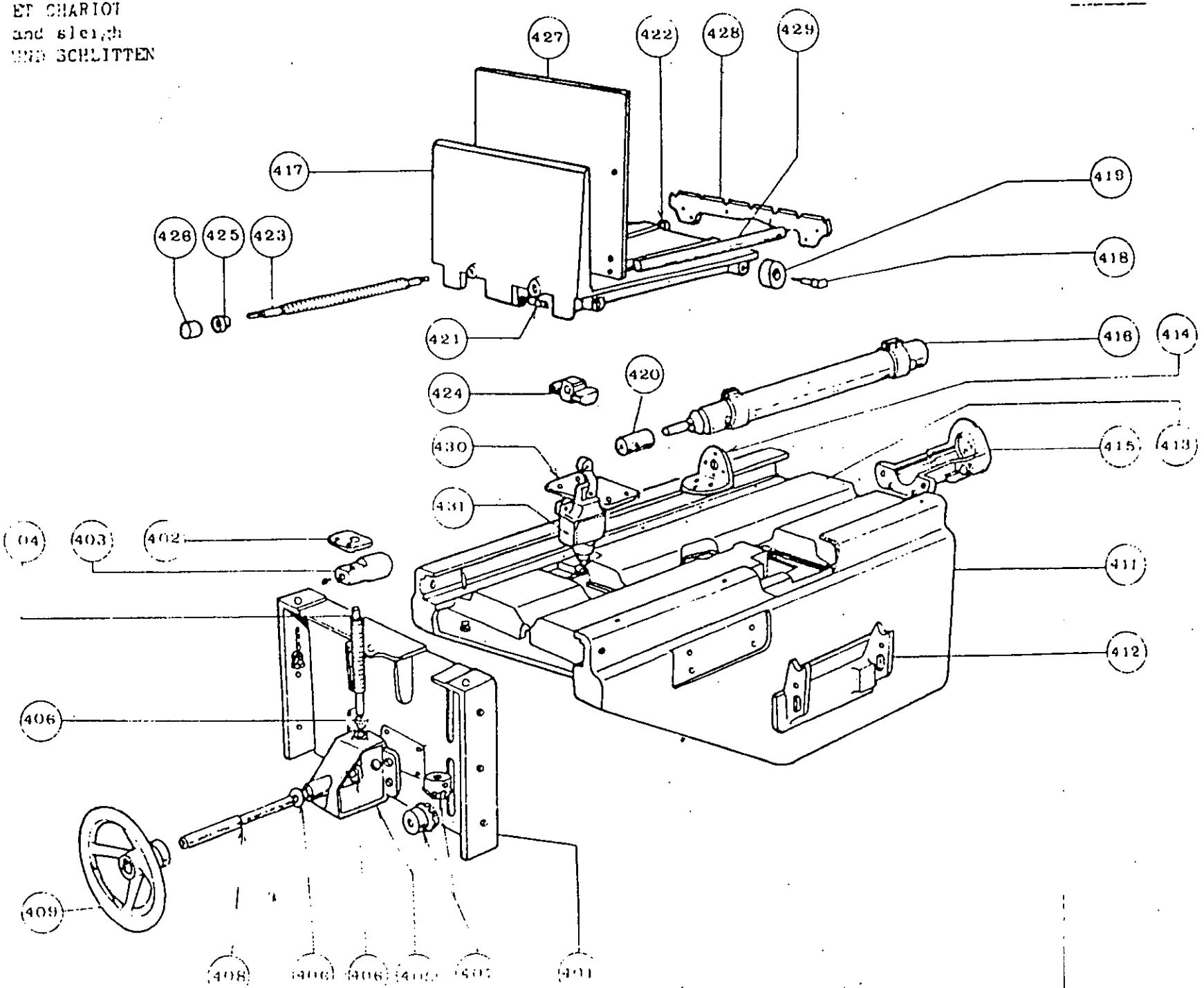
a) take off the cover (1) by loosening the 4 screws
b) by pushing slightly from below, extract the broken contact (2)
c) take off the small protection part (3) from the new contact
d) place the new contact (2)
e) connect the wires with the screws (in 4)
f) make sure that the switch works well, by actioning the roller lever (6)
g) re-fit the cover (1)

ANLEITUNG

a) Die 4 Befestigungsschrauben lösen, die Schutzkappe 1 abnehmen
b) Den schadhaften Kontakt 2 durch leichten Druck von unten herausnehmen
c) Die Anschluss-Schutzkappe 3 am Austausch-Schalter abnehmen
d) Den Austauschkontakt 2 einsetzen
e) Die Kabelenden in 4 mittels der Schrauben anschliessen
f) Durch Betätigung des Rollen-Kontakthebels 6 das gute Funktionieren des Federkontaktes 5 überprüfen
g) Die Schutzkappe 1 wieder aufsetzen und festschrauben.

Plan N° 73.438

TABLE ET CHARIOT
table and sleigh
TISCH UND SCHLITTEN

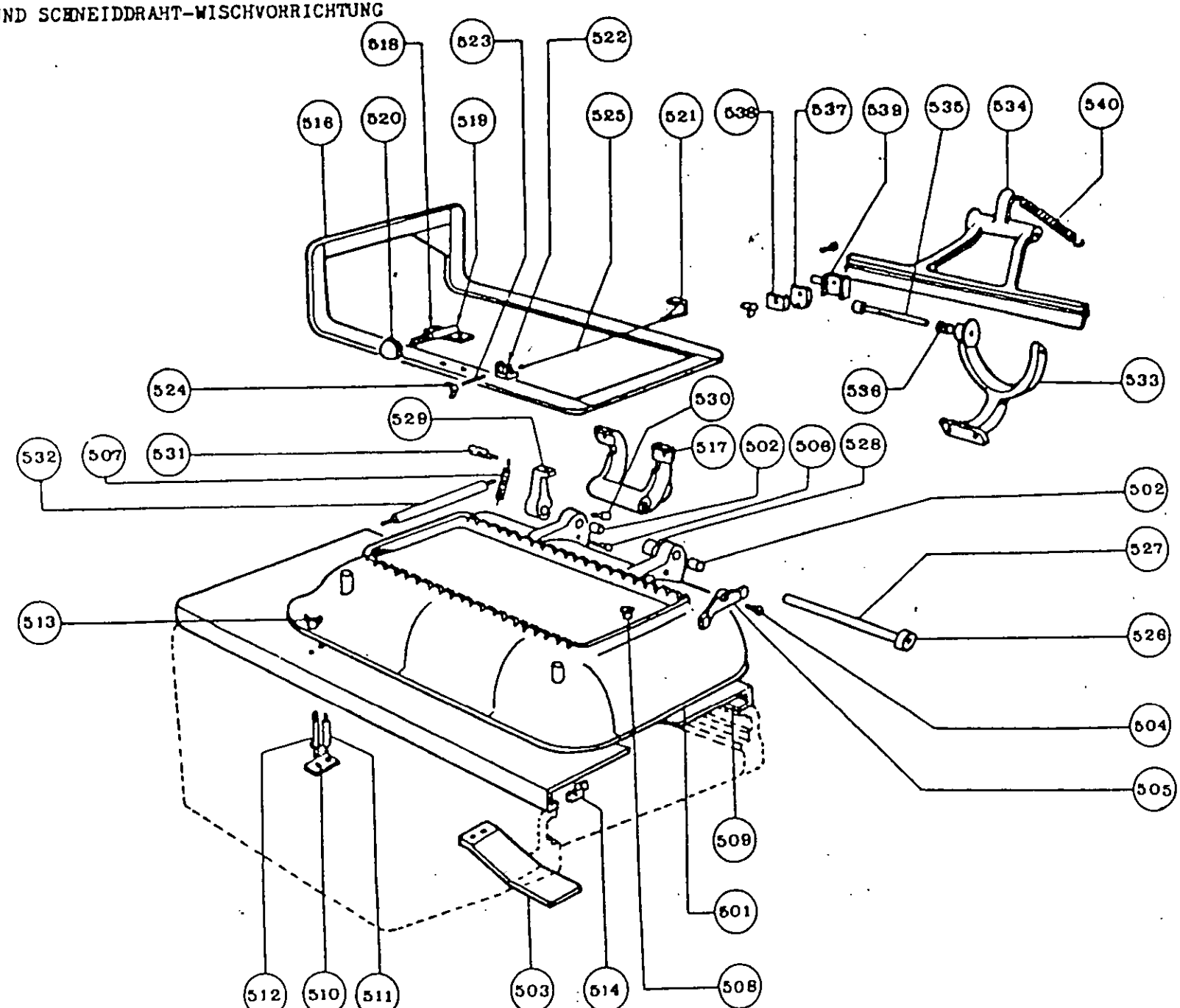


ROLLER-TABLE AND WIRE WIPER

Description	Position	
Roller table support	509	
Screw fixing table on support		
Washer		
Nut		
Table support flange	510	
Flange foot	511	
Flange rod	512	
Flange lock nut	513	
Table support guide	514	
Guide fixing screw		
Guide washer		
Guide nut		
Cutting frame	516	
Frame hinge	517	
Hinge fixing screw		
Nut		
Frame handle plate	518	Plan 5
Handle rod	519	
Frame handle	520	
Screw fixing handle on rod		
Nut		
Plain slider	521	
Tension slider	522	
Tension screw	523	
Slider lock nut	524	
Cutting wire	525	
Electrical control cam	526	
Cam spindle	527	
Spindle stop ring	528	
Ring and screw		
Cutting frame catch	529	
Cutting frame stop	530	
Catch fixing screw		
Top spring attachment	531	
Nylon table rollers	532	
Wire wiper support	533	) Device supplied
Support fixing screw		)
Brush holder	534	) as extra
Brush holder spindle	535	)
Spindle spring	536	) Plan 5

TABLE A ROULEAUX ET ESSUIE-FILS
table with rollers and wire cleaning device
ROLLENTISCH UND SCHNEIDDRAHT-WISCHVORRICHTUNG

PL. 5



Ets SIMON FRERES

TABLE AND CARRIAGE

Description	Position
Table slide rails	401
Upper bearing of table adjustment screw	402
Bearing fixing screw	
screw washer	
Table adjustment nut	403
Nut fixing screw	
Nut greaser	432
Table adjustment screw	404
Lower screw support	405
Shoulder ring	406
Conical 19-teeth gear	407
Gear fixing screw	
Washer	
Table control shaft	408
Table control wheel	409
Handwheel fixing screw	
Left hand panel of table	410
Right Hand panel of table	411
Slide rail and panel fixing screws	
Washer	
Studs fixing spacer and panels - Length 40	
Studs fixing spacer and panels - Length 50	
Washer	
Nut	
Nut	
Table panel lug	412
Lug fixing stud	
Transfer roller	
Side table spindle	
Spindle fixing screws	
Base plate foot	
foot screws	
Carriage	417
Roller spindle	418
Carriage roller	419
Lock washer (M-10) on spindle	
Lock washer (M-10) on spindle	
Spindle lock nut	
Cylinder yoke	420
Yoke spindle	421
Yoke greaser	
Spindle set screws	
Stop screw rear bearing	422
Stop adjustment screw	423
Adjustable stop	414
Stop adjustment screw front bearing	425
Front bearing set screw and handle	
Adjustment screw handle	426

.../...

Rollers front support	427	
Rollers rear support	428	
Front support retaining screw		
Rear support retaining screw		
Rear bearing greaser		
Transfer roller	429	
Table spacer	413	
Cylinder front support	414	
Front support retaining screw		
Washer		
Cylinder rear support	415	
Rear support fixing stud		Plan 4
Spindle set screw		
Brush fixing nuts		
Brush	537	
Brush plates	538)	
Rock nut	)	Device supplied
Wire wiper finger	539)	as extra
Return spring	540)	

SOME ADDITIONAL RECOMMENDATIONS CONCERNING THE CONTISTOCK ELECTRICAL EQUIPMENT

PRIOR TO ANY INTERVENTION :

- Check if the power supply voltage is correct using a lamp, or better still a voltmeter,
- Check that the protection fuses have not blown,
- Check that the relay is closed for first start-up, or reclosed in the case of a breakdown. The reclosing is obtained by depressing the red push button.

BEFORE RECLOSING THE RELAY, IT IS ESSENTIAL TO LOCATE AND CORRECT THE FAULT CAUSING THE TROUBLE. IF THE DISCONNECTOR WILL NOT CLOSE WHEN THE PUSH BUTTON IS DEPRESSED, YOU SHOULD :

- Check the voltage, as previously indicated
- Check the connections
- Check the coil
- Check all terminal connections.

NEVER TAMPER WITH A PART OR ELEMENT OF THE ELECTRICAL APPARATUS AND ENSURE THAT THE MACHINE IS WELL EARTHED.

RECOMMENDATIONS FOR THE STARTING OF THE ELECTROMAGNETIC CLUTCHES AND BRAKES

When a Warner Electric Clutch is properly assembled and installed, no further servicing, lubrication or maintenance should be required throughout the life of the unit. As with any friction-type device, some initial care should be given to wear rate, as minor adjustment in actuation time can sometimes greatly extend the life of the unit.

FOREIGN MATERIALS

If units are used on machinery where fine abrasive dust, chips or grit are dispelled into the atmosphere, shielding of the clutch may be necessary if maximum life is to be obtained. Where units are used near gear boxes or tran-smissions requiring frequent lubrication, means should be provided to protect friction surfaces from oil and grease to prevent serious loss of torque. Oil and grease accidentally reaching the friction surfaces may be removed by wiping with a rag dampened with trichlorethylene. In performing this operation, do not drench the friction material. If the friction mate-rial has been saturated with oil or grease no amount of cleaning will be completely effective. Once such a unit has been placed back in service, heat will cause the oil to be boiled to the surface resulting in further torque loss.

HEAT

Excessive heat and high operating temperatures are causes of rapid wear. Units, therefore, should be ventilated as efficiently as possible, especially if the application requires fast, repetitive cycle operation.

TORQUE LOSS

If a clutch slips or looses torque completely, the initial check should be the input voltage to the field as follows :

90 volt series : Connect a DC voltmeter with a range of 0-100 or more directly across the field coil. With power on and the potentiometer turned up, a normal reading is 90 volts, although 85 to 95 is satisfactory. The reading should drop as the potentiometer control is adjusted counter-clockwise.

For a 6 volt field use a DC voltmeter of approximately 0-15 volt range. A nor-mal reading is from 5,5 to 6,5 volts depending on the power supply.

The above checks normally are sufficient. Further checks may be made as follows : a low range ammeter, when connected in series with one field lead will normally indicate approximately 35 amperes for the 90 volt units and 5,0 amperes for the 6 volt series. These readings are with the power on the po-tentiometer control in the maximum position.

Ohmmeter checks should be made with the power off and the circuit open (to be certain, disconnect one lead to the field). Average resistance for the 90 volt series is 250 ohms, for the 6 volt series, 1,2 ohms. A very light or infinite resistance reading would indicate an open coil.

If the above checks indicate that the proper voltage and current is being supplied to the field, mechanical parts should be checked to assure that they are in good operating condition and properly installed.

WIEGAND Karlsruhe GmbH D-7505 Ettlingen	Betriebsanleitung für eine WIEGAND-Fallstrom-Eindampfanlage	2 2 4 7

Kom.-Nr.: 5-stage EVAPORATOR WIEGAND

Anlage: Vorverdampfer
5-stufige Fallstrom-Eindampfanlage
mit Brüdenkompression in Spezial-
ausführung für die Milchindustrie.

Schaltschema: 222-3o2-o

Montagezeichnung: 3o9-3o3-o

Betriebsdaten: specifications :

Produkt	SKIM MILK Magermilch	WHEY Molke
Zulauf-Menge input	18.ooo kg/h	16.8oo kg/h
-Konzentration	9 % TS	6 % TS
-Temperatur	5-1o °C	5-1o °C
Verdampfleistung evaporation	13.95o kg/h	14.ooo kg/h
Konzentrat-Menge concentrate	4.o5o kg/h	2.8oo kg/h
-Temperatur	4o °C	4o °C
gekühlt cooled	ca. 8 °C	ca. 8 °C
Endkonzentration final concentration	4o % TS	36 % TS

Temperaturen:

Vorwärmung pre-heating		72 °C			72 °C	
Erhitzung heating		max. 92 °C				
Verdampfung evaporation		1.St.	2.St.	3.St.	4.St.	5.St.
Heizdampftemperatur steam	°C	75	7o	65	6o	52
Siedetemperatur boiling	°C	7o	65	6o	52	4o

Energieverbrauch: requirements:

Dampf für Vorwärmung und Erhitzung sowie Verdampfung	steam for heating & pre-heating & evaporation max. 1.84o kg/h
Dampf für Entspannungskühlung	17o kg/h 15 bar Überdruck steam
Kühlwasser für die gesamte Anlage	cooling water for complete installation max. 1oo m³/h von 26 °C
Stromart electric current	22o/38o Volt, 5o Hz.

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