

IPP

**INTERMEDIATE
PROOFER**

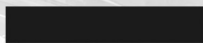
**INTERMEDIATE AND
USER MANUAL**



MEMAK



IPP





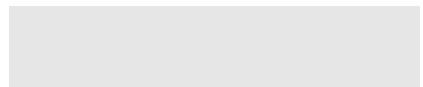
PROFESSIONAL
MACHINE

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INSTALLATION AND USER MANUAL

INTRODUCTION	6
WARNING SIGNS USED	7
WARRANTY	8
MANUFACTURER COMPANY	9
PRODUCT INFORMATION	9
MANUFACTURING SITE DESIGN	10
ABOUT THE MACHINE	11
PRODUCT DESCRIPTION	11
OPERATING PRINCIPLE OF THE PRODUCT	11
PRODUCT TECHNICAL DETAILS	12
PRODUCT COMMISSIONING	13
General Rules On Unpacking The Machine	13
Rules On Stockpiling The Machine	14
Load Structure	14
PRODUCT TRANSPORT	14
EQUIPMENT AND TOOLS FOR TRANSPORTING AND LIFTING THE MACHINE	14
GENERAL RULES FOR LIFTING AND TRANSPORTING THE MACHINE	15
PRODUCT ASSEMBLY	16
PLACING AND OPERATION OF THE PRODUCT	16
ELECTRICAL CONNECTION RULES	20
GENERAL CLEANING	28
CLEANING RULES	28
SAFETY	28
RULES	28
MAINTENANCE AND SETTING	29



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Introduction

Manual

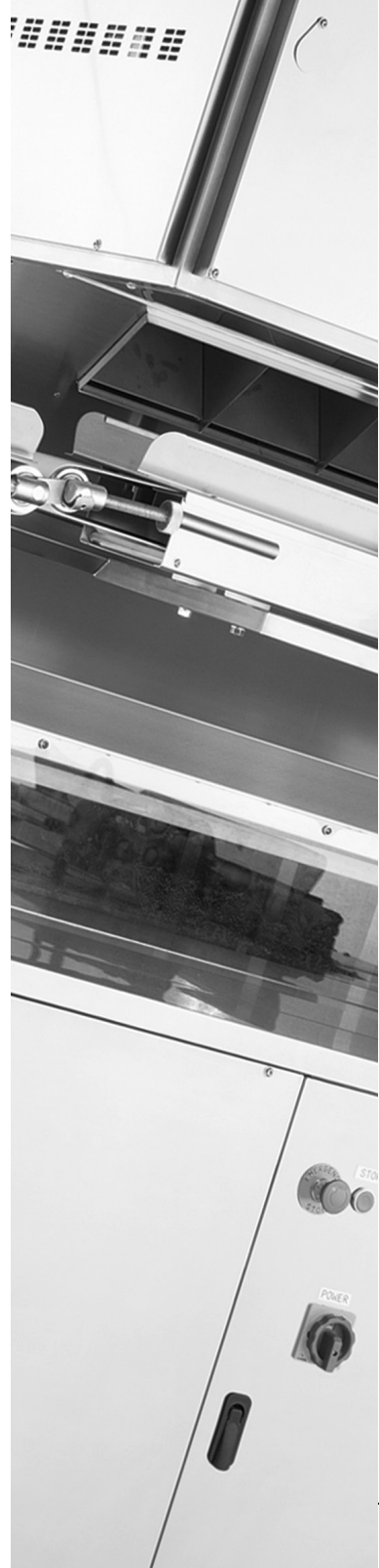
- Installation instructions are part of the device and contain information for the safe device use.
- Installation instructions must be fully read before installation.
- Installation instructions must always be ready to be accessed by the installer at the installation site.
- Installation instructions must be maintained along the device service life.
- MEMAK MAKİNA shall not be held responsible for the problems arising from unintended use of the oven.
- Installation instructions must be delivered device's subsequent operators.

Figure












- All figures given in this manual are exemplary.
- It may show differences according to the current device.

The company reserves its rights for technical modifications for development!

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Warning Signs Used

	This way up	Move in a manner as the direction looks upwards with the arrow sign.
	Fragile	Handle the package with care.
	Keep it dry	Packed so as not to contact with open air.
	CE Mark	The machine meets the basic safety requirements.
	Center of Weight	Indicates the point where the machine should be lifted.
	Hanger Point	Indicates where to attach ropes or chains.
	Warning	A hazardous situation, it may result in severe injury and death.
	Fire	Fire hazard!
	High Voltage	Attention, Death Risk
	High Temperature	Door, glass and its vicinity reach high temperatures when the oven is operating.
	Operating Mechanical Parts	Do not perform maintenance or repair work on moving parts.

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Warranty


Those not covered by the warranty;

- Glass damages, ampoules and seals.
- Unintended use of the device,
- Modifications or technical modifications to the device by person and persons not authorized by the manufacturer,
- Avoiding use of the manufacturer company's original parts,
- Damages with mechanical impacts during the oven transportation by the customer.
- Losses due to the insufficiency of all network systems supplying the oven.
- Faults that may occur due to user's neglect of the oven.
- No person other than Memak Makine's authorized personnel or authorized services should under any circumstances interfere with the repair and modification of the device.
- Due to the failures in electric motors.
- Due to the failures those may occur with the entire electricity materials.
- In cases of tempering and damaging settings on oven.
- In cases of failing to adhere with the rules specified in instructions of use.
- Memak Makine cannot be held responsible for failures or problems caused by the use of the oven by a person who is not familiar with the oven's operation.

Manufacturer Company Information

Manufacturer: MEMAK PLASTİK GIDA MAKİNA SAN. TİC. A.Ş
 Address: 4.Organize Sanayi Böl. Kayacık Mah. 103. Cad.
 No: 10 Selçuklu/KONYA/TURKEY
 Telephone: +90 332 345 36 16
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 Web: www.memak.com
 E-Mail: memak@memak.com

Product Information

		Organize Sanayi Bölgesi Kayacık Mah. 103. Cad. No: 10 Selçuklu/Konya/TÜRKİYE T: +90 332 345 36 16 - F: +90 332 239 06 90 www.memak.com - memak@memak.com		
TİP TYPE	(2)		AĞIRLIK WEIGHT (Kg)	(3)
MAKİNA MODELİ MACHINE TYPE	(4)		İMALAT TARİHİ CONSTR. YEAR	(5)
SERİ NUMARASI SERIAL NUMBER	(6)			
CE markı (7)	V (8)	HZ (9)	kW (10)	

LABEL INFORMATION

- | | |
|-------------------------------------|------------------------|
| 1. Manufacturer company information | 6. Serial number |
| 2. Machine type | 7. CE mark |
| 3. Machine weight | 8. Operating voltage |
| 4. Machine model | 9. Operating frequency |
| 5. Production date | 10. Operating power |

Production Area Design

1. In the entire area, there should be some room to allow for inspection and cleaning when manufacturing equipment is installed.
2. When placing the machines, all connections must be closed so that there are no openings.
3. The floor on which the machines are placed should be accessible from the point of view of the cleaning operation or should be completely closed.
4. In cases where equipment passes through sections such as ceiling, floor, wall, sufficient floor should be provided between equipment and wall for cleaning or machine should be mounted on the wall not to permit any gap.
5. Auxiliary equipment must be removable and can be reassembled to facilitate cleaning.
6. Production base should be covered with hard, smooth, easy to clean and non-absorbent material.
7. Stacking should be made on pallets to let minimum 100 mm distance with the floor when storing the products.
8. Vessels used to collect waste products and waste water should be made of easy to clean materials and should have sufficient volume.
9. Doors and windows opening out of the plant should be isolated to prevent any outsourced contamination.
10. Sufficient ventilation should be ensured in the washing rooms.
11. Water and water vapor that come into direct contact with the products should be of drinkable quality.
12. Drainage systems for wastewater must be installed in areas where cleaning is required.
13. Floor slope should be such as to prevent water accumulation on the surface.
14. Illumination lamps should be protected as to prevent falling and breaking.
15. Power cables should be stabilized (their contact with the ground should be prevented)
16. Machine's electrical components should be closed to prevent dust formation. Water should be prevented from entering electrical panels.
17. Machine parts such as fan, motor should be accessibly mounted.



About the Machine

Intermediate Proofer manufactured by MEMAK MAKİNA is designed for bakeries or patisseries that produce baked products.

Since it is designed in different sizes, it can meet the needs of small, medium and large enterprises.

Product Description

Intermediate Proofer is a machine that transfers the dough coming from the turning machine to a forming machine or an independent section after resting them for a certain period of time.

Operating Principle of The Product

Intermediate Proofer takes the dough coming from the turning machine into the machine by means of the inlet groove. It does the resting process in the nets on the carrying straps attached to the chain conveying system in the machine. The dough circulates between the nets with the transfer method, and exits the machine within 4.5 min or 8.5 min depending on the machine model.

During the resting period, the doughs are transferred to the long forming machine which is another processing unit through the outlet groove.

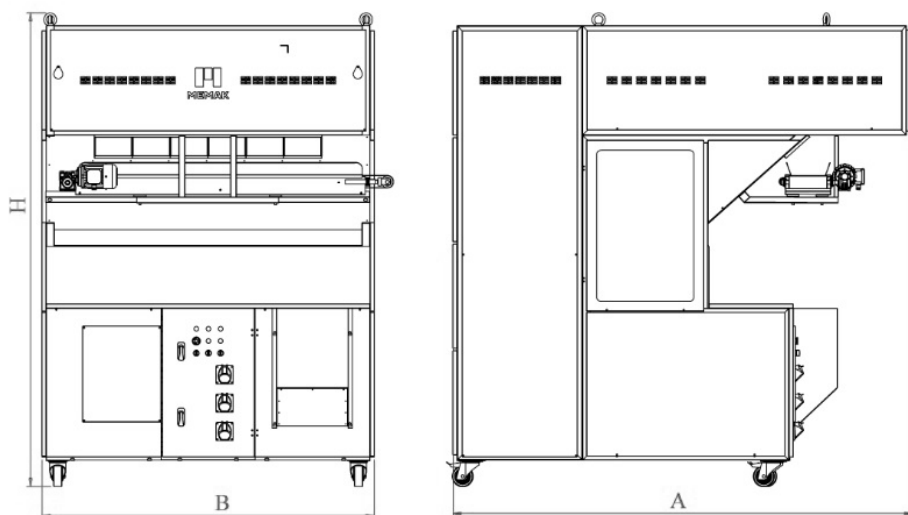
The inlet and outlet grooves can be adjusted as right or left depending on the position of the machine.

Product Technical Details

	IPP-156	IPP-240	IPP- 276	IPP- 276 STATIC
Number of nets	156	240	276	276
Number of net straps	26	40	46	46
Resting Duration	1,5 – 5 dk	2 – 7,5 dk	3 – 10 dk	9 dk
Weight in Grams	100 - 1200 gr	100-1200 gr	100-1200 gr	100-1200 gr
Electric Power	0,75 KW	0,75 KW	0,75 KW	0,75 KW
Electric Connection	380/50-60 hz 3 phase	380/50-60 hz 3 phase	380/50-60 hz 3 phase	380/50-60 hz 3 phase
Dough Capacity	132	176	220	240
Weight	600 kg	900 kg	950 kg	1100 kg

PRODUCT OUTSIDE DIMENSIONS

The lettering measures in the following figure (Figure 1) are indicated in the table.



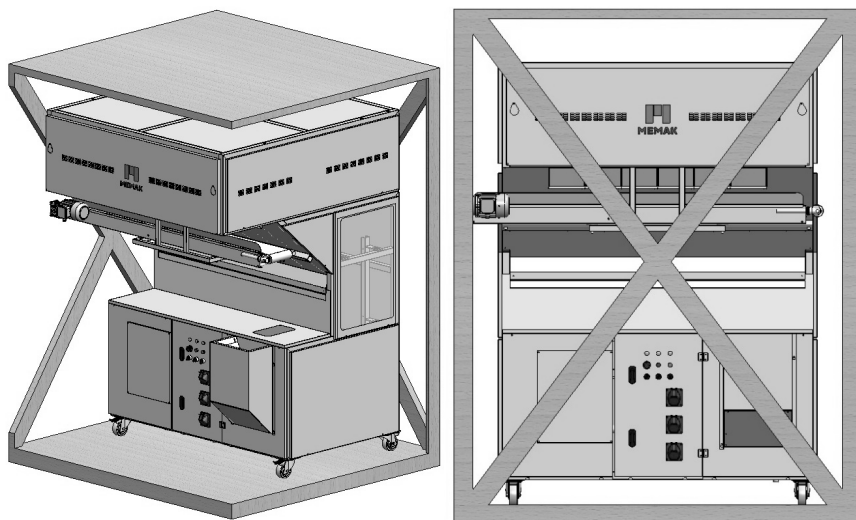
(Figure1)

	IPP 156	IPP 240	IPP 276	IPP 276 STATIC
DEPTH mm / inc (A)	1660	2270	2300	2300
WIDTH mm / inc (B)	1700	1700	1700	1700
HEIGHT mm / inc (H)	2300	2300	2300	2300

PRODUCT COMMISSIONING

General Rules on Unpacking the Machine

- Inspect the machine for damages during transportation before unpacking. Check that all parts listed in the shipping documents are present. If there are missing parts, manufacturer must be informed within 24 hours.
- Dispose of the packaging material in accordance with the applicable legal regulations when the machine is fully installed.
- Store the materials used for lifting the machine in a suitable place for future use. (Figure 2)



(Figure2)

Rules for Machine Storage

- Machine must be stored in indoors away from dust, moisture and heat.
- Permissible ambient values for storage are as follows: Temperature: -5 C° to 45 C°
- Maximum moisture: 60 %
- It should be ensured that the place where the machine is stored bears no risk of vehicle crash.
- Guarded parts must be checked regularly.
- Do not stack machines on top of each other.
- If the machine is stored without a package, it must be raised from the ground with the help of wooden pallets. Cover to prevent dust and dirt accumulation.

Load Structure

Machine can be shipped in form as stated below:

- Completely assembled;
- Partially assembled;
- Not completely assembled; parts are stacked on the pallet or optionally on top of any wooden structure.

The vehicle to be transported must have the required lifting capacity. (Please see machine's technical information chart.). Furthermore, vehicle's minimum loading areas should be as follows. (Width: 2300 mm; Length: 5000 mm)

Lifting device used to raise the machine; should have sufficient lifting capacity and fork length.

PRODUCT TRANSPORT

Equipment and Tools for Transporting and Lifting The Machine

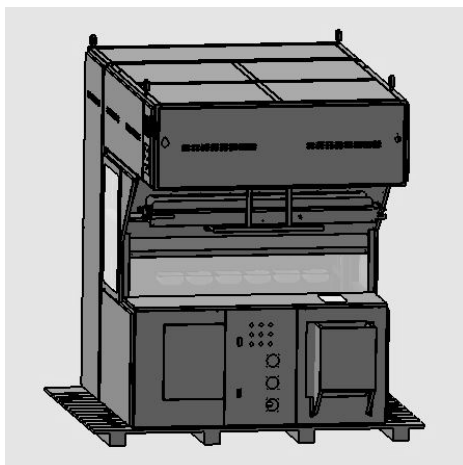
If the machine is in the box or palette

- The forklift truck must have sufficient capacity. Or,
- Cranes and its equipments (ropes, belts or chains) must have sufficient capacity, if there are transporting points on the machine.

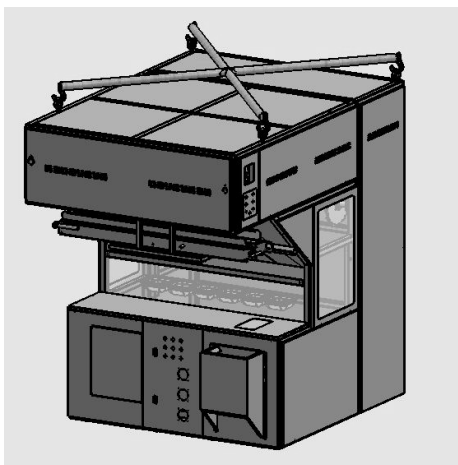
If the machine is not packed

- The forklift truck must have sufficient capacity. Or;
- If transport points are available on the machine, the crane and its equipment (rope, strap or chains) must have sufficient capacity.

The wheels on the machine allow the machine to move smoothly on the flat floor. The machine can also be transported on the pallet (figure 3) or by means of a chain to be mounted from above the machine (figure 4).



(Figure3)



(Figure4)

General Rules on Lifting and Transporting the Machine

- Before starting the operation, designate and inspect the entire transport area, the parking area of the vehicle carrying the transport and the area where the machine will be installed. Ensure there is no hazardous situation.
- Make sure that the vehicle to carry out the machine's lifting and transport procedure of the machine has sufficient lifting capacity. Weights are stamped on the packaging and / or are available in this manual.
- Check that the hoisting ropes and chain types are approved and that the capacity instructed by the manufacturer is clearly written on the ropes. Check whether there is a damage and corrosion with the lifting ropes before use.
- Do not knot or twist the lifting ropes and follow the rules written in this manual by the manufacturer. Same rules apply to chains and belts.
- Particular attention should be paid for lifting the machine centrally.
- Do not climb over and pass under when the machine is loaded and moving.
- Care must be paid that unauthorized personnel are not in the loading area.
- In order not to cause any accident and injuries; all operators must stand at a safe distance when lifting the machine.
- Special care must be paid to keep the system stable when realizing machine lifting procedure.

After this point, chains and belts can be used preferably while transferring the machine.

WARNING: Take necessary cautions during transport! Start with the lifting procedures after ensuring that hangers are fully installed.

PRODUCT ASSEMBLY

Ready assembled machine:

Machine arrives as ready assembled requires special installation settings in special areas assigned to it.

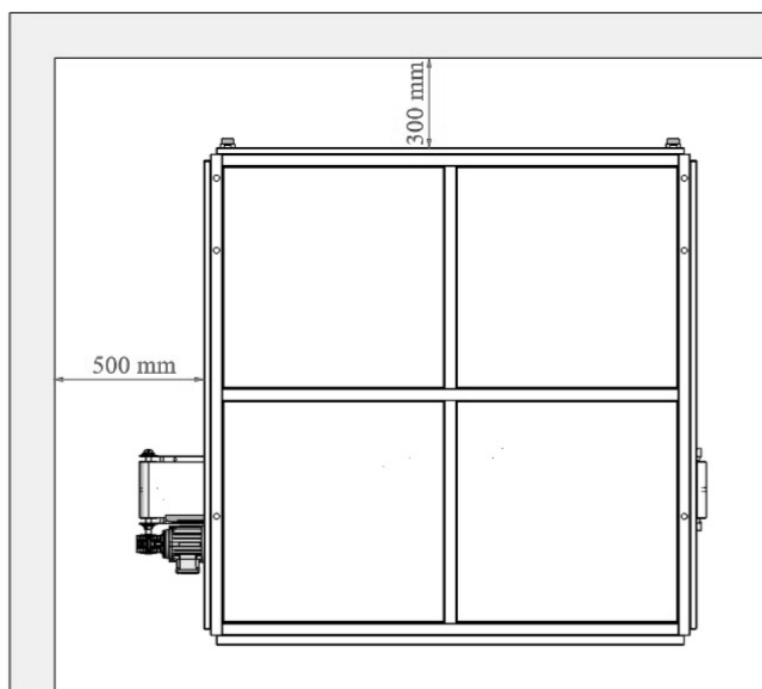
Semi assembled or unassembled machine:

If the machine shipped as unassembled or semi-assembled; the assembly operation must be performed by the personnel authorized by the manufacturer.

If there is no previous layout designed for the machine, it shall be suitably placed.

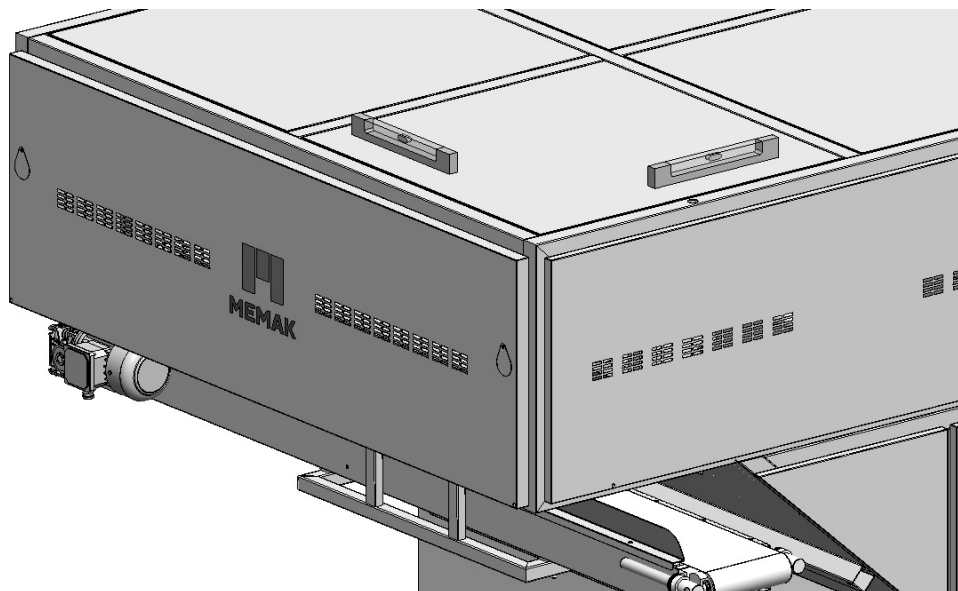
IMPORTANT: Distance between the oven and wall should be at least 500 mm (half meter) from the side and 300 mm (30cm) from the rear.

The placement of the machine should be as following (figure 5).

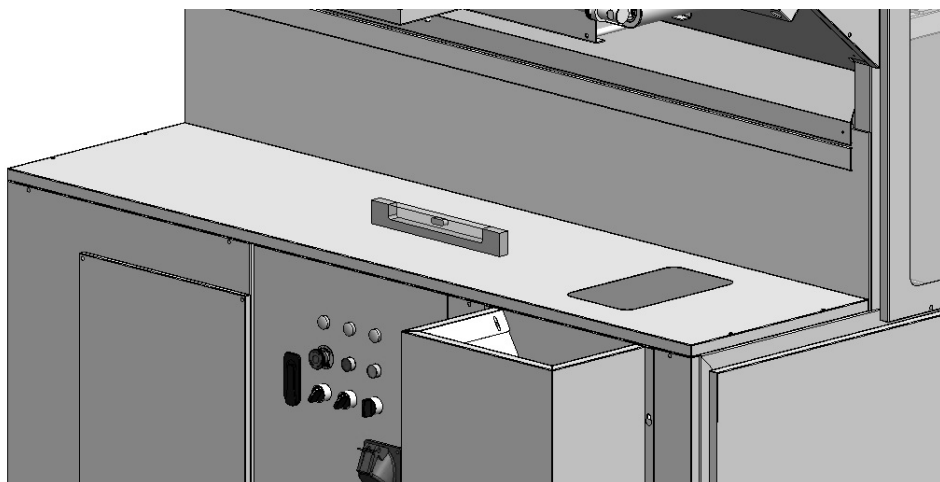


(Figure5)

NOTE: Machine is taken on the scale firstly. (Figure 6), (Figure 7)



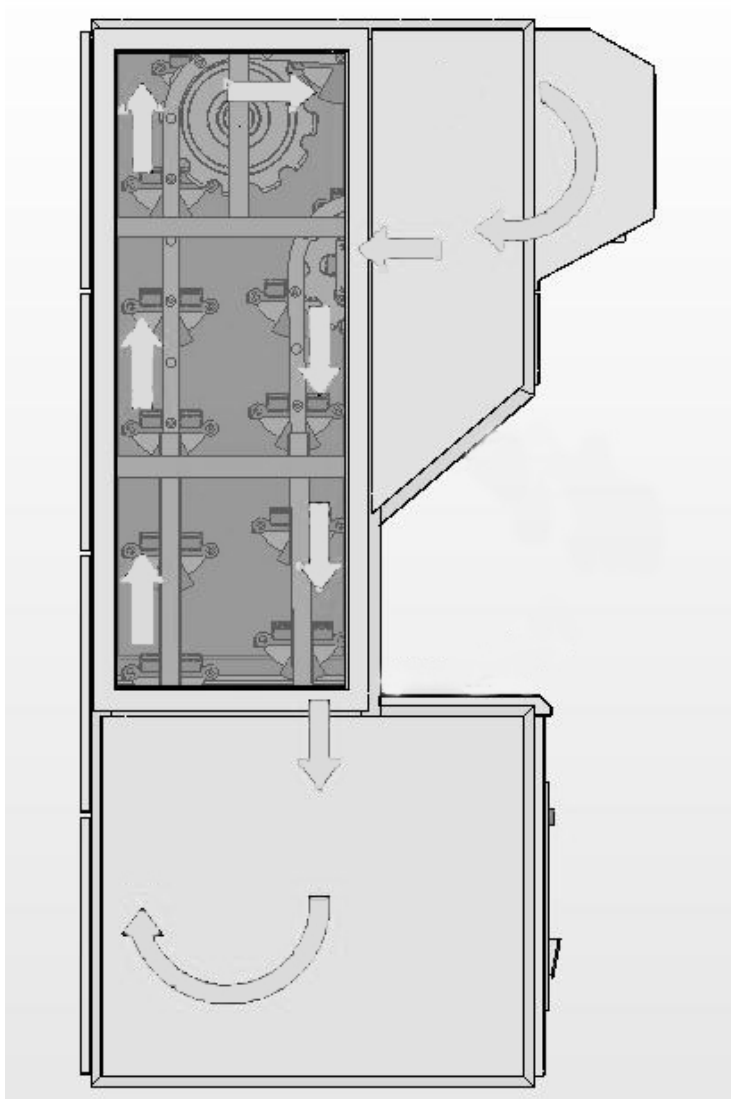
(Figure6)



(Figure7)

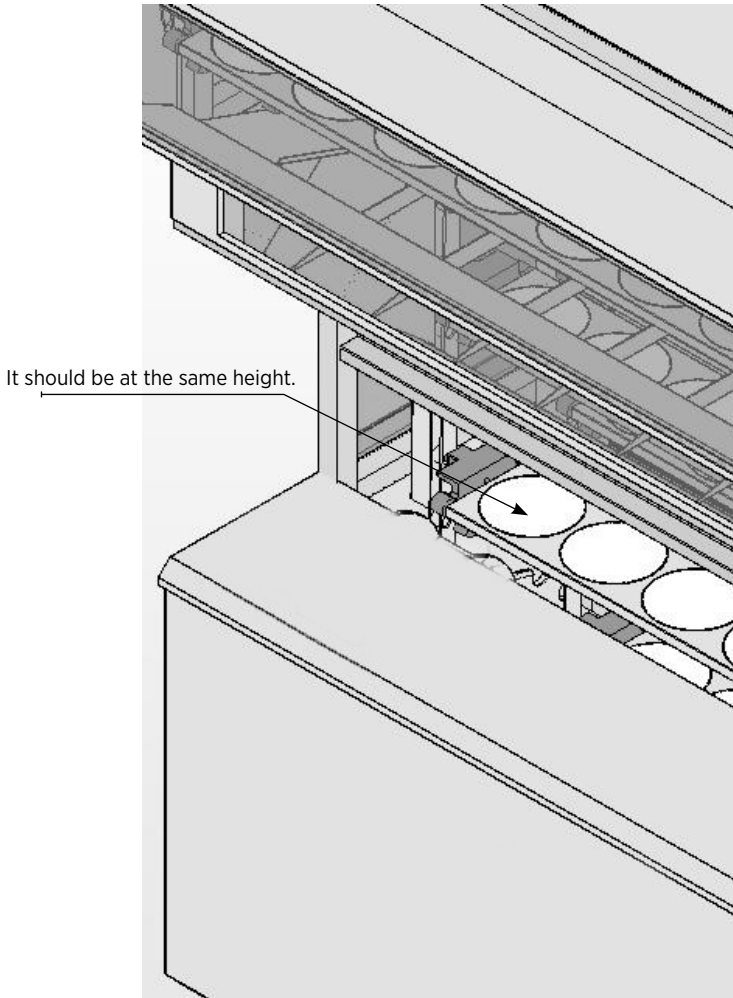
1. Place the machine on a flat surface.
2. Check the appearance of the machine.
3. Ensure the necessary electrical voltage.
4. Provide the movement of machine in the direction of the arrow by operating it. (Figure 8)

- The working direction of the machine is clockwise.



(Figure8)

1. Lubricate the machine's drive system.
2. Lubricate the machine conveyor gear with grease.
3. Adjust the input drum of the machine. (Figure 9)



(Figure9)

- The dough entry drum and carrying strap must be at the same height.
- Do not forget to tighten the bolt of the dough input drum!

Electricity Connection Rules

- Electrical connection of the machine is made according to the regulations in force and is the responsibility of the client.
- It is the customer's responsibility to maintain electrical connections and circuits from the power supply.
- Please use cable in sections, approved and cable suitable for the currency passing in electricity panel. Electrical power data is available in the label information. Depending on where the oven is used, the length of the connecting cables must be adjusted.
- Make sure that the power supply is disconnected when you intend to connect electricity.
- Cable's locations to damage shall be set and these parts shall be covered to prevent its damage against contact.



Electricity panel has an air conditioning system to prevent damaging of the electricity circuits from overheating.

Those required for electricity connection;

- 3 x 20 A FUSE 1 EA. REQUIRED
- OPERATED WITH 3 PHASE (380 V/ 50 Hz), ITS AVERAGE CURRENCY DRAWN IS 7 A.
- 5x4 ANTIGRON CABLE (SINGLE VEIN) REQUIRED
- CABLE SIZES DEPEND ON DISTANCE.

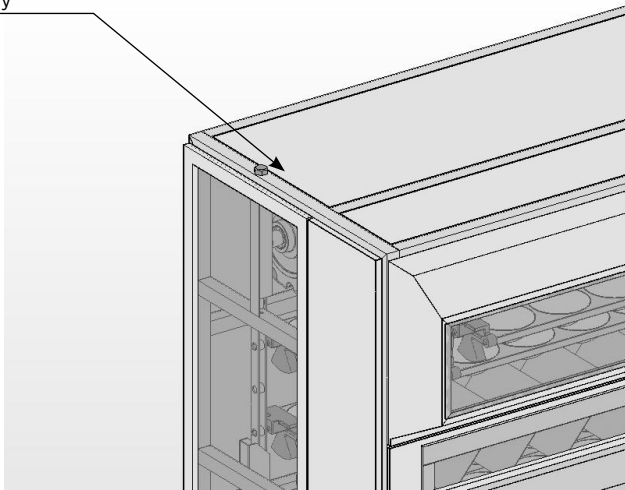
Dough Resting Process

1. The dough transfers to the resting machine from the conic turning machine by having floured.
2. It is loaded into the bowls by the loading drum.
3. It circulates between nets via transfer.
4. Dough goes outside the machine after 4.5 min or 8.5 min.

Things to be considered when operating the product

1. Check the tension of the conveyor chain. If it is loosened, eliminate the chain excess by using the tensioning mechanism. (Figure 10)

Check it regularly

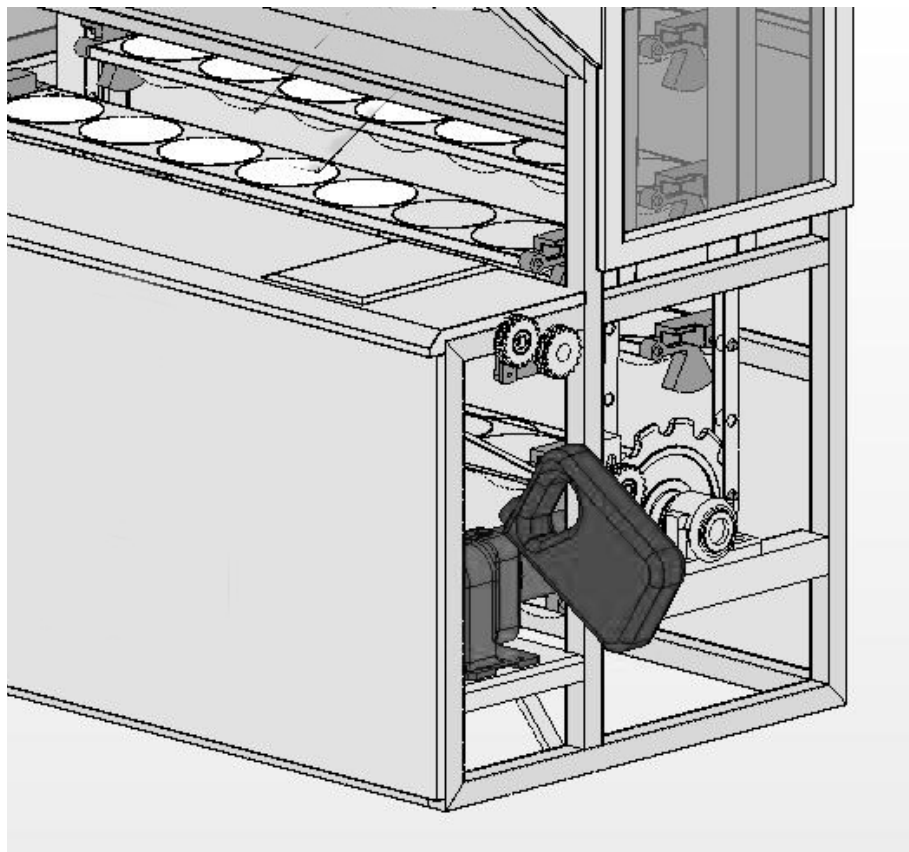


(Figure10)

2. Periodically check the tension of the drive system gear. If it is loosened, stretch it by using the tensioning mechanism.
3. Continuously control the loading of dough by looking. If necessary, adjust the inlet drum according to figure 4.
4. Check the nets and replace the rent, old and dirtied nets with the new ones.
5. If the dough adheres to the nets, check the flouring mechanism of the conic turning machine.
6. Check the tapping system. Make the necessary adjustments.

Things should be done to make the product long lasting

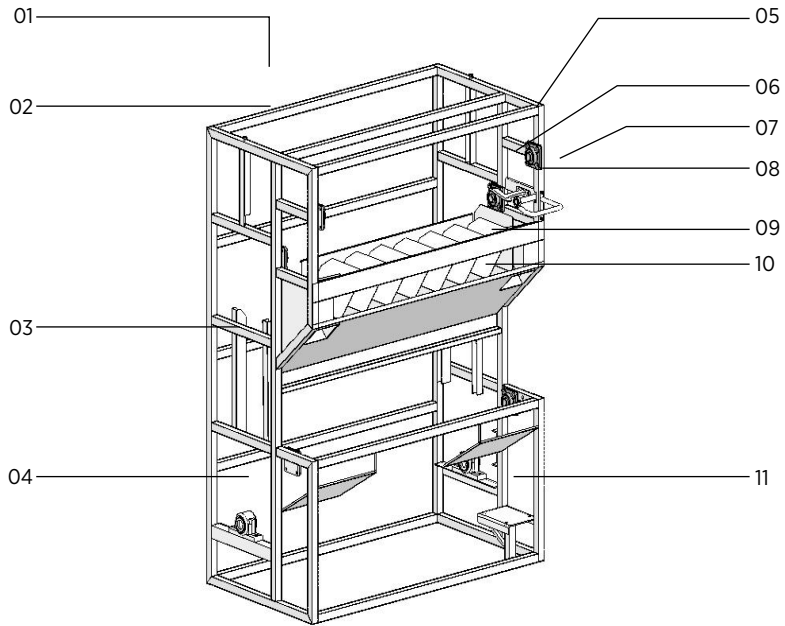
1. Do not leave the dough in the net, and check the nets by looking at the end of each job.
2. Carry out the maintenance of rollers and bearings regularly.
3. Check the gear unit oil level regularly. If necessary, add oil. (Figure 11)
4. Carry out the maintenance of conveyor chain and transport chain by lubricating.
5. The transport chain and drive system chains will creep over time after the machine is put into operation. Do not forget to stretch the chains.

*(Figure11)*

MATERIAL LISTS

PART LIST

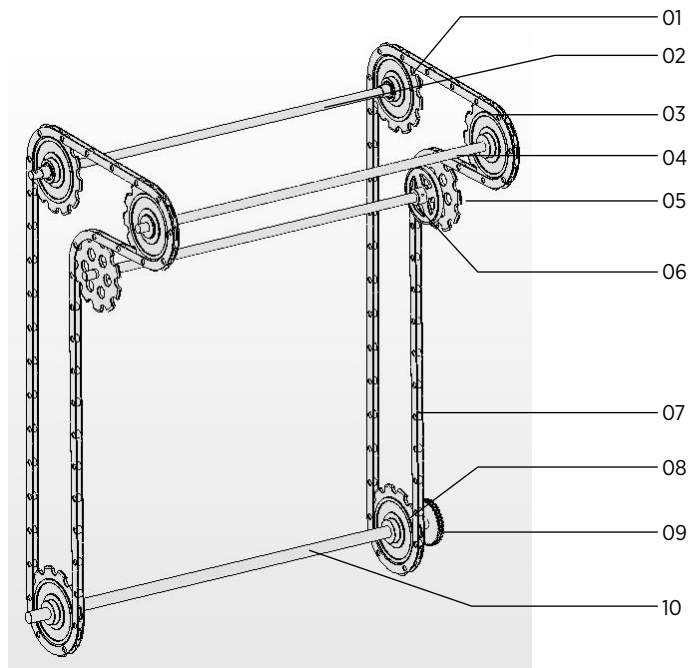
PROFILE FRAME PART LIST



(Figure12)

	PART NAME
1	Profile Frame
2	Transportation System Tension Screw
3	Chain Slides
4	Plain (SN 509)
5	Plain Bearing (UCF 206)
6	Tapping Plate
7	Increasing Tapping Shaft
8	Bearing (6303 2RS)
9	Transfer Plates
10	Transfer Mechanism
11	Reducer Platform

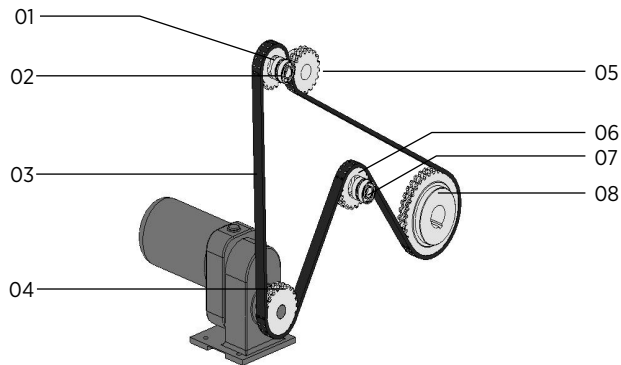
TRANSPORTATION SYSTEM PART LIST



(Figure13)

PART NAME	
1	Casting Gear Bearing
2	Steel Shaft Diameter 30
3	Casting Gear Diameter 32
4	Steel Shaft Diameter 32
5	Casting Gear Z:10
6	Tapping Tambour
7	Carring Strap Chain 3" (H674ZP) (5 Mt. for ADM-154 – 9 Mt. for ADM-280)
8	Casting Gear Diameter 40
9	½*2*38 Chain Gear
10	Steel Shaft Diameter 40

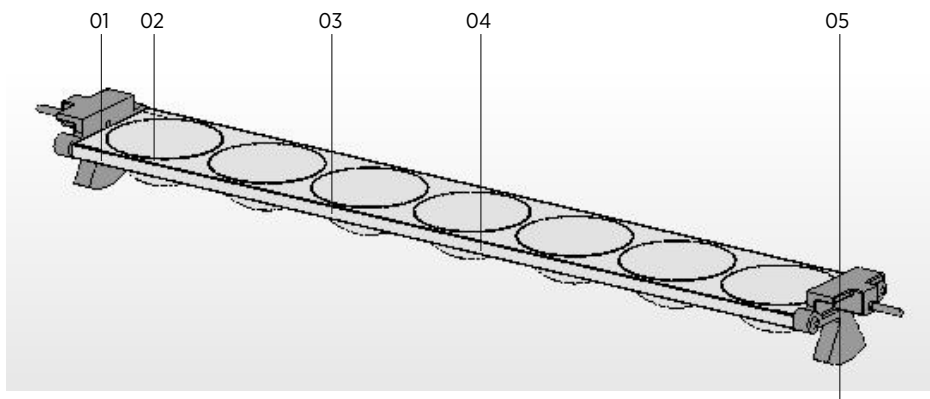
CHAIN GEAR PART LIST



(Figure14)

PART NAME	
1	½*2*19 Sliding Gear
2	Bearing (6203 2RS)
3	½” Double-Row Chain (08B-2)
4	½*2*21 Reduction Gear
5	½*2*19 Drum Gear
6	½*2*19 Tension Gear
7	Bearing (6203 2RS)
8	½*2*38 Chain Gear

CARRYING STRAPS PART LIST



(Figure15)

PART NAME	
1	Carrying Strap Pins
2	Casting Weight
3	Plastic Nets
4	Carrying Strap
5	Special Rivet

CONTROL PANEL AND OPERATION OF THE MACHINE



(Figure16)

1. Power button is turned on.
2. The emergency stop is turned on.
3. When the start button is pressed, the system operates.
4. When we activate the fan button, air circulation is ensured in the resting.
5. When we activate the lamp button, it helps to destroy harmful organisms in scattering by radiating ultraviolet light.
6. To stop or shut down the system, first stop or emergency stop, and then the power is interrupted.

GENERAL CLEANING

Cleaning Rules

The machine has been manufactured in accordance with the laws on foodstuffs in force at the time of shipment by the manufacturer. If there is an indication of misuse, all parts (dough, ground, water, etc.) on the machine should be replaced immediately.

- The manufacturer cannot be held liable for deterioration/fraying due to incorrect or poor cleaning of the machine.
- Cleaning should be carried out after the machine is secured.
- Do not use compressed air to clean internal electronics. Use vacuum devices.



For devices that must be connected to a chimney, periodical maintenance and cleaning of the chimney is required according to the rules in force in the country where the device is to be installed.



Device's gas flow to burner shall be interrupted when there is a defect with the combustion production discharge for devices containing safety mechanisms in reference to chimney drawing and an obligation to be connected to a chimney. In case of continuous interruption despite re-commissioning, the authorized personnel should immediately be contacted and it should be repaired and cleaned.

SECURITY



The instructions in this section apply only if the country code is shown on the device. If the country code is not visible on the device, refer to the technical instructions giving the necessary instructions for adapting the device to the current conditions in the country.

RULES

- Do not tamper with the machine and do not disable the machine's safety systems.
- This device is for professional use. It should only be used by qualified personnel.
- Do not damage or disassemble safety warnings on the top of the machine. If there are any damaged warnings, contact our company immediately and ask for a new one.
- In emergency situations, press the emergency stop button.
- Keep the machine and its working area tidy and clean.
- Persons with inappropriate psychological status should not use the machine.
- Wear your suitable personal protective equipment for the procedures.
- Check the sufficiency of your machine in compliance with the maintenance schedule.

MAINTENANCE AND SETTING

Cleaning, maintenance and repairs that can be made by the user

The maintenance instructions must be adhered to in order to ensure efficient operation for Memak Intermediate Proofer.

The maintenance of the machine should be done by the user every day at the end of work.

Things should be done to make the product long lasting

After use, keep the machine continuously cleaned from flour and dough pieces. To do this, clean the machine with a soft brush and cloth once a week. Wipe operations should be done with a damp cloth. Never use pressurized water.

The drive and strap chain must also be lightly greased. In the same way, the strap pins and the chain guides that come into contact with each other during the topling of the straps must be grased.

To ensure that the gear unit is ventilated under all conditions, it is necessary to keep the vent hole in the filling cap clean. If there are dough crumbs in the strap eyes, they should be cleaned at least once a week or more.

The unit must not be operated without the safety pin being disconnected.

The main strap chains from the hitch tilting device should always move downwards, no matter where the inlet is located.

Weekly Maintenance

1. Make sure the machine is not working.
2. Remove the undercoat hair of the machine.
3. By using a vacuum cleaner, clean any flour and dust accumulated on the motor, tape, etc.

Monthly Maintenance

Check the oil level of the drive reducer. Add oil if it is missing.

ATTENTION: Our company is not responsible for any damage caused by unauthorized persons interfering with the machine.



MEMAK



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PROFESSIONAL MACHINE

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