

AMF

COMBO-MAT BREAD AND BUN MAKE-UP SYSTEM



Shown with Optional Equipment

- Automated combination bread and roll make-up system - from dividing all the way through panning
- Designed to produce bun, soft roll, and pan baked bread
- Featuring state-of-the-art extrusion dividing technology

FEATURES & BENEFITS

Design Innovations

- Extrusion dividers offer the most accurate scaling available with superior product quality
- Hinged spiral tunnel rounder bars with gas spring assist for improved rounding symmetry and offering easier access for sanitation and maintenance while eliminating sticking
- Electronic synchronization between the divider and proofer allows accurate timing without high maintenance chain or shaft drives
- Non-stop magnetic pan indexing provide precision and durability for high speed production
- Four piece or six piece bread production process

Design Flexibility

- The Combo-Mat can handle a variety of production requirements including buns, soft rolls and pan baked bread
- The Combo-Mat is designed with OIT driven recipe management for quick product changeovers for buns, to rolls to bread



COMBO-MAT BREAD AND BUN MAKE-UP SYSTEM

MECHANICAL FEATURES

- AccuMax Extrusion Dough Divider
- Heavy duty stainless steel frame for durability and corrosion resistance
- Poly-slick rounder belt
- Hinged rounder bar frame with gas spring assist
- New spiral tunnel rounder bars
- Direct drive rounder belt
- Cantilevered rounder frame design for quick belt changes
- Adjustable feet with lagging capability
- Independently driven UHMW kicker roller
- UHMW zig-zag board and lane guides
- Pneumatic flapper gate dough ball transfer system
- Pneumatic pulse sifter with linear motion at zig-zag and moulder areas
- Stainless steel flour catch pan with integral design to zig-zag for flour containment and recycling
- Heavy duty proofer trays with stainless steel frame, non-stick analytic plastic snap-in trays
- 12' (3658 mm) stacked or 24' (7315 mm) stretched proofer configuration
- Punched stainless steel proofer side panels
- Hinged catch pans on underside of proofer with key latch
- Single action flapper gate controls the drop from the proofer into the sheeter
- 6" (152 mm) diameter sheeter rollers
- Open design sheeter drive for easy maintenance
- Cantilevered moulder belt frame design for easy belt access
- Synthetic/cotton-topped moulder belt for flour retention and stretch resistance
- Pneumatic driven hot dog gates with PLC control for on-the-fly adjustment
- Non-stop magnetic pan indexer



AccuMax Divider



Magnetic Pan Indexer

SPECIFICATIONS

Product	Speed Range*	Maximum Throughput*	Scaling Range*	Pan Size	
				Width Range	Height Range
Bun and Roll	80 to 600 ppm	6,000 lb./hr. (2722 kg/hr.)	7/8 oz. to 5 oz. (25 g to 142 g)	13" - 33" (330 mm - 838mm)	1/2" - 2" (13 mm - 51 mm)
Pan Baked Bread	20 to 100 lpm	6,000 lb./hr. (2722 kg/hr.)	7 oz. to 36 oz. (198 g to 1020 g)	13" - 20" (330 mm - 508mm)	2 1/2" to 4 1/2" (64 mm to 114 mm)

*Throughput, speed and scaling range are dependent on several factors including dough condition, product configuration and other associated equipment.

OPTIONS

- Stainless steel remote electrical enclosure
- Reverse axis rounder
- Chilled rounder bed
- Servo rotary gate upgrade
- Additional proofer sections
- CE confirmed electrical package
- Allen Bradley PLC upgrade
- Second Allen Bradley PanelView 1000 operator interface at moulder
- Panel modem option
- Panel air conditioner
- 3' (914 mm) infeed pan conveyor extension for hand feed
- 3' (914 mm) discharge pan conveyor extension
- UHMW moulder board assemblies
- Twin roll cutter
- Zig-zag vacuum flour reclaim system with stainless steel flour catch pan with integral design to zig-zag for flour containment and recycling
- Pan dust collector
- Accupan four point flour reclaim system
- Magnetic pan pre-indexer conveyor
- Stainless steel proofer support legs
- Roll imprinters
- Pan shakers
- Bun seeders
- Tool kit
- Spare parts kit



Zig-Zag Vacuum Flour Reclaim System



Pan Dust Collector



Servo Rotary Gate

ELECTRICAL FEATURES

The Combo-Mat is supplied with one NEMA 4 rated operator control station mounted on the side of the tower.

Allen Bradley PanelView 1000 keypad operator interface with alarm messages and recipe management on operator panel to control:

- Divider
- Rounder belt speed
- Rotary gate speed
- Pulse zig-zag flour sifter speed
- Proofer speed
- Sheeter roller speed
- Moulder belt speed
- Pulse moulder sifter speed
- Hot dog gate phasing and speed
- Pan indexer
- Flour recovery (if so equipped)

Allen Bradley pushbuttons on operator panel for:

- Two-button start
- Stop/Emergency stop
- MCR reset

Operator station at S/M/P with Allen Bradley button controls for:

- Pan gate control
- Pan indexer Auto/Stop/Jog
- Two-button start
- MCR reset
- Stop
- Emergency stop
- Sheeter/moulder belt/pan conveyor speed adjustment with LED readout

NEMA 12 remote enclosure (painted steel) including:

- Main disconnect switch
- Allen Bradley PLC control
- AC inverters



Operator Interface Panel

