



# ACCUPAN BUN SYSTEM



*Shown With Optional Equipment*

- **High Efficiency Technology That Reduces Production Costs and Improves Product Quality and Consistency**
- **Integral Dough Development System for Optimal Performance on a Variety of Products**
- **High Production Speeds - Up to 3,750 Dozen Per Hour**

## 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 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
- Available options for servo rotary gate and non-stop magnetic pan indexing provide precision and durability for high speed production

### Design Flexibility

- The Accupan can handle a variety of production requirements with 4 and 6 across configurations
- AMF offers a variety of divider options with the Accupan Bun System, including the KRDIIe extrusion divider with a built-in developer, and the new AccuMax extrusion bun divider for high speed production

### MECHANICAL FEATURES

- Heavy duty stainless steel frame for durability and corrosion resistance throughout the machine
- Adjustable feet with lagging capability

#### AccuMax Divider

- Precision scaling, typically +/- 1-2% and no divider oil required
- Patented quarter block system provides quick and simple port blocking
- DoFlow dough charging system for consistent doughs
- Stainless steel metering pump for precise, linear flow control with ultra-low shear peristaltic action
- E-Z flow distribution and scaling manifold features internal flow diverters to precisely balance flow
- Quick clean manifold; quarter block port block-off system for larger rolls
- Rotary cut-off with individual UHMW cut-off knives
- PLC controlled CIP cleaning cycle

#### KRDIIe Divider

- Precision scaling, typically +/- 1-2% and no divider oil required
- DoFlow dough charging system for consistent doughs
- Precision impeller type stainless steel metering pump for precise dough flow control
- Channeled UHMW manifold with valve control for each port
- Rotary UHMW cut-off knife with four-bar linkage drive design
- PLC controlled CIP cleaning cycle

#### Rounder

- Poly-slick rounder belt
- Hinged rounder bar frame with gas spring assist for easy cleaning and maintenance access
- UHMW spiral tunnel rounder bars
- Direct drive rounder belt
- Cantilevered rounder frame design for quick belt changes
- Independently driven UHMW kicker roller

#### Proofer

- 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 zig-zag design that is adaptable to optional automatic flour recycling systems
- Heavy duty proofer trays with stainless steel frame, non-stick analytic plastic snap-in trays
- 12' (3658 mm) or 24' (7315 mm) stretched proofer configuration
- Punched stainless steel proofer side panels
- Hinged catch pans on underside of proofer with safety key latch
- Single action flapper gate controls the drop from the proofer into the sheeter

#### Sheeter/Moulder/Panner

- 6" (152 mm) diameter grooved steel sheeter roller
- Adjustable 6" (152 mm) diameter smooth sheeter roller with non-stick coating
- 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
- Rotary pan indexer for smooth pan indexing and quick change index bars for easy product changeover (magnetic indexing is available as an option)



*AccuMax Divider*



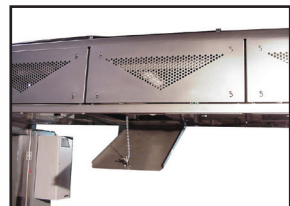
*Patented Quick Clean Manifold*



*KRDIIe Divider*



*Hinged Rounder Bars with Gas Spring Assist*



*Punched Stainless Steel Side Panels and Hinged Catch Pans*



*Rotary Pan Indexer*



## ELECTRICAL FEATURES

The Accupan Bun System is supplied with one NEMA 4 rated operator control station mounted on the side of the tower.

Allen Bradley PanelView Plus 1250 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
- Magnetic pan indexer
- Flour recovery (if so equipped)



Operator Interface Panel

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 CompactLogix PLC
- Allen Bradley PowerFlex inverters

## OPTIONS

### Mechanical Options

- Reverse axis rounder
- Chilled rounder bed
- Patented quick clean manifold
- Aluminum spiral tunnel rounder bars with Teflon coating
- Non-stop magnetic pan indexer kit
- Pneumatic rotary gate upgrade
- Servo rotary gate upgrade
- Additional proofer sections
- Mesh cup proofer trays with stainless steel frame
- 3' (914 mm) infeed pan conveyor extension for hand feed
- 3' (914 mm) discharge pan conveyor extension
- UHMW moulder board assemblies
- Twin roll cutter
- Moulder board hoist systems



Zig-Zag Flour Reclaim System

- Zig-zag vacuum flour reclaim system
- Pan dust collector
- Multi-Vac Flour Recycling System
- Magnetic pan pre-indexer conveyor
- Stainless steel proofer support legs
- CE compliant design package
- Roll imprinters
- Pan shakers
- Bun seeders
- Spare parts kit

### Electrical Options

- Stainless steel remote electrical enclosure
- Allen Bradley PLC upgrade
- Allen Bradley PanelView upgrade
- Second Allen Bradley PanelView operator interface at moulder
- Panel modem option
- Panel air conditioner in lieu of Exair panel cooler



Magnetic Pan Indexer



Servo Rotary Gate



Pan Dust Collector

## SPECIFICATIONS

	Configuration	Divider Type	Speed Range* (pcs/hr.)	Maximum Throughput*	Scaling Range
Accupan AccuMax	4 across 6 across	AccuMax	9,600-30,000 14,400-45,000	6,000-8,000 (lb./hr.) (2722-3629 kg)	7/8-6 oz. (25-170 g)
Accupan KRDIle	4 across 6 across	KRDIle	9,600-27,600 14,400-41,400	5,000-6,000 (lb./hr.) (2268-2722 kg)	7/8-6 oz. (25-170 g)

\*Throughput, maximum speed and scaling range are dependent on several factors including dough condition, product configuration and other associated equipment. Gearmotors are sized to meet a specific production range.

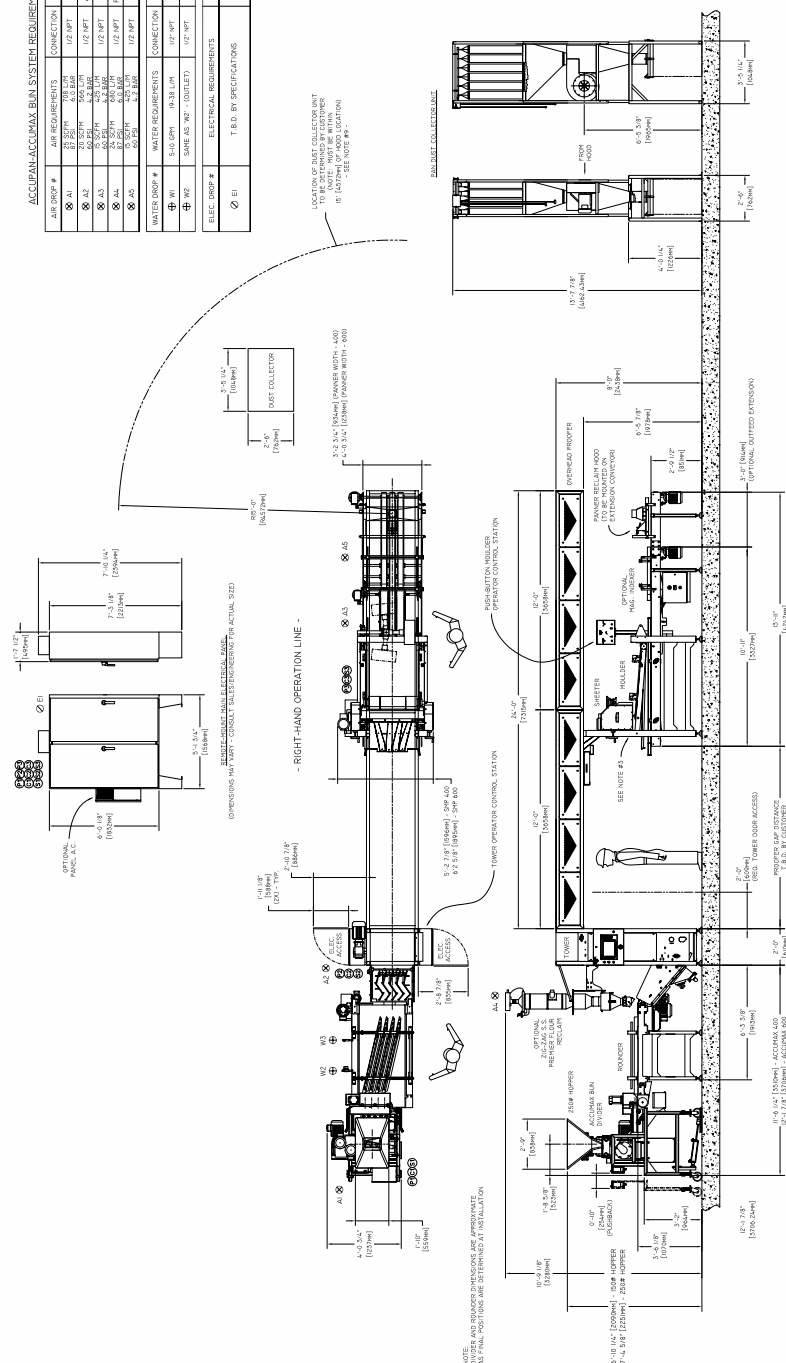


# ACCUPAN BUN SYSTEM

**(Shown with AccuMax Divider)**

## DIMENSIONAL DRAWING

ACCUPLAN-ACCU MAX SYSTEM REQUIREMENTS			
AIR DROP #	AIR REQUIREMENTS	CONNECTION	MACHINE
1	17.5 PSI 1.5 GPM	1/2" NPT	ACCUPLAN
2	17.5 PSI 1.5 GPM	1/2" NPT	ACCUPLAN
3	17.5 PSI 1.5 GPM	1/2" NPT	ACCUPLAN
4	17.5 PSI 1.5 GPM	1/2" NPT	PRIMER RELAY
5	17.5 PSI 1.5 GPM	1/2" NPT	PANHER HUI
6	17.5 PSI 1.5 GPM	1/2" NPT	WATER ROUNDER
7	17.5 PSI 1.5 GPM	1/2" NPT	ROUNDER
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244	17.5 PSI 1.5 GPM	1/2" NPT	ROUNDER
245	17.5 PSI 1.5 GPM	1/2" NPT	ROUNDER
246	17.5 PSI 1.5 GPM	1/2" NPT	ROUNDER
247	17.5 PSI 1.5 GPM	1/2" NPT	ROUNDER
248	17.5 PSI 1.5 GPM	1/2" NPT	ROUNDER
249	17.5 PSI 1.5 GPM	1/2" NPT	ROUNDER
250	17.5 PSI 1.5 GPM	1/2" NPT	ROUNDER
251	17.5 PSI 1.5 GPM	1/2" NPT	ROUNDER
252	17.5 PSI 1.5 GPM	1/2" NPT	ROUNDER
253	17.5 PSI 1.5 GPM	1/2" NPT	ROUNDER
254	17.5 PSI 1.5 GPM	1/2" NPT	ROUNDER
255	17.5 PSI 1.5 GPM	1/2" NPT	ROUNDER
256	17.5 PSI 1.5 GPM	1/2" NPT	ROUNDER
257	17.5 PSI 1.5 GPM	1/2" NPT	ROUNDER
258	17.5 PSI 1.5 GPM	1/2" NPT	ROUNDER
259	17.5 PSI 1.5 GPM	1/2" NPT	ROUNDER
260	17.5 PSI 1.5 GPM	1/2" NPT	ROUNDER
261	17.5 PSI 1.5 GPM	1/2" NPT	ROUNDER
262	17.5 PSI 1.5 GPM	1/2" NPT	ROUNDER
263	17.5 PSI 1.5 GPM	1/2" NPT	ROUNDER
264	17.5 PSI 1.5 GPM	1/2" NPT	ROUNDER
265	17.5 PSI		



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AMF's focus on continuous improvement may result in changes to machinery specifications without notice.

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