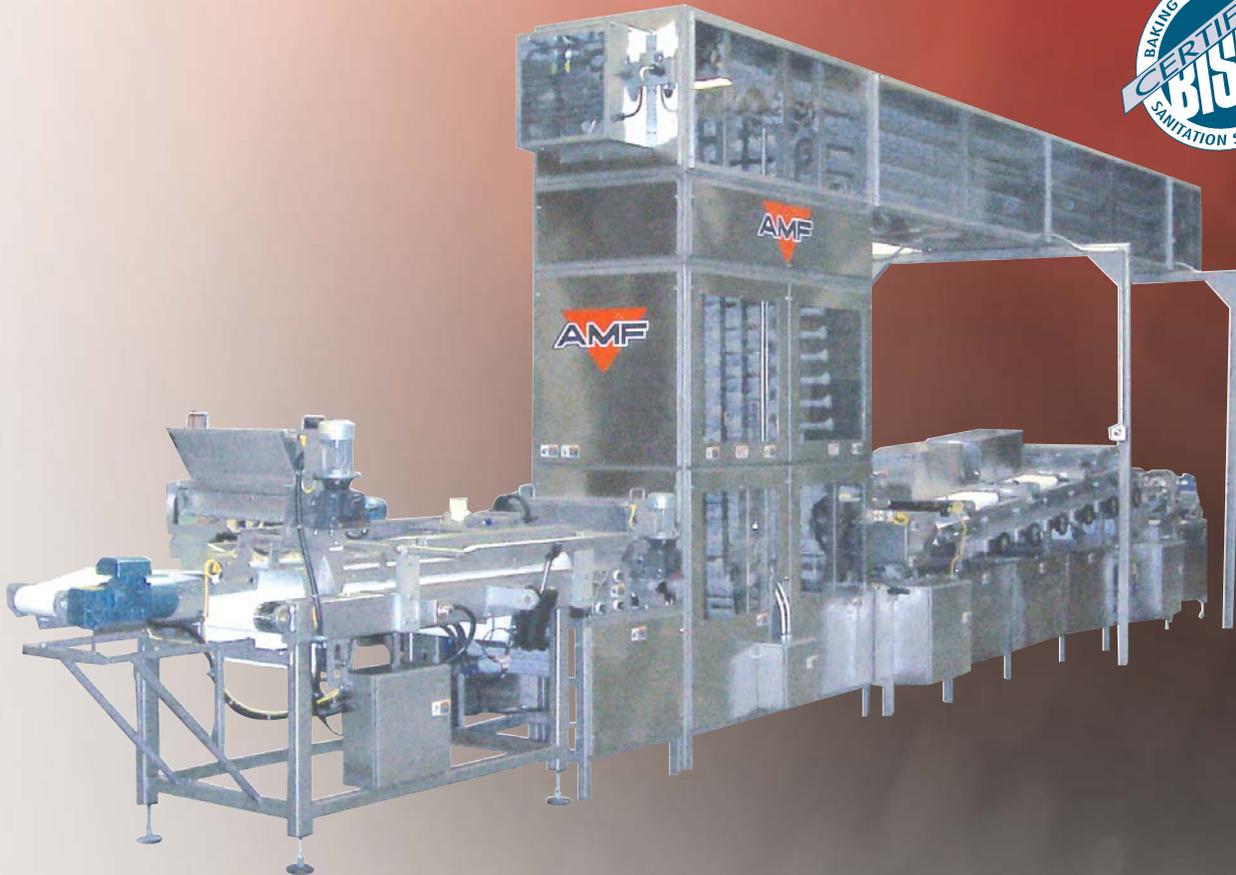




STRING KING



- AMF Stringline for the production of 3,375 of 19 oz. strings of dough up to 26" long
- Advanced electrical system
- Compact design
- Easy to maintain

FEATURES & BENEFITS

- Electronic Infeed Synchronizing System to eliminate doubles
- Heavy Duty Flour dusting of empty and or full proofer trays
- Adjustable dwell of infeed gates
- Self tilting proofer trays to prevent sticking
- High velocity exhaust fans to prevent sticking
- Controlled fall free discharge
- Discharge de-gassing. (optional depending on dough)
- Robotic Centering System
- Stressless Extending System
- Unique Indexing Flap System to Transfer Long Strings and keep them broom stick straight
- Loaf Splitter for two, three or four loaves
- Club Roll Cutting System that cuts strings into rolls and recycles cut offs up to 10 cuts. (depend upon dough and length)
- Multiple discharge options:
 - Peel and Panning
 - Direct Freezer Infeed

MECHANICAL FEATURES

GENERAL INFORMATION

- AMF Stringline for the production of 3,375 of 19 oz. strings of dough up to 26" long
- Infeed Synchronizing Conveyor
- Pressure Board/Moulding Section (C/W Flour Duster)
- Proofer Section (C/W Flour Duster and Two Exhaust Fans)
- Servo-Drive Centering Device
- Three Stages Moulding Section (C/W Two Dough Extenders)
- Lifiable Club Roll Cutting Section
- Transfer Conveyor

Synchronizing Conveyor

- For proper timing of the dough balls into the moulder (controlled by photo eye)
- Double eliminator logic
- Constructed of formed stainless steel with UHMW side wedges
- Powered by a hollow shaft gear brake motor



Moulder Section

- Stainless steel frame
- Air operated lifting device permits:
 - Rapid change over of dough guides
 - Easier access for sanitation and maintenance purposes
- Flour sifter
- Pneumatic pressure board

Common Drive

- Proofer drive is protected by an electronic over torque meter against catastrophic damage

Proofer

- 4.5 min. of proofing time at 3,375 pieces per hour
- Stainless steel tubular construction
- Stainless steel paneling
- Upper horizontal section with sliding plexi glass panels
- Teflon® coated and pneumatically controlled dropping gates with separate timing values
- Adjustable flour duster located above the double dropping gates
- Proofer trays are made of rolled aluminum, plastic end brackets, and sandblasted to a coarse finish
- Proofer chain is 40 mm extended pitch over size rollers
- Over sized hub sprockets
- Horizontal sections of the proofer have angle iron chain guides and rails to tilt to one side (this helps to reduce sticking in the trays)
- Strings are transferred from the trays to the discharge conveyor without dropping
- Discharge conveyor is stainless steel construction and is driven from by the proofer chain

Centering Device

- To bring the string of dough back to the center of the moulding conveyor
- Built on a stainless steel frame with an aluminum based plate
- Conveyor section is built from stainless steel side plates with an adjustable UHMW bed for proper tensioning of the stainless steel balanced weave mesh conveyor belt
- Driven by a flange mount gear motor using a belt drive system
- Centering is accomplished by a multi element infra red light beam source and receiver, processor, servo controller, and linear actuator



Three Stages Moulding Section

- String moulding section consists of a moulding conveyor with two powered extender pressure boards made up of two conveyors at 90 degrees to the moulding conveyor
- Extender pressure boards have rough top conveyor belt and travel to the outside of the moulding conveyor very slowly causing the dough string to extend with very little stress. In addition there is a standard pressure board with universal side guides
- Moulding conveyor is constructed of stainless steel with an adjustable speed gear motor
- Adjustable infeed roller for tracking
- (2) two pressure boards supplied with the stringline. One pressure board is for final moulding of strings to full length. The second pressure board has a slot in the middle, where a stationary knife is located to split long strings into two rounded end loaves



Club Roll Cutting Section

- Cut blunt end rolls and transport the elongated strings to the next step in the process
- Constructed of stainless steel and a flat top Intralox conveyor belt
- Driven by a fixed speed gear motor
- Stainless steel side panels
- Rotary timing flaps at the infeed end to keep the string straight and evenly spaced from each other
- Flaps are driven from a gear motor and controlled from a signal from the common drive
- Slip clutch on the flaps to prevent injury
- Machine comes with one set of cutting devices with 4 knives
- Cutting device is constructed of stainless steel



Transfer Conveyor

- To transfer the loaves or rolls from the Club Roll Cutter next step in the process
- Inverter controlled
- Pneumatic Teflon coated infeed flaps
- Powered transfer roller to ease the transfer of the loaf between two conveyors

STRING KING

MECHANICAL OPTIONS

- Optional de-gassing roller: if needed, an optional de-gassing roller can be supplied with separate drive and two Teflon® lined rollers, 4 inches in diameter. The distance between the rollers is adjustable with a hand wheel. The rollers have adjustable speed. They are located just after the centering device on the long moulding station. In that case the overall length of the long moulding station is increased by 24 inches
- Spare parts kit

ELECTRICAL FEATURES

- Allen Bradley PanelView 1000 keypad operator interface with displays:
 - Status messages
 - Alarm messages
 - System Start/Stop buttons
 - Flour sifters Start/Stop buttons
 - Fans Start/Stop buttons
 - Fans speed control
- NEMA 12 electrical enclosure (painted steel) including:
 - Alarm reset, master relay control, emergency stop
 - Main disconnect switch
 - Allen Bradley 5/03 PLC
 - Allen Bradley PanelView 1000 monochrome keypad
 - Allen Bradley AC inverters
 - Allen Bradley Ultra 3000 servo amplifier
 - Convenience plug to allow programming without having to open panel door



Operator panel

ELECTRICAL OPTIONS

- Nema 12 stainless steel electrical panel
- Allen Bradley PanelView 1000 color
- Spare parts kit

SPECIFICATIONS

Throughput range:

3,375 of 19 oz. strings of dough up to 26" long

Approximate dimensions :

34'-6 3/16" L X 6'-6 3/4" W X 11'-1 13/16" H

Electrical requirements :

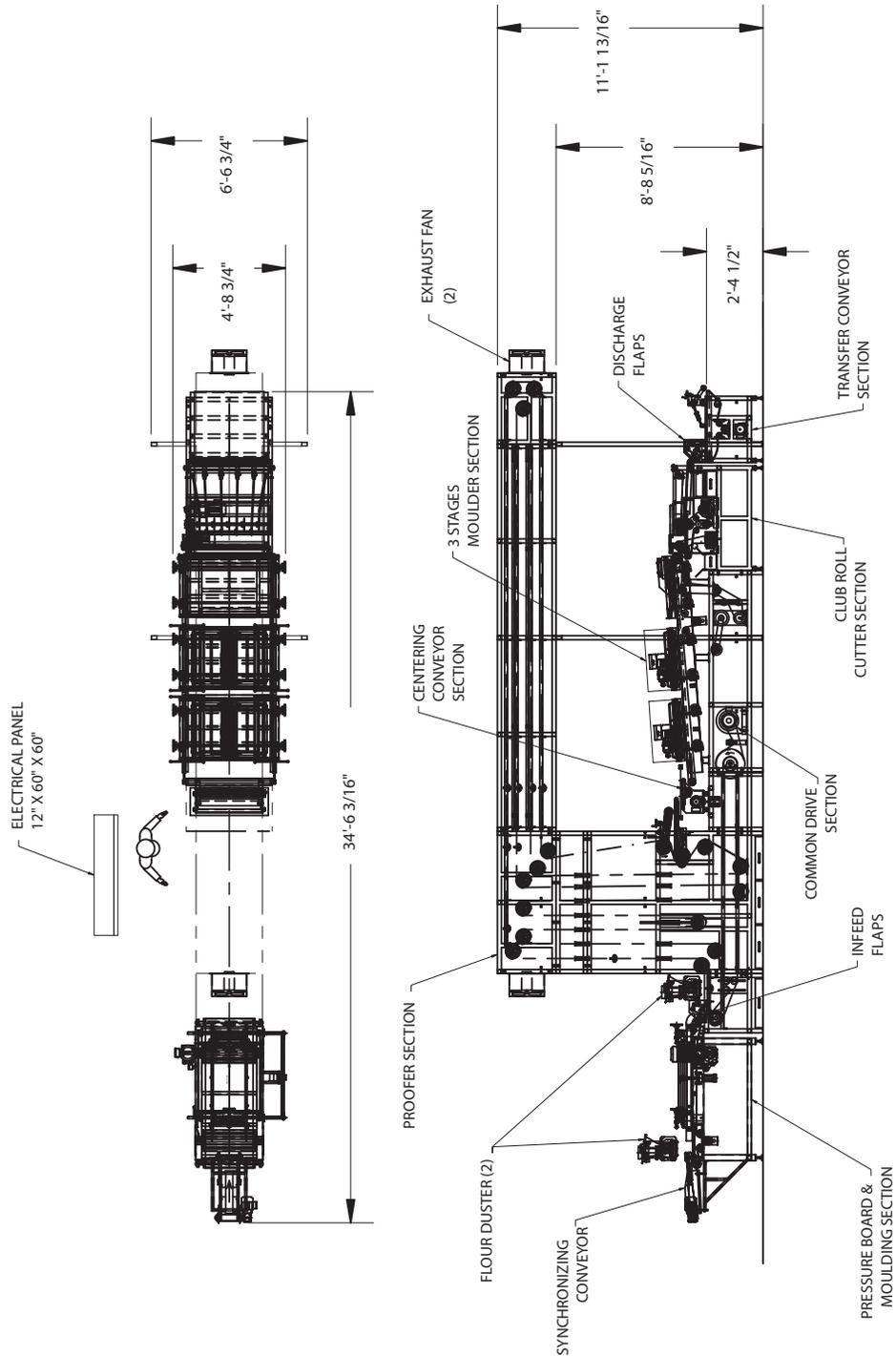
Main Power – 25 KV A

Control power – 24 VD/120 Volts

Air requirements –18 SCFM at 90 PSIG



DIMENSIONAL DRAWING



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