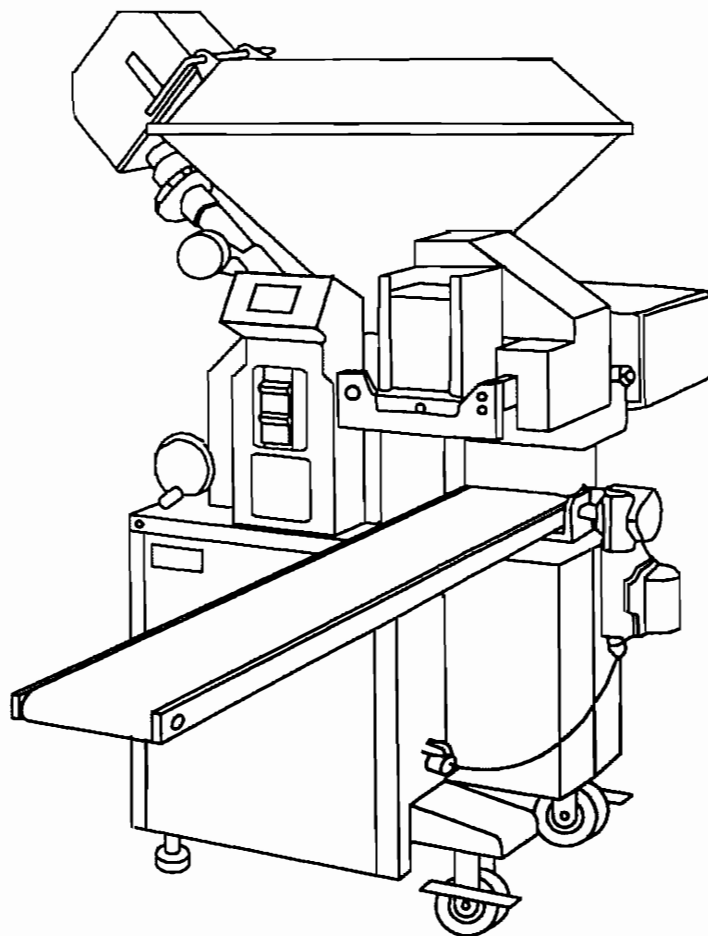


OOOOOO

# HOLLYMATIC MODEL 8/65



## OPERATORS MANUAL – PARTS LIST

FOR 8/65 SERIAL NUMBERS BEGINNING WITH 825

EVERY PERSON OPERATING THIS MACHINE MUST READ THIS MANUAL INCLUDING ALL SAFETY INSTRUCTIONS BEFORE ATTEMPTING TO OPERATE THIS MACHINE. PROPER GUARDS AND SAFETY DEVICES ARE INSTALLED FOR YOUR SAFETY. DO NOT OPERATE THE MACHINE UNLESS ALL GUARDS ARE IN PLACE.

(C) HOLLYMATIC CORPORATION  
ALL RIGHTS RESERVED

FEBRUARY 2000

HOLLYMATIC CORPORATION  
600 E. PLAINFIELD ROAD  
COUNTRYSIDE, ILLINOIS 60525  
PHONE: 708-579-3700  
FAX: 708-579-1057

M-1550

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# SAFETY INSTRUCTIONS

**WARNING TO ALL PURCHASERS, OPERATORS AND OPERATION SUPERVISORS:**

**MAKE CERTAIN EVERY PERSON WHO IS TO OPERATE THIS MACHINE HAS READ THIS MANUAL BEFORE BEING PERMITTED TO OPERATE THE MACHINE. HAVE ALL OPERATORS SIGN THE SIGNATURE PAGE FOUND AT THE END OF THIS MANUAL.**

**FAILURE TO READ AND ADHERE TO THE FOLLOWING IMPORTANT INSTRUCTIONS COULD RESULT IN BODILY INJURY.**

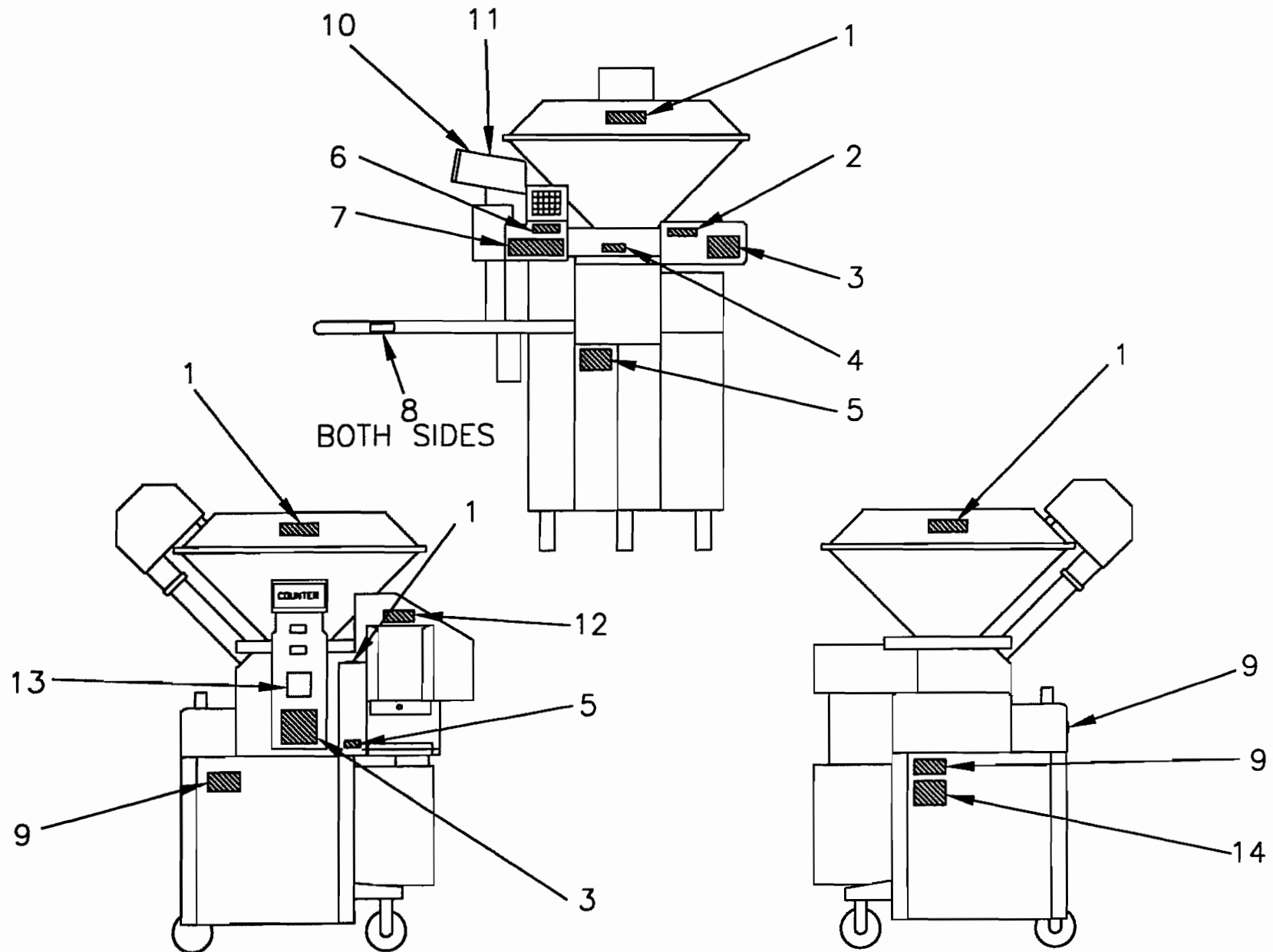
**READ THIS MANUAL COMPLETELY BEFORE OPERATING THE HOLLYMATIC MACHINE. ADDITIONAL MANUALS AS WELL AS REPLACEMENT SAFETY LABELS ARE AVAILABLE FROM HOLLYMATIC CORPORATION OR FROM YOUR LOCAL HOLLYMATIC DEALER AT NO COST.**

1. DO NOT OPERATE THIS MACHINE UNTIL IT HAS BEEN INSPECTED AND MADE READY FOR OPERATION BY AN AUTHORIZED HOLLYMATIC DEALER.
2. DO NOT OPERATE MACHINE WITHOUT ALL GUARDS IN PLACE.
3. UNPLUG MACHINE WHEN NOT IN USE.
4. ALWAYS UNPLUG THE MACHINE FROM ITS POWER SOURCE BEFORE REMOVING PANELS, CHANGING MOLD PLATE, CLEANING OR ADJUSTING THE MACHINE.
5. DO NOT OPERATE THE MACHINE IF THE CORD OR PLUG ARE DAMAGED.
6. KEEP HANDS AWAY FROM MOVING PARTS.
7. BE SURE ALL DOORS, GUARDS AND PANELS ARE IN PLACE BEFORE STARTING MACHINE. IT IS NECESSARY TO OPEN THE ACCESS DOOR COVERING THE DRIVE PULLEYS TO OBSERVE ROTATION (SEE DIAGRAMS PAGE 10).

**WARNING: DO NOT TOUCH MOVING PARTS WHEN ROTATION CHECK IS BEING MADE - CLOSE DOOR IMMEDIATELY.**

8. DO NOT REACH UNDER MOLD PLATE GUARD WHEN MACHINE IS RUNNING.
9. DO NOT REACH INTO HOPPER WHILE MACHINE IS RUNNING.
10. DO NOT ASSEMBLE OR RUN MACHINE WITH ANY DAMAGE (NICKS, BURRS, ETC.) TO MOLDING COMPONENTS.

# SAFETY LABEL PLACEMENT MODEL 8/65 PATTY MACHINE



# LABEL LIST

## MODEL 8/65 PATTY MACHINE

<u>ITEM</u>		<u>QUANTITY</u>	<u>PART NO.</u>
1	CAUTION-KEEP HANDS OUT OF HOPPER	4	900-0610
2	MULTI-FLOW	1	480-0813
3	DO NOT OPERATE WITHOUT GUARDS	2	900-0103
4	DO NOT OPERATE WITHOUT TRAY	1	900-0643
5	UNPLUG FROM POWER SOURCE BEFORE ADJUSTING, CLEANING OR OPENING	2	900-0609
6	CAUTION-KEEP HANDS FROM UNDER GUARDS	1	900-0621
7	NAMEPLATE	1	480-0649
8	KEEP HANDS AWAY FROM MOVING PARTS	2	900-0601
9	DO NOT OPEN DOORS OR PANELS WITHOUT UNPLUGGING MACHINE	3	900-0632
10	PRESS AS FOLLOWS (COUNTER)	1	518-0398
11	8/65 PATENT LABEL	1	480-0898
12	DO NOT OPERATE WITHOUT PAPER FEED OR INSERT IN POSITION	1	900-0629
13	KNOCK-OUT HEATER ON/OFF	1	480-0525
14	WARNING-PROPER ROTATION	1	900-1057
	FOR ROTO-FLOW (SEE PAGE 61)		

# LABELS

WARNING  
KEEP HANDS  
FROM UNDER GUARD  
DO NOT OPERATE WITHOUT GUARDS  
900-0621

KEEP HANDS AWAY  
FROM MOVING PARTS  
900-0601

UNPLUG FROM POWER  
SOURCE BEFORE  
ADJUSTING, CLEANING  
OR OPENING  
900-0609

WARNING  
DO NOT OPERATE  
WITHOUT GUARDS  
READ OPERATORS MANUAL  
BEFORE RUNNING MACHINE  
UNPLUG MACHINE BEFORE  
CLEANING OR ADJUSTING  
KEEP HANDS AWAY FROM  
MOVING PARTS  
900-0103

DO NOT OPERATE  
MACHINE WITHOUT PAPER FEED OR INSERT  
IN POSITION SEE OPERATORS MANUAL  
900-0629

DO NOT OPERATE  
WITHOUT TRAY  
900-0643

CHANGING COUNTER PRESET

1. PUSH "SEL" KEY TO PUT COUNTER INTO P1 INPUT MODE
2. PUSH "SEL" KEY TO MOVE FLASHING DIGIT TO THE DESIRED POSITION
3. PUSH "+" OR "-" KEY TO CHANGE DIGIT VALUE
4. REPEAT STEPS 2 AND 3 FOR EACH DIGIT UNTIL P1 IS SET FOR DESIRED NO. OF PATTIES
5. PUSH "ENT" KEY
6. PUSH "RUN/PGM" KEY
7. PUSH "RST/CLR" KEY TO CLEAR PREVIOUS COUNT

518-0398

OFF  
LOW HIGH  
KNOCKOUT HEATER  
480-0525

CAUTION  
KEEP HANDS  
OUT OF  
HOPPER  
900-0610



WARNING!  
TO AVOID SERIOUS DAMAGE  
TO THE MACHINE:  
-DO NOT CHECK ROTATION OR  
MANUALLY OPERATE MOTOR  
STARTER WITHOUT KNOCKOUT  
ARM BLOCKED IN FULL UPPER  
POSITION  
-DO NOT CHANGE WIRING ON  
PHASE MONITOR  
-DO NOT CHANGE MOTOR WIRING  
AT MOTOR STARTER  
ONLY CHANGE MACHINE  
ROTATION AT POWER  
CORD CONNECTION  
SEE MANUAL FOR CORRECT ROTATION  
900-1087

Hollymatic 8 / 65

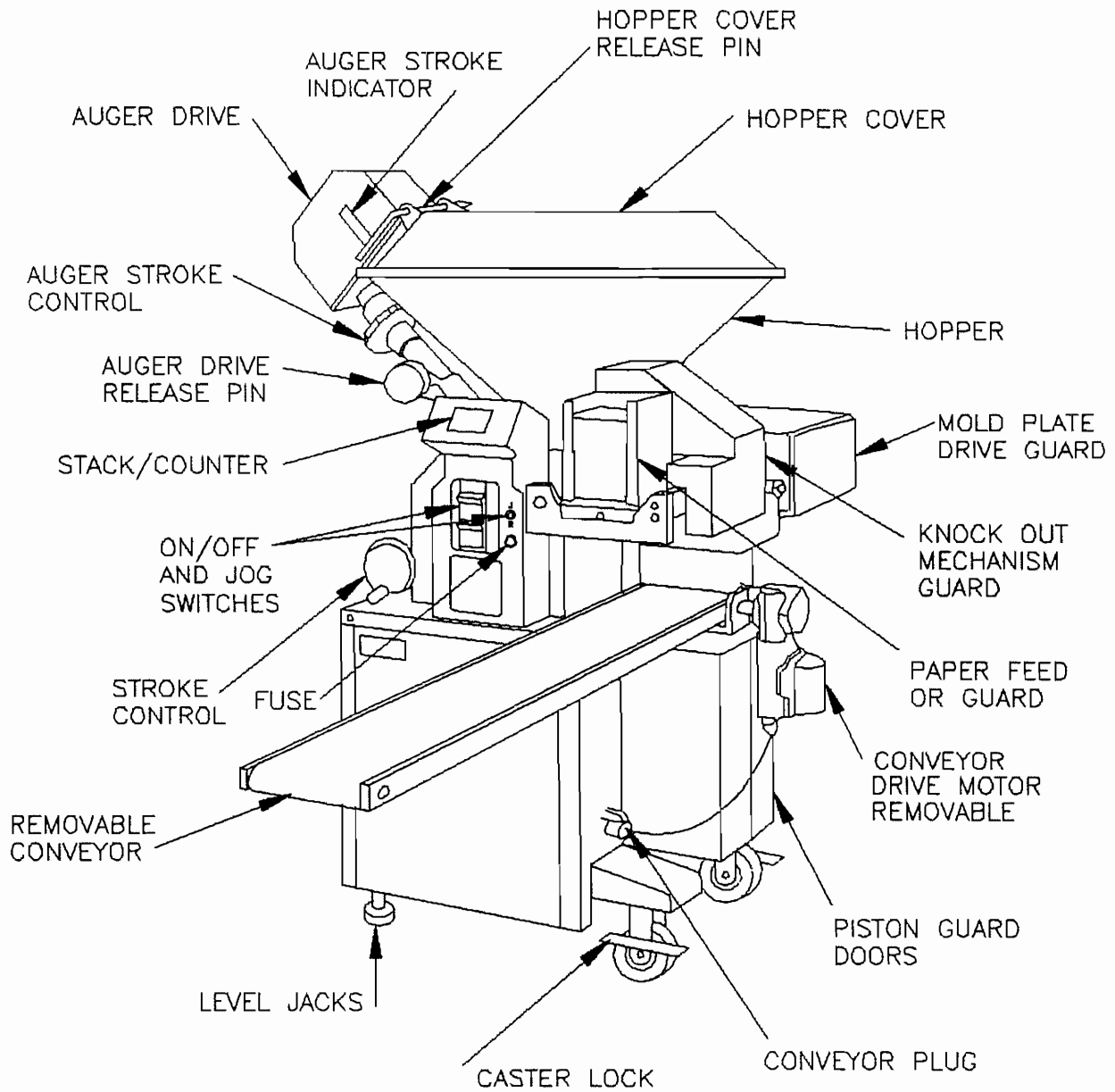
SERIAL NUMBER  
HOLLYMATIC CORP. COUNTRYSIDE, IL 60525

Hp  
Volts  
Ph  
Hz  
Amps

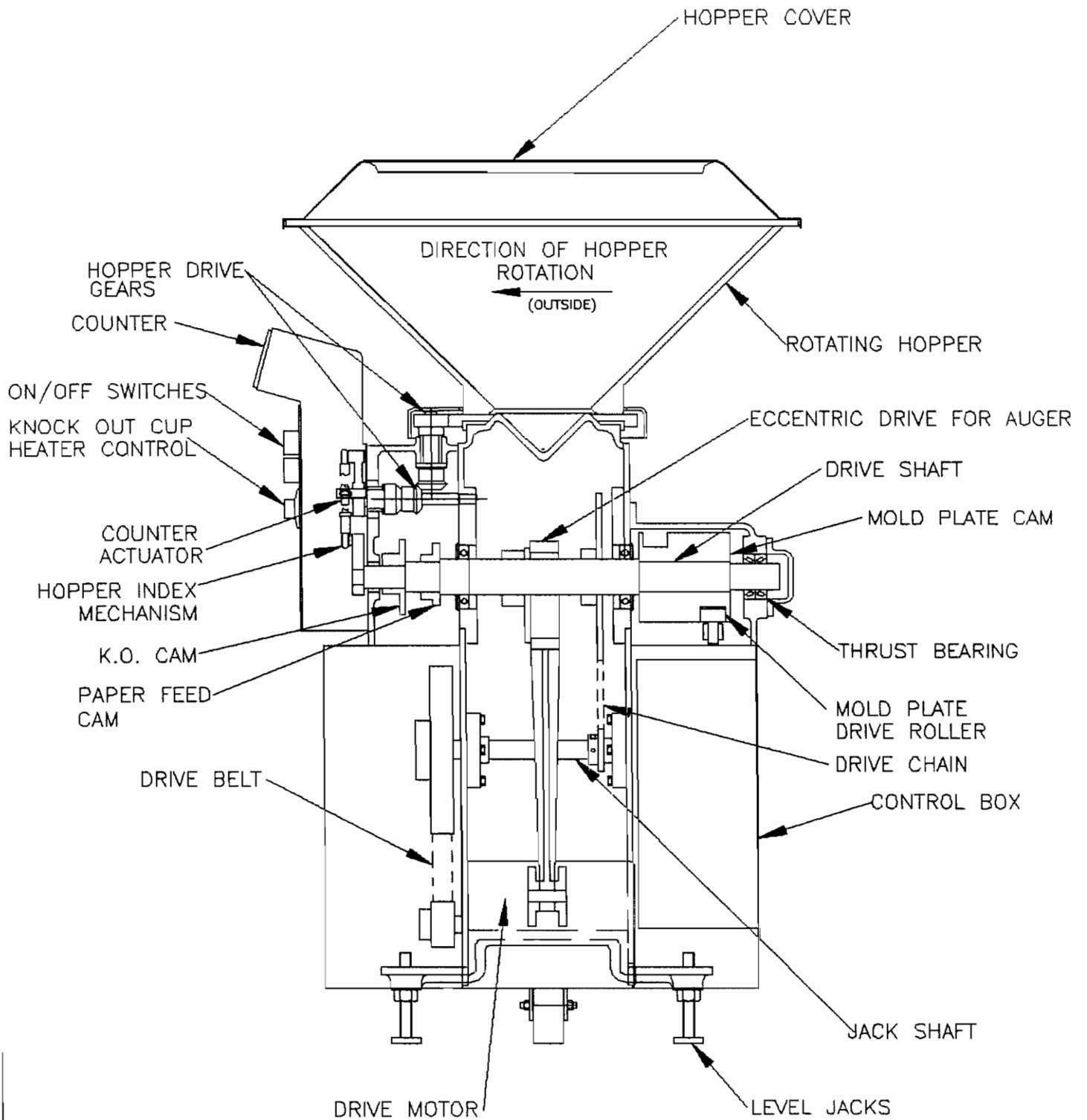
480-0849

DO NOT OPEN DOORS  
OR PANELS WITHOUT  
UNPLUGGING MACHINE  
900-0632

# PARTS LOCATION

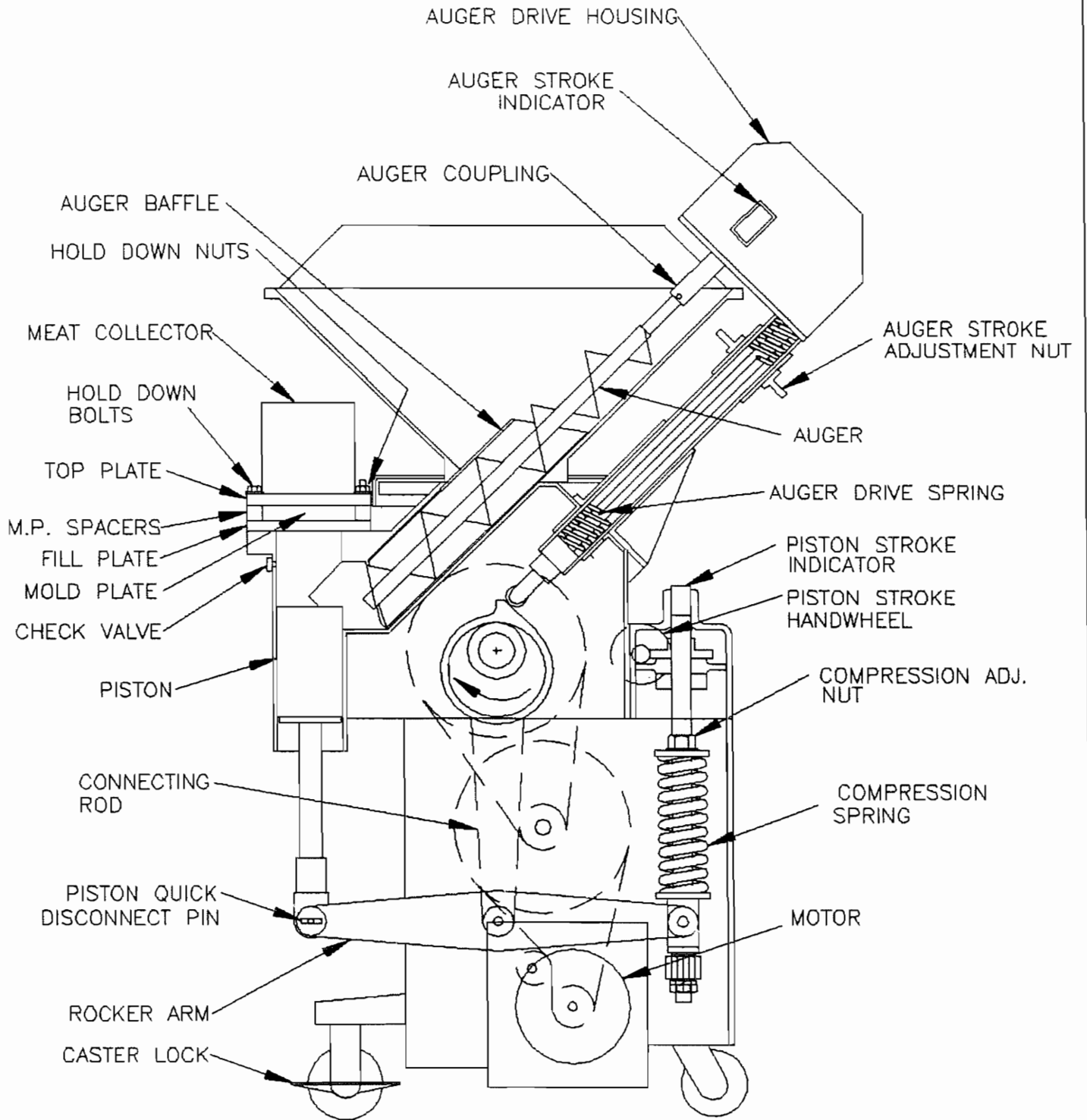


# PARTS LOCATION

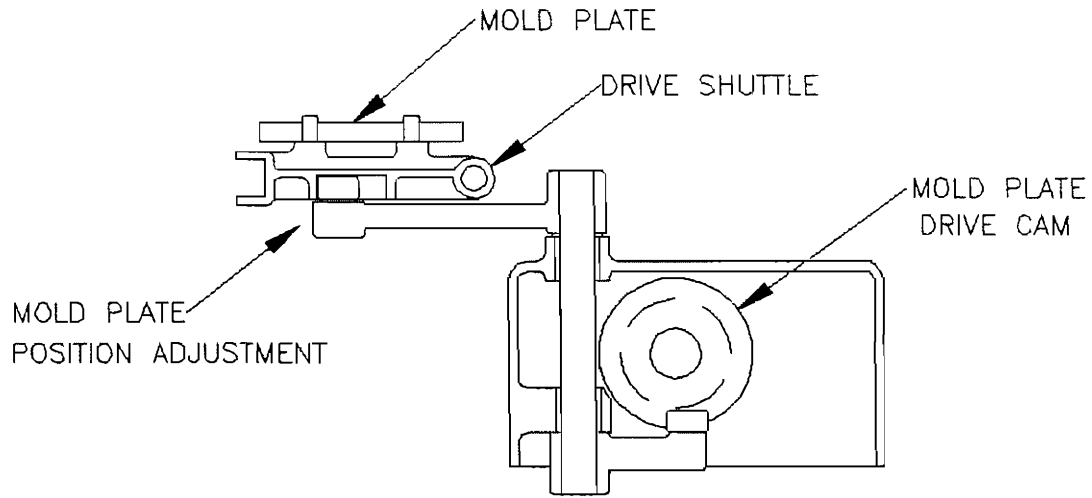




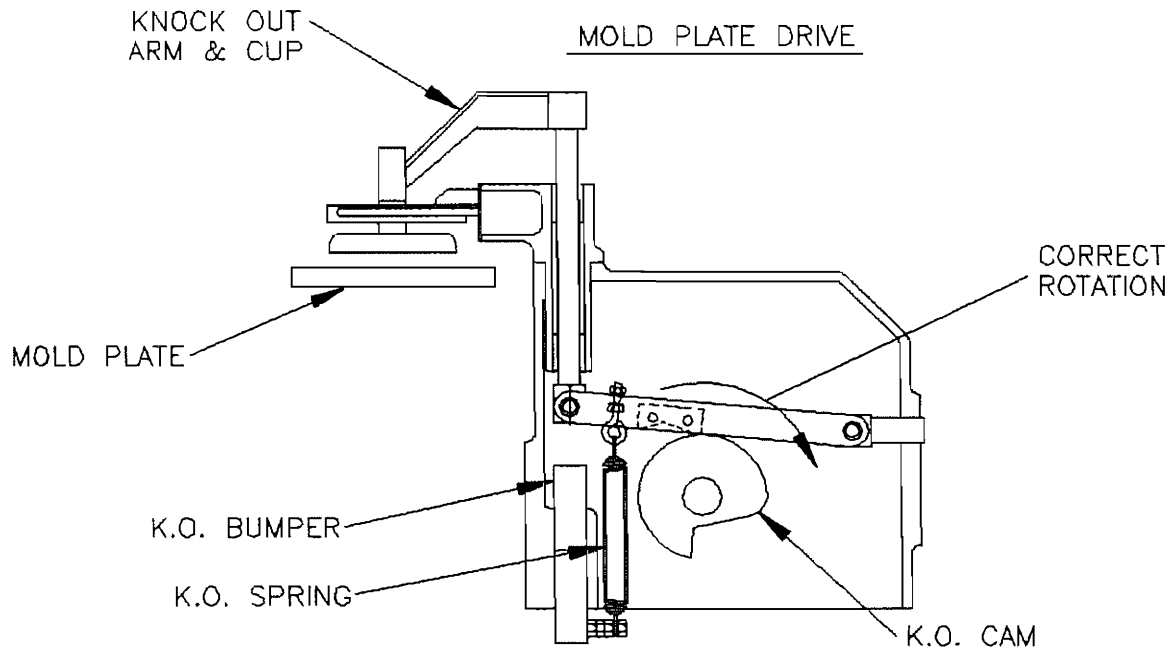
# PARTS LOCATION



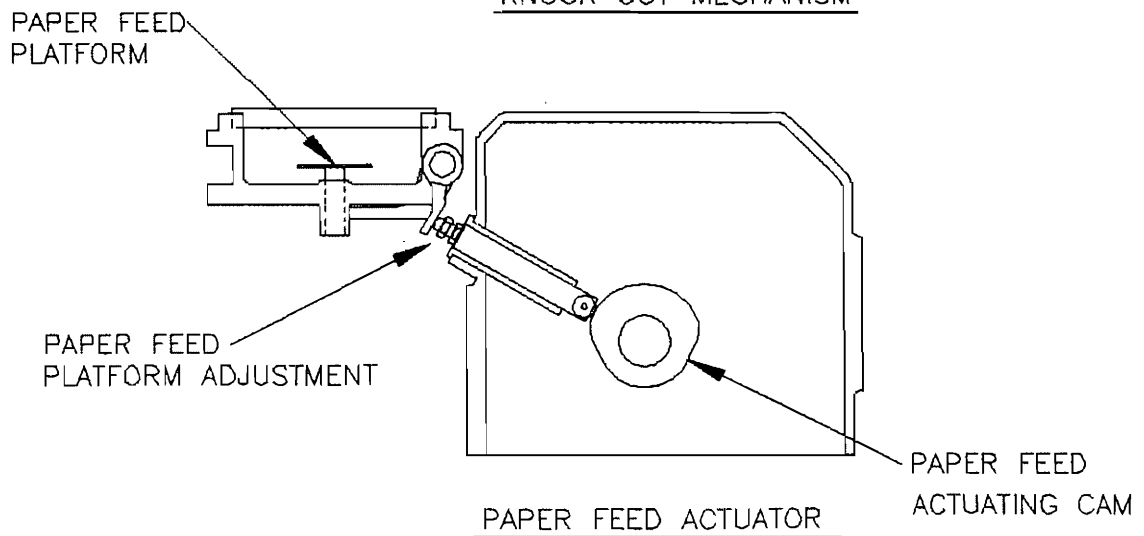
# PARTS LOCATION



MOLD PLATE DRIVE



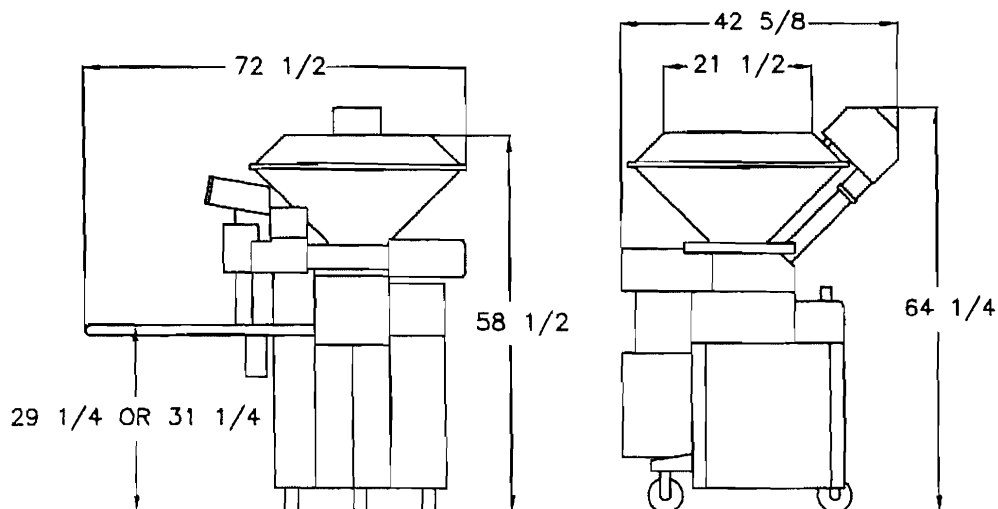
KNOCK OUT MECHANISM



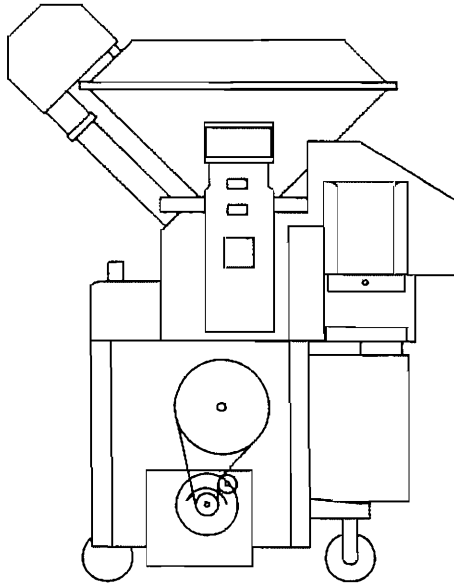
PAPER FEED ACTUATOR

# SPECIFICATIONS

STROKE RATE (SPEED)	3900 PER HOUR (65 STROKES PER MINUTE)	
HOPPER CAPACITY	APPROXIMATELY 200 LBS.	
PATTY THICKNESS RANGE	(MAXIMUM) 1 INCH (MINIMUM) 3/16 INCH	
MAXIMUM PATTY DIAMETERS	4 1/2 INCH PAPER FEED	= 4 1/8 INCH
	5 INCH PAPER FEED	= 4 5/8 INCH
	5 1/2 INCH PAPER FEED	= 5 1/8 INCH
	6 INCH PAPER FEED	= 5 5/8 INCH
	W/O PAPER ROTO-FLOW	= 5 1/2 INCH
	ULTIMATE	= 5 1/2 INCH
	MULTI-FLOW	= 5 1/2 INCH
	STRAIGHT SLOT	= 6 INCH
STACKER COUNTER (SOLID STATE)	ADJUSTABLE STACK HEIGHT AND CONTINUOUS RUN (MAXIMUM STACKING HEIGHT 5 1/2 INCHES)	
TAKE AWAY CONVEYOR	4 FT. LONG X 6 INCH WIDE NEOPRENE OR WIRE MESH	
STANDARD MOTORS (2 HP)	200V	- 60 HZ - 3 PHASE
	230/460V	- 60 HZ - 3 PHASE
	575V	- 60 HZ - 3 PHASE
	220/380V	- 50 HZ - 3 PHASE
ROTO-FLOW MOTOR (1/2 HP)	208/230/460V - 60 HZ - 3 PHASE	
MOLD PLATE MATERIAL	3/16 TO 1/4 (METAL - NI-RESIST)	
	OVER 1/4 (PLASTIC - ACETAL)	
PATTY WEIGHT RANGE	8 OZ (MAXIMUM) 1 OZ (MINIMUM)	
AUTOMATIC PAPER FEED (SIDE NOTCHED)	4-1/2 INCH, 5 INCH, 5-1/2 INCH, & 6 INCH (SQ.)	
	4-1/2 INCH (OCTAGONAL)	
MACHINE WEIGHT	950 LBS.	
ATTACHMENTS	MEATBALL FORMER SKINLESS SAUSAGE FILL SYSTEM	



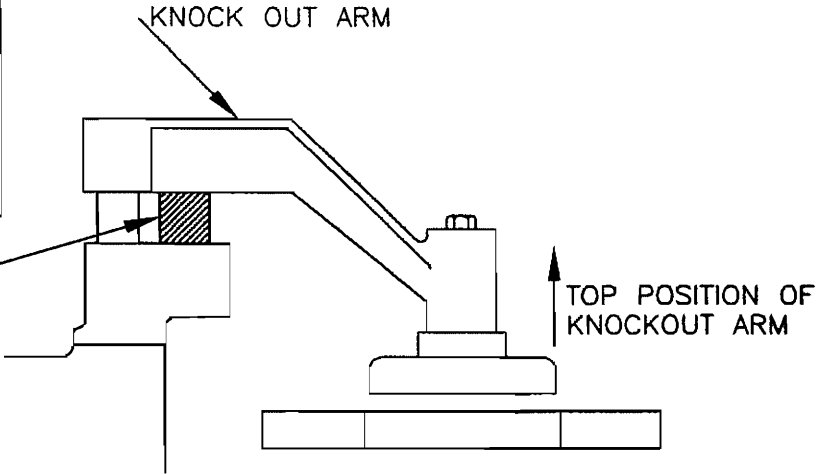
# ROTATION



**WARNING!**  
 TO AVOID SERIOUS DAMAGE TO THE MACHINE:  
 -DO NOT CHECK ROTATION OR MANUALLY OPERATE MOTOR STARTER WITHOUT KNOCKOUT ARM BLOCKED IN FULL UPPER POSITION  
 -DO NOT CHANGE WIRING ON PHASE MONITOR  
 -DO NOT CHANGE MOTOR WIRING AT MOTOR STARTER  
 ONLY CHANGE MACHINE ROTATION AT POWER CORD CONNECTION  
 SEE MANUAL FOR CORRECT ROTATION  
 900-1057 T

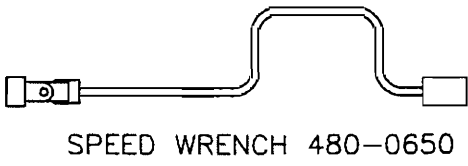
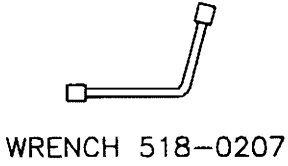
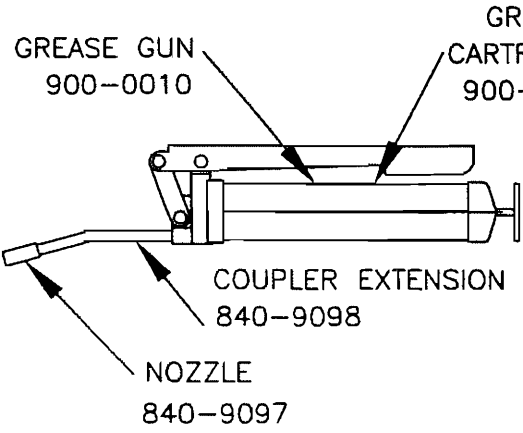
COUNTER CLOCKWISE  
 ROTATION OF MOTOR  
 CAUTION: ROTATION CANNOT BE CHECKED BY HOPPER ROTATION

WOOD BLOCK (REMOVE AFTER PROPER PULLEY ROTATION IS ESTABLISHED)



CAUTION: FAILURE TO BLOCK UP KNOCK OUT ARM MAY RESULT IN SERIOUS DAMAGE TO THE MACHINE

# TOOLS

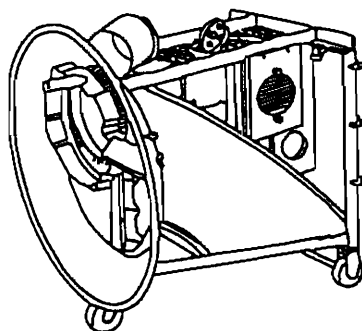


# WASHRACK

THE WASHRACK RECOMMENDED FOR EACH MACHINE GIVES YOU A PLACE TO STORE COMPONENTS AFTER WASH UP. PLACE PARTS AS SHOWN AND AVOID ROUGH HANDLING WHICH WILL CAUSE NICKS AND BURRS.

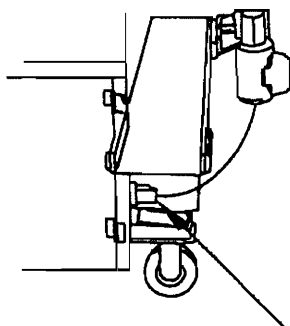
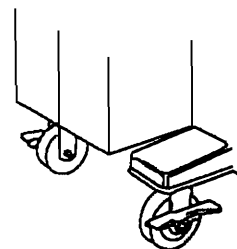
REPLACEMENT PARTS 480-0800 INCLUDES:

SWIVEL CASTER	879-1925
LOCKWASHER	759000591
NUT	749005193
RIGID CASTER	500-0760
CASTER SHAFT	879-1905
HANDLE-RUBBER	879-1924
SCREEN	879-1903



## PREOPERATION

1. ROLL MACHINE TO DESIRED POSITION AND LOCK TWO NON-SWIVEL CASTERS. (STABILIZING JACKS MOVED UP TO CLEAR FLOOR).



CONVEYOR MOTOR PLUG

2. POSITION CONVEYOR AT DESIRED HEIGHT. TOP BOLTS WILL ALLOW A 3 1/2 INCH HIGH STACK AND THE BOTTOM BOLTS WILL ALLOW A 5 1/2 INCH HIGH STACK.

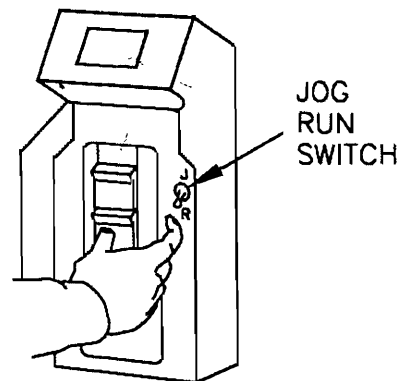
3. BEFORE RUNNING THE 8/65 THE FIRST TIME, MAKE SURE THERE ARE NO LOOSE PARTS INSIDE THE HOPPER OR COMPRESSION AREA. RATED VOLTAGE OF THE UNIT (SEE NAMEPLATE) MUST BE IDENTICAL WITH NOMINAL SUPPLY VOLTAGE.

4. PLUG IN CONVEYOR MOTOR.

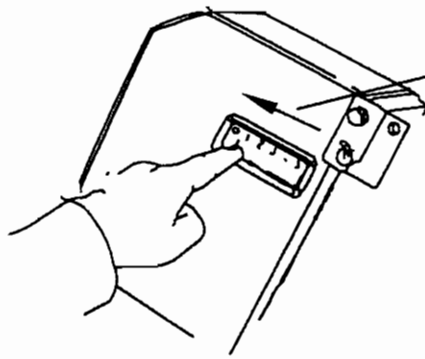
## DISASSEMBLY

1. WHEN DISASSEMBLING THE MACHINE, IT IS NECESSARY TO "JOG" IT UNDER POWER TO DIFFERENT POINTS IN ITS CYCLE. JOGGING IS DONE BY MOVING THE SWITCH UP TO "J". THEN, MOMENTARILY PRESS THE START BUTTON UNTIL THE MACHINE STOPS AT DESIRED POSITION. TO RUN THE MACHINE, MOVE THE SWITCH DOWN TO "R".

**CAUTION:** WHEN OPERATING THE MACHINE UNDER POWER ALWAYS CHECK TO SEE THAT OTHER PERSONNEL, AS WELL AS YOURSELF, ARE CLEAR OF MOVING PARTS.



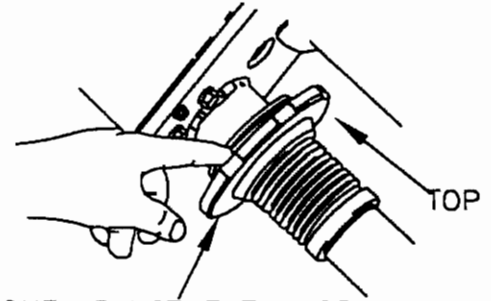
# DISASSEMBLY



FULLY RETRACTED POSITION

2. JOG THE MACHINE TO MOVE THE AUGER TO THE FULLY RETRACTED POSITION (WATCH STROKE INDICATOR WHEN JOGGING UNTIL IT IS IN ITS TOP POSITION). WHILE JOGGING MOVE THE AUGER STROKE AND ADJUSTMENT KNOB TO ITS TOP POSITION.

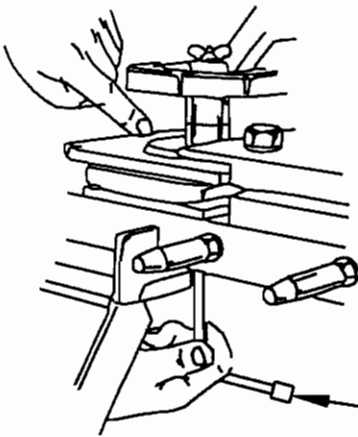
3. MOVING THE STROKE ADJUSTMENT KNOB TO THE TOP POSITION WILL PERMIT STOPPING THE KNOCK OUT CUP TO A DESIRED POSITION DURING ADJUSTMENT, OR MAINTAIN IT ABOVE THE MOLD PLATE DURING DISASSEMBLY AND ASSEMBLY.



STROKE ADJUSTMENT KNOB

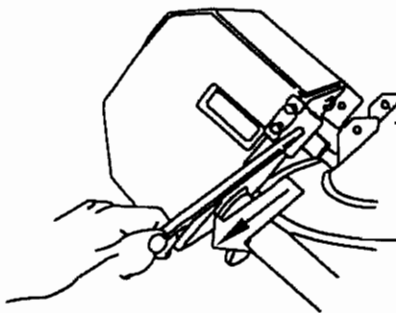
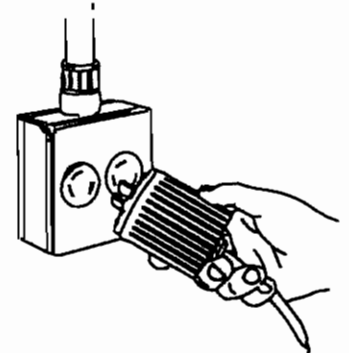
4. JOG THE MACHINE TO WHERE THE KNOCK OUT CUP DROPS THROUGH THE MOLD PLATE AND MOVES UPWARD SLIGHTLY SO THAT THE CUP BOTTOM EDGE IS ABOVE THE TOP SURFACE OF THE MOLD PLATE.

DISCONNECT THE POWER SUPPLY CORD FROM THE POWER SOURCE. OPEN THE KNOCK OUT ARM GUARD AND REMOVE THE KNOCK OUT CUP USING THE WRENCH (P/N 518-0207). HOLD WING NUT WITH HAND WHILE LOOSENING THE KNOCK OUT CUP BOLT.



WRENCH 518-0207

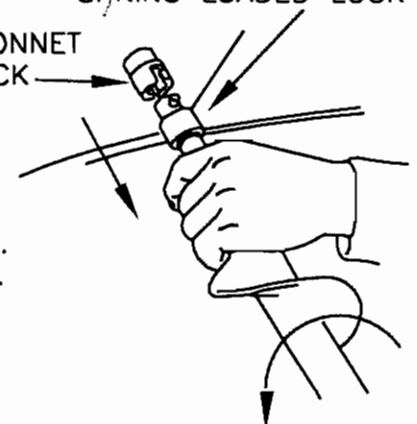
5. DISCONNECT THE MACHINE FROM THE POWER SOURCE.



SLIDE HOPPER TOP FORWARD

6. REMOVE THE HOPPER RELEASE PIN AND REMOVE THE HOPPER TOP BY LIFTING AND SLIDING IT FORWARD.

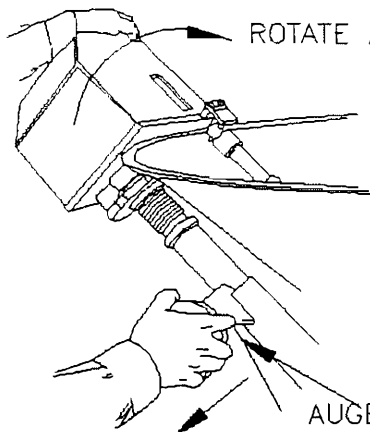
SPRING LOADED LOCK  
BAYONNET LOCK



7. DISCONNECT THE AUGER BY MOVING THE SPRING LOADED LOCK DOWN AND ROTATE TO RELEASE ITS BAYONNET TYPE LOCK. THEN PUSH THE AUGER DOWNWARD TO CLEAR THE DRIVE SHAFT. (NOTE: PRODUCT IN HOPPER SHOULD BE CYCLED OUT OF THE MACHINE TO RELIEVE THE PRESSURE ON THE AUGER).

# DISASSEMBLY

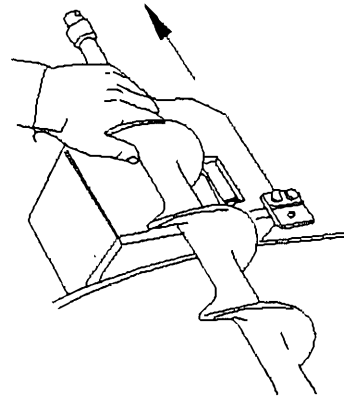
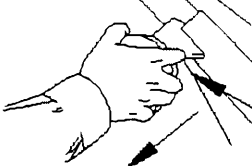
ROTATE AUGER DRIVE



8. PULL THE AUGER RELEASE PIN OUT, ROTATE THE AUGER DRIVE HOUSING APPROXIMATELY 90 DEGREES TO REMOVE THE AUGER.

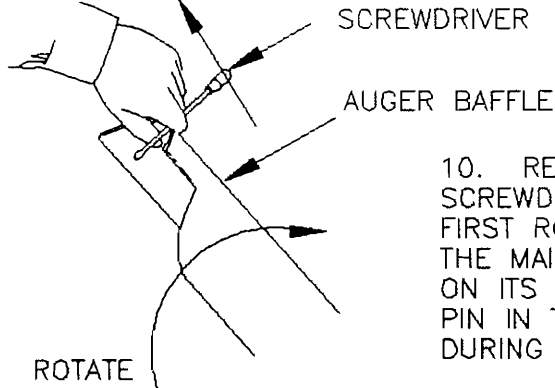
AUGER DRIVE MUST BE IN ITS TOP POSITION ("0" POSITION ON INDICATOR) IN ORDER FOR AUGER DRIVE SHAFT TO CLEAR EDGE OF HOPPER.

PULL OUT PIN  
AUGER RELEASE PIN



9. REMOVE THE AUGER.

PULL OUT  
BAFFLE

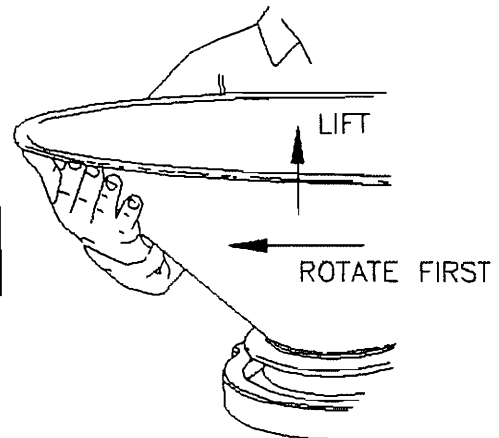


ROTATE  
FIRST

10. REMOVE THE AUGER BAFFLE BY INSERTING THE SCREWDRIVER SHAFT IN THE HOLE PROVIDED. FIRST ROTATE AND THEN PULL THE BAFFLE OUT OF THE MAIN FRAME. NOTICE THAT THE BAFFLE IS SLOTTED ON ITS TOP SIDE. THIS SLOT MUST BE ALIGNED WITH A PIN IN THE MAIN FRAME WHEN THE BAFFLE IS POSITIONED DURING ASSEMBLY.

11. ROTATE THE LOWER HOPPER IN THE DIRECTION OF ITS NORMAL ROTATION UNTIL IT STOPS AND THEN LIFT OFF.

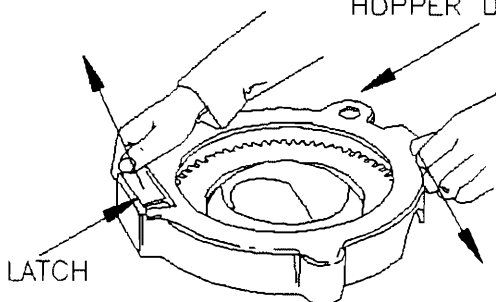
**CAUTION:** THE HOPPER IS HEAVY (19 LBS.) TAKE CARE WHEN MOVING IT TO THE WASHRACK.



HOPPER DRIVE GEAR COVER

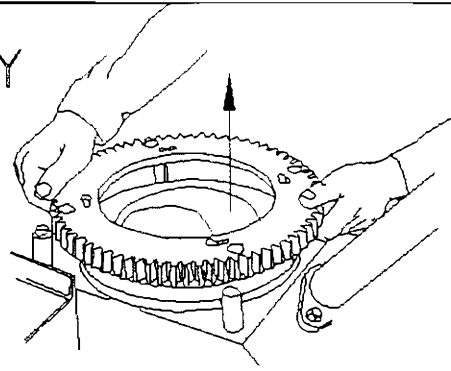
12. REMOVE THE HOPPER DRIVE GEAR COVER BY DISENGAGING LATCHES.

**CAUTION:** THE HOPPER DRIVE GEAR COVER MUST BE IN POSITION WHEN MACHINE IS IN OPERATION. DAMAGE TO THE MACHINE OR INJURY COULD OCCUR IF IT IS NOT IN PLACE.



# DISASSEMBLY

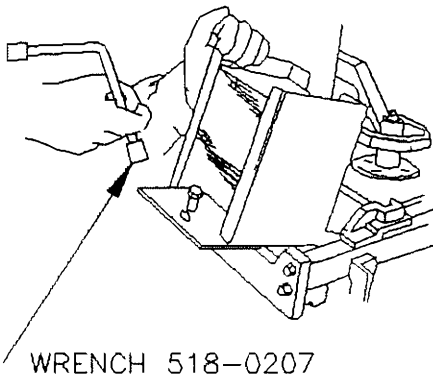
13. REMOVE THE HOPPER DRIVE GEAR.



14. REMOVE THE PAPER FEED BASKET.

**CAUTION:** CARE SHOULD BE TAKEN WHEN REMOVING OR REPLACING THE PAPER FEED BASKET TO PREVENT BENDING OF THE SHEET METAL PARTS.

MOLD PLATE SHOULD BE IN THE KNOCK OUT POSITION FOR EASE OF BASKET REMOVAL.

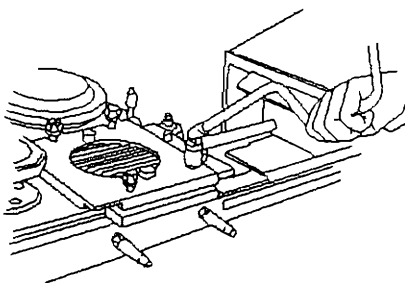
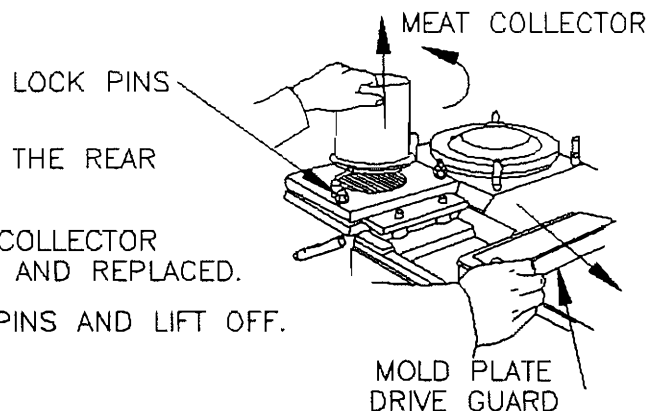


WRENCH 518-0207

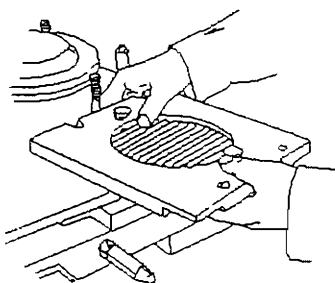
15. SLIDE THE MOLD PLATE DRIVE GUARD TO THE REAR AND REMOVE THE MEAT COLLECTOR.

THE "O" RING ON THE BOTTOM OF THE MEAT COLLECTOR CONTAINER CAN EASILY BE REMOVED, CLEANED AND REPLACED.

ROTATE THE COLLECTOR TO CLEAR THE LOCK PINS AND LIFT OFF.



17. REMOVE TOP PLATE.

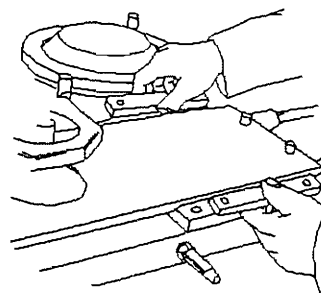


16. LOOSEN THE HOLD-DOWN NUTS AND BOLTS WHICH SECURE THE MOLD PLATE ASSEMBLY. (USE THE SPECIAL WRENCH, P/N 480-0650, WITH UNIVERSAL JOINT SUPPLIED WITH THE MACHINE).

NOTE: DURING THE MOLD PLATE CHANGE, THE NUTS CAN BE LEFT ON IF THE SPACERS ARE THE SAME THICKNESS AS THE NEW PLATE PUT ON THE MACHINE.

MOLD PLATE SPACERS MUST MATCH THE MOLD PLATE.

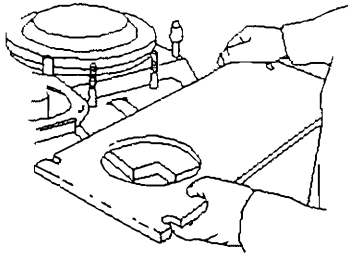
18. REMOVE TWO MOLD PLATE SPACERS.



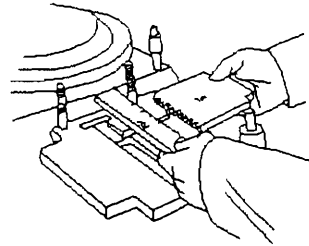


# DISASSEMBLY

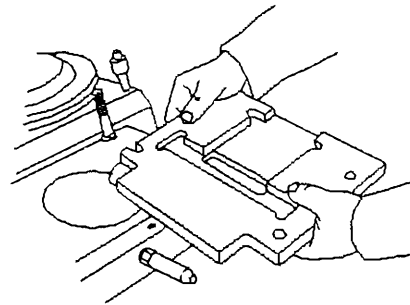
19. REMOVE MOLD PLATE.



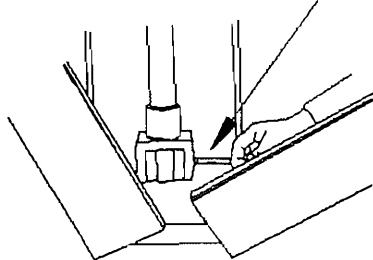
20. REMOVE FILL SYSTEM.



21. MULTI FLOW SYSTEM IS SHOWN, OTHER OPTIONS INCLUDING ROTO-FLOW, ULTIMATE, SAUSAGE ATTACHMENT AND STRAIGHT SLOTS ARE ILLUSTRATED IN DETAIL (SEE INDEX).



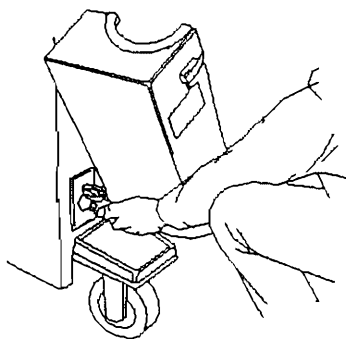
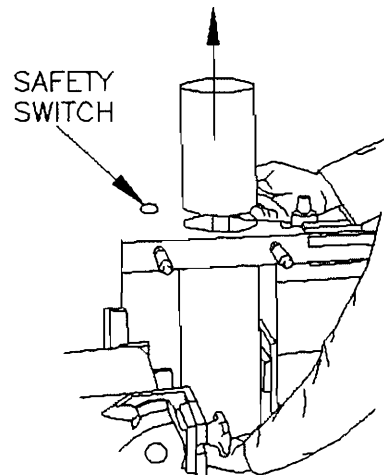
PISTON DISCONNECT PIN



22. OPEN THE PISTON GUARD DOORS AND REMOVE THE PISTON DISCONNECT PIN. THE BUTTON ON THE END OF THE PIN MUST BE DEPRESSED TO RELEASE.

23. REMOVE THE PISTON THROUGH THE TOP OF THE CYLINDER.

**WARNING:** DO NOT LEAVE METAL PARTS OVER THE PROXIMITY SAFETY SWITCH THAT DETECTS THAT THE FILL PLATE HAS BEEN REMOVED.

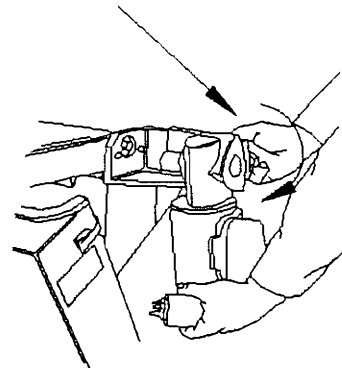


24. UNPLUG THE CONVEYOR MOTOR.

# DISASSEMBLY

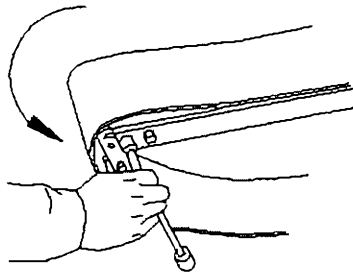
LOOSEN KNOB TO  
REMOVE CONVEYOR MOTOR

25. REMOVE THE CONVEYOR MOTOR.  
(MOTOR SHOULD BE STORED IN A DRY  
AREA TO PREVENT MOISTURE DAMAGE).



**CAUTION:** WHEN REASSEMBLING THE MOTOR  
BE SURE THAT THE COUPLING IS ENGAGED TO  
THE CONVEYOR DRIVE SHAFT. THE CONVEYOR  
SHAFT CAN BE ROTATED BY MOVING THE BELT  
IF IT IS NECESSARY TO ALIGN THE COUPLING.

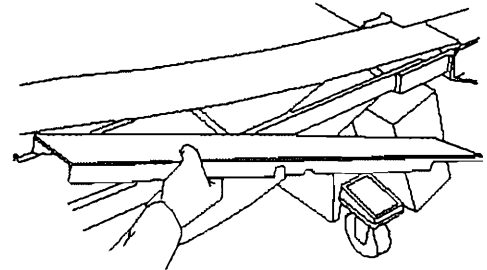
SWING END DOWN  
TO LOOSEN BELT



26. RELEASE THE CONVEYOR BELT  
WITH 518-0207 WRENCH.

27. REMOVE THE CONVEYOR SUPPORT.

**CAUTION:** BEFORE REASSEMBLY OF THE CONVEYOR  
SUPPORT, REMOVE EXCESS MOISTURE FROM THE INSIDE  
SURFACE OF THE BELT AS WELL AS THE CONVEYOR  
SUPPORT. IF THESE SURFACES ARE TOO WET, THERE  
WILL BE A TENDENCY OF THE BELT DRIVE PULLEY TO  
SLIP RELATIVE TO THE BELT.



# CLEANING

CLEAN THE MACHINE BY WASHING DOWN WITH DETERGENT AND HOT WATER.

WITH CONVEYOR BELT TENSION RELEASED, BE SURE TO CLEAN UNDERSIDE OF BELT AND ROLLERS.

LEAVE CONVEYOR BELT LOOSE AND REMOVE CONVEYOR BED PLATE OVERNIGHT TO INSURE PROPER DRYING. DRY THE UNDERSIDE OF THE CONVEYOR BELT BEFORE START UP TO AVOID EXCESS DRAG.

THE HOLLYMATIC 865 FEATURES A HOSE PROOF ELECTRICAL SYSTEM. HOWEVER, IT IS NOT A GOOD PRACTICE TO SPRAY WATER DIRECTLY ON THE MOTORS OR ELECTRICAL BOX TO MINIMIZE MOISTURE PROBLEMS.

COVER THE ELECTRICAL POWER CORD PLUG AND STACK COUNTER WITH A PLASTIC BAG BEFORE CLEANING TO ASSIST IN PROTECTING FROM MOISTURE.

ALL REMOVED PARTS MAY BE CLEANED IN A SINK OR HOSED WITH DETERGENT AND HOT WATER ON THE WASHRACK. PARTS SHOULD ALWAYS BE STORED ON THE OPTIONAL WASHRACK TO PREVENT BEING MISPLACED OR DAMAGED. FOR THE ARRANGEMENT OF LOOSE PARTS ON THE WASHRACK, SEE WASHRACK ON PAGE 11.

**IMPORTANT:** THE PARTS USED FOR THE VARIOUS FILL SYSTEMS SHOULD BE TREATED WITH CARE. THESE PARTS SHOULD BE DRIED AND COATED WITH MINERAL OIL. CARE SHOULD BE TAKEN TO AVOID NICKS AND BURRS. ALSO, BEFORE REASSEMBLY, REFER TO LUBRICATION INSTRUCTIONS AND FOLLOW CAREFULLY.

**CAUTION:** DO NOT CLEAN OUT THE MAIN FRAME MEAT FLOW AREA UNTIL THE PISTON IS REMOVED AND THE MACHINE UNPLUGGED FROM THE POWER SOURCE. DO NOT SPRAY WATER ON A HEATED KNOCK-OUT CUP HEATER.

# ASSEMBLY

REVERSE THE PROCEDURE LISTED FOR DISASSEMBLY WITH THE FOLLOWING PRECAUTIONS:

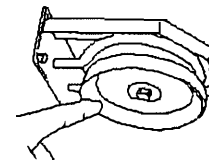
1. IT IS IMPORTANT THAT THE PARTS IN THE MOLD PLATE AREA; IE, TOP PLATE, FILL PLATE, SPACERS AND MOLD PLATE, BE FREE OF NICKS AND BURRS. PARTS SHOULD BE FILED SMOOTH, IF NECESSARY, TO INSURE FREE OPERATION AND MINIMUM PRODUCT LEAKAGE.
2. MAKE SURE THE PROPER MOLD SPACERS ARE USED WITH THE MOLD PLATE SET UP ON THE MACHINE. SPACERS TOO THIN WILL CAUSE BINDING OF THE MOLD PLATE AND POSSIBLE DAMAGE TO THE MACHINE. SPACERS TOO THICK WILL CAUSE EXCESSIVE LEAKAGE.
3. WHEN REPLACING THE CONVEYOR MOTOR, MAKE SURE THAT THE COUPLING ENGAGES THE CONVEYOR SHAFT SLOT TO GET PROPER ENGAGEMENT.
4. WHEN POSITIONING A MOLD PLATE IN THE MACHINE, MAKE SURE THAT IT IS PROPERLY ENGAGED AT BOTH ENDS. FAILURE TO DO THIS WILL RESULT IN DAMAGE TO THE MACHINE. ALSO, LUBRICATE PLATES TOP AND BOTTOM WITH HOLLY OIL.
5. IT IS NOT NECESSARY TO EXCESSIVELY TIGHTEN THE HOLD-DOWN BOLTS AND NUTS.
6. DO NOT INSTALL THE PAPER FEED BASKET UNTIL THE MACHINE IS CYCLED WITH MEAT AND ADJUSTED TO FORM FULL PORTIONS.
7. WHEN REPLACING THE AUGER, MAKE SURE IT IS ROTATED TO ITS "LOCK" POSITION BEFORE OPERATING THE MACHINE.
8. WHEN SELECTING THE KNOCK-OUT CUP FOR THE MOLD PLATE, MAKE SURE THAT YOU HAVE THE PROPER SIZE. BOTH ARE WELL MARKED.

IN ORDER TO JOG THE MACHINE TO STOP IN THE "KNOCK-OUT" POSITION IT IS NECESSARY TO FIRST MOVE THE AUGER STROKE TO THE FULLY RETRACTED POSITION. FOLLOW STEPS 2 AND 3 OF DISASSEMBLY ON PAGE 12.

CAUTION: WHEN REPLACING THE KNOCK OUT CUP, DISCONNECT THE MACHINE FROM THE POWER SOURCE.

SEE PAGE 60 FOR THE PROCEDURE TO SET UP SELF-ALIGNING KNOCK-OUT CUPS. ALWAYS USE A METAL VALVE (518-0529) TO GET THE BEST "STACKING" OF PATTIES. VALVE SHOULD BE REPLACED IF DAMAGED.

BOTTOM EDGE OF CUP SHOULD BE LEVEL WITH THE PLATE. A DISTORTED CUP WILL RESULT IN POOR STACKING.

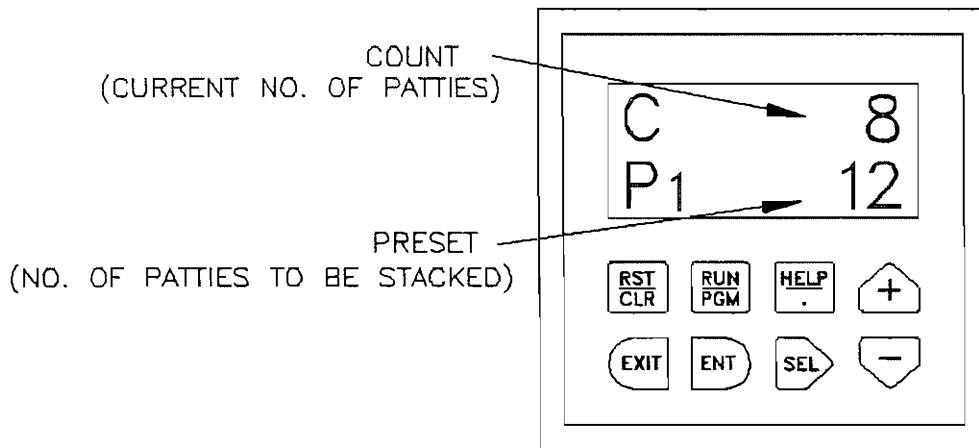


9. BEFORE STARTING THE MACHINE FOR NORMAL OPERATION, "JOG" IT CAREFULLY TO CHECK KNOCK-OUT CUP ALIGNMENT WITH THE PLATE. STARTING THE MACHINE WITH A MISALIGNED CUP WILL CAUSE DAMAGE.
10. AS A SAFETY/PRECAUTIONARY MEASURE, ALWAYS INSTALL THE MEAT COLLECTOR TRAY OVER THE TWO PINS ON THE RIGHT SIDE OF THE MACHINE. FIRST, IT SERVES AS A MEAT COLLECTOR; AND SECOND, IT BLOCKS ANYONE FROM ACCIDENTALLY REACHING MOVING PARTS.










# COUNTER ADJUSTMENTS

THE 8/65 MACHINE PATTY TAKE-AWAY CONVEYOR IS CONTROLLED BY A MOTOR COUPLED TO AN ELECTRONIC COUNTER. THE COUNTER WHICH IS LOCATED IN FRONT OF THE MACHINE HAS BEEN PROGRAMMED AT THE FACTORY TO INDEX THE TAKE-AWAY CONVEYOR THE PROPER DISTANCE BETWEEN STACKS (APPROXIMATELY 6 3/8 INCH MOVEMENT).




















TO ENTER THE NUMBER OF PATTIES DESIRED IN THE STACK, USE THE INSTRUCTION TAG ABOVE THE COUNTER WHICH READS AS FOLLOWS:

1. PUSH  KEY. (DISPLAY WILL CHANGE AS SHOWN)
2. PUSH  KEY UNTIL THE BLINKING LIGHT ARRIVES AT THE DIGIT YOU WANT TO CHANGE.
3. PUSH THE  OR  KEY TO SET THE DIGIT VALUE.
4. REPEAT STEPS 2 AND 3 UNTIL THE DIGIT VALUE IS OBTAINED.
5. PUSH  KEY.
6. PUSH  KEY.
7. PUSH  TO RESET COUNT TO ZERO

## CHANGING BELT TRAVEL DISTANCE

IF IT IS NECESSARY TO CHANGE THE BELT TRAVEL DISTANCE FOR ANY REASON, THE COUNTER WOULD HAVE TO BE PROGRAMMED TO CHANGE THE TIME THE CONVEYOR MOTOR IS ON BETWEEN STACKS (.80 SECONDS FACTORY SETTING). THIS IS DONE AS FOLLOWS:

THIS PROCEDURE SHOULD BE DONE BY AN AUTHORIZED HOLLYMATIC DEALER OR A QUALIFIED ELECTRICIAN

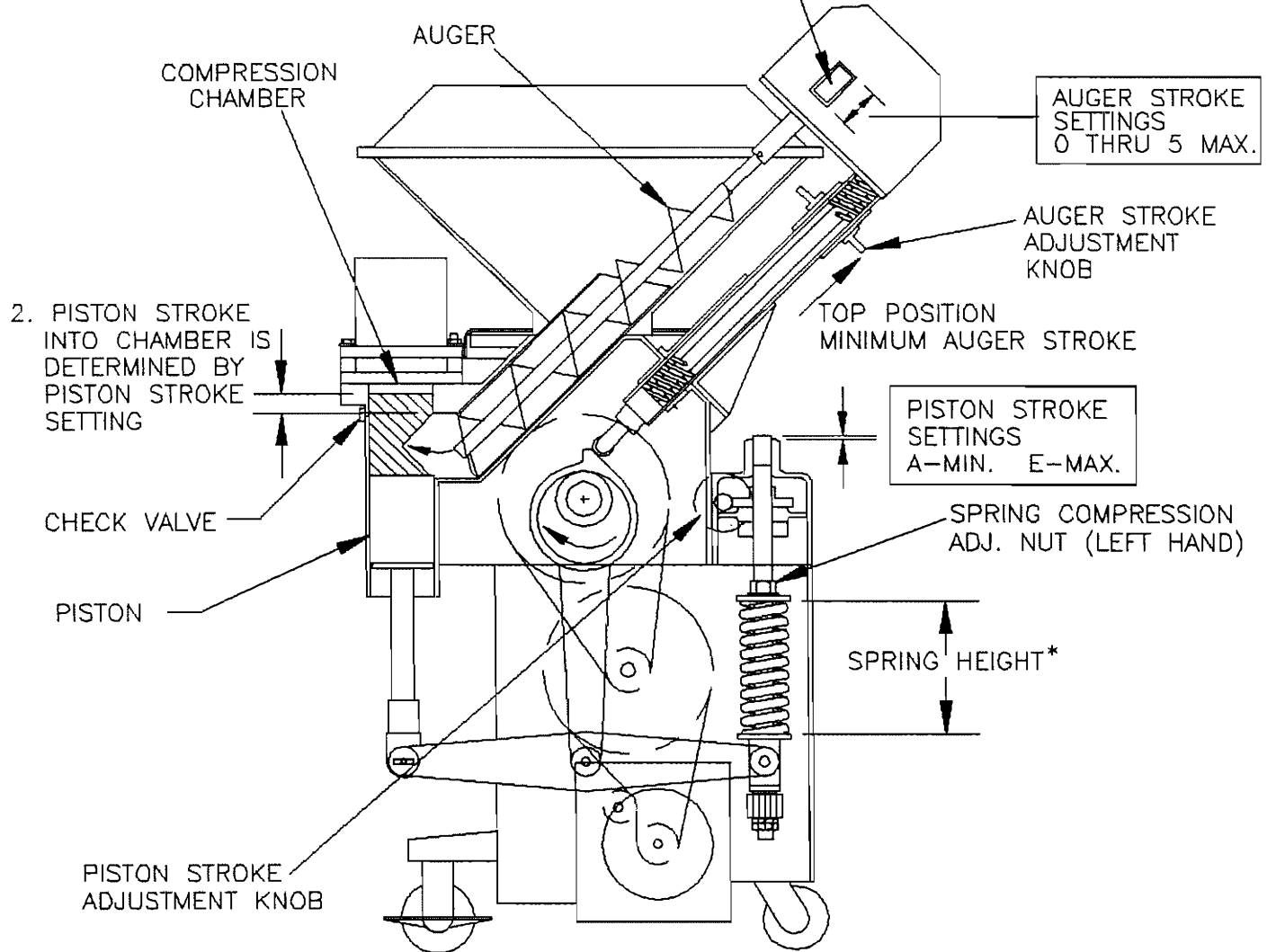
1. REMOVE JUMPER FROM TERMINAL 15.
2. PUSH  KEY, DISPLAY READS "CAUTION PROGRAM MODE".
3. PUSH  KEY WITHIN 5 SECONDS OF PUSHING  KEY, DISPLAY WILL READ "PROGRAM SCALERS".
4. PUSH  KEY THREE TIMES UNTIL DISPLAY READS "PROGRAM MODE OUT".
5. PUSH  KEY, DISPLAY WILL READ "RELAY 1 PROGRAM".
6. PUSH  KEY, DISPLAY WILL READ "TRANS 1 PROGRAM"
7. PUSH  KEY, DISPLAY WILL READ "TRANS 1 NORMAL"
8. PUSH  KEY, DISPLAY WILL READ "TRANS 1 PULSED"
9. PUSH  KEY, DISPLAY WILL READ "TRANS 1 PULSED" & WILL FLASH.
10. PUSH  KEY, DISPLAY WILL STOP FLASHING.
11. PUSH  KEY, DISPLAY WILL READ "TRANS 1 PUL .80" (FACTORY SETTING).
12. PUSH  KEY AND THE FIRST DIGIT WILL FLASH.
13. PUSH  KEY UNTIL YOU REACH THE DIGIT WHOSE VALUE YOU WANT TO CHANGE - DIGIT WILL FLASH.
14. PUSH  OR  KEY TO SET THE NEW DIGIT VALUE.
15. REPEAT STEP 14 UNTIL DESIRED TIME VALUE IS REACHED.
16. PUSH  KEY TO ENTER THE NEW VALUE.
17. PUSH  KEY TO RETURN TO START.
18. RECONNECT JUMPER TO TERMINAL 15.

**WARNING:** IF YOU GET LOST OR ENTER A DISPLAY FROM WHAT IS LISTED ABOVE, PRESS RUN/PGM TO RETURN TO START, THEN START OVER AT STEP 2.

# PRODUCTION ADJUSTMENTS & CHECKS

TWO ADJUSTMENTS ARE REQUIRED TO PROPERLY FILL THE MOLD PLATE. THESE INCLUDE AUGER AND PISTON STROKE SETTINGS.

1. THE AMOUNT OF MEAT PUSHED FROM THE HOPPER TOWARD THE PISTON IS DETERMINED BY THE AUGER STROKE SETTING



2. PISTON STROKE INTO CHAMBER IS DETERMINED BY PISTON STROKE SETTING

CHECK VALVE

PISTON

PISTON STROKE ADJUSTMENT KNOB

\* NOTES:

1. PRECOMPRESSION ON COMPRESSION SPRING IS FACTORY PRESET TO 9 1/2 INCHES HEIGHT FOR AVERAGE MEAT PRODUCT.

2. FOR SOFT PRODUCT, LIKE SAUSAGE MEAT, IT MAY BE NECESSARY TO INCREASE SPRING HEIGHT UP TO 10 INCHES.

3. FOR HARD TO FILL PRODUCT, IT MAY BE NECESSARY TO DECREASE SPRING HEIGHT DOWN TO 8 7/8 INCHES MINIMUM. AT THIS POINT, THE MAXIMUM PRECOMPRESSION IS OBTAINED.

# PRODUCTION ADJUSTMENTS & CHECKS

THE SETTINGS OF THE AUGER STROKE AND PISTON STROKE ARE DETERMINED BY THE SIZE OF THE PORTION BEING MOLDED AS WELL AS THE FLOWABILITY OF THE PRODUCT BEING PROCESSED. LARGER PORTIONS AND MORE DIFFICULT TO FLOW PRODUCT WILL REQUIRE LARGER STROKE SETTINGS.

THE BEST WAY TO SET THE MACHINE IS TO START WITH A HIGHER THAN NECESSARY AUGER STROKE SETTING THAT WILL INSURE GETTING AN ADEQUATE SUPPLY OF PRODUCT TO THE PISTON. THE PISTON SETTING SHOULD BE SET LOW (LETTER A) AND GRADUALLY INCREASED TO OBTAIN A FULL PORTION.

WHEN THE PISTON STROKE IS SET, GRADUALLY DECREASE THE AUGER STROKE UNTIL THE MOLD WILL NOT FILL OUT PROPERLY AND THEN INCREASE IT SLIGHTLY UNTIL FULL PORTIONS ARE FORMED.

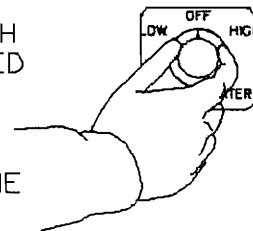
EXCESS AUGER STROKE WILL CAUSE OVERWORKING OF THE MEAT AND EXCESS MEAT OUT OF THE VENT HOLE ON THE SIDE OF THE CYLINDER.

1. AUGER STROKE IS SET BY ROTATING THE AUGER STROKE ADJUSTMENT KNOB. THIS KNOB CAN ONLY BE ROTATED WHEN THE SPRING LOAD, WHICH DRIVE THE AUGER, IS NOT AGAINST THE KNOB. THE SPRING LOAD CAN BE RELEASED BY "JOGGING" THE MACHINE TO MOVE THE AUGER UPWARD. ALSO, WHILE THE MACHINE IS OPERATING, THE KNOB CAN BE EASILY ROTATED DURING THAT PART OF THE CYCLE WHERE THE SPRING LOAD IS RELEASED.

2. PISTON STROKE IS SET BY ROTATING THE PISTON STROKE ADJUSTING HAND WHEEL IN THE DESIRED DIRECTION TO INCREASE OR DECREASE THE AMOUNT OF PRODUCT FLOW INTO THE MOLD PLATE. EXCESS PISTON STROKE WILL CAUSE EXCESS LEAKAGE OF PRODUCT IN THE MOLD PLATE AREA AND AN UNDESIRABLE "LIP" ON THE LOWER FRONT EDGE OF THE PORTION. INADEQUATE STROKE WILL RESULT IN A SHORT PORTION WHICH MAY FALL OUT OF THE MOLD BEFORE REACHING THE KNOCK-OUT POINT.

## PATTY KNOCK OUT CUP HEATER

THE 865 MACHINE USES A RADIANT KNOCK OUT CUP HEATER WHICH HAS A VARIABLE TEMPERATURE CONTROL. THE CONTROL IS LOCATED ON THE CONTROL BOX UNDER THE ON/OFF SWITCH. IT IS INTERLOCKED THROUGH THE MOTOR STARTER SO THAT WHEN THE MACHINE IS OFF, THE HEATER IS OFF. THIS IS TO PREVENT DAMAGE TO PLASTIC MOLD PLATES IN THE EVENT THAT THE MACHINE IS STOPPED WITH THE MOLD PLATE UNDER THE HEATER.



THE CONTROL KNOB IS ADJUSTABLE FROM HIGH TO LOW AND WITH AN "OFF" POSITION. THE BEST SETTING IS ONE WHERE THE KNOCK OUT CUP IS WARM ENOUGH TO NOT BUILD UP WITH FAT DEPOSIT, BUT NOT TOO HOT TO CAUSE "COOKED" PARTICLES TO FORM AND PERIODICALLY DROP OFF THE CUP. THE SETTINGS WILL VARY WITH MEAT AND ROOM TEMPERATURE. INITIALLY START AT A SETTING HALF WAY BETWEEN HIGH AND LOW AND ADJUST FROM THAT POINT.

**NOTE:** FOR SOME STICKY PRODUCTS, IT IS NECESSARY FOR THE K.O. CUP TO BE WARM WHEN THE MACHINE STARTS, TO PREVENT PATTIES FROM STICKING TO THE K.O. CUP. IN THIS CASE, UNPLUG THE MACHINE, THEN DISCONNECT LEADS 69 FROM THE AUXILIARY INTERLOCK ON THE STARTER AND CONNECT IT UNDER LEAD 67 ON THE OTHER SIDE OF THE AUXILIARY INTERLOCK. (SEE WIRING DIAGRAM).

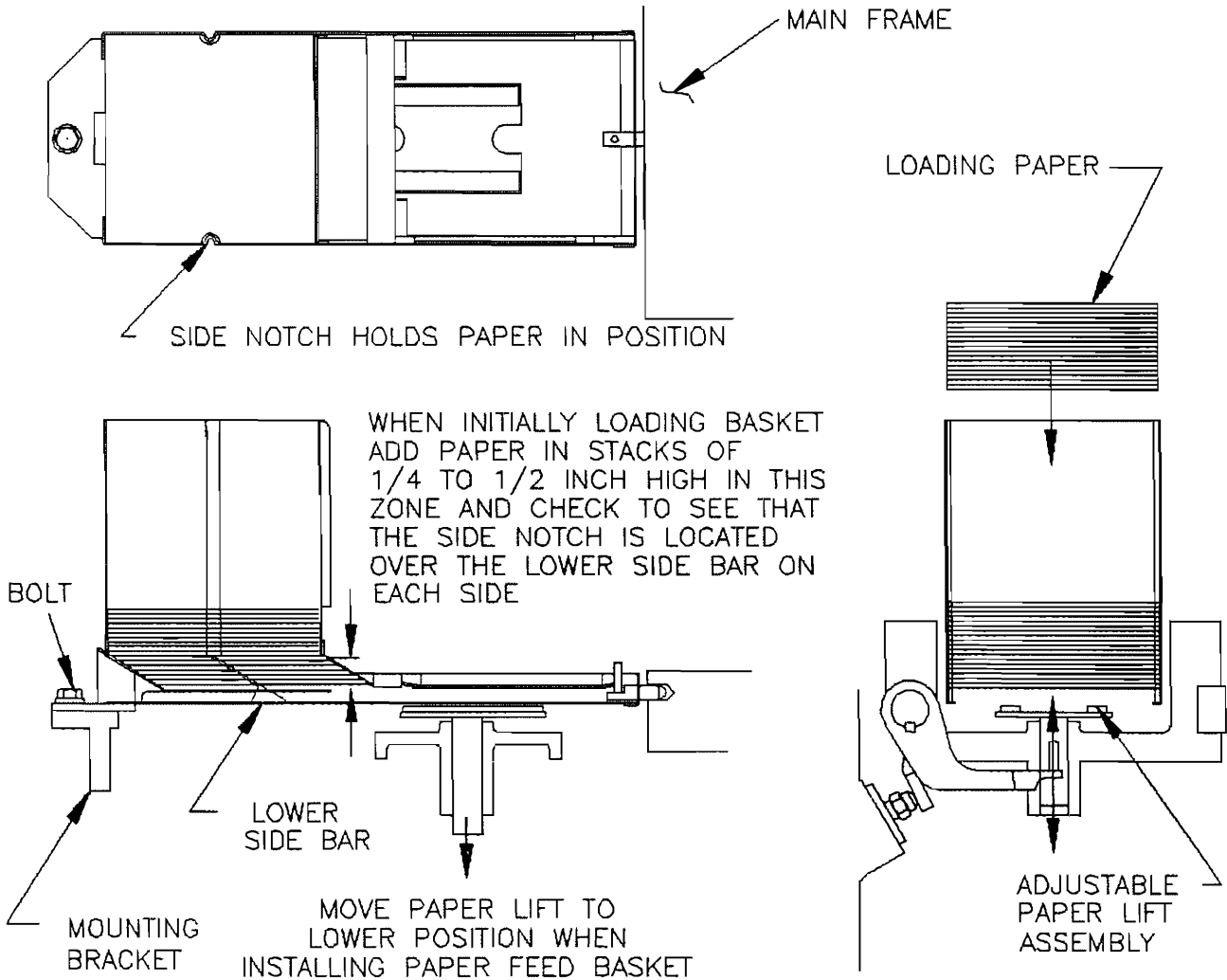
**CAUTION:** THE K.O. HEATER WILL NOW BECOME HEATED UPON PLUGGING THE POWER CORD INTO THE POWER SOURCE. WHEN STOPPING THE MACHINE, DO NOT LEAVE PLASTIC MOLD PLATES IN K.O. POSITION. HEAT FROM THE K.O. HEATER WILL WARP THE PLATES.

**NOTE:** A RUBBER AIR VALVE IS LOCATED ON THE SIDE OF THE PISTON CYLINDER. IT IS ONLY NECESSARY TO BE IN POSITION IF THERE IS DIFFICULTY IN FILLING LARGE VOLUME PATTIES. TURN SIDWAYS AWAY FROM THE VENT HOLE WHEN NOT BEING USED. FLOW OF MEAT OUT OF THIS HOLE IS DUE TO EXCESSIVE AUGER STROKE OR A WORN PISTON.



# PAPER FEED

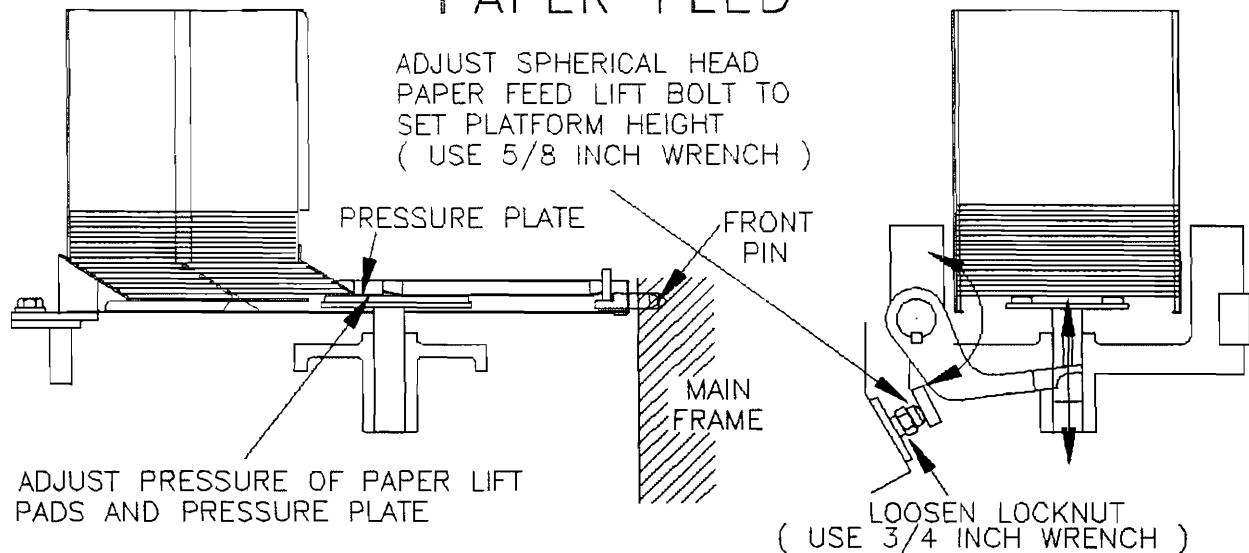
A SPECIAL SIDE NOTCHED PAPER ALONG WITH A COMPATABLE SHEET DISPENSING IS USED ON THE 8/65 PATTY MACHINE. BOTH ARE PATENTED BY HOLLYMATIC CORPORATION. THE DISPENSER IS DESIGNED TO FEED 4 1/2, 5, 5 1/2 AND 6 INCH SQUARE PAPER. THE NEW PAPER AND FEEDER ENABLES QUICK LOADING OF THE SHEETS DURING OPERATION OF THE MACHINE. THE BLOCK OF PAPER TO BE INTERLEAFED IS SIMPLY DROPPED INTO THE DISPENSER AFTER THE INITIAL SHEETS ARE LOADED AS NOTED BELOW.



THE SHEETS ARE HELD IN POSITION IN THE DISPENSING BASKET BY THE LOWER SIDE BARS THAT FIT IN THE PAPER SIDE NOTCHES.

**NOTE:** PAPER SHOULD MOVE FREELY DOWN THE LOWER ANGLED PART OF THE DISPENSER. THIS IS NECESSARY SO THAT THE PAPER LIFT WITH THE RUBBER PADS CONSISTENTLY GET A FIRM GRIP ON THE BOTTOM SHEET. IF IT DOES NOT, CHECK BOTH THE PAPER AND BASKET FOR POSSIBLE INTERFERENCE.

## PAPER FEED



ONE ADJUSTMENT MAY BE NECESSARY ON THE PAPER FEED SYSTEM (SEE ABOVE ILLUSTRATIONS). A SLIGHT PRESSURE IS REQUIRED BETWEEN THE RUBBER PADS ON THE PAPER FEED SHUTTLE PLATE AND THE BOTTOM OF THE PRESSURE PLATE. THIS CAN BE CHECKED BY FIRST PLACING THE PAPER FEED BASKET IN POSITION WITH PAPER (PRESSURE PLATE SHOULD BE IN THE DOWN POSITION WHEN ASSEMBLING THE BASKET). SECURE THE BASKET IN POSITION USING THE (518-0207) WRENCH. MAKING SURE THE FRONT PIN IS POSITIONED IN THE MAIN FRAME. JOG THE MACHINE UNTIL THE PRESSURE PLATE IS DIRECTLY UNDER THE BOTTOM OF THE SHEET OF PAPER.

**WARNING:** UNPLUG THE MACHINE FROM THE POWER SOURCE.

CHECK THE PRESSURE ON THE SHEET OF PAPER BY PULLING IT OUT OF ITS GRIP BETWEEN THE RUBBER PADS AND PRESSURE PLATE. THERE SHOULD BE A SLIGHT DRAG.

IF ADJUSTMENT IS REQUIRED ADJUST THE PAPER FEED LIFT BOLT (BOLT WITH SPHERICAL HEAD) WITH A 5/8 INCH WRENCH. LOOSEN THE LOCKNUT (USE A 3/4 INCH WRENCH) MOVE THE SPHERICAL HEAD BOLT UNTIL A SLIGHT DRAG IS FELT ON THE SHEET OF PAPER. RETIGHTEN LOCKNUT.

### HELPFUL NOTES

1. IF THE PAPER HAS A TENDENCY TO BOW, PLACE THE CONCAVE SIDE DOWN WHEN LOADING THE BASKET.
2. IN GENERAL, THE DULLER SIDE OF THE SHEET SHOULD BE ON BOTTOM.
3. WHEN LOADING THE BASKET, BEND THE BLOCKS OF SHEETS IN BOTH DIRECTIONS TO LOOSEN ANY TENDENCY OF THE SHEETS TO STICK TOGETHER.
4. CHECK SQUARENESS OF SHEETS AND POSITION OF SIDE NOTCHES WHICH SHOULD BE CENTERED ACROSS THE SHEET.
5. CHECK CONDITION AND POSITION OF RUBBER STRIPS ON PAPER FEED PLATFORM. CLEAN SURFACE OF STRIPS WITH FINE EMERY CLOTH IF COATED WITH WAX OR OIL.
6. USE HOLLYMATIC PAPER.

**CAUTION:** WHEN NOT RUNNING PAPER, REMOVE PAPER FEED BASKET AND INSTALL GUARD 480-1394.

## MOLD PLATE CHANGE

1. "JOG" MACHINE UNTIL THE "KNOCK OUT" CUP DROPS THROUGH THE MOLD PLATE AND MOVES UP SLIGHTLY.

IN ORDER TO JOG THE MACHINE TO STOP IN THE "KNOCK OUT" POSITION, IT IS NECESSARY TO FIRST MOVE THE AUGER STROKE TO THE FULLY RETRACTED POSITION. (FOLLOW STEPS 1, 2, 3 OF DISASSEMBLY ON PAGES 11 & 12).

2. DISCONNECT THE MACHINE FROM THE POWER SOURCE, OPEN THE MOLD PLATE DRIVE AND KNOCK-OUT ARM GUARDS.
3. REMOVE THE KNOCK-OUT CUP USING THE (518-0207) WRENCH.
4. REMOVE THE MEAT COLLECTOR AND EMPTY INTO THE HOPPER.
5. USING SPEED WRENCH, P/N 480-0650, REMOVE THE TWO TOP PLATE HOLD-DOWN NUTS AND BOLTS. REMOVE THE TOP PLATE AND SPACERS.

NOTE: IF THE SPACERS ARE NOT CHANGED, THE HOLD-DOWN NUTS DO NOT HAVE TO BE REMOVED - ONLY LOOSENED.

6. REMOVE THE MOLD PLATE AND REPLACE WITH NEW SIZE.

CAUTION: WHEN POSITIONING THE NEW MOLD PLATE IN THE MACHINE, MAKE SURE THAT IT IS PROPERLY ENGAGED AT BOTH ENDS. FAILURE TO DO THIS WILL RESULT IN DAMAGE TO THE MACHINE. ALSO, LUBRICATE PLATES TOP AND BOTTOM WITH HOLLY FLUID.

7. SELECT THE PROPER THICKNESS MOLD PLATE SPACERS AND POSITION. REPLACE THE TOP PLATE, HOLD DOWN BOLTS, AND NUTS. TIGHTEN FIRMLY WITH THE SPEED WRENCH (DO NOT OVERTIGHTEN).
8. SELECT THE PROPER SELF-ALIGNING "KNOCK-OUT" CUP AND INSTALL WITH THE TEE WRENCH (SEE PAGE 60).
9. REPLACE THE MEAT COLLECTOR - (PUSH DOWN AND ROTATE).

## LUBRICATION

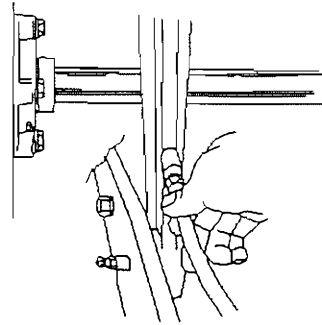
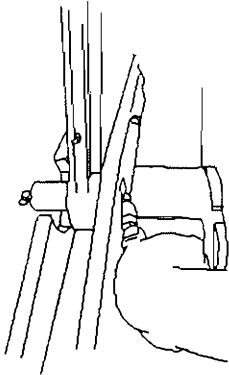
IN ORDER TO OBTAIN LONG TROUBLE-FREE OPERATION OF THE 8/65 PATTY MACHINE, IT WILL BE NECESSARY TO PROPERLY LUBRICATE THE BEARING AREAS. FOUR BASIC TYPES OF LUBRICANTS SHOULD BE USED:

HOLLY FLUID (H.F.), HOLLY LUBE (H.L.), WHICH ARE FOOD GRADE LUBRICANTS. MULTI-LUBE (M.L.) AND LUBRIPLATE #8 (S.A.E. 140) (L8) WHICH IS A HEAVY DUTY GREASE AND OIL FOR MACHINE PARTS. THE HOLLY FLUID AND HOLLY LUBE SHOULD BE USED IN ALL AREAS OF THE FOOD ZONE. THE TYPE OF LUBRICANT, LOCATION OF LUBRICATION, AS WELL AS THE FREQUENCY OF LUBRICATION, IS SPECIFIED ON THE FOLLOWING PAGES.

# DAILY LUBRICATION

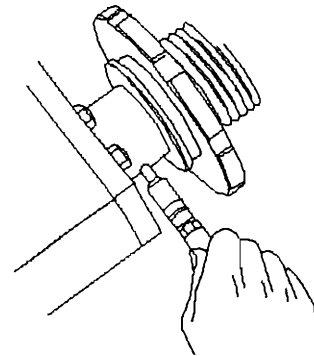
## 1. (M.L.) MAIN ECCENTRIC BEARING

OPEN CYLINDER ACCESS DOORS. GREASE FITTING IS LOCATED AT LOWER END OF CONNECTING ROD.



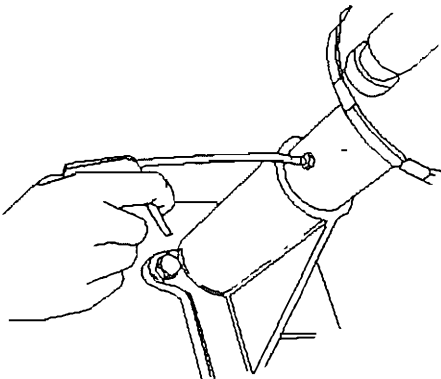
## 2. (M.L.) CRANK PIN

OPEN CYLINDER ACCESS DOORS. 2 GREASE FITTINGS ON EITHER SIDE OF CRANK PIN.



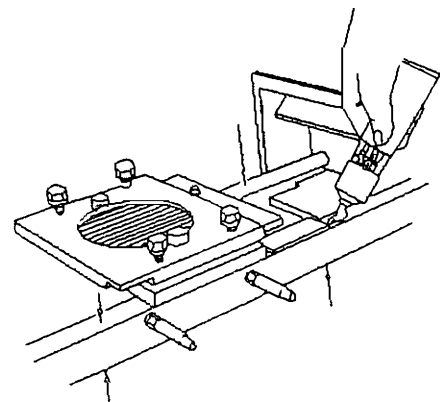
## 3. (M.L.) UPPER AUGER DRIVE SHAFT BEARING

GREASE FITTING ON TOP END OF AUGER DRIVE SUPPORT TUBE.



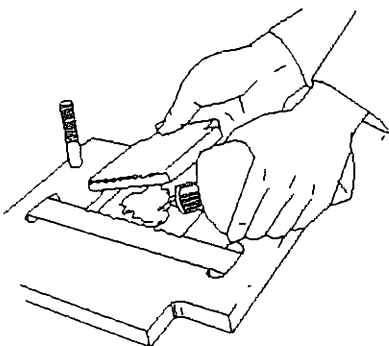
## 4. (L8) LOWER AUGER DRIVE SHAFT BEARING

OIL FITTING ON BOTTOM END OF AUGER DRIVE SUPPORT TUBE.



## 5. (H.L.) PAPER FEED SHUTTLE AND MOLD PLATE SHUTTLE GUIDES

SPREAD A LIGHT COAT OF LUBRICANT ON THE THREE GUIDE BARS WHICH SUPPORT THE TWO SHUTTLES.



## 6. (H.F.) MOLD PLATE AND MULTI-FLOW<sup>TM</sup> SLIDING PLATE

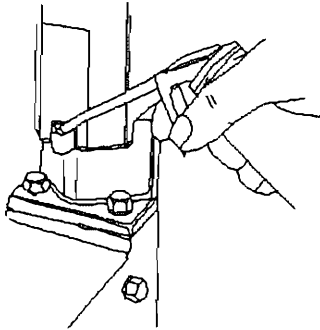
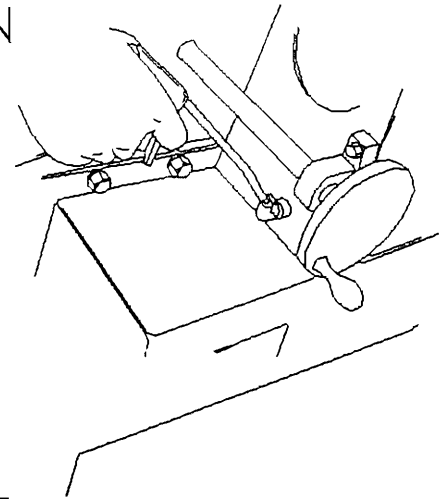
SPREAD A LIGHT COAT OF LUBRICANT ON THE MOLD PLATE AND SLIDING PLATE.

MULTI-FLOW<sup>TM</sup> SHOWN. OTHER FILL SYSTEM OPTIONS AVAILABLE (SEE INDEX).

# DAILY LUBRICATION

## 7. (L8) KNOCK OUT CAM

OIL FITTING AT LOWER LEFT OF KNOCK OUT HOUSING.

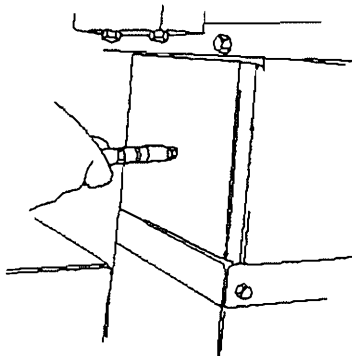
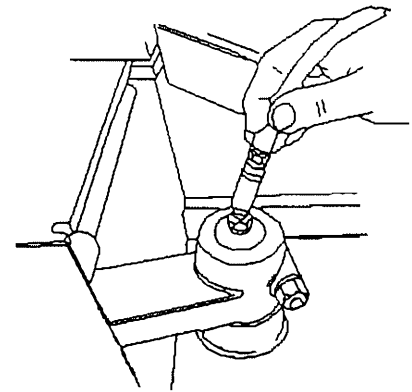


## 8. (L8) KNOCK OUT SHAFT

OIL FITTING AT REAR OF KNOCK OUT SHAFT.

## 9. (M.L.) UPPER MOLD PLATE DRIVE SHAFT BEARING

GREASE FITTING AT TOP OF MOLD PLATE DRIVE SHAFT.

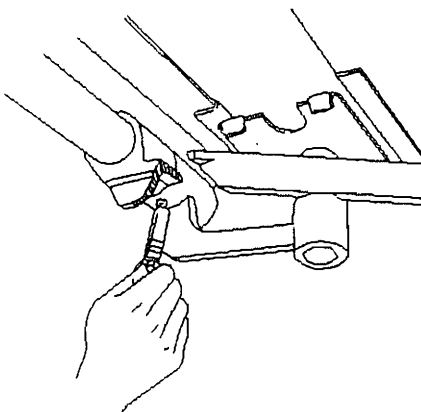
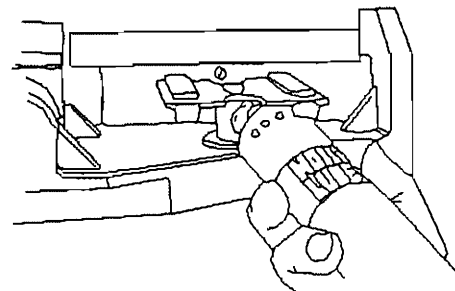


## 10. (M.L.) LOWER MOLD PLATE DRIVE SHAFT BEARING

GREASE FITTING UNDER MOLD PLATE DRIVE GUARD.

## 11. (H.L.) PAPER FEED PLATFORM SHAFT

SPREAD COAT OF LUBRICANT AT TOP OF SHAFT WHICH WILL WORK ITS WAY DOWN DURING OPERATION.



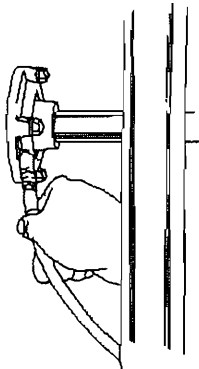
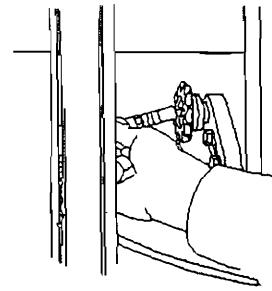
## 12. (H.L.) PAPER FEED LIFT ARM

GREASE FITTING ON BOTTOM OF PAPER LIFT ARM.

# WEEKLY LUBRICATION

## 1. (M.L.) CHAIN IDLER SPROCKET

OPEN CYLINDER ACCESS DOORS – GREASE FITTING IS LOCATED ON IDLER SHAFT.

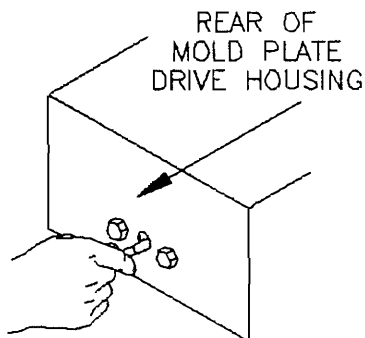
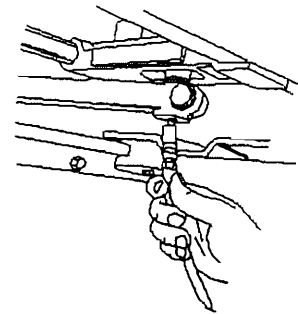


## 2. (M.L.) JACK SHAFT BEARINGS

OPEN CYLINDER ACCESS DOORS – TWO GREASE FITTINGS ON EACH OF TWO BEARINGS.

## 3. (M.L.) CAM FOLLOWER – MOLD PLATE DRIVE SHUTTLE

GREASE FITTING UNDER MOLD PLATE DRIVE SHUTTLE.

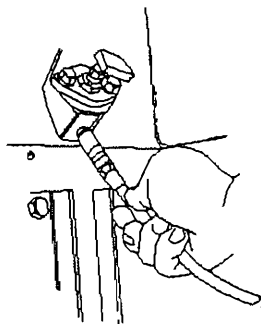
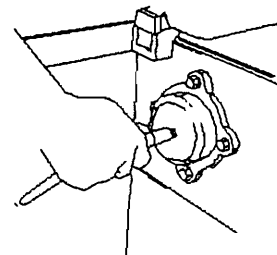


## 4. (M.L.) CAM FOLLOWER MOLD PLATE DRIVE CAM

THE GREASE FITTING FOR CAM FOLLOWER IS LOCATED AT THE REAR OF THE MOLD PLATE DRIVE HOUSING. A FLEXIBLE TUBE CONNECTS THE GREASE FITTING TO THE MOVING CAM FOLLOWER.

## 5. (M.L.) MAIN SHAFT THRUST BEARING

GREASE FITTING AT END OF DRIVE SHAFT LOCATED ABOVE CONTROL BOX.

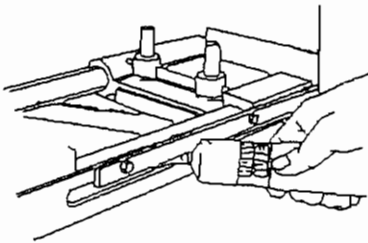
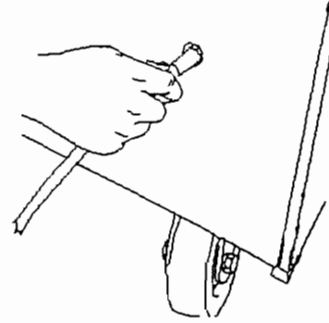


## 6. (M.L.) PAPER FEED INDEX ROD

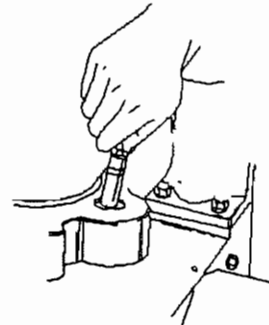
GREASE FITTING UNDER PAPER FEED DRIVE SHUTTLE.

# WEEKLY LUBRICATION

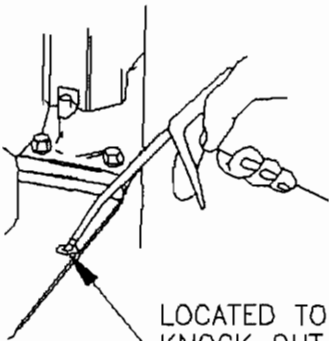
7.  
(M.L.) COMPRESSION SPRING BEARING  
GREASE FITTING ABOVE PIVOTING CASTER  
AND IS ACCESSABLE THRU A HOLE MARKED  
LUBE.



8.  
(H.L.) MOLD PLATE DRIVE GUARD GUIDE TRACK  
SPREAD A LIGHT COAT OF LUBRICANT ON THE  
TWO TRACK AREAS ON WHICH THE GUARD SLIDE



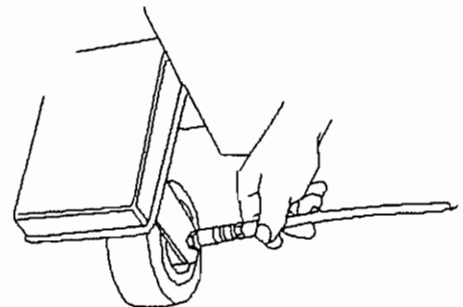
9.  
(L.8) HOPPER DRIVE PINION BEARING  
GREASE FITTING AT TOP OF PINION GEAR.



10. (L.8) HOPPER DRIVE SHAFT BEARINGS  
OIL FITTING AT TOP OFF KNOCK OUT HOUSING.

LOCATED TO THE REAR OF THE  
KNOCK OUT ARM AND BEHIND  
THE STACKER COUNTER.

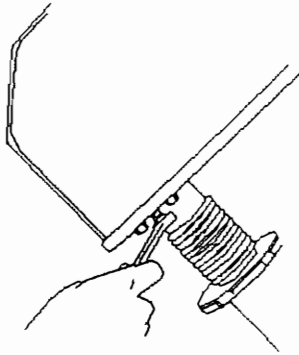
11. (M.L.) CASTERS  
ONE GREASE FITTING ON EACH OF THREE CASTERS.



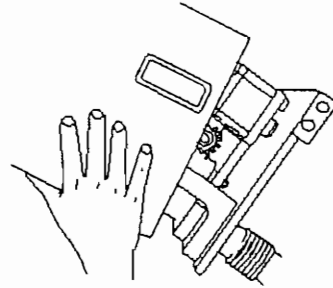
# MONTHLY LUBRICATION

THERE ARE SEVERAL LUBRICATION POINTS ON THE AUGER DRIVE MECHANISM WHICH REQUIRES REMOVAL OF THE AUGER HOUSING. REMOVE FOUR HEX HEAD BOLTS WHICH HOLD THE HOUSING IN POSITION AND LIFT TO CLEAR THE MECHANISM.

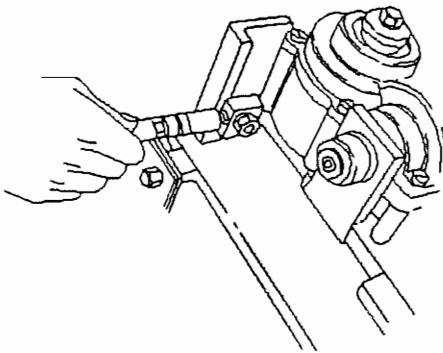
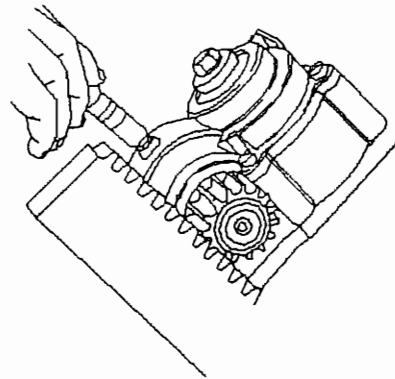
**CAUTION:** MAKE SURE THE MACHINE POWER SUPPLY CORD IS UNPLUGGED.



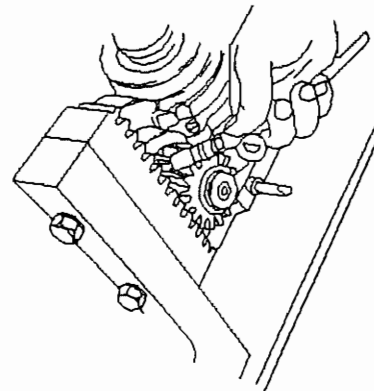
1. (M.L.) TRANSMISSION  
GREASE FITTING AT LOWER REAR.



2. (M.L.) CAM FOLLOWER  
GREASE FITTING AT SIDE OF CAM FOLLOWER.



3. (M.L.) GEAR AND RACK  
SPREAD A MEDIUM AMOUNT OF GREASE OVER THE GEAR AND RACK.

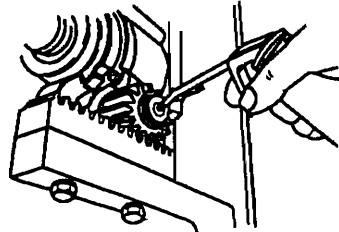
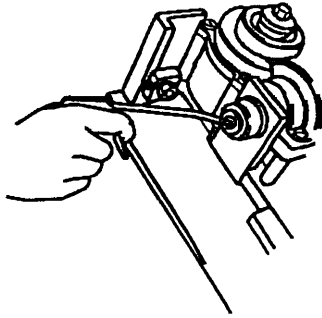




# MONTHLY LUBRICATION

4. (H.F.) ONE-WAY CLUTCH BEARINGS  
TWO OIL FITTINGS ON EITHER SIDE OF PINION SHAFT.

**CAUTION:** DO NOT OPERATE MACHINE WITHOUT AUGER DRIVE COVER IN POSITION. REPLACE AFTER LUBRICATION IS COMPLETED.

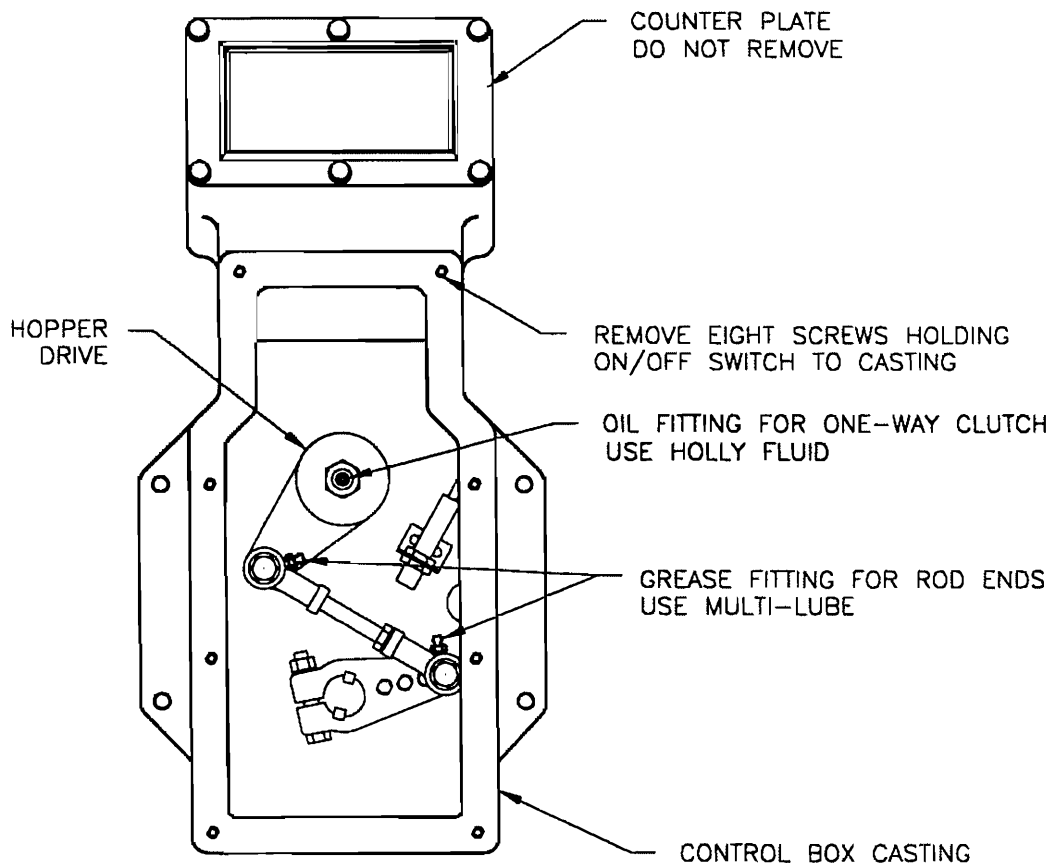


5. THE HOPPER DRIVE MECHANISM SHOULD BE LUBRICATED MONTHLY AS SHOWN BELOW.

**WARNING:** UNPLUG THE MACHINE FROM POWER SOURCE BEFORE PROCEEDING.

REMOVE THE EIGHT SCREWS THAT HOLD THE ON/OFF SWITCH PLATE TO THE CONTROL BOX CASTING.

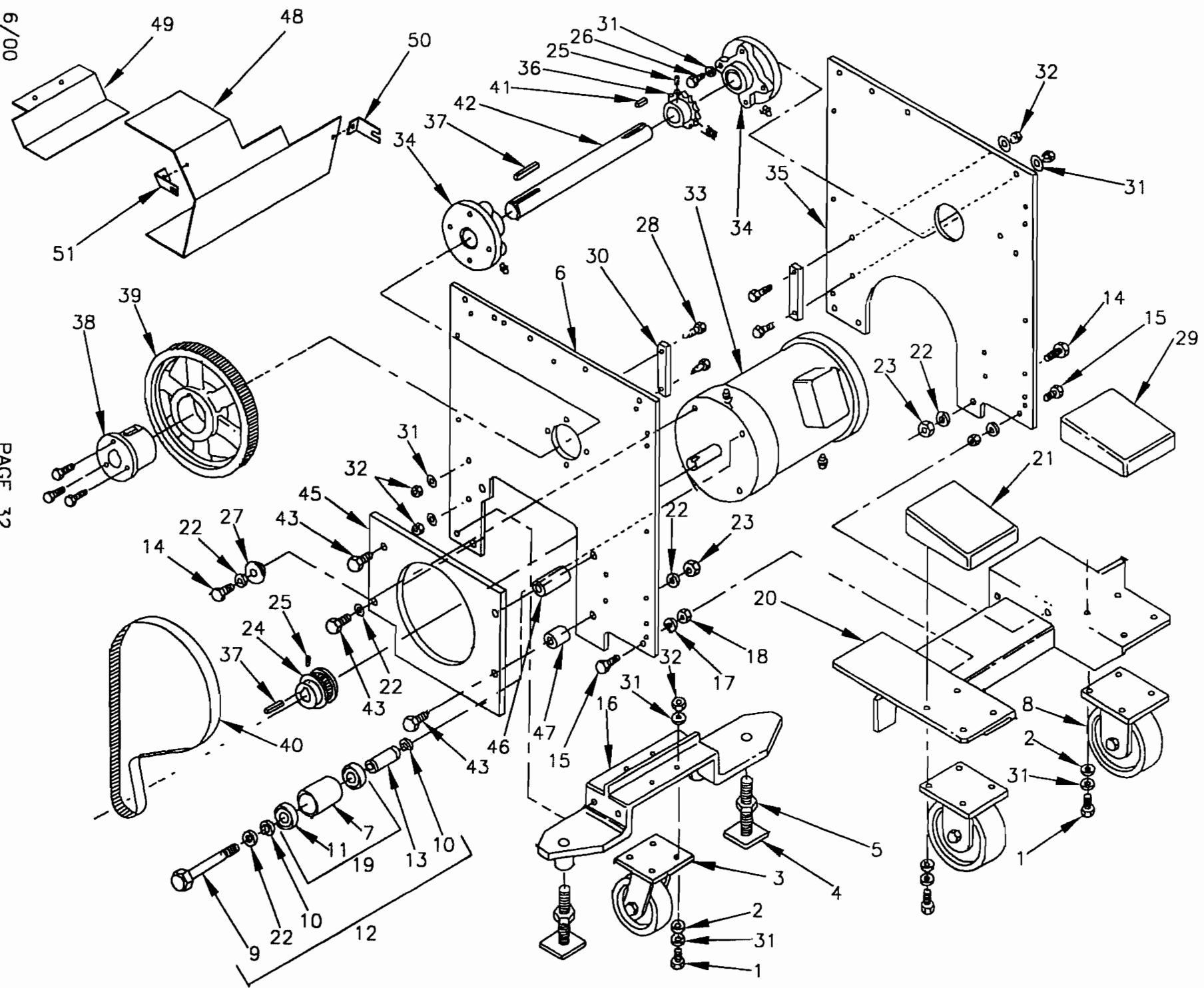
DO NOT REMOVE ANY ELECTRICAL WIRES, JUST MOVE THE PANEL OUT ENOUGH TO GET ACCESS TO THE HOPPER DRIVE AS SHOWN BELOW.



# BASE ASSEMBLY

6/00

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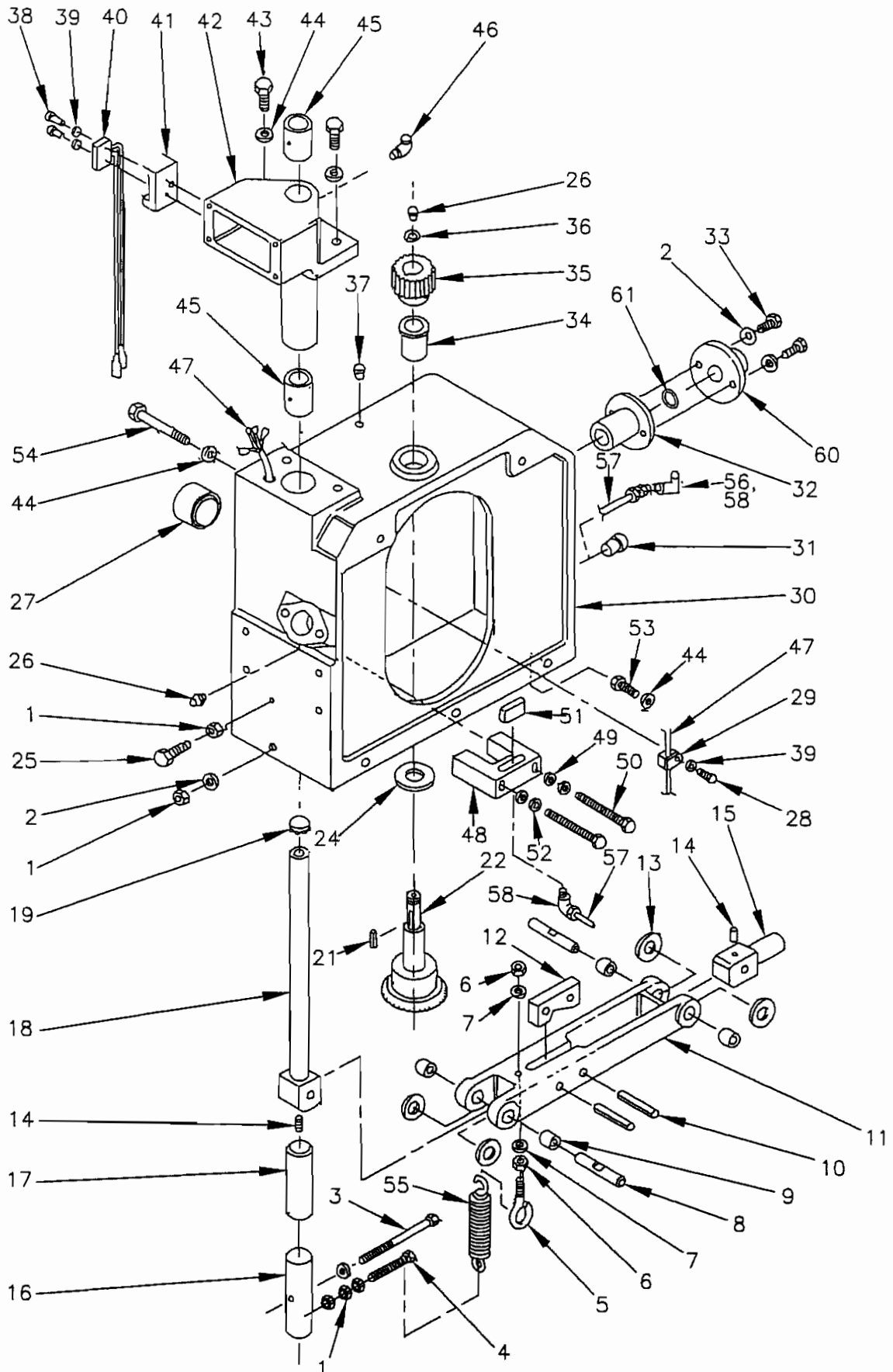
# 480-0428 BASE ASSEMBLY

\*\*4801506 (New Style)  
4800197 (Old Style)

ITEM	QTY	PART NO.	ITEM	QTY	PART NO.
1	12	3/8-16 X 1 1/2 HHCS	716140283	26	* 3/8-16 X 1 3/8 HHCCS
2	12	3/8 FLAT WASHER	500-1005	27	* WASHER-MOTOR SUPPORT
3	1	SWIVEL CASTER	879-1474	28	GUIDE STOP SCREW
4	2	PAD WELDMENT	480-0546	29	COVER-CASTER REAR
5	2	3/4-10 HEX NUT	730005121	30	GUIDE STOP
6	1	PLATE-FRONT	480-1159	31	3/8 SPLIT LOCKWASHER
7	1	BEARING TUBE	500-0693	32	3/8-16 HEX NUT
8	2	RIGID CASTER	480-0792	33	MOTOR-2HP, 3PH, 1200 RPM:
9	1	1/2-13 X 3 1/4 HHCS	718320253		200V, 60HZ
10	2	RETAINING RING	776001393		230/460V, 60HZ
11	2	BEARING	500-0718		575V, 60HZ
12	1	MOUNT & ROLLER BEARING ASSY (INCL. ITEMS 9,10,13,19,22)	480-0435		220/380V, 50 HZ
13	1	SHAFT	480-0434	34	FLANGE BEARING
14	7	1/2-13 x 1 1/4 HHCS	718120183	35	PLATE-REAR
15	2	5/16-18 x 1 1/4 HHCS	715120253	36	SPROCKET 13T
16	1	SUPPORT-REAR	480-0345	37	1/4 X 2 1/4 SQ. KEY
17	2	5/16 SPLIT LOCKWASHER	755000591	38	BUSHING
18	2	5/16-18 HEX NUT	735005123	39	PULLEY-GEARBELT 72T
19	1	ROLLER BEARING ASSY (INCL. ITEMS 7,11)	500-0692	40	GEARBELT
20	1	CASTER SUPPORT WELDMENT	480-0337	41	1/4 X 1 1/8 SQ. KEY
21	1	COVER-CASTER FRONT	480-0432	42	** SHAFT-INTERMEDIATE
22	10	1/2 SPLIT LOCKWASHER	758000591	43	1/2-13 X 2 1/2
23	4	1/2-13 HEX NUT	738005123	44	
24		PULLEY-GEAR BELT:		45	MTG. PLATE-MOTOR
	1	17T FOR 60 HZ MACHINE	480-0225	46	SPACER 1" LG
	1	21T FOR 50 HZ MACHINE	480-1122	47	SPACER 11/16 LG
25	4	5/16-18 X 3/8 HSS	715033693	48	SHIELD, MOTOR FRONT
				49	SHIELD, MOTOR REAR
				50	BRACKET, SHIELD MOTOR
				51	BRACKET, SHIELD MOTOR

\*\*4801506 (New Style = 18")  
4800197 (Old Style = 13.5")

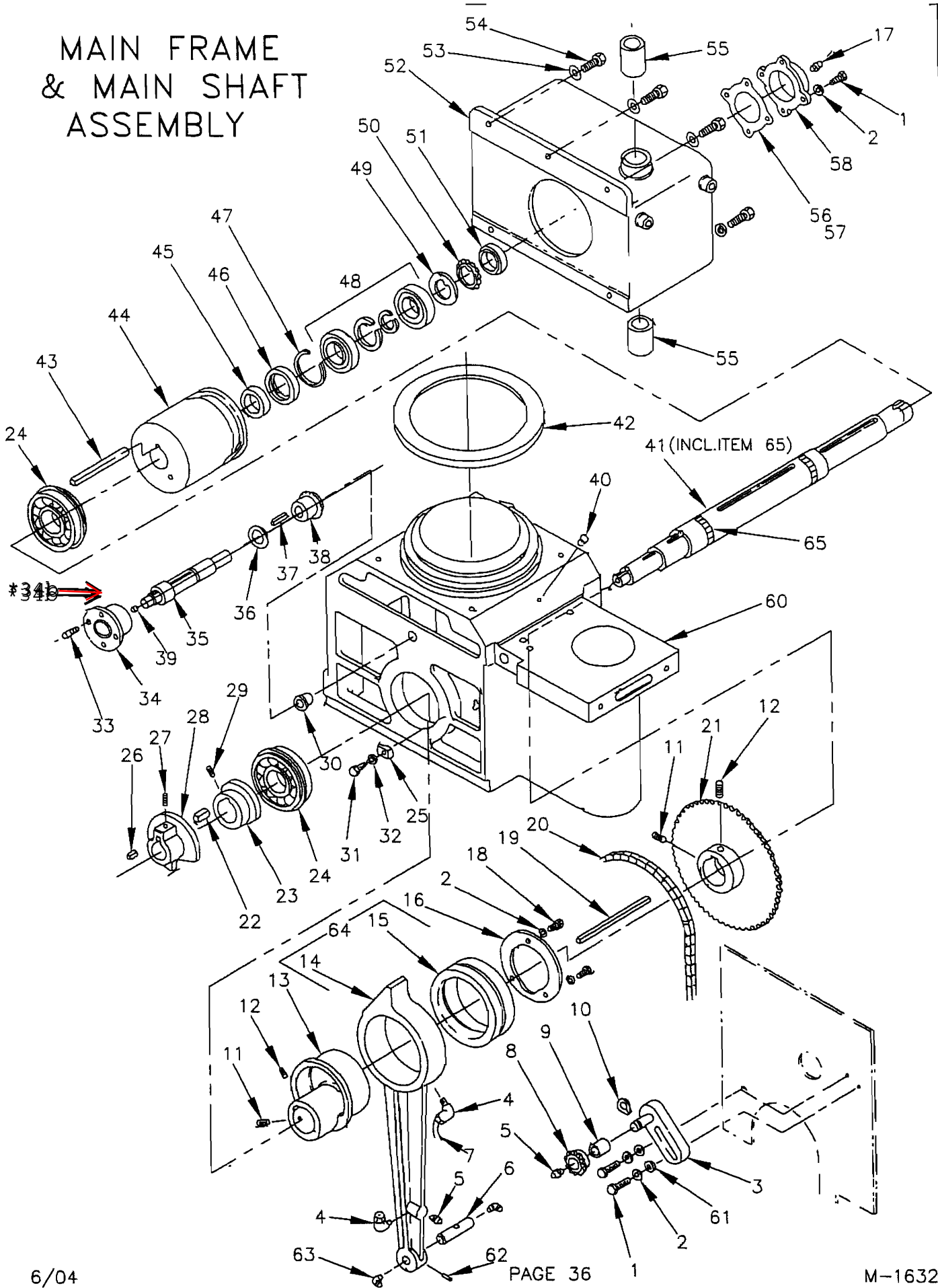
# HOUSING ASSEMBLY



## K.O. HOUSING ASSEMBLY (480-0411)

ITEM	QTY	PART NO.	ITEM	QTY	PART NO.
1 3/8-16 HEX NUT	5	736005123	33 3/8-16 X 1-1/8 HEX HEAD CAP SCREW	2	716110253
2 3/8 SPLIT LOCKWASHER	4	756000591	34 BUSHING	1	480-0101
3 3/8-16 X 3-1/4 HEX HEAD CAP SCREW	1	716320253	35 DRIVE GEAR-HOPPER	1	480-0413
4 3/8-16 X 1-3/4 HEX HEAD CAP SCREW	1	716160453	36 SNAP RING-EXT.	1	774002493
5 EYE BOLT	1	480-0190	37 OILER FLUSH FIT	1	480-0412
6 1/4-20 HEX NUT	2	734005153	38 #10-24 X 1 HEX HEAD CAP SCREW	2	713100293
7 1/4 SPLIT LOCKWASHER	2	754000591	39 #10 INTERNAL TOOTH LOCKWASHER	4	753000640
8 PIN	2	480-0154	40 SAFETY SWITCH	1	879-0933
9 BEARING	4	480-0163	41 INSULATOR	1	879-1152
10 3/8 X 2 ROLL PIN	2	766201691	42 HOUSING-K.O. HEATER	1	480-0125
11 K.O. ARM	1	480-0153	43 1/2-13 X 1-1/4 HEX HEAD BOLT	2	718120183
12 K.O. WEAR PAD	1	480-0156	44 1/2 SPLIT LOCKWASHER	7	758000591
13 THRUST WASHER	4	480-0165	45 SLEEVE BEARING	2	480-0167
14 5/16-18 X 3/8 HEX SOCKET SET SCREW	2	715033799	46 ELBOW OIL CUP	1	480-0389
15 ROD END	1	480-0155	47 CORD ASSEMBLY-K.O. HEATER	1	480-1132
16 BUMPER SOP	1	480-0161	48 K.O. CAM OILER	1	480-0578
17 K.O. BUMPER	1	400-0422	49 1/4 FLAT WASHER	2	754000191
18 K.O. SHAFT WELDMENT	1	480-0159	50 1/4-20 X 3 HEX HEAD CAP SCREW	2	714300253
19 CLOSURE CAP-KO SHAFT	1	400-0517	51 LUBRI PAD	1	500-0145
20			52 1/4 SPLIT LOCKWASHER	2	754000591
21 3/8-16 SQ X 31/32 KEY	1	480-0105	53 1/2-13 X 1-3/4 HEX HD. CAP SCREW	3	718160253
22 HOPPER SHAFT WELDMENT	1	480-1141	54 1/2-13 X 7 HEX HEAD BOLT	2	718700153
23			55 SPRING-K.O.	1	675-1149
24 THRUST BEARING	1	480-0099	56 COUPLING STRAIGHT	1	180-8101
25 3/8-16 X 1-3/4 HEX HEAD CAP SCREW	1	716160453	57 K.O. CAM LUBE TUBE	1	480-0581
26 GREASE FITTING	3	840-1074	58 COUPLING ELBOW	1	180-8102
27 BUSHING-MAIN SHAFT	1	480-0103	59		
28 #10-24 X 1/2 HEX HEAD MACH. SCREW	2	713040223	60 CAP-K.O. ARM RETAINER	1	480-0861
29 CORD CLAMP	2	500-0930	61 O-RING-CAP	1	480-0918
30 K.O. HOUSING	1	480-0126			
31 OILER WALL COUPLER	1	480-0579			
32 RETAINER	1	480-0127			

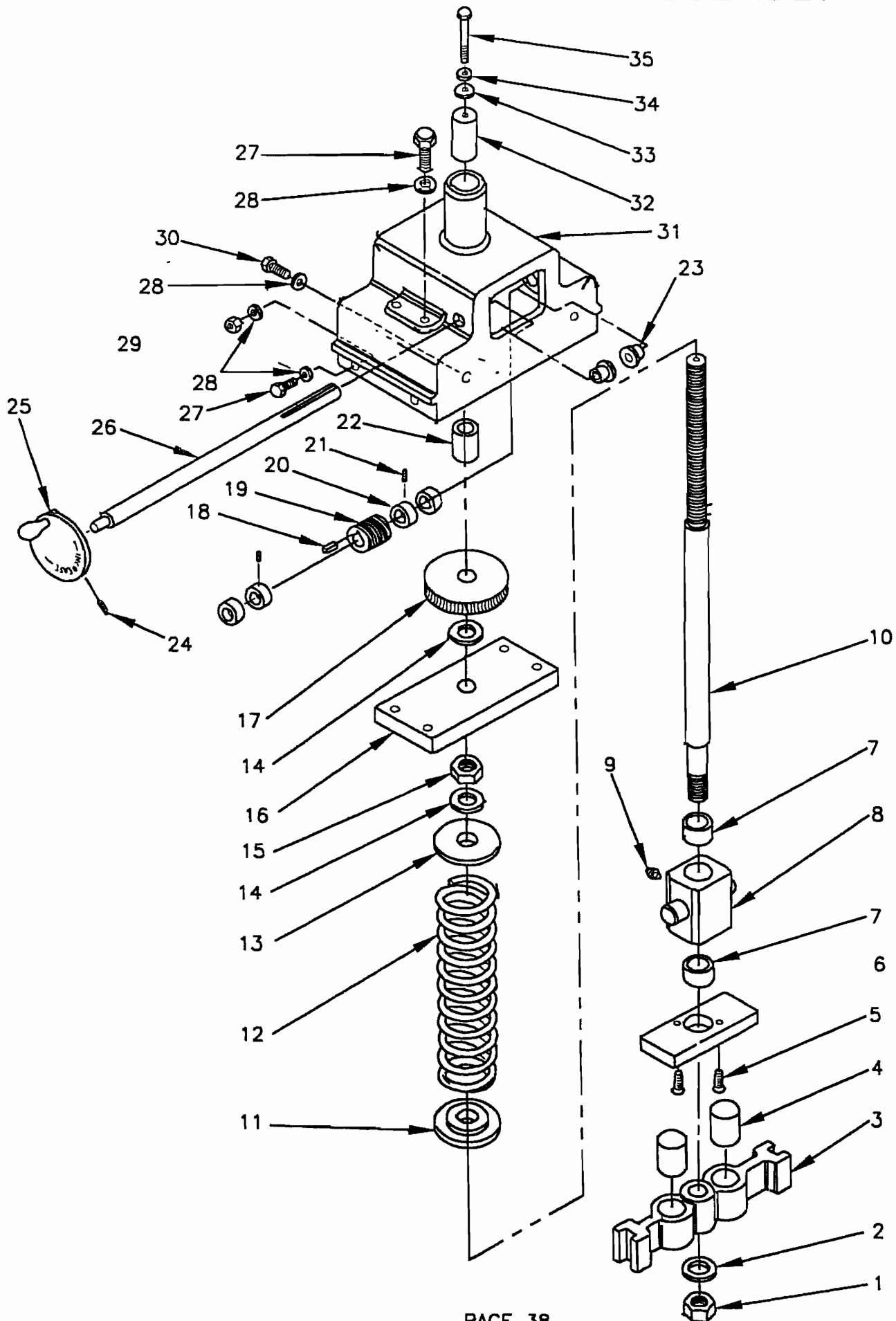
# MAIN FRAME & MAIN SHAFT ASSEMBLY



# MAIN FRAME AND MAIN SHAFT ASSEMBLY (480-0420)

ITEM	QTY	PART NO.	ITEM	QTY	PART NO.
			0.01" shim 03500037		
1	6	716120283	*34b 0.02" shim 03500038	1	480-0128
2	9	756000591	34	1	480-1137
3	1	480-0518	35	1	480-0100
4	2	180-8102	36	1	480-0105
5	2	800-1075	37	1	480-1139
6	1	480-0172	38	1	480-1295
7	1	480-0736	39	1	480-0555
8	1	860-0026	40	1	480-0188
9	1	860-0031	41	1	480-0537
10	1	774002493	42	1	480-0393
11	2	719103999	43	1	480-0076
12	2	719064599	44	1	480-0399
13	1	480-0176	45	1	489-0388
14	1	480-0177	46	1	480-0907
15	1	480-0174	47	1	480-0547
16	1	480-0175	48	1	480-0557
17	1	840-1074			
18	3	716100253			
19	1	480-0392	49	1	480-0397
20	1	480-0230	50	1	480-0398
21	1	480-0227	51	1	480-0010
22	1	480-0394	52	1	758000591
23	1	480-0071			
24	2	480-0395	53	5	718160253
25	4	480-0572	54	2	480-0115
26	1	480-0211	55	A/R	480-0560
27	1	716044499	56	A/R	480-0561
28	1	480-0157	57	1	480-0400
29	2	715044499	58		
30	1	480-0098	59	1	480-0189
31	4	715110253	60	2	756000291
32	4	755000591	61	1	714053699
33	4	716060353	62	2	625-0633
			63	1	480-0421
			64	2	480-1412
			65		

# STROKE AND SPRING ASSEMBLY

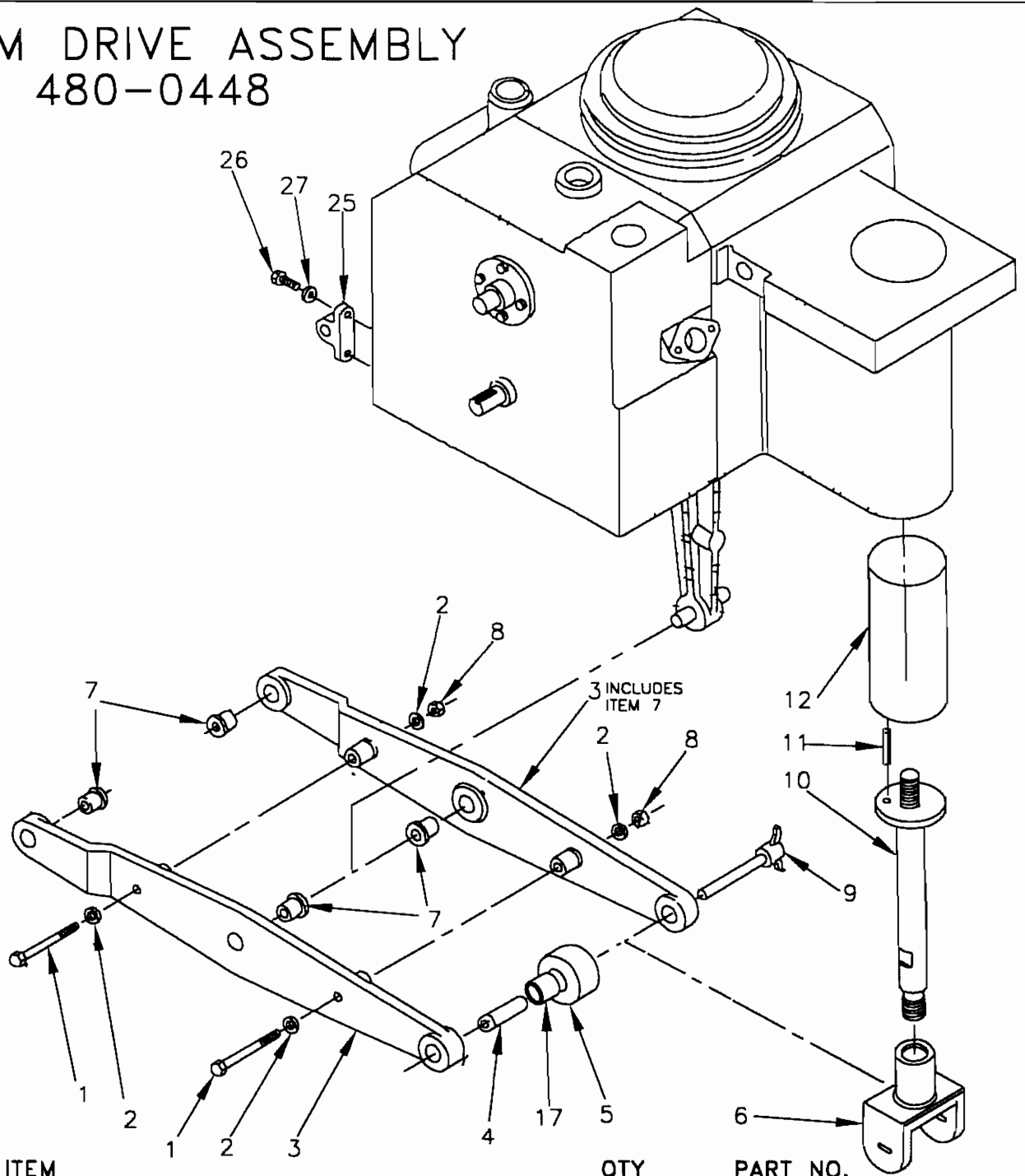




# STROKE AND SPRING ASSEMBLY

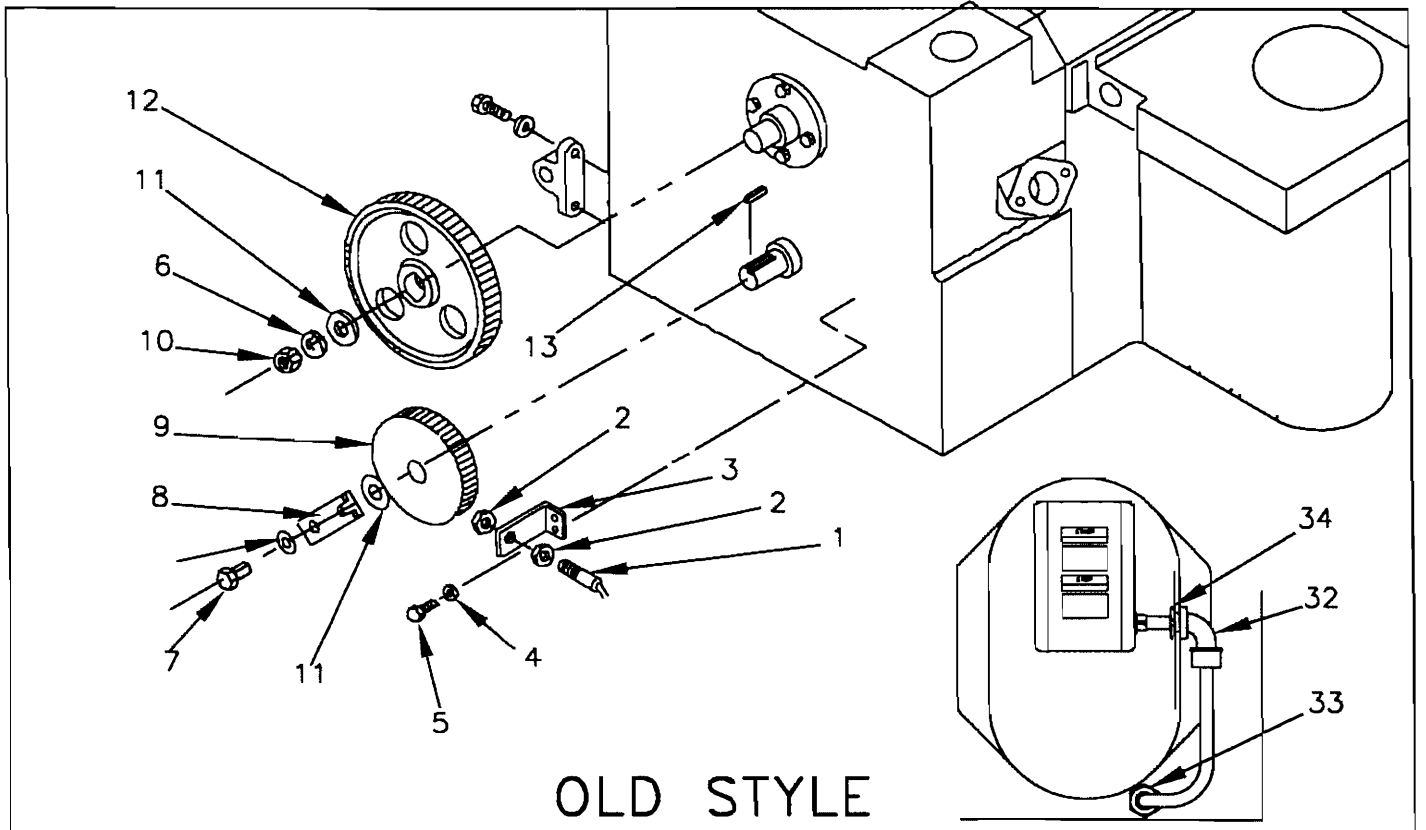
ITEM		QTY	PART NUMBER
1	1-8 HEX NUT	1	480-0139
2	1" SPLIT LOCKWASHER	1	480-0307
3	GUIDE	1	480-0196
4	BUMPER	2	480-0292
5	1/4-20 X 1 FLAT HEAD SCREW	2	714100793
6	PLATE-BUMPER	1	480-0191
7	SLEEVE BEARING	2	480-0294
8	PIVOT-ROCKER ARM	1	480-0171
9	GREASE FITTING	1	800-1075
10	SHAFT-RAM ADJUSTING	1	480-0170
11	PAD-LOWER SPRING	1	480-0195
12	SPRING	1	879-0141
13	PAD-UPPER SPRING	1	480-0194
14	THRUST WASHER	2	480-0099
15	NUT-ADJUSTING	1	480-0303
16	RETAINER PLATE	1	480-0109
17	WORM GEAR ASSEMBLY	1	480-0114
18	3/16 SQ X 1-3/8	1	500-0134
19	WORM	1	480-0113
20	COLLAR	2	500-0727
21	SPACER	2	480-0112
22	BUSHING	1	480-0111
23	BUSHING-FLANGED	2	480-0110
24	5/16-18 X 3/8 HHCS	1	715033699
25	WHEEL & HANDLE ASSEMBLY	1	500-3014
26	SHAFT-STROKE ADJUSTING	1	480-0378
27	1/2-13 X 1-1/2 HHCS	8	718140253
28	1/2 SPLIT LOCKWASHER	14	758000591
29	1/2-13 HEX NUT	4	738005123
30	1/2-13 X 1-1/4 HEX HEAD BOLT	2	718120183
31	SUPPORT-STROKE ADJUSTING	1	480-0108
32	TUBE INDICATOR	1	480-0439
33	1/4 FLATWASHER	1	754000191
34	1/4 SPLIT LOCKWASHER	1	754000591
35	1/4-20 X 2-3/4 HHCS	1	714260140

# RAM DRIVE ASSEMBLY 480-0448

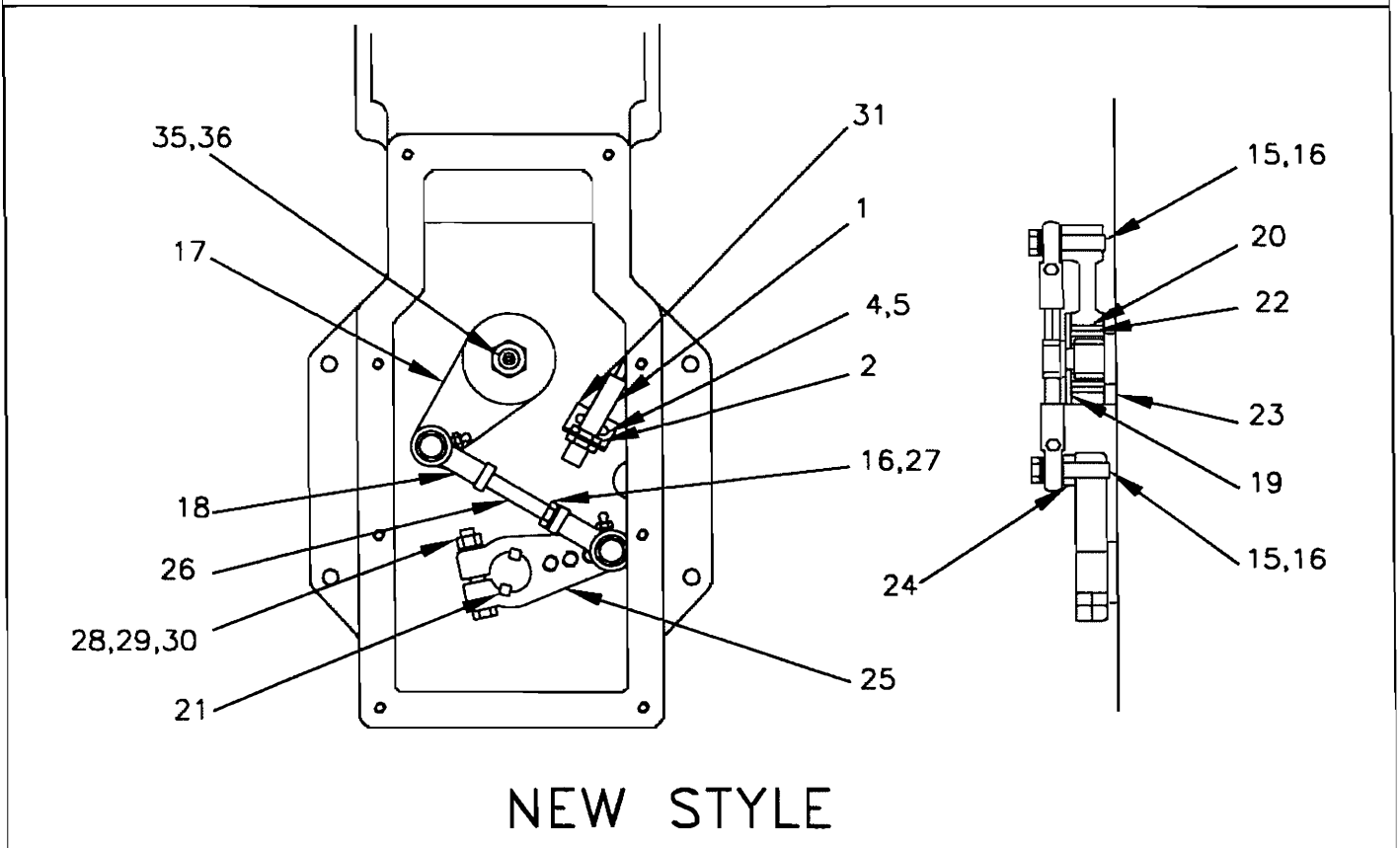


ITEM		QTY	PART NO.
1	3/8-16 X 3 HH BOLT	2	716360153
2	3/8 SPLIT LOCKWASHER	4	756000591
3	ROCKER ARM ASSY (INCL. ITEM 7)	2	480-0447
4	ROLLER SHAFT	1	480-0192
5	ROLLER-RAM DRIVE	1	480-0193
6	YOKE-RAM DRIVE	1	480-0117
7	FLANGE BEARING	4	480-0295
8	3/8-16 HEX NUT	2	736005123
9	PIN-QUICK RELEASE	1	480-0301
10	ROD-RAM	1	480-0120
11	1/4 ROLL PIN	1	764051640
12	RAM	1	480-0118
13	BRACKET	1	480-0244
14	1/4-20 X 3/4 HHCS	2	7140602530
15	1/4 SPLIT LOCKWASHER	2	7540005400
16	1/4 EXTERNAL TOOTH LOCKWASHER	2	7540001910
17	BEARING	1	879-0758

# HOPPER INDEX MECHANISM



OLD STYLE

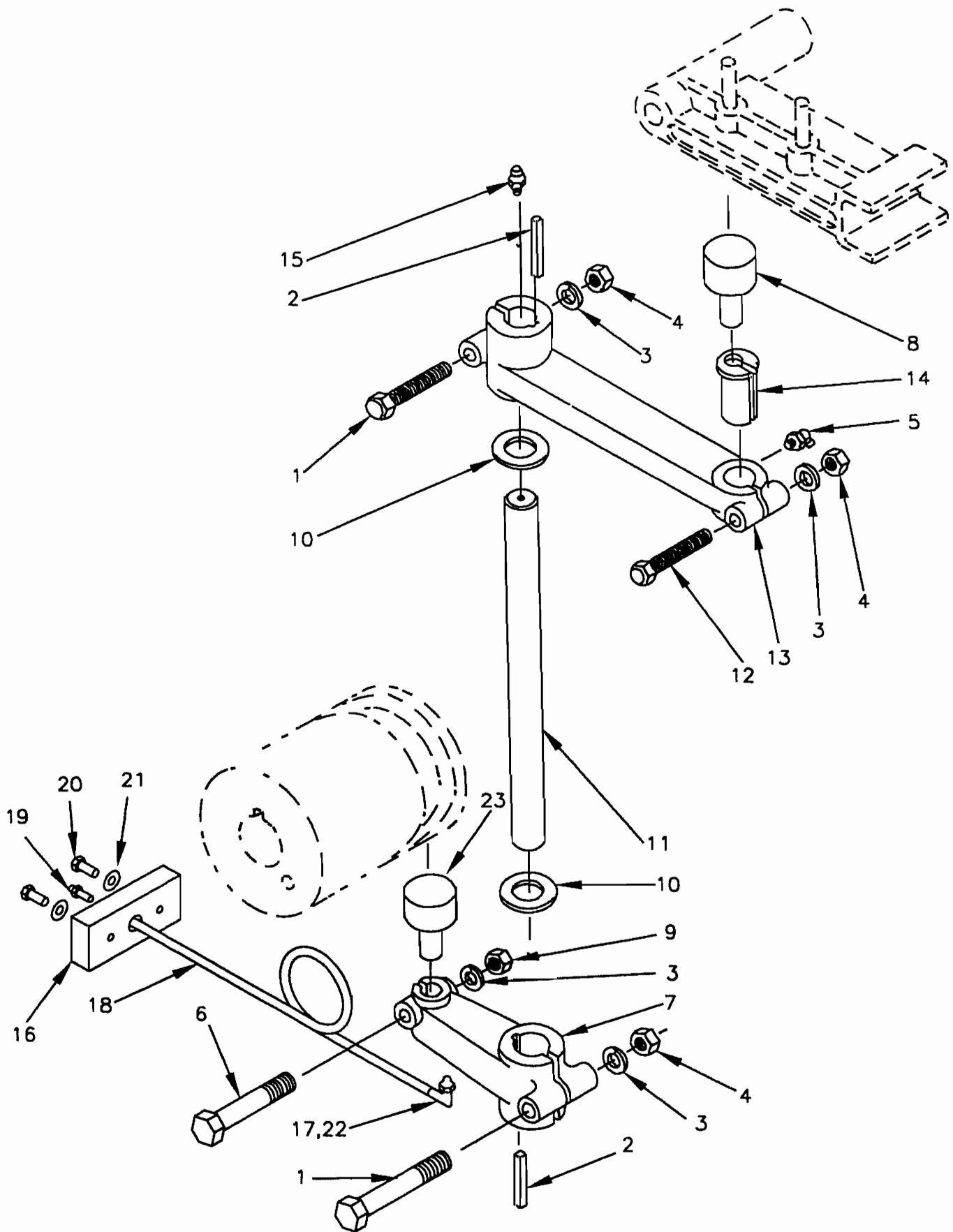


NEW STYLE

# HOPPER INDEX MECHANISM

ITEM		QTY	PART NUMBER
1	SENSOR-COUNTER	1	879-2252
2	(INCLUDED WITH ITEM 1)		
3	BRACKET-PROXIMITY SWITCH	1	480-0644
4	#10 SPLIT LOCKWASHER	2	753000591
5	#10-24 X 1/2 HHMS	2	713042123
6	1/2 SPLIT LOCKWASHER	2	758000591
7	1/3-13 X 1 HHCS	1	718100253
8	PICKUP POINTER	1	480-0645
9	CHANGE GEAR-50 T	1	480-0445
10	1/2-13 HEX NUT	1	738005123
11	SPACER WASHER	2	500-0604
12	CHANGE GEAR-76 T	1	480-0446
13	1/4 SQ X 23/32 KEY	4	480-0104
14			
15	3/8-16 X 1 5/8 HHCS	2	716150253
16	3/8 SPLIT LOCKWASHER	3	756000591
17	DRIVEN LINK	1	480-1048
18	ROD END	2	480-1057
19	RETAINER-OUTER	1	480-1053
20	CLUTCH-ONE WAY	1	480-1056
21	.215 X .250 X .800 KEY	4	480-1059
22	BUSHING-CLUTCH	1	480-1052
23	RETAINER-INNER	1	480-1054
24	SPACER	1	480-1055
25	DRIVE LINK	1	480-1047
26	ROD-CONNECTING	1	480-1058
27	3/8-24 HEX NUT	1	746005123
28	5/16-18 X 2 HHCS	1	715200253
29	5/16 SPLIT LOCKWASHER	1	755000591
30	5/16-18 HEX NUT	1	735005153
31	BRACKET-PROXIMITY SWITCH	1	480-0644
32	CORD-CLAMP-90 DEGREE	1	860-0518
33	CORD GRIP	1	580-8041
34	LOCKNUT 1/2 NPT	1	860-0525
35	5/8-18 JAM NUT	1	749008223
36	5/8 SPLIT LOCKWASHER	1	759000591

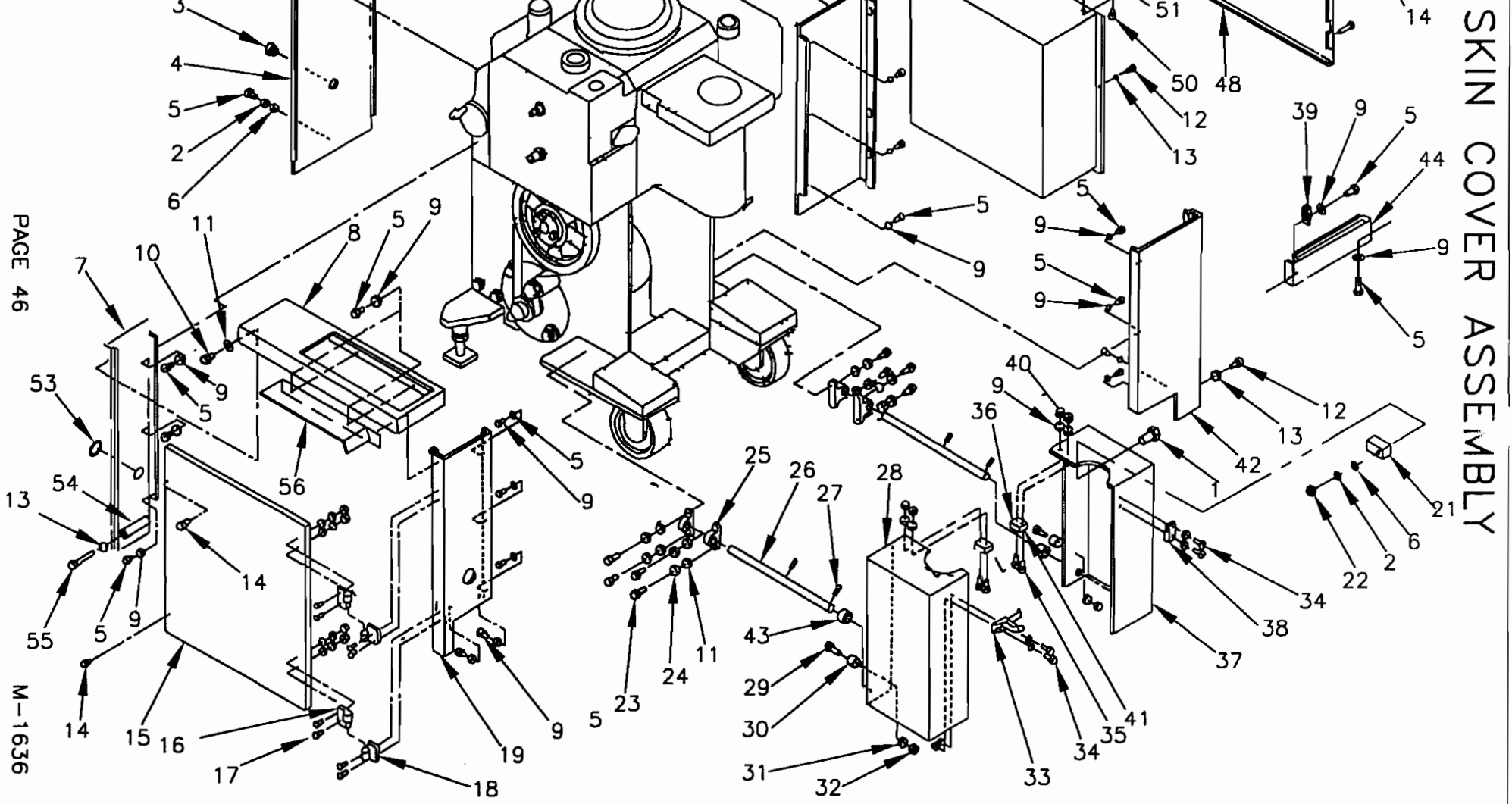
# MOLD PLATE DRIVE LEVER ASSEMBLY



# MOLD PLATE DRIVE LEVER ASSEMBLY

## 480-0629

ITEM		QTY	PART NUMBER
1	1/2-13 X 3-1/4 HHCS	2	718320253
2	3/8 SQ X 2 KEY	2	480-0092
3	1/2 SPLIT LOCKWASHER	4	758000591
4	1/2-13 HEX NUT	3	738005153
5	GREASE FITTING 1/4-28 X 90 DEG.	1	625-0633
6	1/2-20 X 2 SHCS	1	728200393
7	ARM-LOWER MOLD PLATE DRIVE	1	480-0090
8	CAM ROLLER-M.P. DRIVE ARM	1	480-0575
9	1/2-20 HEXT NUT	1	748005153
10	THRUST BEARING	2	480-0093
11	SHAFT-MOLD PLATE DRIVE	1	480-0079
12	1/2-13 X 2-7/8 HHCS	1	718270253
13	ARM-UPPER M.P. DRIVE	1	480-0091
14	ADJ. BUSHING-UPPER M.P. DRIVE	1	480-0594
15	GREASE FITTING	1	840-1074
16	BLOCK FITTING	1	480-1060
17	CONNECTOR ASSEMBLY	2	150-1972
18	GREASE LINE	1	150-9168
19	GREASE FITTING	1	2406
20	1/4-20 X 1-1/4 HHCS	2	714120240
21	1/4 LOCKWASHER	2	754000540
22	ELBOW-90 DEGREE	1	150-2526
23	CAM ROLLER-LOWER M.P. DRIVE ARM	1	480-0035



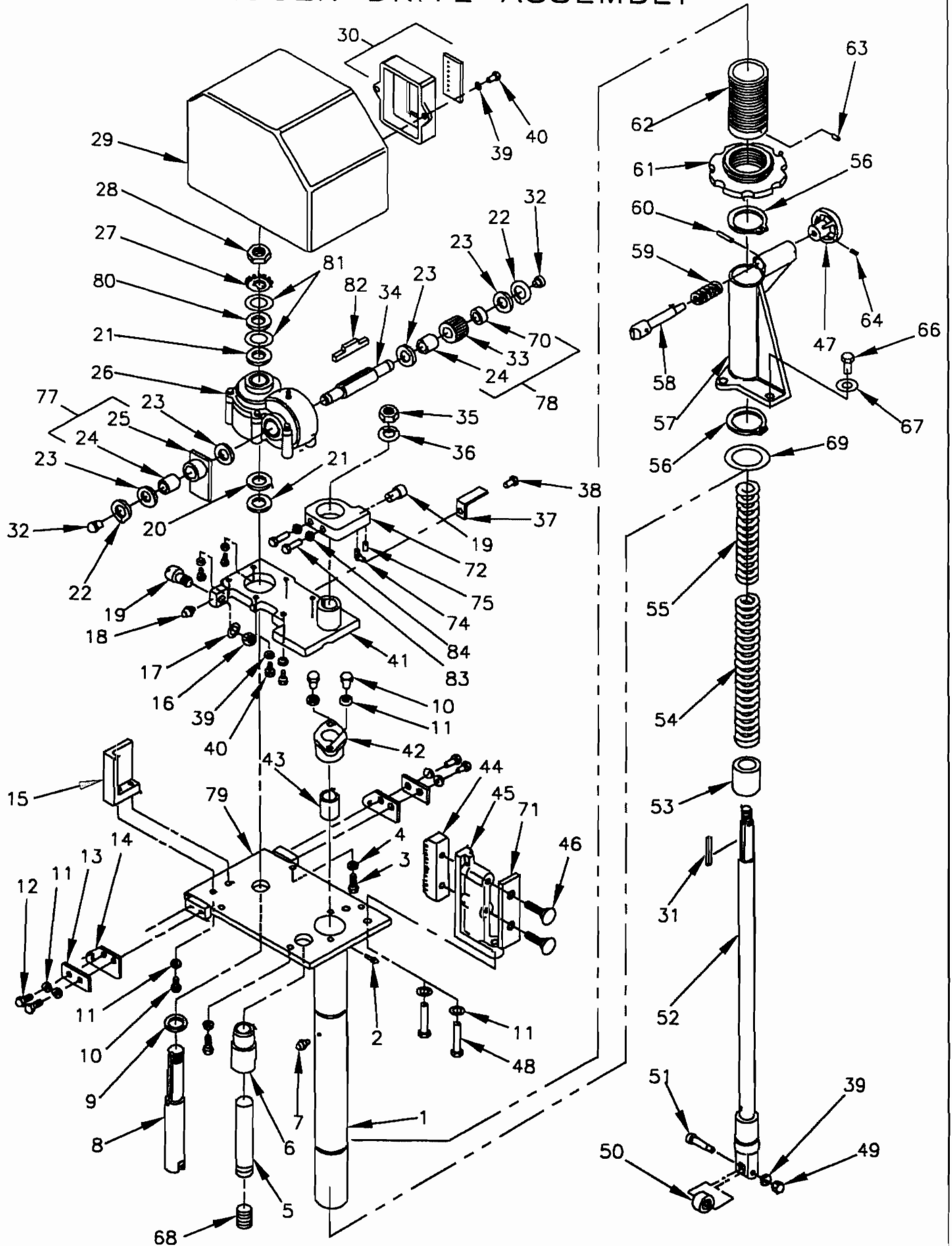
SKIN COVER ASSEMBLY

# SKIN COVER ASSEMBLY

ITEM		QTY	PART NUMBER
1	#10-32 X 1 HEX HEAD CAP SCREW	3	723100240
2	#10 SPLIT LOCKWASHER	4	753000591
3	1" DIA. PLUG BUTTON	2	2469
4	PANEL WELDMENT-LEFT	1	480-0643
5	#10-32 X 1/2 HEX HEAD CAP SCREW	25	723040223
6	#10 FLAT WASHER	2	753000191
7	PANEL WELDMENT-FRONT, LEFT	1	480-1176
8	COVER-FRONT	1	480-1179
9	#10 EXTERNAL TOOTH LOCKWASHER	28	753000791
10	1/4-20 X 1/2 HEX HEAD CAP SCREW	4	714040240
11	1/4 FLAT WASHER	12	754000191
12	1/4-20 X 1/2 PHMS	7	714041640
13	1/4 EXTERNAL TOOTH LOCKWASHER	9	754000191
14	1/4-20 X 1 HEX HEAD CAP SCREW	4	714100240
15	DOOR-FRONT	1	480-0377
16	TOP DOOR HINGE PLATE	4	500-0799
17	SCREW ASS'T (HINGE PLATE)	16	500-0928
18	LOWER DOOR HINGE PLATE	4	500-0833
19	PANEL WELDMENT-FRONT, RIGHT	1	480-1178
20			
21	CORD CLAMP (SINGLE)	1	80005876
22	#10-32 HEX NUT	1	743005123
23	1/4-20 X 3/4 HEX HEAD CAP SCREW	8	714060253
24	1/4 SPLIT LOCKWASHER	8	754000591
25	BRACKET	5	480-0244
26	SHAFT-RAM GUARD	2	480-0246
27	1/4 X 1 1/4 ROLL PIN	4	764121691
28	GUARD WELDMENT-RAM FRONT	1	480-0237
29	5/16-18 HSH SHOULDER BOLT	2	840-2821
30	BUMPER	2	840-2822
31	5/16 SPLIT LOCKWASHER	2	755000591
32	5/16-18 HEX NUT	2	735005153
33	DRAW LATCH	1	120-0063
34	BOLT ASS'T (LATCH)	4	120-0121
35	#10-24 X 3/4 HEX HEAD CAP SCREW	4	713060223
36	SAFETY SWITCH	1	879-1541
37	GUARD WELDMENT-RAM REAR	1	480-0238
38	KEEPER-LATCH	1	120-0064
39	CORD CLAMP	1	500-0930
40	#100-24 HEX NUT	4	733005123
41	ACTUATOR SAFETY SWITCH	1	879-0934
42	PANEL WELDMENT-REAR RIGHT	1	480-0600
43	SPACER	2	480-0245
44	PANEL UPPER	1	480-0242
45	COVER-REAR	1	480-0367
46	PANEL WELDMENT-REAR LEFT	1	480-0601
47	ELECTRICAL BOX WELDMENT (NO WIRING) (SEE WIRING DIAGRAM)	1	480-0296
48	DOOR, REAR	1	480-1279
49	ELECT. DOOR SEAL	1	480-1050
50	1/4-20 X 5/8 HEX HEAD MACH. SCREW	3	714050253
51	1/4 INT. TOOTH LOCKWASHER	3	754000640
52	1/4-20 HEX NUT	3	734005153
53	HOLE PLUG (FIXED SPEED ONLY)	1	480-1368
54	SPACER-TUBE (3 X 13/32 OD)	2	480-1174
55	1/4-20 X 3 1/2 HHCS	2	714341440
56	SHIELD-DRIP (VARIABLE SPEED ONLY)	1	480-1377
57	HOUR METER (SEE PGS. 74 & 75)	1	900-0220



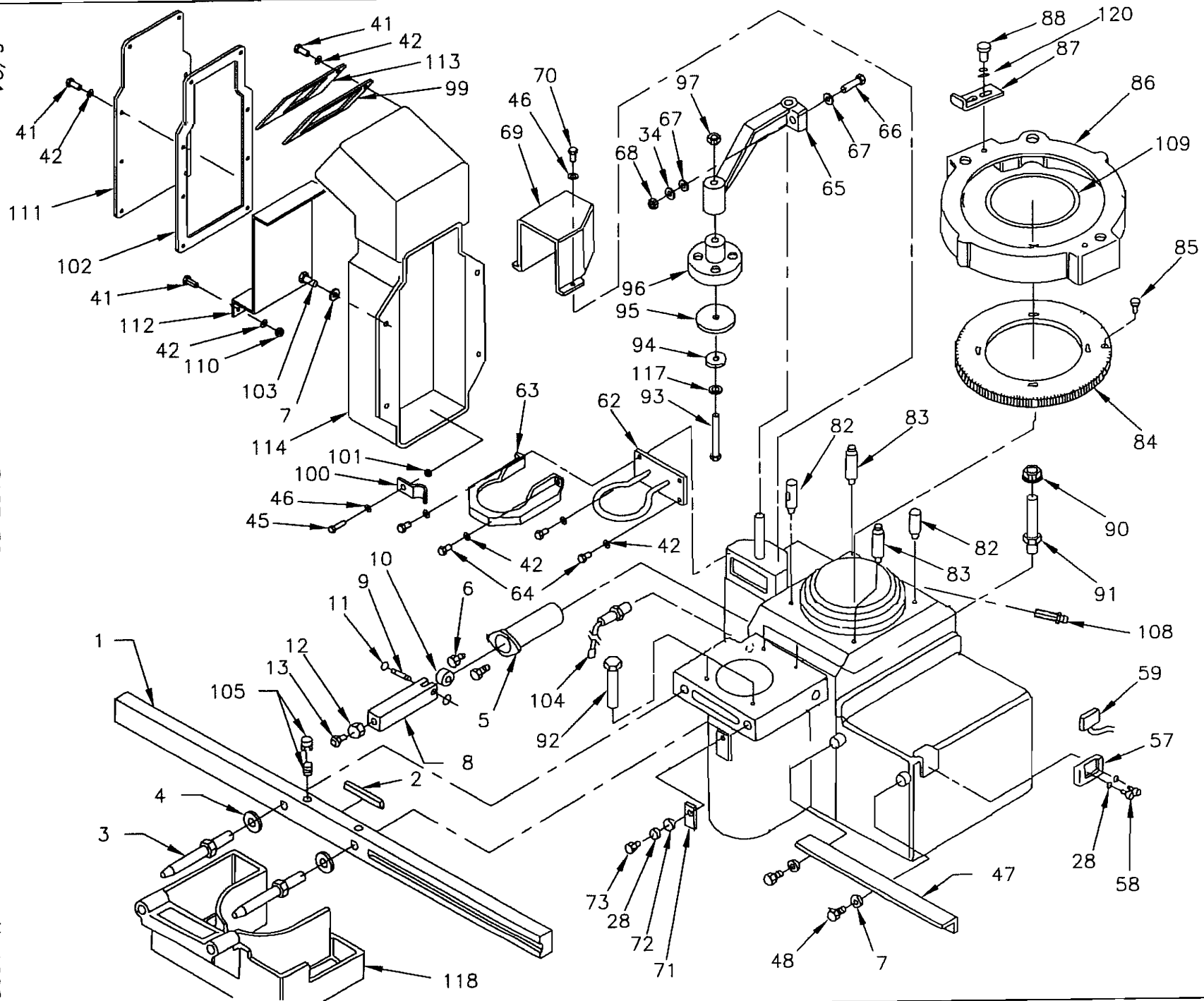
# AUGER DRIVE ASSEMBLY



## AUGER DRIVE ASSEMBLY (480-0082)

ITEM	QTY	PART NO.	ITEM	QTY	PART NO.
1	1	(SEE ITEM 79)			
2		2406	44	1	480-0460
3	4	714100253	45	1	480-0459
4	5	654000591	46	2	480-0889
5	1	480-0568	47	1	2066
6	1	(SEE ITEM 79)	48	2	716120253
7	1	480-0585	49	1	735005153
8	1	480-0489	50	1	480-0138
9	1	480-0499	51	1	100-0394
10	4	716100253	52	1	480-0490
11	10	756000591	53	1	480-0136
12	4	716070253	54	1	480-0333
13	2	480-0034	55	1	480-0331
14	2	480-0703	56	2	480-0036
15	1	480-0461	57	1	480-0335
16	1	747008223	58	1	480-0334
17	1	757000591	59	1	7005
18	1	800-1075	60	1	764121691
19	2	879-0010	61	1	480-0565
20	1	480-0744	62	1	480-0566
21	2	480-0745	63	1	763061691
22	2	774001093	64	1	714034593
23	4	480-0477	65	5	715100253
24	2	625-3440	66	3	718120183
25	1	(SEE ITEM 77)	67	3	758000591
26	1	480-0500	68	1	580-5020
27	1	480-0743	69	AR	480-0842
28	1	480-0742	70	1	480-0827
29	1	480-0831	71	1	480-0887
30	1	480-0829	72	1	480-0888
31	1	480-0137	73		
*32	2	480-0412	74	1	625-0633
33	1	(SEE ITEM 78)	75	1	724034593
*34	1	480-0828	76		
35	1	739005153	77	1	480-0474
36	1	759000591	78	1	480-0825
37	1	480-0824	79	1	480-0631
38	1	714050253	80	1	480-0205
39	9	755000591	81	2	480-0206
40	3	715060253	82	2	480-1147
41	1	480-0470	83	2	714140440
42	1	480-0375	84	2	734008240
43	1	480-0135			

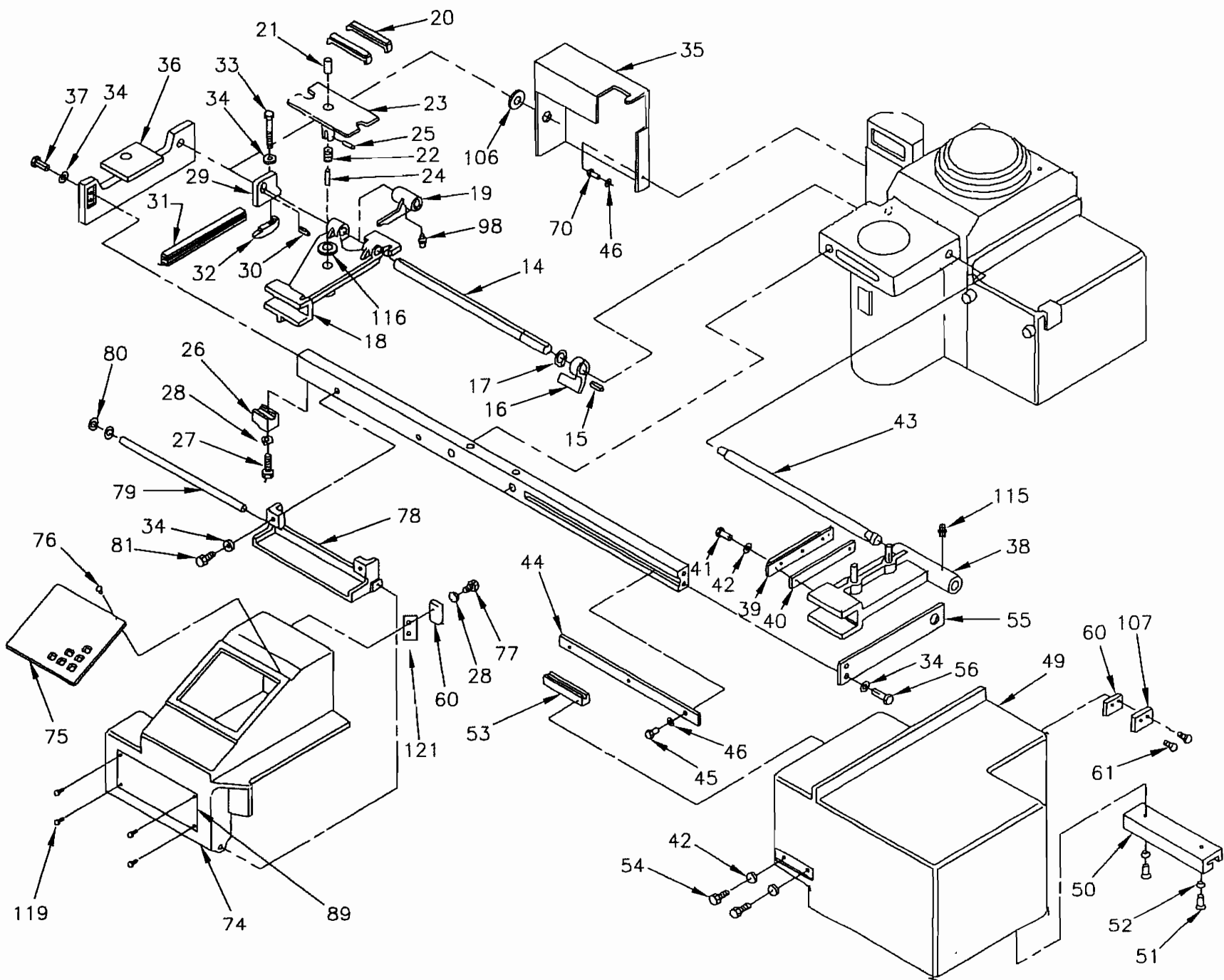
\* MUST ORDER TWO (2) OF ITEM 32 WITH ITEM 34.



MAIN SUB-ASSEMBLY

## MAIN SUBASSEMBLY

ITEM		QTY	PART NUMBER
1	GUIDE RAIL ASSY (INCLUDES ITEM 105 INSERT)	1	480-0577
2	KEY-RAIL	1	480-0183
3	BOLT-MEAT COLLECTOR	2	480-0373
4	1/2 SPLIT LOCKWASHER	2	758000591
5	ACTUATOR GUIDE ASSY	1	480-0062
6	5/16-18 X 3/4 HEX HEAD CAP SCREW	2	715060253
7	5/16 SPLIT LOCKWASHER	6	755000591
8	ROD	1	480-0057
9	SHAFT	1	480-0053
10	CAM ROLLER	1	480-0058
11	1/4 RETAINING RING	2	770001040
12	1/2-20 HEX JAM NUT	1	748008253
13	LOCATING BUTTON	1	480-0449
14	SHAFT-P.F. ACTUATOR	1	480-0075
15	KEY-P.F. ACTUATOR	1	480-0630
16	ACTUATOR-P.F.	1	480-0056
17	1" RETAINING RING	1	776001093
18	SHUTTLE	1	480-0072
19	PAPER LIFT ARM ASSY	1	480-0051
20	PAPER LIFT RUBBER CLIP	2	500-0443
21	PAPER LIFT PLUG-SET SCREW	1	714043740
22	SPRING	1	500-0433
23	PAPER LIFT WELDMENT	1	518-0592
24	1/4 DIA X 3/4 DOWEL PIN	1	764062091
25	CROSS PIN	1	765052191
26	RETAINER	1	480-0063
27	#10-24 X 1 1/2 HEX HEAD MACH SCREW	1	713142123
28	#10 INTERNAL TOOTH LOCK WASHER	6	753000640
29	BRACKET-SPRING	1	480-0054
30	KEY-SPRING BRACKET	1	480-0074
31	SPRING-P.F. RETURN	6	480-0064
32	RETAINER-SPRING	1	480-0055
33	3/8-16 X 3 1/4 HEX HEAD CAP SCREW	1	716320253
34	3/8 SPLIT LOCKWASHER	8	756000593
35	GUARD-LRG. P.F. SHUTTLE	1	480-0329
36	FRONT PLATE ASSY	1	480-1189
37	3/8-16 X 1 HEX HEAD CAP SCREW	2	716100253
38	M.P. SHUTTLE DRIVE ASSY	1	480-0210
39	BUMPER ASSEMBLY	1	480-0615
40	SHIM-BUMPER (.030 THK)	A/R	480-0616
41	1/4-20 X 5/8 HEX HEAD CAP SCREW	18	714050240
42	1/4 SPLIT LOCKWASHER	24	754000591
43	SHAFT-M.P. GUIDE	1	480-0185
44	RETAINER-GUIDE RAIL	1	480-0543
45	#10-24 X 5/8 HEX HEAD MACH SCREW	3	713052153
46	#10 SPLIT LOCKWASHER	9	753000591
47	RAIL-M.P. SLIDE	1	480-0620
48	5/16-18 X 1 HEX HEAD CAP SCREW	2	715100253
49	SHUTTLE DRIVE GUARD	1	480-0556
50	LEFT SLIDE-M.P. GUARD	1	480-0622
51	5/16-18 X 3/4 HSFHCS	2	715060730
52	5/16 EXTERNAL TOOTH CONICAL L/W	2	755000393
53	RIGHT SLIDE-M.P. GUARD	1	480-0425
54	1/4-20 X 1 1/4 HEX HEAD CAP SCREW SS	2	714120240
55	PLATE-REAR	1	480-0427
56	3/8-16 X 7/8 HEX HEAD CAP SCREW	2	716070253
57	INSULATOR (SHUTTLE DRIVE GUARD)	1	879-1152
58	#10-24 X 1 HEX HEAD CAP SCREW	2	713100293
59	SAFETY SWITCH	1	879-0933

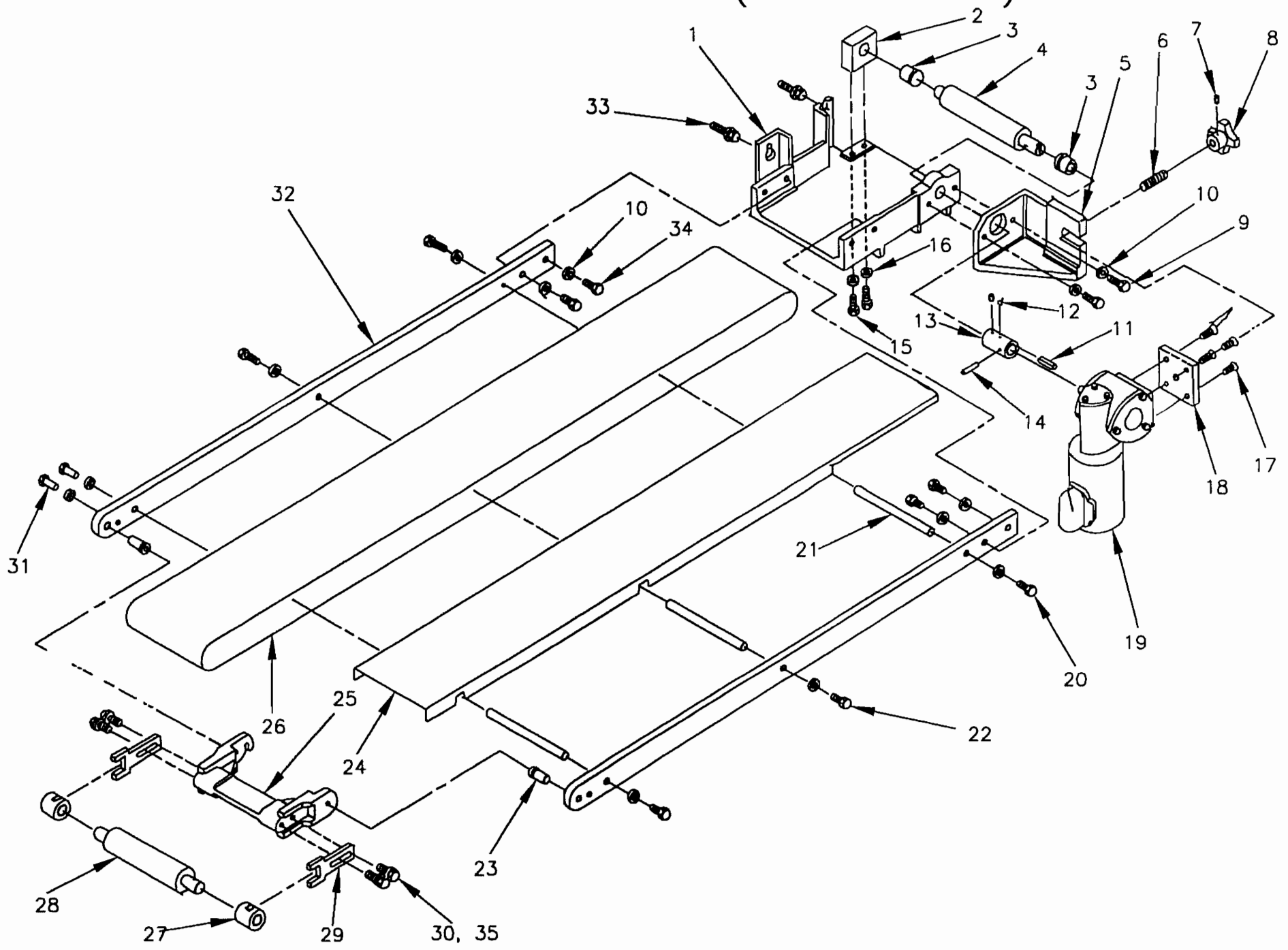


MAIN SUB-ASSEMBLY

# MAIN SUBASSEMBLY

ITEM		QTY	PART NUMBER
60	ACTUATOR-SAFETY SWITCH	2	879-0934
61	#10-24 X 3/4 FLAT HEAD MACH SCREW	2	713061823
62	HEATER-K.O. CUP WELDMENT	1	480-0380
63	REFLECTOR-K.O. HEATER WELDMENT	1	480-0416
64	1/4-20 X 5/8 HEX HEAD CAP SCREW	4	714050253
65	ARM-K.O. CUP	1	480-1285
66	3/8-16 X 1 1/2 HEX HEAD CAP SCREW	1	716140253
67	3/8 FLAT WASHER	2	756000191
68	3/8-16 HEX NUT	1	745005153
69	GUARD-K.O. ARM WELDMENT	1	480-0415
70	#10-24 X 1/2 HEX HEAD MACH SCREW	3	713042123
71	VENT FLAP	1	480-0509
72	SHOULDER SCREW	1	480-0510
73	#10-32 X 3/8 HEX HEAD MACH SCREW	1	723032140
74	GUARD-K.O.	1	480-0564
	GUARD-K.O. (ROTO-FLOW MACHINE)	1	480-1237
75	PLATE-K.O. GUARD	1	480-0569
76	DRIVE SCREW-K.O. GUARD	8	480-0570
77	#10-24 X 3/4 HEX HEAD MACH SCREW	2	713062191
78	HINGE-K.O. GUARD	1	480-0563
79	HINGE PIN-K.O. GUARD	1	480-0571
80	5/16 RETAINING RING	2	480-0819
81	3/8-16 X 1 1/8	2	716110253
82	SPACER-GEAR COVER	2	480-0184
83	SPACER-GEAR COVER LOCK	2	480-0530
84	DRIVE GEAR-HOPPER	1	480-0531
85	WEAR PLUG-DRIVE GEAR	4	480-0532
86	COVER-DRIVE GEAR	1	480-0526
87	LATCH COVER	2	480-0528
88	SHOULDER RIVET	2	480-0529
89	NAMEPLATE	1	480-0649
90	FLANGE NUT-TOP PLATE	2	480-0284
91	STUD-TOP PLATE	2	480-0286
92	BOLT ASSORTMENT-TOP PLATE	2	480-0654
93	BOLT-K.O. CUP 3-3/4 LG	1	500-0791
	BOLT-K.O. CUP 4 LG	1	500-0794
94	STEPPED WASHER	1	518-0540
95	METAL VALVE	1	518-0539
96	K.O. CUP	A/R	SEE PAGE 60
97	5/16-18 HEX NUT	1	735005240
98	GREASE FITTING-STRAIGHT	1	800-1075
99	GASKET-COUNTER MTG. PLATE	1	480-1297
100	CORD CLIP	3	500-0930
101	#10-24 HEX NUT	3	733005123
102	GASKET-SWITCH PLATE	1	480-1296
103	5/16-18 X 3/4 HEX HD CAP SCREW	4	715060453
104	PROXIMITY SWITCH-FILL PLATE	1	244-0376
105	THREADED INSERT	2	879-1163
106	SPACER WASHER	1	2063
107	REINF. HSG. ACTUATOR	1	879-1148
108	GREASE FITTING	1	2406
109	"O" RING HOPPER	1	480-0910
110	1/4-20 HEX NUT	2	734005153
111	PLATE-SWITCH MOUNTING	1	480-1092
112	SHIELD	1	480-1093
113	PLATE-COUNTER MOUNTING	1	480-1490
114	CASTING-CONTROL BOX	1	480-1090
115	GREASE FITTING	1	840-1074
116	SPACER-PLASTIC	1	879-1216
117	5/16 SPLIT LOCKWASHER	1	755000540
118	MEAT COLLECTOR-TRAY	1	480-0371
119	DRIVE RIVET	4	500-0996
120	WASHER-WAVE SPRING	2	480-1294
6/04 121	SPACER BLOCK	1	480-0574 M-1693

# CONVEYOR ASSEMBLY (FABRIC BELT)



# CONVEYOR ASSEMBLY (FABRIC BELT)

ITEM		QTY	PART NUMBER
1	MOUNTING BRACKET ASSY (INCL (1) #3)	1	480-0612
2	BEARING BLOCK-CONVEYOR	1	480-0606
3	BEARING-CONVEYOR	2	480-0607
4	DRIVE ROLLER-CONVEYOR	1	480-0617
5	MOTOR MOUNT-CONVEYOR	1	480-0605
6	STUD	1	480-0144
7	1/8 X 1 ROLL PIN	1	762101691
8	KNOB	1	480-0143
9	5/16-18 X 1 1/4 HEX HEAD CAP SCREW	2	715120440
10	5/16 SPLIT LOCKWASHER	6	755000540
11	3/16 SQ X 1 1/8 KEY	1	500-0133
12	#10-24 X 1/4 HEX SOCKET SET SCREW	2	713024540
13	COUPLING ASSY (INCL #14)	1	480-0613
14	1/8 X 1 1/4 DOWEL PIN (S.S.)	1	762122040
15	1/4-20 X 1 HEX HEAD CAP SCREW	2	714100240
16	1/4 SPLIT LOCKWASHER	2	754000540
17	1/4-20 X 3/4 SFHS	4	714061823
18	MOTOR BLOCK	1	480-0148
19	MOTOR	1	480-0724
20	BOLT ASSORTMENT	6	879-1231
21	SPACER-SIDE RAIL	3	879-0298
22	RH SIDE RAIL-CONVEYOR	1	480-0610
23	RAIL STUD	2	300-0130
24	BELT SUPPORT	1	480-0611
25	LOCK BRACKET	1	879-2028
26	FABRIC BELT (4 FT)	1	879-1765
27	BEARING-CONVEYOR IDLER	2	879-2030
28	IDLER ROLLER ASSEMBLY	1	879-0804
29	IDLER ADJUSTING PLATE	2	879-2029
30	5/16 FLAT WASHER	4	755000240
31	BOLT ASSORTMENT	1	879-1232
32	LH SIDE RAIL-CONVEYOR	1	480-0609
33	FLANGE SCREW-CONVEYOR	2	480-0737
34	5/16-18 X 3/4 HEX HEAD CAP SCREW	4	715060240
35	5/16 X 24 X 1 HHCS SS	4	725100240

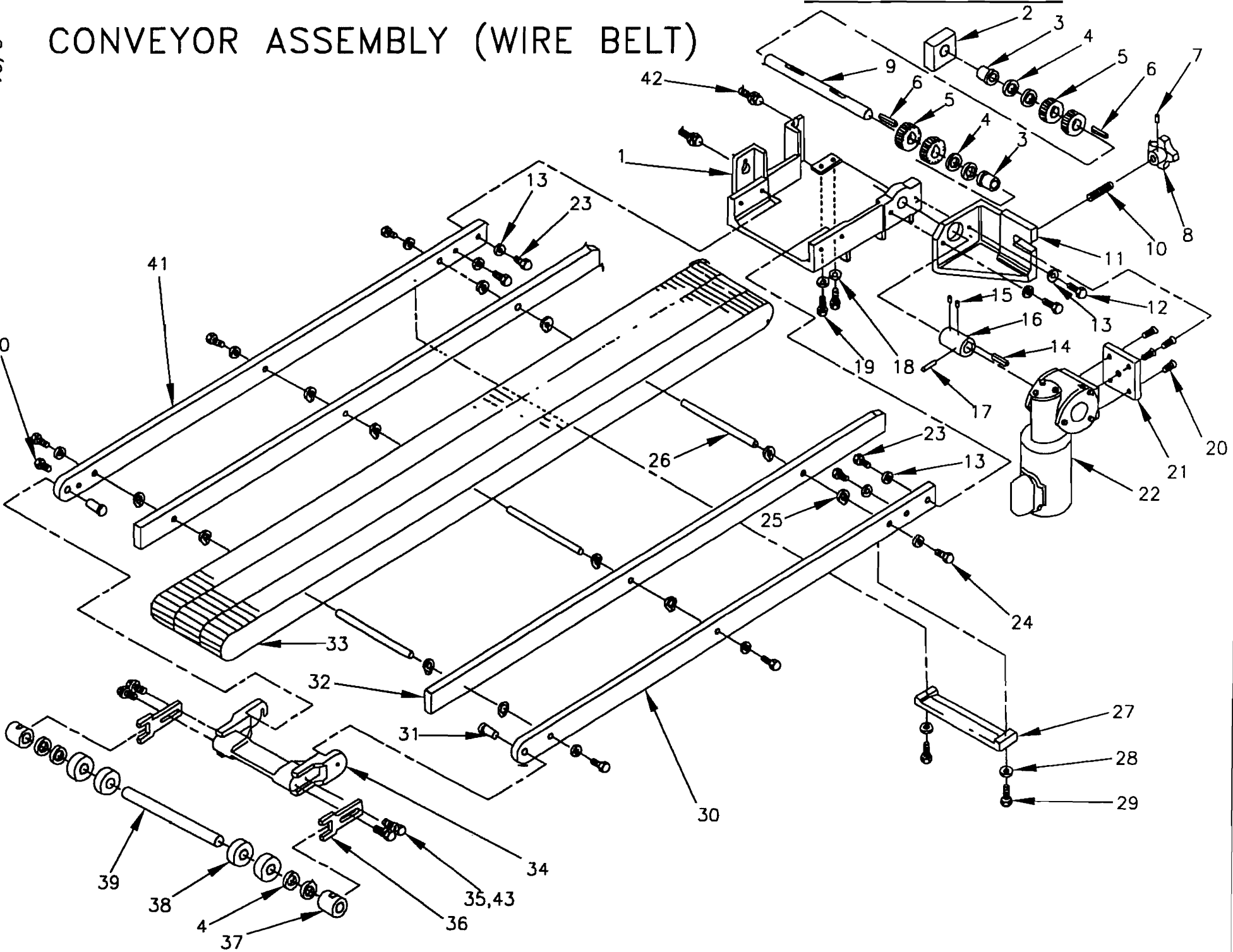


# CONVEYOR ASSEMBLY (WIRE BELT)

6/01

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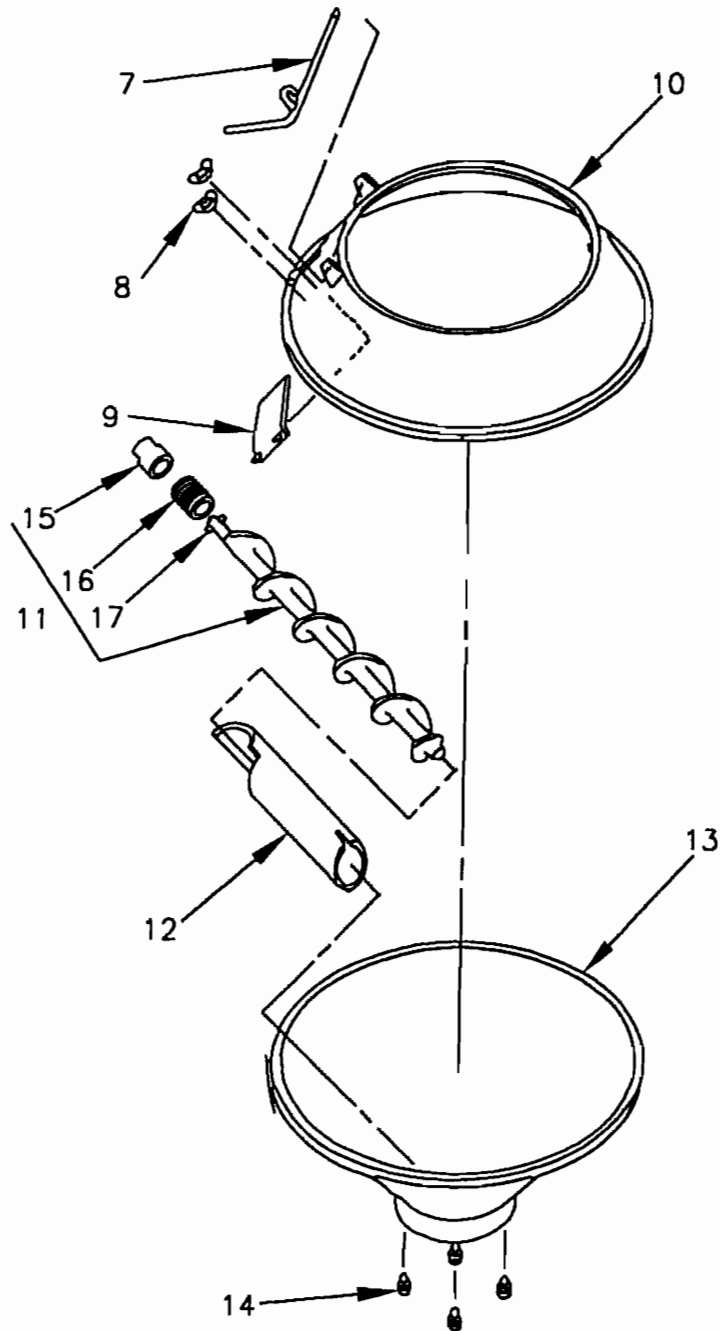
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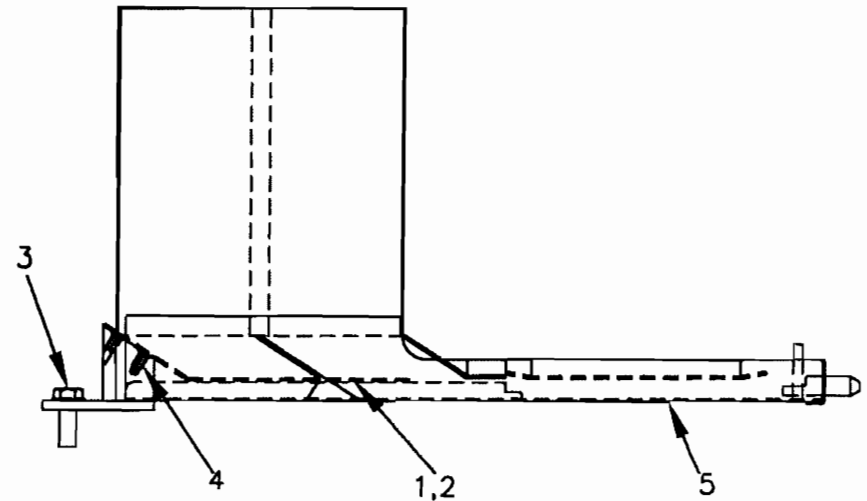
# CONVEYOR ASSEMBLY (WIRE BELT)

ITEM		QTY	PART NUMBER
1	MOUNTING BRACKET ASSY (INCL (1) #3)	1	480-0612
2	BEARING BLOCK-CONVEYOR	1	480-0606
3	BEARING-CONVEYOR	2	480-0607
4	SPACER	8	879-1216
5	DRIVE GEAR	4	535-0261
6	3/16 SQ X 1 1/2 KEY (S.S.)	2	879-1471
7	1/8 X 1 ROLL PIN	1	762101691
8	KNOB	1	480-0143
9	DRIVE SHAFT	1	480-0795
10	STUD	1	480-0144
11	MOTOR MOUNT-CONVEYOR	1	480-0605
12	5/16-18 X 1 1/4 HEX HEAD CAP SCREW	2	715120440
13	5/16 SPLIT LOCKWASHER	6	755000540
14	3/16 SQ X 1 1/8 KEY	1	500-0133
15	#10-24 X 1/4 HEX SOCKET SET SCREW	2	713024540
16	COUPLING ASSY (INCL #17)	1	480-0613
17	1/8 X 1 1/4 DOWEL PIN (S.S.)	1	762122040
18	1/4 SPLIT LOCKWASHER	2	754000540
19	1/4-20 X 1 HEX HEAD CAP SCREW	2	714100240
20	1/4-20 X 3/4 SFHS	4	714061823
21	MOTOR BLOCK	1	480-0148
22	MOTOR	1	480-0724
23	5/16-18 X 3/4 HEX HEAD CAP SCREW	4	715060240
24	BOLT ASSORTMENT	6	879-1231
25	RETAINING RING 5/8 DIA.	12	733002440
26	SPACER-SIDE RAIL	3	879-0298
27	GUIDE	1	480-0794
28	#10 SPLIT LOCKWASHER	2	753000591
29	#10-32 X 7/8 HEAD HEAD CAP SCREW	2	723070223
30	RH SIDE RAIL-CONVEYOR	1	480-0798
31	RAIL STUD	2	300-0130
32	SUPPORT STRIP	2	480-0812
33	WIRE BELT (S.S.)	1	879-1493
34	LOCK BRACKET	1	879-2028
35	5/16-24 X 1 HEX HEAD CAP SCREW	4	725100240
36	IDLER ADJUSTING PLATE	2	879-2029
37	BEARING-CONVEYOR IDLER	2	879-2030
38	DELTRIN BLANK	4	535-0262
39	SHAFT-IDLER ROLLER	1	879-1486
40	BOLT ASSORTMENT	1	879-1232
41	LH SIDE RAIL-CONVEYOR	1	480-0796
42	FLANGE SCREW-CONVEYOR	2	480-0737
43	5/16 I.D. FLAT WASHER	5	755000240

## HOPPER ASSEMBLY

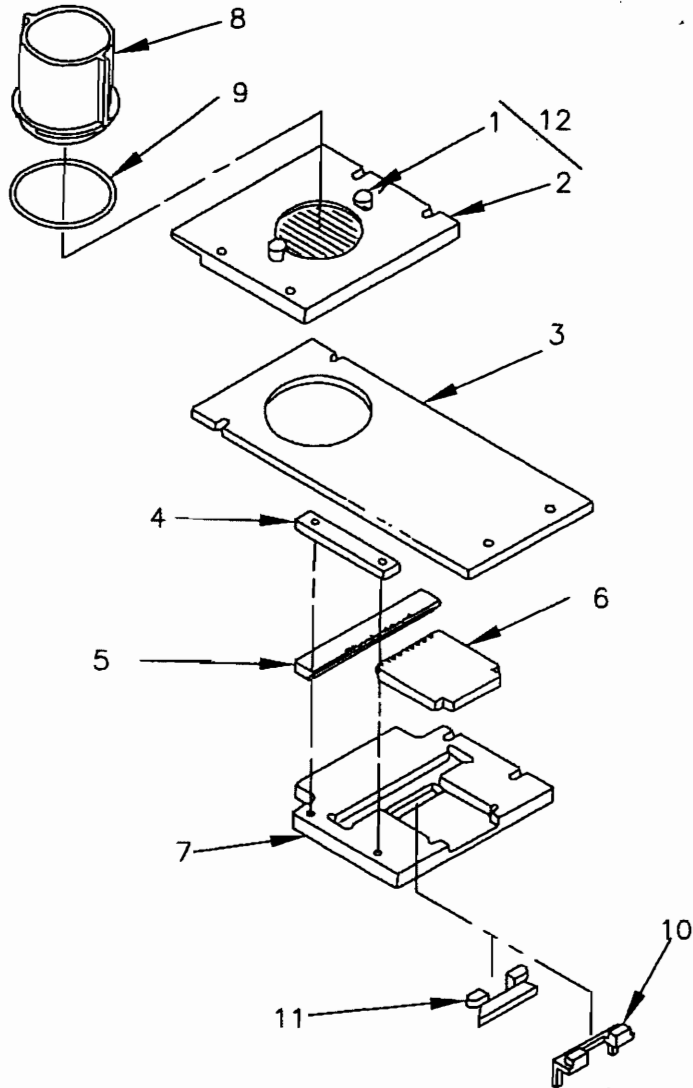


## PAPER FEED BASKETS



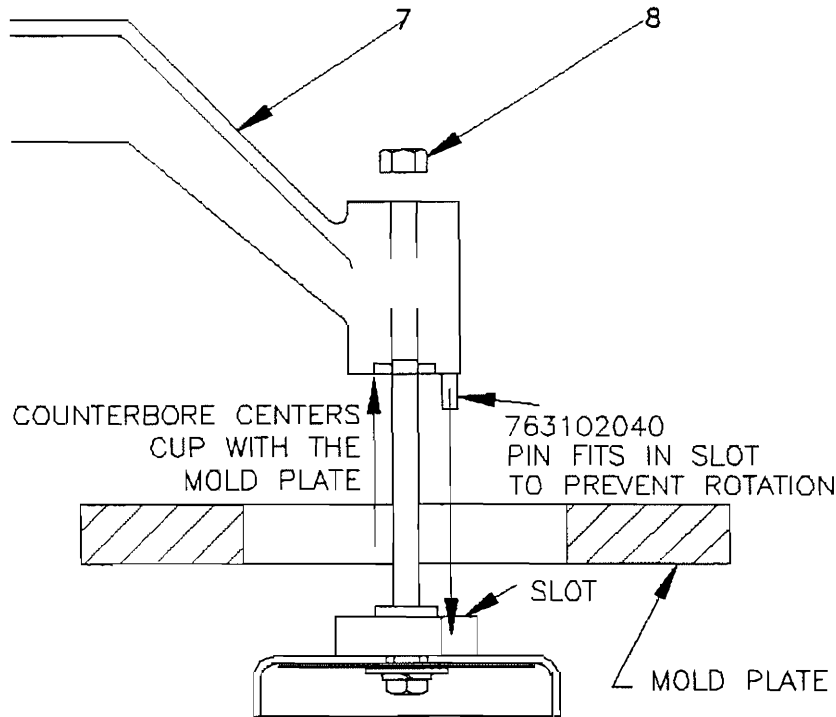
ITEM		QTY	PART NO.
1	PAPER SUPPORT (4 1/2, 5)	1	518-0595
2	PAPER SUPPORT (5 1/2, 6)	1	518-0594
3	FLANGE BOLT	1	400-0818
4	#10-24 X 3/8 F.H.S.	2	713031840
5	PAPER FEED ASSEMBLY: SIDE NOTCHED (INC. ITEMS 1, 2, AND 4)		
	4 1/2	1	518-0195
	5	1	518-0196
	5 1/2	1	518-0197
	6	1	480-1367
6	GUARD-W/O PAPER FEED (NOT SHOWN)	1	480-1394
7	CONNECTING ROD WELDMENT	1	480-0821
8	5/16-18 WING NUT	2	480-1078
9	HOPPER BAFFLE WELDMENT	1	480-0705
10	HOPPER TOP WELDMENT	1	480-0590
11	AUGER ASSEMBLY (INC. 15, 16 & 17)	1	480-1080
12	DEFLECTOR	1	480-0405
13	HOPPER	1	480-0070
14	DRIVE PIN	4	480-0647
15	LOCKING COLLAR	1	480-0899
16	SPRING-AUGER COLLAR	1	480-0900
17	DOWEL PIN	1	480-1079

## MULTI-FLOW FILL SYSTEM



ITEM	QTY	PART NO.
1	2	480-0717
2	1	480-0285
3	A/R	SPECIFY
4	A/R	SPECIFY
5	1	480-0282
		490-0950
		480-0836
6	1	480-0281
		480-0908
		480-0835
7	1	480-0280
8	1	480-0716
9	1	480-0738
10	1	480-1145
11	1	480-0873
12	1	480-0653
(INCLUDES ITEM 1 AND 2 )		

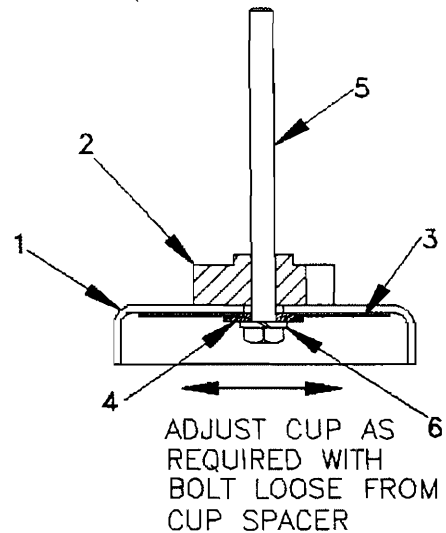
# SELF ALIGNING KNOCK OUT CUP



## NOTE:

IF THE KNOCK OUT CUP ASSEMBLY HAS BEEN PREALIGNED, IT CAN BE POSITIONED WITH THE PIN ENGAGING THE CUP SPACER AND TIGHTENED WITH THE 5/16 NUT.

IF THE CUP IS NOT PREALIGNED WITH THE MOLD PLATE IT WILL BE NECESSARY TO LOOSEN THE 5/16 BOLT RELATIVE TO THE CUP SPACER AND MOVE THE CUP UNTIL IT IS CENTERED IN THE MOLD PLATE OPENING. (SEE ILLUSTRATION BELOW)



ITEM		PART NO.
1	CUP-NON RD-SELF ALIGNING (ASSEMBLY)	480-1083
1	CUP-ROUND-SELF ALIGNING (ASSEMBLY)	480-1084
2	SPACER (3/4 TO 1 THICK PLATE)	480-1283
2	SPACER (1/2 TO 5/8 THICK PLATE)	480-1282
2	SPACER (5/16 TO 3/8 THICK PLATE)	480-1281
2	SPACER (3/16 TO 1/4 THICK PLATE)	480-1280
3	METAL VALVE	518-0539
4	STEPPED WASHER	518-0540
5	BOLT 5/16 18 UNC X 3 3/4 LG (USE WITH 1/2 TO 1 THICK PLATE)	500-0791
5	BOLT 5/16 18 UNC X 4 LG (USE WITH 3/16 TO 3/8 THICK PLATE)	500-0794
6	LOCKWASHER	755000540
7	KNOCK OUT ARM-MULTIFLOW	480-1285
7	KNOCK OUT ARM-ULTIMATE	480-1287
7	KNOCK OUT ARM-ROTO FLOW	480-1286
8	NUT 5/16 18 UNC	735005240

AN OLDER STYLE MACHINE WOULD REQUIRE THE KNOCK OUT ARM TO BE CHANGED TO BE ABLE TO USE THE NEW SELF ALIGNING CUPS.

**CAUTION:** MAKE SURE THE METAL VALVE DISC IS NOT PINCHED BETWEEN THE STEPPED SPACER AND CUP. IT SHOULD BE FREE TO SHIFT SLIGHTLY SIDWAYS AFTER THE 5/16 BOLT IS TIGHT

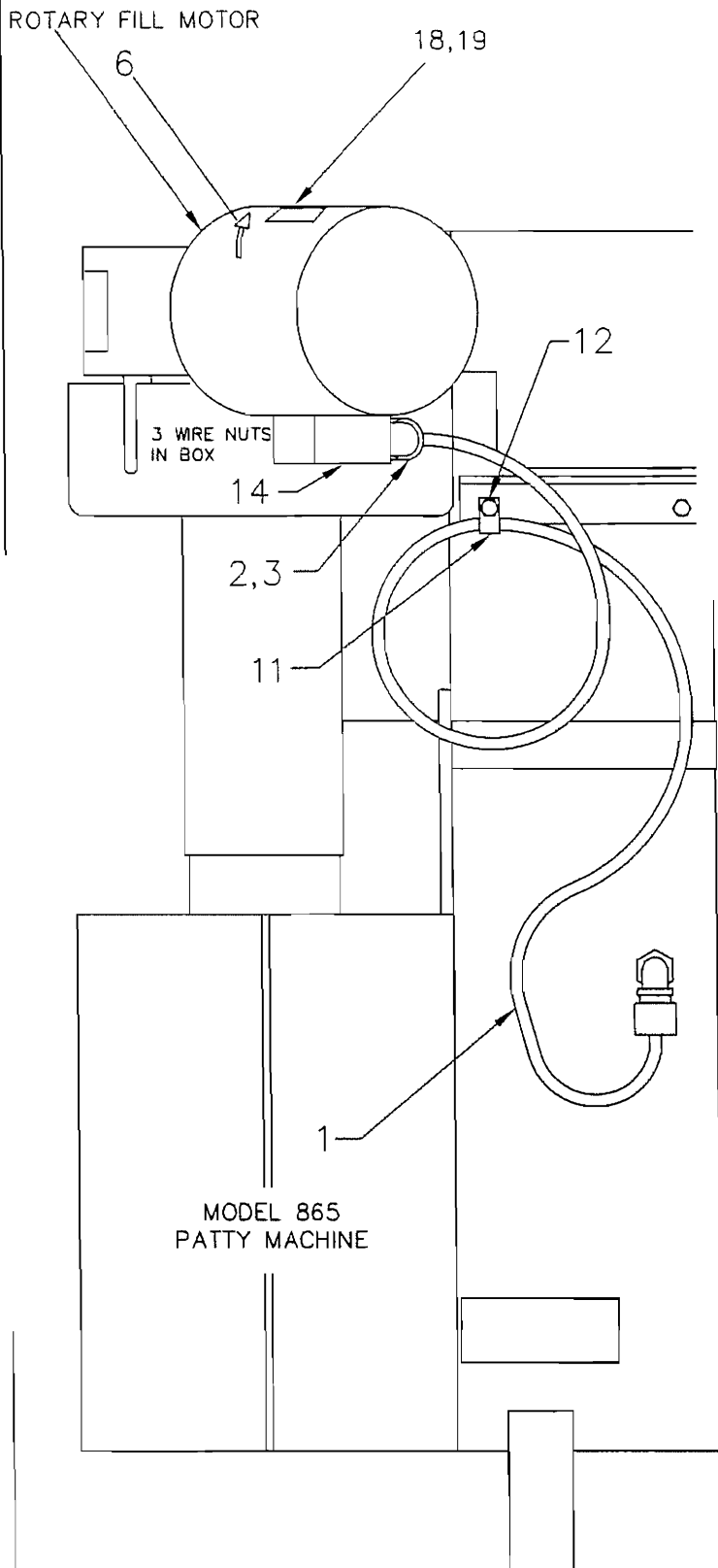
**NOTE:** ALL NEW 8/65 K.O. ASSEMBLIES WILL BE EQUIPPED WITH METAL VALVE DISCS PART NUMBER 518-0539

WHEN ORDERING COMPLETE ASSEMBLIES SPECIFY:

480-1084 FOR A ROUND-SELF ALIGNING CUP ASSEMBLY

480-1083 FOR A NON-ROUND-SELF ALIGNING CUP ASSEMBLY

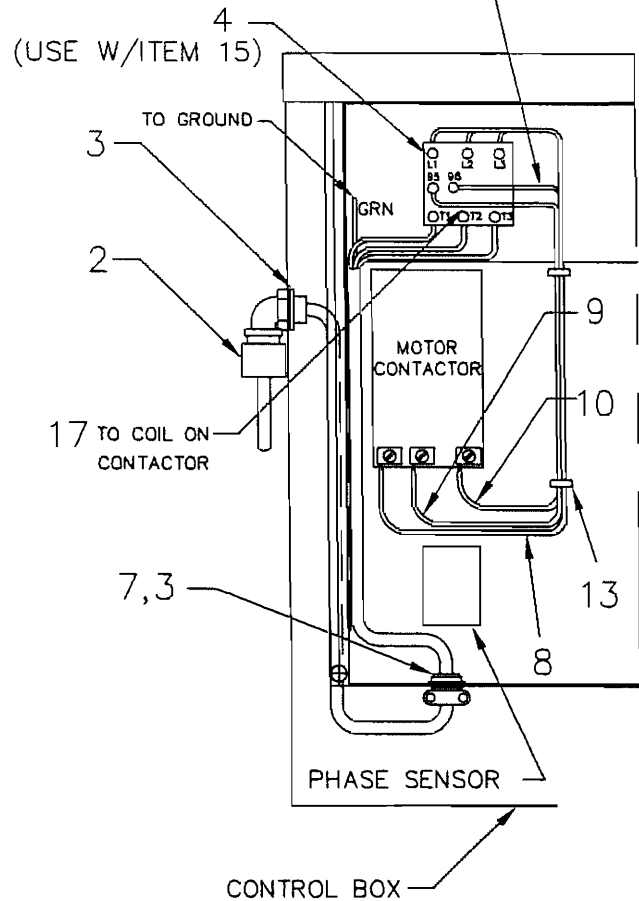
# ROTO-FLOW ELECTRICAL ASSEMBLY



ITEM	REQD	DESCRIPTION	PART NO.
1	1	CORD-MOTOR	480-1225
2	2	CORD GRIP	120-0070
3	3	NUT	400-1150
4	1	OVERLOAD RELAY ASSEMBLY	480-1529
5			
6	1	ROTATION LABEL	900-1001
7	1	CORD CLAMP	2274
8	1	WIRE (RED)	480-1226
9	1	WIRE (BLACK)	480-1227
10	1	WIRE (WHITE)	480-1228
11	1	CORD CLAMP	480-1525
12	1	5/16-18 X 1 1/4 H.H.C.S.	715120453
13	2	TIE WRAP	8000-3668
14	3	WIRE NUT	500-1264
15	2	8-32 X 3/4 P.H.SCR.	712061640
16	1	WIRE ASSY-RED	480-1513
17	1	WIRE-RED	480-1514
18	1	LABEL-ROTO-FLOW	900-1051
19	1	PATENT LABEL-FILL SYSTEM	480-1264

SEE CONTROL CIRCUIT SCHEMATIC

16 TO TERM. 8 ON PHASE MONITOR

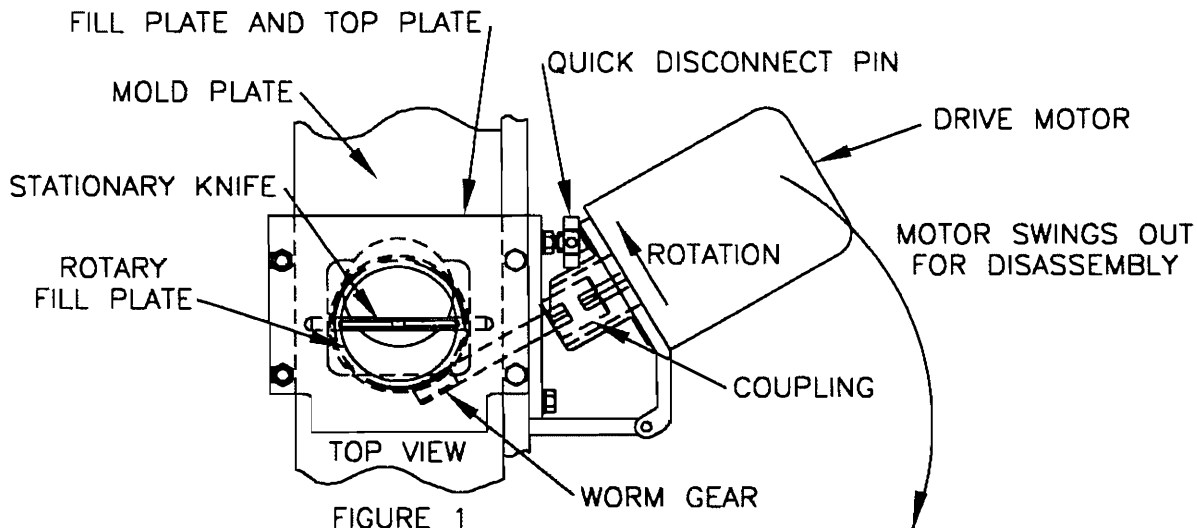


# ROTO-FLOW FILL SYSTEM

THE ROTO-FLOW FILL SYSTEM IS A FACTORY OPTION ON YOUR 8/65 PATTY MACHINE OR CAN BE SUPPLIED SEPARATELY AS A RETROFIT KIT. REVIEW THE FOLLOWING INFORMATION PRIOR TO START UP OF THE MACHINE TO BECOME FAMILIAR WITH THE OPERATION, COMPONENTS, ASSEMBLY, LUBRICATION, AND MAINTENANCE OF THE COMPONENTS.

## OPERATION AND COMPONENTS

THE ROTO-FLOW FILL SYSTEM IS POWERED BY A SEPARATE 3 PHASE MOTOR (SEE FIGURE 3) WHICH IS STARTED BY THE SAME CONTACTOR THAT STARTS THE MAIN DRIVE MOTOR FOR THE PATTY MACHINE. OVERLOAD PROTECTION IS PROVIDED BY AN OVERLOAD RELAY LOCATED IN THE TOP LEFT AREA OF THE CONTROL BOX (SEE THE ROTO-FLOW ELECTRICAL ASSEMBLY). THE MOTOR IS COUPLED TO A WORM GEAR BY A COUPLING WHICH ALLOWS THE MOTOR TO BE MOVED OUT OF POSITION SO THAT THE ROTO-FLOW PARTS CAN BE REMOVED FOR DISASSEMBLY OF PARTS.



THE MOTOR DRIVES THE WORM AND WORM GEAR CONNECTED TO THE ROTARY PLATE AT A ROTATIONAL SPEED TO INTERLEAF FIBERS OF MEAT DURING THE FILL CYCLE AND ALSO PROVIDE RELATIVE MOTION BETWEEN THE STATIONARY KNIFE AND ROTATING FILL PLATE. THIS CUTS MEAT FIBERS AT THE FILL HOLES TO KEEP THE HOLES CLEAR. THE PARTS INVOLVED IN THIS AREA ARE MADE TO CLOSE TOLERANCES AND CARE SHOULD BE TAKEN TO AVOID NICKS AND BURRS.

## ASSEMBLY AND LUBRICATION

1. WITH THE PARTS CLEAN, PLACE THE FILL PLATE (ITEM 2, PAGE 64 PARTS EXPLODED VIEW) UPSIDE DOWN ON A FLAT SURFACE. COAT THE SURFACES MARKED IN FIGURE 2 WITH A THIN LAYER OF HOLLY LUB. THIS IS NECESSARY TO PROVIDE INITIAL LUBRICATION UNTIL MEAT MOVES TO THE FILL AREA.

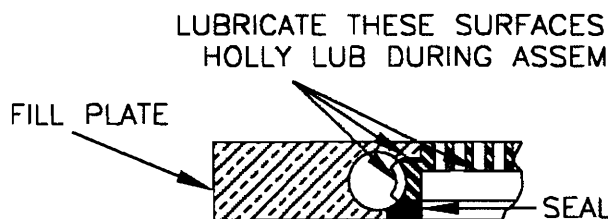


FIGURE 2

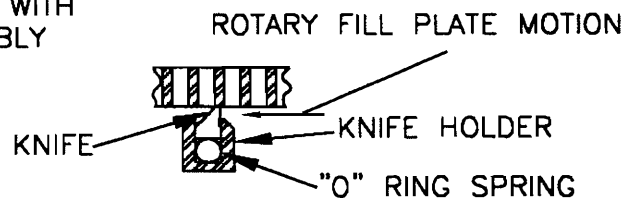


FIGURE 3

2. ASSEMBLE THE KNIFE (ITEM 5), "O" RING SPRING (ITEM 4), AND KNIFE HOLDER (ITEM 3) SEPARATELY AS SHOWN IN FIGURE 3. BE SURE THAT THE KNIFE EDGES ARE TOWARD THE ROTATING FILL PLATE (ITEM 31). IT IS POSSIBLE TO ASSEMBLE THE KNIFE UPSIDE DOWN.

# ROTO-FLOW FILL SYSTEM

3. PLACE THE ROTARY PLATE STRAIGHT DOWN INTO THE FILL PLATE. TAKE CARE NOT TO INSERT IT AT AN ANGLE WHICH WILL CAUSE IT TO BIND. BE SURE THAT THE ROTARY PLATE HAS A THRUST WASHER (ITEM 32, PAGE 64) IN POSITION. CAUTION: IF THE WASHER IS NOT INCLUDED IN THE ASSEMBLY IT WILL RESULT IN DAMAGE TO THE MOLD PLATES. WHEN THE ROTARY PLATE IS ASSEMBLED IN THE FILL PLATE IT SHOULD ROTATE FREELY. IF NOT, CHECK FOR NICKS AND BURRS.

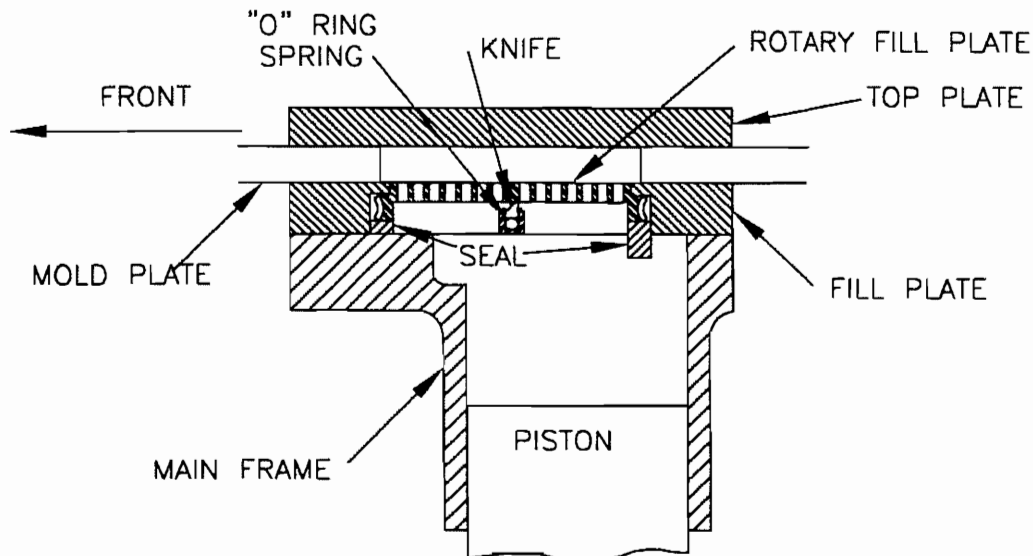


FIGURE 4

4. PLACE THE KNIFE, "O" RING SPRING AND KNIFE HOLDER ASSEMBLY INTO THE ROTARY PLATE WITH THE KNIFE EDGES TOWARD THE PLATE. YOU WILL HAVE TO HOLD THE KNIFE IN POSITION IN THE HOLDER UNTIL THE HOLDER IS ENGAGED IN THE SLOTS IN THE FILL PLATE. TO MAKE THIS ENGAGEMENT IT IS NECESSARY TO ROTATE THE HOLDER SLIGHTLY CLOCKWISE.
5. PLACE THE SEAL INTO THE KNIFE HOLDER AND DOWN INTO THE COUNTER BORE IN THE FILL PLATE SO THAT THE NARROW (1/16 WIDE) SLOT IN THE SEAL IS TOWARD THE REAR OF THE FILL PLATE. (THE SEAL IS USED TO ALIGN THE PRODUCT FLOW TO THE ROTARY FILL PLATE AND SEPARATE THE ROTARY FILL PLATE GEARING FROM THE PRODUCT FLOW ZONE.)
6. CAREFULLY TURN THE ENTIRE ASSEMBLY OVER AND LOWER TO THE MAIN FRAME. THE COMBINATION OF THE UNDERCUTS ON THE KNIFE HOLDER AND COMPRESSION OF THE SEAL WILL HOLD THE KNIFE ASSEMBLY IN POSITION WHILE THE FILL PLATE IS LOWERED ON TO THE MAIN FRAME. (SEE FIGURE 4)
7. SLIDE THE WORM SHAFT (ITEM 9, PAGE 64) INTO THE SIDE OF THE FILL PLATE TAKING CARE TO ENGAGE THE WORM GEAR ON THE ROTARY PLATE.
8. ASSEMBLE THE MOLD PLATE, SPACERS AND TOP PLATE AS YOU NORMALLY WOULD.
9. TIGHTEN THE HOLD DOWN BOLTS FIRMLY (DO NOT OVERTIGHTEN).
10. BEFORE SWINGING THE MOTOR INTO POSITION, CHECK THE POSITION OF THE FLEXIBLE COUPLING. ROTATE THE MOTOR SHAFT UNTIL APPROXIMATE ALIGNMENT IS ATTAINED.
11. SWING THE MOTOR INTO POSITION AND INSTALL THE QUICK DISCONNECT PIN. (THE BUTTON ON THE END OF THE PIN MUST BE DEPRESSED TO ENGAGE THE PIN). COMPLETE THE REST OF THE NORMAL ASSEMBLY AS OUTLINED PREVIOUSLY.



# ROTO-FLOW FILL SYSTEM

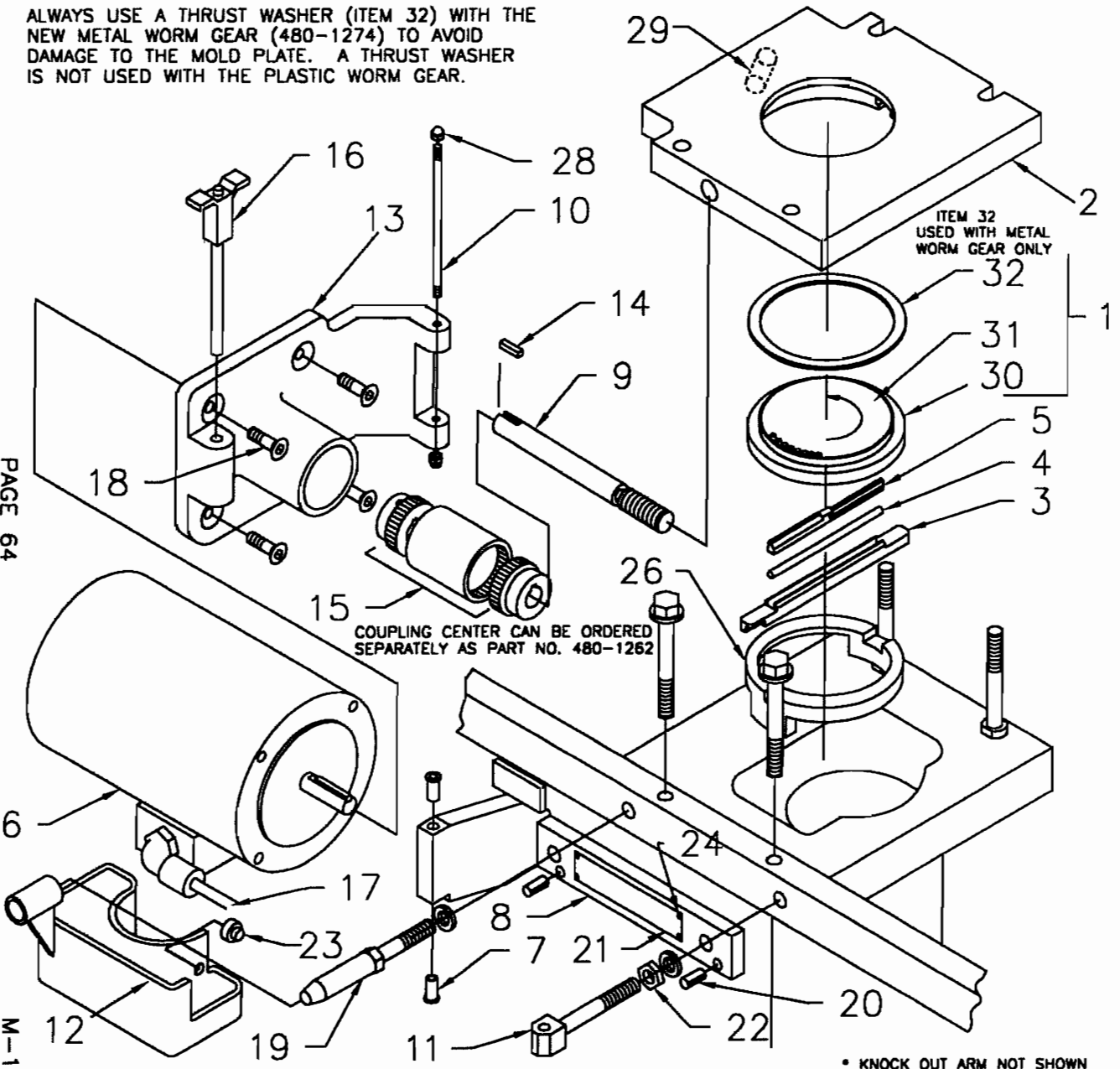
10/00

## WARNING:

ALWAYS USE A THRUST WASHER (ITEM 32) WITH THE NEW METAL WORM GEAR (480-1274) TO AVOID DAMAGE TO THE MOLD PLATE. A THRUST WASHER IS NOT USED WITH THE PLASTIC WORM GEAR.

PAGE 64

M-1497



ITEM	RECD	DESCRIPTION	PART NO.
1	AR	ROTARY FILL PLATE ASSEMBLY	
INCLUDES ITEMS 30, 31 & WITH METAL GEAR ASSEMBLIES ITEM 32		.156 DIA. HOLES-PLASTIC	480-1229
		.199 DIA. HOLES-PLASTIC	480-1201
		.250 DIA. HOLES-PLASTIC	480-1263
		.156 DIA. HOLES-METAL	480-1085
		.199 DIA. HOLES-METAL	480-1086
		.250 DIA. HOLES-METAL	480-1087
2	1	FILL PLATE WITH ITEM 29	480-1215
3	1	BLADE HOLDER	480-1202
4	1	"O" RING SPRING	480-1203
5	1	BLADE	480-1204
6	1	MOTOR 208/230/480 VOLT 3 PH 60HZ	480-1205
		MOTOR 220/380 VOLT 3 PH 50HZ	480-1119
7	2	BUSHING	480-1206
8	1	BRACKET-MOTOR MOUNT WELDMENT	480-1207
9	1	SHAFT-WORM	480-1208
10	1	ROD-HINGE	480-1254
11	1	BOLT-EYE	480-1210
12	1	MEAT COLLECTOR (MODIFIED)	480-1211
13	1	BRACKET-MOTOR	480-1212
14	1	KEY	675-0421
15	1	COUPLING ASSEMBLY	480-1214
16	1	PIN-QUICK DISCONNECT	480-0301
17	1	ELECTRICAL ASSEMBLY	480-1230
18	4	3/8-16 X 1 1/4 H.S.F.H.C.S.	716120753
19	1	BOLT-MEAT COLLECTOR	480-1216
20	2	ROLL PIN	763061640
21	1	WARNING LABEL	900-0643
22	1	JAM NUT	738008240
23	1	PLUG-MEAT COLLECTOR	480-1502
24	4	PIN-DRIVE	500-0996
25	1	* KNOCK OUT CUP ARM ASSEMBLY	480-1286
26	1	SEAL (ROTARY FILL PLATE)	480-1251
27			
28	2	ACORN NUT 1/4-20	150-1041
29	1	DOWEL PIN	480-1231
30	1	WORM GEAR - PLASTIC	480-1276
		WORM GEAR - METAL	480-1274
31	1	ROTARY FILL PLATE-.156 HOLES	480-1390
		ROTARY FILL PLATE-.199 HOLES	480-1391
		ROTARY FILL PLATE-.250 HOLES	480-1392
32	1	THRUST WASHER (USE WITH METAL WORM GEAR ONLY)	480-1448

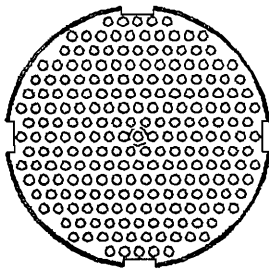
\* KNOCK OUT ARM NOT SHOWN

# ROTO-FLOW FILL SYSTEM

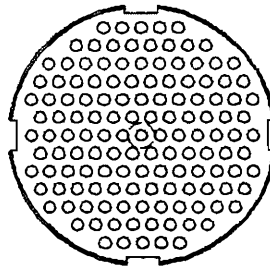
## SELECTION OF ROTARY PLATE HOLE SIZE AND GENERAL OPERATION

THE ROTO-FLOW FILL SYSTEM PRODUCES A LOW DENSITY PRODUCT. AS A GUIDE EXPERIENCE HAS SHOWN THAT AN (FM) DENSITY MOLD PLATE SHOULD BE USED FOR THICKNESSES OF 1/2 INCH AND GREATER AND (F) DENSITY FOR THOSE UNDER 1/2 INCH. THIS SHOULD PRODUCE A PORTION WEIGHT CLOSE TO DESIRED WEIGHT. IT SHOULD BE NOTED THAT PRODUCTS DO VARY IN DENSITY DEPENDING ON MOISTURE CONTENT, FAT CONTENT, AND FORMULATION. KEEP IN MIND THAT IT IS EASIER TO OPEN UP A PLATE TO A LARGER SIZE TO GET THE DESIRED WEIGHT RATHER THAT PURCHASE A NEW ONE.

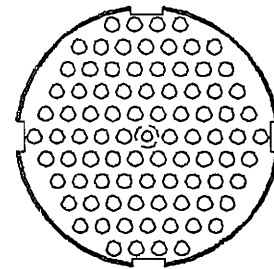
WITH THE 8/65 PATTY MACHINE OPTIONAL ROTO-FLOW FILL SYSTEM, THREE OPTIONAL FILL PLATE HOLE SIZES ARE OFFERED AS SHOWN BELOW. THE SMALLER HOLE SIZE (.156 DIAMETER HOLES) WILL PRODUCE THE TIGHTEST KNIT PATTY AND THE LARGEST HOLE SIZE (.250 DIAMETER HOLES) THE LOOSEST.



.156 DIAMETER HOLES  
INSERT NUMBER  
480-1390



.199 DIAMETER HOLES  
INSERT NUMBER  
480-1391



.250 DIAMETER HOLES  
INSERT NUMBER  
480-1392

WHEN STARTING UP A MACHINE TO PROCESS PATTIES NEVER RUN THE MACHINE FOR AN EXTENDED PERIOD OF TIME WITHOUT MEAT. THE PARTS ARE LUBRICATED BY THE PRODUCT FLOW SIMILAR TO A MEAT GRINDER. ALSO, ALWAYS REDUCE THE PISTON STROKE WHEN A MOLD PLATE CHANGE IS MADE (ESPECIALLY WHEN CHANGING FROM A LARGER TO A SMALLER SIZE. THIS WILL AVOID DEVELOPING EXCESSIVE PRESSURES ON MACHINE COMPONENTS. BRING THE PISTON STROKE UP SLOWLY TO FORM A FULL PATTY. DO NOT OVERSTROKE TO TRY TO MAKE THE DESIRED WEIGHT. THE MOLD PLATE SHOULD BE INCREASED IN SIZE TO GAIN THE WEIGHT REQUIRED. HOLLYMATIC CAN ASSIST IN DETERMINING THE INCREASE IN SIZE IN THE PLATE OPENING.

### RECOMMENDED SPARE PARTS

- 1 480-1274 WORM GEAR - METAL
- 1 480-1276 WORM GEAR - PLASTIC
- 1 480-1251 SEAL
- 1 480-1204 KNIFE
- 1 480-1262 COUPLING
- 1 480-1203 "O" RING SPRING
- \* 480-1448 THRUST WASHER

\*THE OPERATOR SHOULD HAVE SEVERAL WASHERS AVAILABLE. THE FILL SYSTEM SHOULD NOT BE OPERATED WITHOUT THIS PART IN POSITION TO PREVENT DAMAGE TO MOLD PLATES.

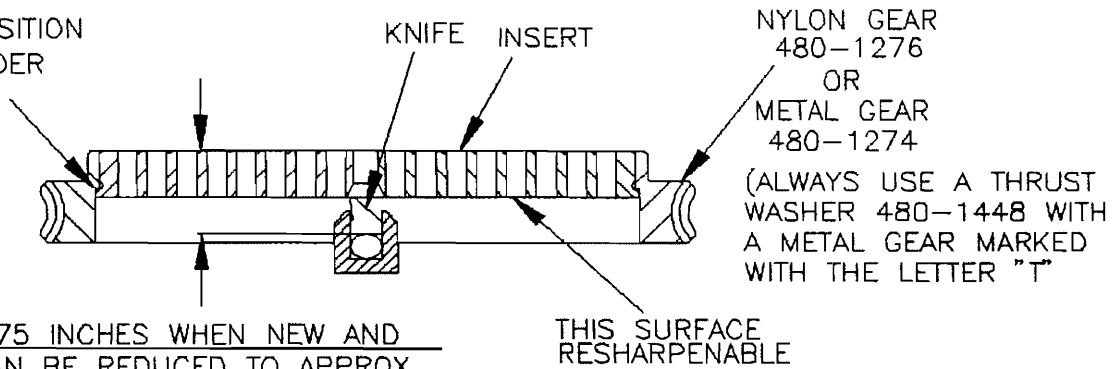
# ROTO-FLOW FILL SYSTEM

## MAINTENANCE

AS WITH ANY MOVING PARTS, SOME WEAR WILL BE EXPERIENCED WITH THE COMPONENTS INVOLVED. THE KNIFE AND ROTARY PLATES WILL WEAR OVER AN EXTENDED PERIOD OF TIME (SUCH AS WITH A GRINDER PLATE AND KNIFE). THE DESIGN IS SUCH THAT THE ROTARY PLATE IS HARDER THAN THE KNIFE AND WILL WEAR THE LEAST. BOTH THE KNIFE AND FILL PLATE INSERT ARE RESHARPENABLE WITHIN LIMITS. WHEN NEW, THE KNIFE THICKNESS IS .300 INCHES AND THE INSERT .375 INCHES, FOR A TOTAL OF .675 INCHES. THE COMBINATION OF THESE TWO PARTS CAN BE REDUCED IN TOTAL THICKNESS IN A SERIES OF RESHARPENINGS TO ABOUT .665 INCHES.

NOTE: ABOUT .001 OF MATERIAL REMOVED WILL RESHARPEN THE INSERT.

NOTICE POSITION  
OF SHOULDER



.675 INCHES WHEN NEW AND  
CAN BE REDUCED TO APPROX.  
.665 BY RESHARPENING BOTTOM  
OF INSERT AND TOP SURFACE  
OF THE KNIFE

(USE MICROMETER TO MEASURE THICKNESS)

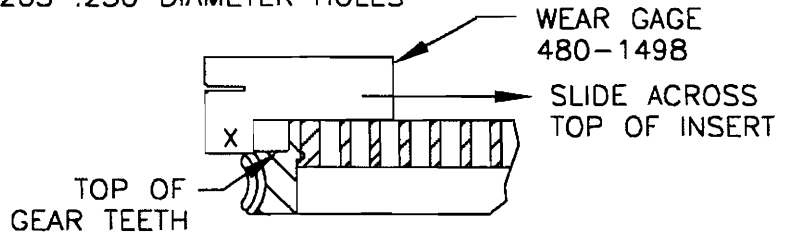
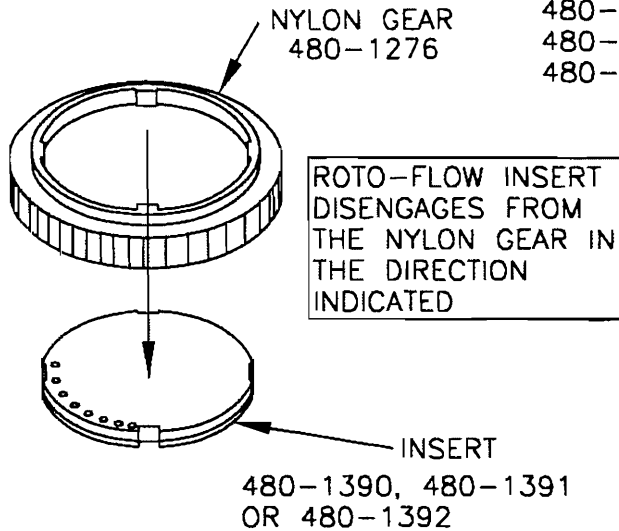
A SURFACE GRINDER SHOULD BE USED TO SHARPEN THE INSERT AND KNIFE. THE AMOUNT OF MATERIAL REMOVED SHOULD BE A MINIMUM TO RESTORE A SHARP EDGE ON THE KNIFE OR EDGE OF THE FILL HOLES. THE INSERT MUST BE REMOVED FROM GEAR TO SHARPEN.

THE ROTARY FILL PLATE ASSEMBLIES ARE OFFERED WITH A PLASTIC GEAR OR A METAL GEAR TO DRIVE THE INSERT. THE METAL GEAR PROVIDES ADDED STRENGTH FOR COLD AND HARD TO FLOW PRODUCT. THE PLASTIC GEAR OFFERS EASIER DISASSEMBLY FROM THE INSERT FOR CHANGING OR SHARPENING. THE INDIVIDUAL COMPONENTS CAN BE PURCHASED SEPARATELY. THE TWO ASSEMBLIES ARE SHOWN ON THE NEXT PAGE.

# ROTO-FLOW FILL SYSTEM

THE FOLLOWING ASSEMBLIES USE A NYLON GEAR:

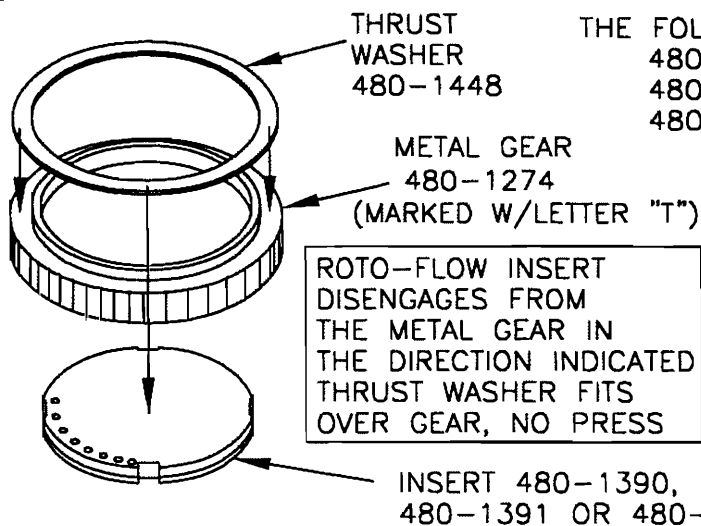
- 480-1229 .156 DIAMETER HOLES
- 480-1201 .199 DIAMETER HOLES
- 480-1263 .250 DIAMETER HOLES



PLACE THE WEAR GAGE ON TOP OF THE INSERT WITH THE INSERT ASSEMBLED INTO THE NYLON GEAR. THE EDGE OF GAGE STAMPED 'X' SHOULD NOT SLIDE OVER THE TOP OF THE NYLON GEAR TEETH. IF IT DOES THE GEAR IS WORN AND SHOULD BE REPLACED TO AVOID DAMAGE TO THE MOLD PLATE.

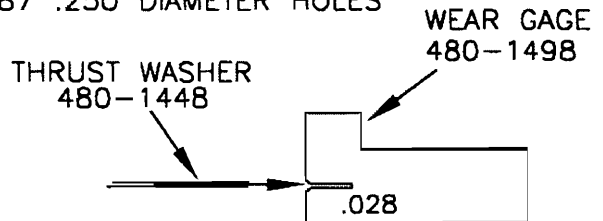
THE ILLUSTRATION ABOVE SHOWS THE DIRECTION THE INSERT DISENGAGES FROM THE NYLON GEAR 480-1276. ITS A PRESS FIT, BUT CAN BE DISASSEMBLED FOR CLEANING OR CHANGING WHEN PRESSED BY HAND OR TAPPING WITH A SOFT HAMMER.

TAKE CARE IN REASSEMBLY TO ALIGN THE NOTCHES IN THE INSERT WITH THE DRIVE LUGS ON THE NYLON GEAR. WHEN THE GEAR TEETH ARE VISIBLY WORN OR THE TOP SURFACE OF THE GEAR TEETH WEARS (SEE ILLUSTRATION ABOVE, RIGHT) THE GEAR SHOULD BE REPLACED.



THE FOLLOWING ASSEMBLIES USE A METAL GEAR:

- 480-1085 .156 DIAMETER HOLES
- 480-1086 .199 DIAMETER HOLES
- 480-1087 .250 DIAMETER HOLES



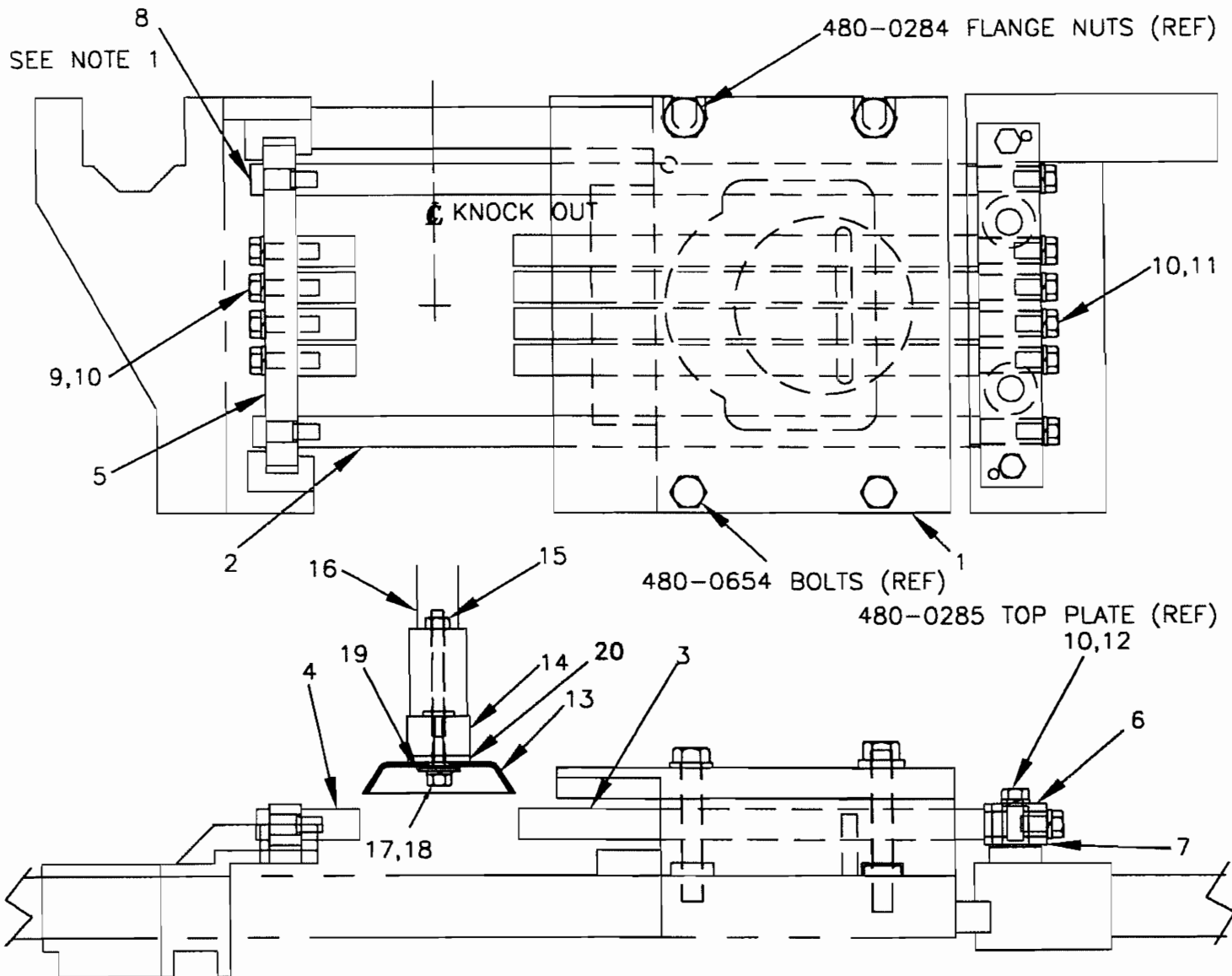
USE THE GAGE TO CHECK THE THICKNESS OF THE THRUST WASHER. IF THE WASHER FITS EASILY INTO THE SLOT IN THE GAGE, THE WASHER IS WORN AND SHOULD BE REPLACED

ADD A SMALL AMOUNT OF DOW CORNING RTV SEALANT NO. 732 ALL AROUND THE INSERT FLANGE BEFORE PRESSING INTO METAL GEAR. REMOVE ALL EXCESS SEALANT AFTER PRESSING THE ASSEMBLIES TOGETHER.

THE METAL GEAR 480-1274 DOES NOT USE DRIVE LUGS. THE INSERT IS HELD IN PLACE BY A HEAVY PRESS FIT. USE AN ARBOR PRESS TO DISASSEMBLE INSERT FOR CHANGING (DUE NOT USE A HAMMER !). DUE TO THE HEAVY PRESS FIT DISASSEMBLY OF THE INSERT IS NOT REQUIRED FOR CLEANING.

**WARNING:** ALWAYS USE A THRUST WASHER (480-1448) WITH THE METAL GEAR TO AVOID DAMAGE TO THE MOLD PLATE. CHECK THE THRUST WASHER FOR WEAR USING THE GAGE 480-1498 (SHOWN ABOVE, RIGHT). WHEN THE METAL GEAR TEETH ARE VISIBLY WORN, THE GEAR SHOULD BE REPLACED.

# SAUSAGE FILL SYSTEM



ITEM	QTY	
20	1	K.O.SPACER (SEE NOTE)
19	1	STEP WASHER
18	1	5/16 SPLIT L.WASHER
17	1	BOLT
16	1	K.O.ARM
15	1	5/16-18 HEX NUT
14	1	SPACER (SEE NOTE)
13	1	K.O. CUP - SAUSAGE
12	2	3/8-16X1" HHCS
11	6	3/8-16X3/4 HHCS
10	12	3/8 SPLIT LOCKWASHER
9	4	3/8-16X1 3/8 HHCS
8	2	SHOULDER BOLT
7	1	REAR BOTTOM BAR ASSEMBLY
6	1	REAR BAR TOP
5	1	FRONT BAR
4	4	FRONT MOLDING ROD
3	4	REAR MOLDING ROD
2	2	TIE ROD
1	1	FILL BLOCK ASSY

PART NO.	PART NO.	PART NO.	PART NO.
480-1434	480-1434	480-1434	480-1434
518-0540	518-0540	518-0540	518-0540
755000540	755000540	755000540	755000540
500-0794	500-0794	500-0794	500-0794
SEE NOTE			
735005240	735005240	735005240	735005240
480-1281	480-1281	480-1281	480-1281
480-1410	480-1469	480-1432	480-1433
716100440	716100440	716100440	716100440
716060240	716060240	716060240	716060240
756000540	756000540	756000540	756000540
716130240	716130240	716130240	716130240
480-1409	480-1409	480-1409	480-1409
480-1408	480-1423	480-1423	480-1424
480-1402	480-1419	480-1419	480-1421
480-1401	480-1417	480-1417	480-1418
480-1407	480-1467	480-1425	480-1426
480-1406	480-1468	480-1427	480-1428
480-1405	480-1405	480-1405	480-1405
480-1436	480-1437	480-1437	480-1438

NOTE: USE ITEM 20 K.O. SPACER 480-1434 ONLY WITH MEATBALL K.O. ARM ASSY 480-1288. USE SPACER 480-1282 WITH MULTIFLOW K.O. ARM ASSEMBLY 480-1282

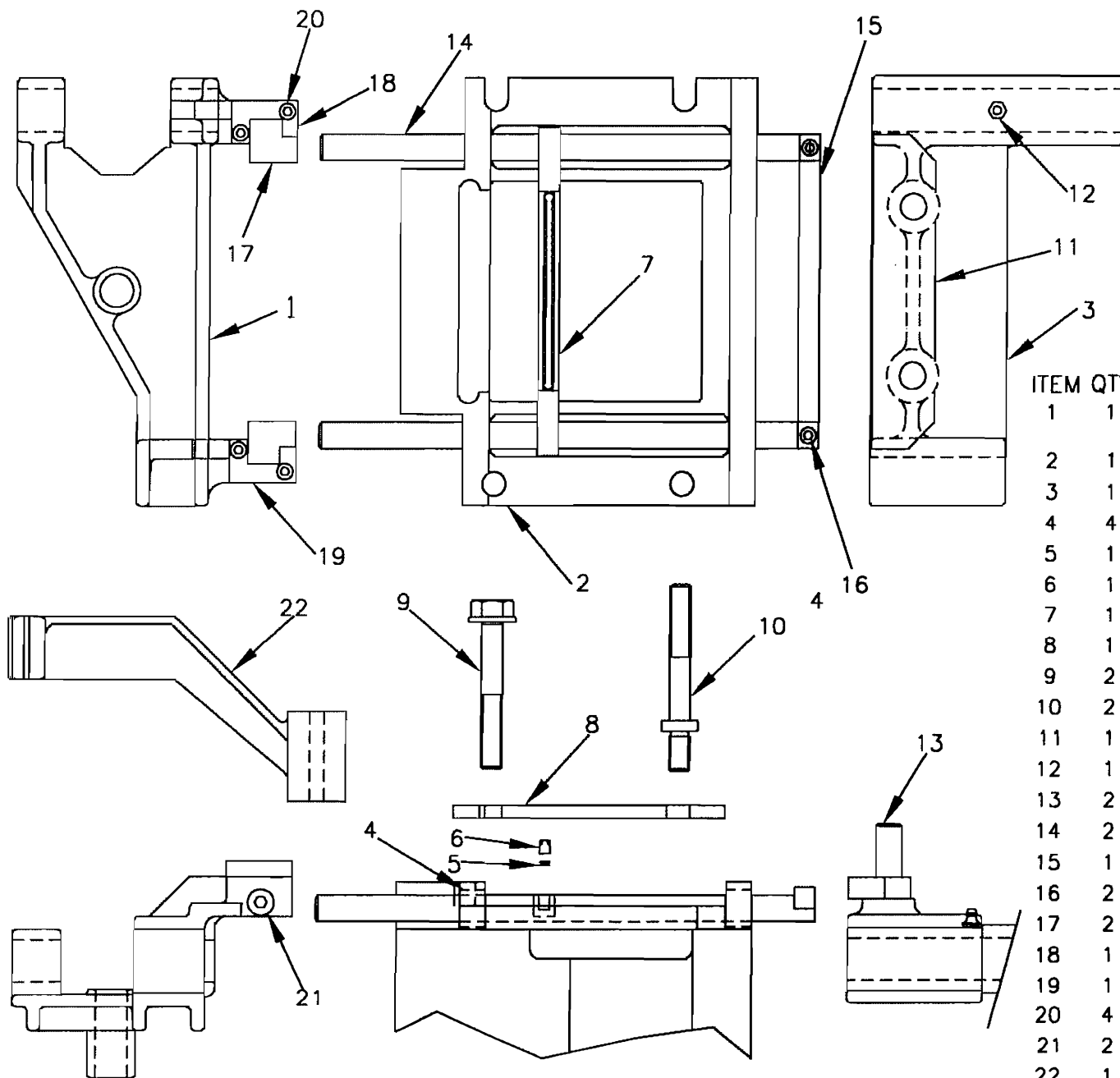
1 OZ.

1 1/4 OZ.

1 1/2 OZ.

2 OZ.

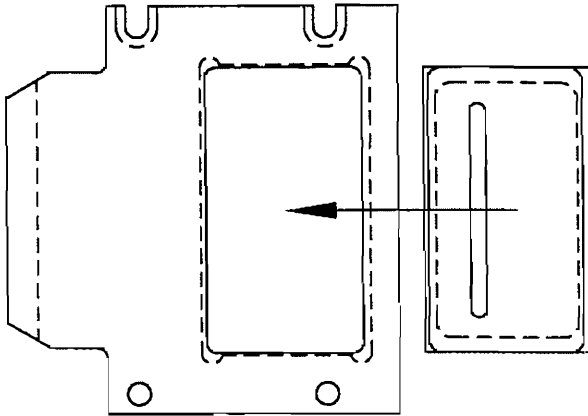
# ULTIMATE FILL SYSTEM



ITEM	QTY	PART NO.
1	1	SPECIAL P.F. SHUTTLE (INCLUDES 17,18,19,20,21) 480-1110
2	1	FILL PLATE ONLY 480-1101
3	1	M.P. SHUTTLE ASSEMBLY 480-1115
4	4	BUSHING FILL PLATE 480-1118
5	1	LEAF SPRING 480-1109
6	1	CUTTING BLADE 480-1108
7	1	BLADE HOLDER 480-1107
8	1	INS'T. 45~ ROUND HOLES 480-1105
9	2	BOLT ASSEMBLY 480-0654
10	2	STUD TOP PLT. LONG 480-1224
11	1	BUMPER 480-1106
12	1	GREASE FITTING 840-1074
13	2	5/8 X 2 1/2 D.PINS 769242090
14	2	SHAFT KNIFE 480-1102
15	1	CROSS BAR 480-1103
16	2	1/4-20 X 3/4" H.S.C.S. 714060340
17	2	BUMPER P.F. SHUTTLE 480-1104
18	1	BLOCK R.H. SHUTTLE 480-1111
19	1	BLOCK L.H. SHUTTLE 480-1112
20	4	#8 X 3/4" H.S.F.H.C.S. 712060740
21	2	5/16 X 1" H.S.F.H. 715100740
22	1	ARM K.O. CUP ULTIMATE 480-1096

# 8/65 STRAIGHT SLOT FILL SYSTEM

## 8/65 FILL PLATE FOR STRAIGHT SLOT INSERT 480-1349



## 8/65 FILL PLATE INSERTS

FILL PLATE INSERT	PART NO.	PATTY DIAMETER RANGE (INCHES)
A	480-0013	6.000 TO 5.250
B	480-0014	5.250 TO 4.500
C	480-0015	4.500 TO 3.750
D	480-0016	3.750 TO 3.000
E	480-0017	3.000 TO 2.250

## SLOT TYPE FILL SYSTEM FOR THE 8/65 AND 518 PATTY MACHINE

FOR THOSE CUSTOMERS WHO ARE NOT INTERESTED IN A TEXTURED TYPE PATTY, A STRAIGHT FILL SLOT SYSTEM IS AVAILABLE THAT CAN BE USED. THIS FILL SYSTEM PRODUCES A PATTY SIMILAR IN CONSISTENCY TO THE SUPER OR THE MODEL 580 MACHINE, WITH AN IMPROVED COOKED SHAPE. IN ORDER TO GET OPTIMUM "COOK OUT" OF THE PATTY IT IS NECESSARY TO POSITION THE FILL SLOT RELATIVE TO THE PATTY DIAMETER BEING FORMED. THIS REQUIRES A SERIES OF INSERTS (SHOWN ABOVE). FOR EACH PATTY DIAMETER RANGE THERE IS A MATCHING INSERT STAMPED AS A, B, C, D & E RELATED TO THE PATTY DIAMETER. THE INSERTS ARE DESIGNED TO FIT ONLY ONE WAY.

# MOLD PLATE DRIVE ADJUSTMENT

## ASSEMBLY AND ADJUSTMENT OF M.P. SHUTTLE DRIVE

(SEE ITEMS 38, 39 & 40, PAGE 52 AND ITEMS 8, 13 & 14, PAGE 44)

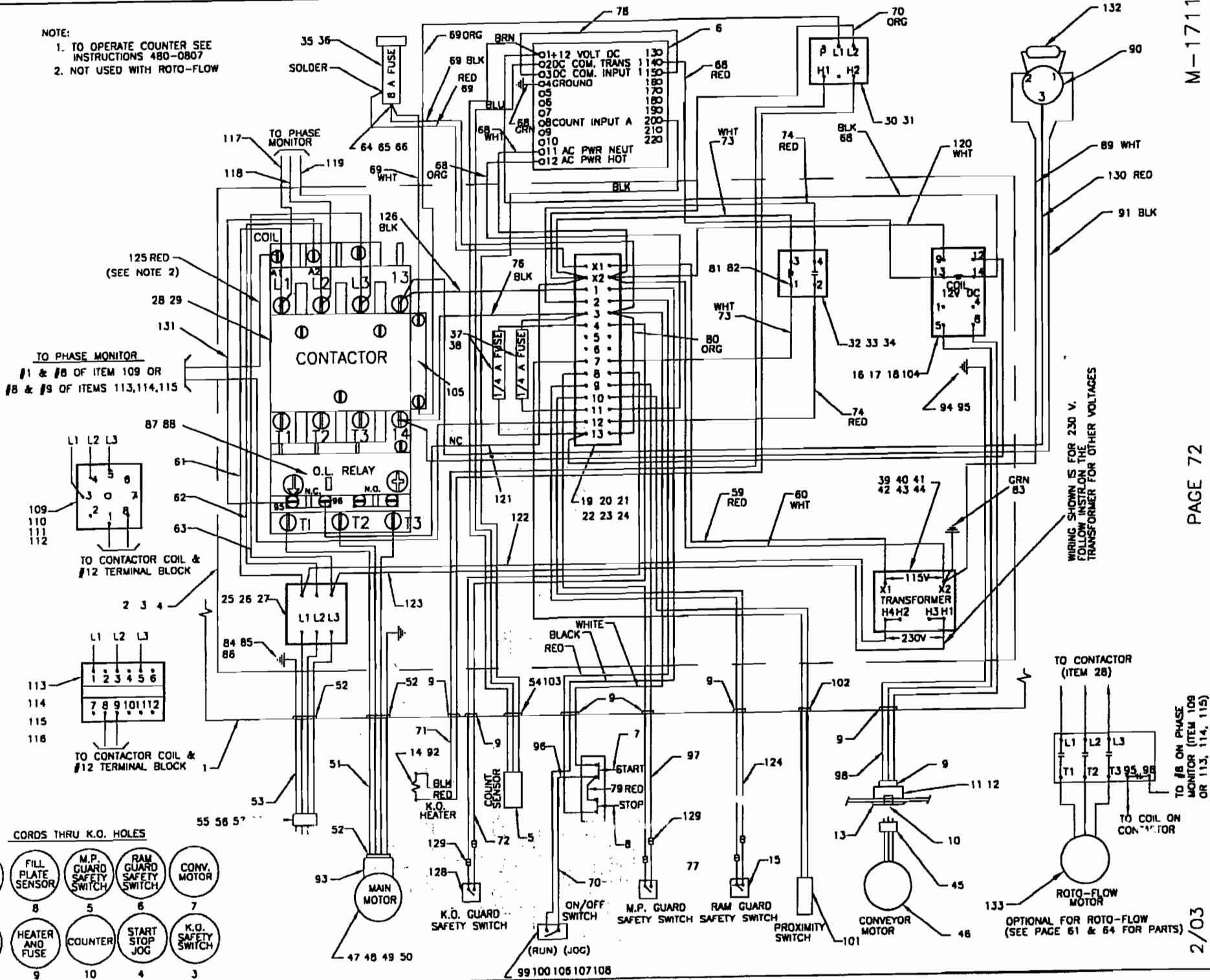
THE FOLLOWING PROCEDURE IS USED WHEN ASSEMBLING A MOLD PLATE SHUTTLE DRIVE AND ADJUSTING ITS LOCATION ON THE DRIVE ARM. THE REASON FOR THE PROCEDURE IS TO INSURE THAT THE MOLD PLATE MOVES TO ITS PROPER ALIGNMENT UNDER THE KNOCK OUT CUP.

1. WARNING: MAKE CERTAIN THAT THE POWER CORD IS DISCONNECTED FROM THE POWER SOURCE.
2. LEAVE MOLD PLATE OUT OF THE MACHINE.
3. ASSEMBLE THE CAM ROLLER AND SPLIT ADJUSTABLE BUSHING INTO THE LEVER ARM WITH THE SPLIT IN THE BUSHING ON THE LEFT SIDE OF THE SPLIT IN THE ARM. TIGHTEN FASTENERS LIGHTLY.
4. ADD BUMPER ASSEMBLY ONLY TO THE MOLD PLATE DRIVE SHUTTLE. THEN, ASSEMBLE THE SHUTTLE ONTO THE MACHINE.
5. IT IS NECESSARY TO FIRST MOVE THE AUGER STROKE TO THE FULLY RETRACTED POSITION. (FOLLOW STEPS 1, 2, AND 3 OF DISASSEMBLY SHOWN ON PAGES 11 AND 12.
6. START THE MACHINE. WHILE MACHINE IS RUNNING, TURN THE AUGER STROKE ADJUSTMENT KNOB TO THE END OF UPPER POSITION. THEN, JOB THE MACHINE UNTIL MOLD PLATE DRIVE SHUTTLE COMES TO DWELL IN A FORWARD POSITION.
7. WARNING: DISCONNECT POWER CORD FROM THE ELECTRICAL POWER SOURCE.
8. LOOSEN THE CLAMPING FASTENERS IN THE LEVER ARM FOR THE SPLIT ADJUSTABLE BUSHING. INSERT SCREW DRIVER INTO THE SPLIT NOTCH OF THE BUSHING AT THE BOTTOM OF LEVER ARM AND ROTATE THE BUSHING UNTIL BUMPER TOUCHES THE MAIN FRAME. THEN, TIGHTEN THE CLAMPING FASTENERS TIGHT.
9. PLUG THE CORD TO POWER SOURCE AND JOG THE MACHINE UNTIL M.P. DRIVE SHUTTLE IS AWAY FROM THE MAIN FRAME. UNPLUG THE CORD. REMOVE BUMPER FROM THE SHUTTLE. PLACE ONE SHIM UNDER THE BUMPER AND FASTEN THEM IN PLACE ON THE SHUTTLE. THIS WILL SET THE M.P. STROKE IN THE KNOCK-OUT POSITION.

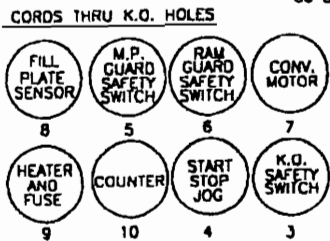


# 8/65 WIRING DIAGRAM

NOTE:  
 1. TO OPERATE COUNTER SEE INSTRUCTIONS 480-0807  
 2. NOT USED WITH ROTO-FLOW



WIRING SHOWN IS FOR 230 V. FOLLOW INSTRON THE TRANSFORMER FOR OTHER VOLTAGES

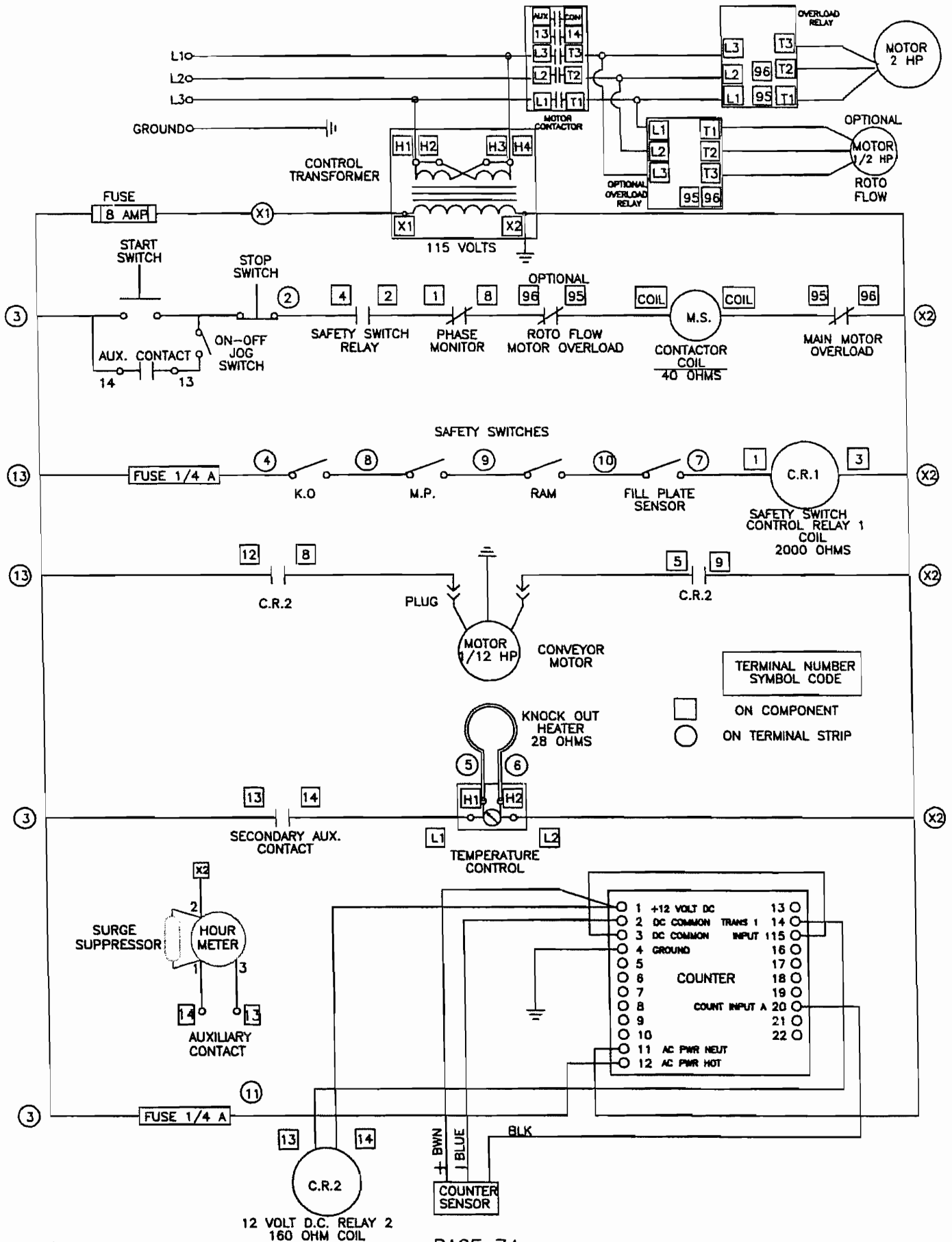


ELECTRICAL COMPONENTS

133	1	MOTOR 220/380 VOLT 3 PH 50 HZ	480-1119
	1	MOTOR 208/230/460 VOLT 3 PH 60 HZ	480-1205
132	1	SURGE SUPPRESSOR	900-0221
131	1	WIRE	150-9352
130	1	WIRE ASSY-RED	480-1520
129	4	COUPLER-FEMALE	879-1160
128	1	SAFETY SWITCH 14 LEAD	879-0933
127	5	TY-RAP CABLE TIES	8000-3669
126	1	WIRE-18 GA x 10 BLACK	480-0848
125	1	WIRE ASSY 18 GA RED	480-0847
124	1	CORD ASSY-SAFETY SW.	480-0865
123	1	WIRE ASSY 18 GA WHITE	480-0845
122	1	WIRE ASSY 18 GA RED	480-0844
121	1	WIRE 18 GA x 12 WHITE	480-0843
120	1	WIRE-18 GA x 8 WHITE	480-0696
119	1	WIRE ASSY 18 GA RED	879-0839
118	1	WIRE ASSY 18 GA BLACK	879-0838
117	1	WIRE ASSY 18 GA WHITE	480-0837
116	4	BOLT ASSORTMENT	879-1283
115	1	PHASE MONITOR 380 VAC	879-1799
114	1	PHASE MONITOR 575 VAC	879-1784
113	1	PHASE MONITOR 440/460	879-1785
112	2	#6 LOCKWASHER	751000640
111	2	#6-32 x 1" P.H.M.S.	711101640
110	1	SOCKET-FOR ITEM 109	879-1138
109	1	PHASE MONITOR 208/230	879-1786
108	1	ON/OFF INDICATOR PLT.	120-1080
107	1	SEAL-TOGGLE SWITCH	500-1167
106	2	HEX FACENUT	120-1095
105	1	INTERLOCK AUX.CONTACT	480-1099
104	2	WASHER-PAWL RIVET	2381
103	1	HEYCO ADAPTER	7711
102	1	CORD CONNECT.1/2 K.O.	2274
101	1	PROXIMITY SWITCH	244-0376
100	1	RING LOCK	120-1079
99	1	ON-OFF SWITCH	120-0018
98	1	CORD ASSY-CONVEYOR	480-0710
97	1	CORD ASSY-SAFETY SW.	480-0708
96	1	WIRE ASSY-JOG/START	480-1134
95	1	#10 INTERNAL L/WASHER	753000640
94	1	10-24 x 3/8 R.H.M.S.	713031623
93	4	WIRE NUT	500-1375
92	2	#8 INTERNAL L/WASHER	752000640
91	1	WIRE ASSY-BLK	480-1519
90	1	HOUR METER	900-0220
89	1	WIRE ASSY-WHT	480-1518
88	1	O.L. RELAY 200/230/380	480-1512
87	1	O.L. RELAY 420/460/575	480-1116
86	1	1/4 SPLIT LOCK WASHER	754000591
85	1	1/4-20 x 3/8 H.H.C.S.	714030253
84	1	CABLE LUG	8000-3359
83	1	WIRE ASSY-14 GA GREEN	480-0700
82	4	#6 EXTERNAL L/WASHER	751000740
81	4	#6-32 x 3/8 P.H.M.S.	711031623
80	1	WIRE-18 GA x 6 ORANGE	480-0699
79	1	WIRE-18 GA x 3 RED	480-0698
78	1	WIRE - 18 GA WHT	480-0697
77	1	SAFETY SWITCH-26 LEAD	879-0933
76	1	WIRE-18 GA x 9 BLACK	480-0695
75	1	WIRE ASSY-18 GA RED	480-0694
74	2	WIRE ASSY-18 GA RED	480-0692
73	2	WIRE ASSY-18 GA WHITE	480-0690
72	1	CORD ASSY-SAFETY SW	480-1133
71	1	CORD ASSY-K.O.HEATER	480-1132
70	1	CORD ASSY-START,STOP	480-1131
69	1	CORD ASSY-HEATER,FUSE	480-1130
68	1	CORD-COUNTER	480-1125
67			

66	1	#4-40 HEX NUT	730005123
65	1	#4 EXT. LOCK WASHER	750000740
64	1	#4-40 X 3/4 PHMS	710061623
63	1	WIRE 14 GA.x 14 RED	480-0673
62	1	WIRE 14 GA.x 14 BLACK	480-0672
61	1	WIRE 14 GA.x 14 WHITE	480-0671
60	1	WIRE ASSY 18 GA.WHITE	480-0668
59	1	WIRE ASSY 18 GA.RED	480-0667
58	1	SEAL COVER	100-0922
57	1	PLUG-575 V MACH	100-0927
56	1	PLUG-380,440 & 460	100-0917
55	1	PLUG-200 & 250V MACH	100-0929
54	1	BUSHING-STRAIN RELIEF	7712
53	1	CORD SUPPLY	480-0729
52	3	CORD CONNECT.3/4 K.O.	100-0846
51	1	MOTOR CORD ASSY	480-0664
50	1	MOTOR -220/380/415V 50 CY	480-0641
49	1	MOTOR - 575 V	480-0640
48	1	MOTOR - 200 V	480-0639
47	1	MOTOR - 230/460 V	480-0223
46	1	MOTOR-CONV 115 V.A.C.	480-0724
45	1	PLUG-115 V.A.C.	120-0175
44	3	5/16 SPLIT LOK WASHER	755000591
43	3	5/16 FLAT WASHER	755000191
42	3	5/15-18 H.H.C.S.	715040253
41	1	TRANSFORMER-575 V	879-1389
40	1	TRANSFORMER-208/380 V	879-1388
39	1	TRANSFORMER-220/440 V	860-0516
38	2	FUSE HOLDER	879-1381
37	2	FUSE-1/4 AMP	480-0313
36	1	FUSE HOLDER	500-1251
35	1	FUSE - 8 AMP	860-0530
34	2	6-32 x 3/8 P.H.M.S.	711031623
33	2	#6 SPLIT LOK WASHER	751000540
32	1	RELAY (CR1)	879-1136
31	1	CONTROL KNOB	879-1438
30	1	HEATER SWITCH-K.O.	879-1130
29	2	8-32 X 1/2 P.H.M.S.-S.S.	712041640
28	1	CONTACTOR	480-1114
27	2	10-24 x 5/8 P.H.M.S.	713051623
26	3	TERMINAL BLOCK	8000-3353
25	1	TERMINAL BLOCK-END	8000-3354
24	2	#8 SPLIT LOK WASHER	752000591
23	2	8-32 x 1/4 P.H.M.S.	712021623
22	1	CHANNEL-MOUNTING	480-0407
21	2	CLAMP	8000-0990
20	1	TERMINAL BLOCK-END	8000-3355
19	15	TERMINAL BLOCK	8000-0989
18	1	RELAY (CR2)	480-0369
17	2	4-40 x 7/8 RD HD SCR	480-0642
16	1	BASE RELAY (CR2)	480-0368
15	1	SAFETY SWITCH ASSY.	879-1541
14	1	HEATER WELDMENT K.O.	480-0380
13	1	COVER PLATE-RECEPTICAL	500-3182
12	2	6-32 x 3/8 P.H.M.S.	711031623
11	1	HANDY BOX	480-0658
10	1	RECEPTICAL-CONV 115 A	480-0655
9	6	CORD CONNECT.1/2 K.O.	100-0954
8	1	P.B. SWITCH-STOP	879-1132
7	1	P.B. SWITCH-START	879-1131
6	1	COUNTER	518-0342
5	1	COUNT SENSOR	879-2252
4	4	5/16 SPLIT LOCK WASHER	755000591
3	8	5/16-18 HEX JAM NUT	735008293
2	1	PANEL-ELECTRICAL	480-0293
1	1	ELEC BOX WELDMENT	480-0296
ITEM	REQD	DESCRIPTION	PART NO.

# CONTROL CIRCUIT SCHEMATIC



**TERMINAL NUMBER SYMBOL CODE**

□ ON COMPONENT

○ ON TERMINAL STRIP

1	+12 VOLT DC	13	○
2	DC COMMON TRANS 1	14	○
3	DC COMMON INPUT 115	16	○
4	GROUND	17	○
5		18	○
6		19	○
7		20	○
8	COUNTER	21	○
9	COUNT INPUT A	22	○
10			
11	AC PWR NEUT		
12	AC PWR HOT		

# TROUBLESHOOTING

THIS TROUBLESHOOTING GUIDE IS PROVIDED TO ASSIST YOU IN DIAGNOSING AND CORRECTING SOME MACHINE MALFUNCTIONS. IF YOU CANNOT LOCATE OR CORRECT THE PROBLEM THAT YOUR MACHINE IS HAVING, CONTACT AN AUTHORIZED HOLLYMATIC SERVICE REPRESENTATIVE.

PROBLEM	POSSIBLE CAUSES	REMEDIES
1. "LIP" TOO LARGE ON PATTY.	EXCESS PISTON STROKE	REDUCE PISTON STROKE UNTIL LIP IS DECREASED.
2. SHORT PATTY	INADEQUATE AUGER STROKE INADEQUATE PISTON STROKE PRECOMPRESSION TOO LOW  PRODUCT "TOO COLD"	INCREASE AUGER STROKE INCREASE PISTON STROKE INCREASE SPRING PRECOMPRESSION WITH ADJUSTABLE NUT. (CAUTION: NUT IS LEFT HAND THREAD). INCREASE TEMPERATURE OR PRODUCT
3. BOTTOM PATTY OF STACK NOT IN LINE WITH ALL OTHER PATTIES ABOVE.	CONVEYOR IS STILL MOVING WHEN FIRST PATTY IS DEPOSITED ON BELT.	ADJUST THE COUNTER ACTUATOR POSITION SO THAT THE CONVEYOR STARTS TO MOVE IMMEDIATELY AFTER THE TOP PATTY IS DEPOSITED ON THE STACK. IF THIS DOES NOT SOLVE THE PROBLEM, REDUCE THE CONVEYOR TRAVEL.
4. TOP OF PATTY OF STACK NOT IN LINE WITH ALL OTHER PATTIES BELOW.	CONVEYOR IS STARTING TO MOVE BEFORE TOP PATTY IS DEPOSITED ON STACK.	ADJUST THE COUNTER ACTUATOR POSITION SO THAT THE CONVEYOR STARTS TO MOVE IMMEDIATELY AFTER THE TOP PATTY IS DEPOSITED.
5. PATTIES NOT STACKING.	PATTY NOT FULL  K.O. CUP NOT STRAIGHT  K.O. DISC NOT FUNCTIONING  K.O. SPRING BROKEN  K.O. CUP NOT GOING THROUGH PLATE  K.O. CUP HEATER NOT ADJUSTED PROPERLY OR NOT WORKING.	INCREASE AUGER STROKE; IF AUGER STROKE INCREASE DOES NOT HELP, INCREASE PISTON STROKE.  STRAIGHTEN CUP SO THAT BOTTOM SURFACE IS PARALLEL TO M.P. OR REPLACE K.O. CUP  ADD OR REPLACE PAPER DISC  REPLACE SPRING  READJUST K.O. ARM SO THAT BOTTOM SURFACE OF CUP IS SLIGHTLY BELOW BOTTOM SURFACE OF PLATE.  CHECK K.O. CUP HEATER & CONTROL REPLACE IF NECESSARY.
6. EXCESS MEAT OUT OF CHECK VALVE.	AUGER STROKE TOO HIGH.	REDUCE AUGER STROKE UNTIL PATTY BECOMES SHORT THEN INCREASE SLIGHTLY.

# TROUBLESHOOTING

PROBLEM	POSSIBLE CAUSES	REMEDIES
7. DIFFICULT TO FILL LARGER PATTIES.	AUGER AND/OR PISTON STROKE NOT ADEQUATE. CHECK VALVE ON CYLINDER NOT FUNCTIONING.	INCREASE STROKE AS REQUIRED. CLEAN OR REPLACE VALVE.
8. PAPER SHEET NOT MOVING TO STOP PIN.	DEBRIS IN RAILS. PLATFORM SET TOO LOW. PAPER FEED RUBBER CLIPS NOT IN POSITION. PAPER FEED RUBBER CLIPS WITH WAX OR OIL BUILD-UP.	CLEAR DEBRIS. READJUST PLATFORM HEIGHT. REPOSITION RUBBER CLIPS IF NECESSARY. CLEAN CLIPS WITH EMERY CLOTH.
9. PAPER SHEET SLIDING OVER STOP PIN.	PAPER FEED PLATFORM SET TOO HIGH.	READJUST HEIGHT OF PLATFORM JUST ADEQUATE TO PULL SHEET INTO POSITION.
10. PAPER WILL NOT DROP FREELY TO BOTTOM OF BASKET.	PAPER FEED BASKET DISTORTED OR DEBRIS HOLDING BACK FREE FALL OF PAPER. SIDE NOTCH NOT CENTERED IN PAPER. PAPER NOT CUT SQUARE OR TOO LARGE FOR BASKET.	STRAIGHTEN BASKET OR REMOVE DEBRIS (COULD BE WELD SPLATTER) REPLACE PAPER. REPLACE PAPER.
11. CONVEYOR BELT WILL NOT MOVE OR IS SLIPPING, BUT MOTOR IS OPERATING.	BELT TOO LOOSE OR TOO TIGHT. BELT & CONVEYOR BELT TOO WET, CAUSING EXCESSIVE DRAG.	ADJUST BELT FOR MEDIUM TENSION. DRY CONVEYOR BELT INSIDE SURFACE AND CONVEYOR BED.
12. CONVEYOR MOTOR WILL NOT RUN.	FAULTY CR2 RELAY. WITH POWER DISCONNECTED THE COIL RESISTANCE SHOULD BE 160 OHMS BETWEEN TERMINALS 13 AND 14 ON RELAY. FAULTY CONVEYOR MOTOR. CONVEYOR NOT PLUGGED IN. FAULTY COUNTER. WITH MACHINE OPERATING THERE SHOULD BE 12 VOLTS D.C. OUTPUT AT CR2 RELAY TERMINALS 13 AND 14.	REPLACE PLUG IN RELAY CR2 IF COIL RESISTANCE IS INCORRECT. REPLACE MOTOR. PLUG IN CONVEYOR. REPROGRAM COUNTER AND IF THAT DOES NOT SOLVE PROBLEM, REPLACE COUNTER.
13. COUNTER COUNTING IRRATICALLY.	COUNTER SENSOR TOO FAR FROM PICK-UP POINTER.	SENSOR SHOULD BE ADJUSTED TO .032" FROM PICK-UP POINTER.
14. COUNTER WILL NOT RESET TO ZERO.	FAILED TO HIT RESET BUTTON AS LAST STEP. NOT PROGRAMMED PROPERLY.	REPROGRAM STACK HEIGHT. FOLLOW PROGRAM PROCEDURE IN MANUAL AND REPROGRAM.

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3. BOTTOM PATTY OF STACK NOT IN LINE WITH ALL OTHER PATTIES ABOVE.	CONVEYOR IS STILL MOVING WHEN FIRST PATTY IS DEPOSITED ON BELT.	ADJUST THE COUNTER ACTUATOR POSITION SO THAT THE CONVEYOR STARTS TO MOVE IMMEDIATELY AFTER THE TOP PATTY IS DEPOSITED ON THE STACK. IF THIS DOES NOT SOLVE THE PROBLEM, REDUCE THE CONVEYOR TRAVEL.
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6. EXCESS MEAT OUT OF CHECK VALVE.	AUGER STROKE TOO HIGH.	REDUCE AUGER STROKE UNTIL PATTY BECOMES SHORT THEN INCREASE SLIGHTLY.

# TROUBLESHOOTING

PROBLEM	POSSIBLE CAUSES	REMEDIES
<p>19. STARTER COIL WILL NOT PULL IN.</p>	<p>FAULTY START SWITCH WITH POWER DISCONNECTED. CHECK CONTINUITY ACROSS 2 AND 3 ON TERMINAL STRIP WITH SWITCH DEPRESSED.</p> <p>FAULTY STARTER COIL WITH POWER DISCONNECTED. CHECK COIL RESISTANCE WHICH SHOULD BE 38 OHMS. (TERMINALS ON MOTOR CONTACTOR MARKED "COIL".)</p> <p>FAULTY TRANSFORMER OUTPUT VOLTAGE. SHOULD BE 110 VOLTS BETWEEN X AND X2.</p>	<p>IF CONTINUITY CHECK INDICATES OPEN SWITCH - REPLACE.</p> <p>IF RESISTANCE IS NOT CORRECT, REPLACE COIL OR STARTER.</p> <p>IF CONTROL CIRCUIT VOLTAGE IS NOT CORRECT REPLACE TRANSFORMER.</p>
<p>20. EXCESSIVE NOISE IN KNOCK-OUT AREA.</p>	<p>KNOCK-OUT BUMPER FAILURE.</p>	<p>REPLACE KNOCK-OUT BUMPER.</p>







HOLLYMATIC CORPORATION 600 E. PLAINFIELD ROAD COUNTRYSIDE, IL 60525 Telephone: (708) 579-3700