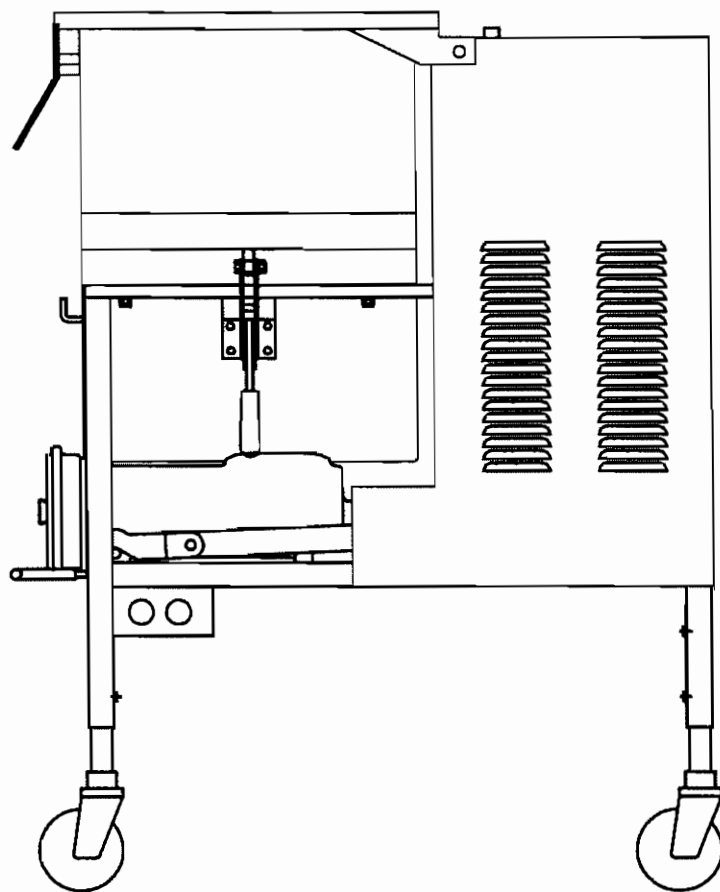




# HOLLYMATIC MODEL 180A GMG



## OPERATORS MANUAL – PARTS LIST

FOR 180A SERIAL NUMBERS BEGINNING WITH 5646

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.

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

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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.

1. READ THIS MANUAL BEFORE YOU OPERATE THE MACHINE.
2. DO NOT OPERATE THE MACHINE IF THE CORD OR PLUG IS DAMAGED.
3. ALWAYS DISCONNECT THE MACHINE FROM ITS POWER SOURCE BEFORE OPENING THE REAR PANEL, OR DOING ANY CLEANING, SERVICING, OR ADJUSTING OF THE MACHINE.
4. UNPLUG THE MACHINE WHEN IT IS NOT IN USE.
5. DO NOT PUT HANDS IN TUB WHEN THE MACHINE IS CONNECTED TO THE POWER SUPPLY.
6. FAILURE TO PROPERLY GROUND THIS MACHINE COULD RESULT IN ELECTRICAL SHOCK. ONLY A QUALIFIED ELECTRICIAN, WHO IS FAMILIAR WITH THE APPROPRIATE ELECTRICAL CODES SHOULD WIRE THIS MACHINE.
7. ALLOW ONLY AN AUTHORIZED HOLLYMATIC DEALER TO REPAIR YOUR MACHINE. HE'LL REPLACE THE SAFETY LABELS WHEN NECESSARY AND SEE THAT ALL SAFEGUARDS ARE IN GOOD CONDITION TO PREVENT INJURIES.

# SAFETY LABEL PLACEMENT MODEL 180A GRINDER

6/03

900-1035  
LOCATED ON  
BACK

900-1032  
900-1033  
900-1034  
LOCATED ON  
BACK

900-2003  
LOCATED ON  
SIDE PANEL

150-9012  
LOCATED ON  
BACK

181-0650  
LOCATED  
ON BACK  
BELOW HOUR  
METER

900-1025  
UL LABEL  
BACK PANEL

900-0610

100-1374

181-0657  
LOCATED ON  
BACK

900-1047

900-1045

100-1377

900-1030

900-1049  
BOTH SIDES

900-1037  
(GEMINI  
TUBS ONLY)

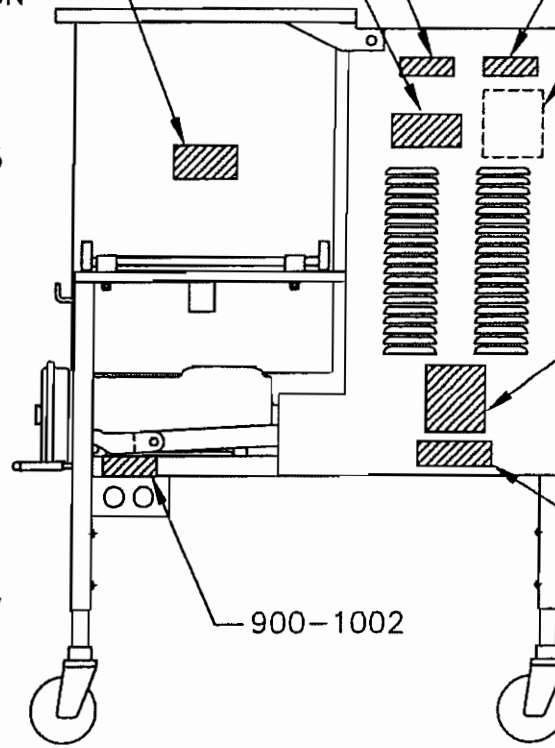
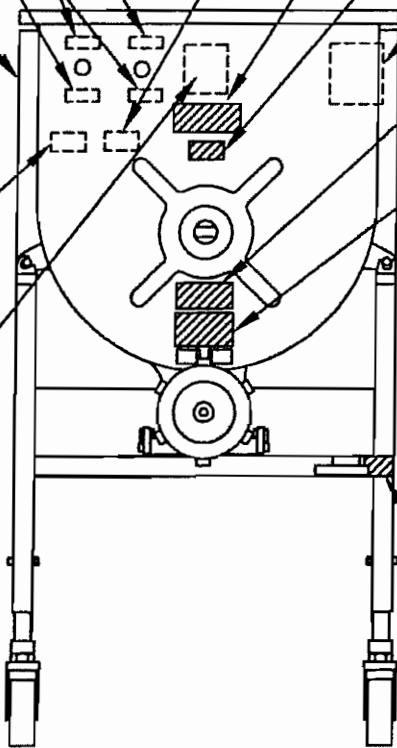
900-1046

900-0103  
OTHER SIDE

900-0103

900-1038  
ON BOTH SIDES

900-1002



PAGE 2

900-3012

# LABEL LIST

## MODEL 180A GRINDER

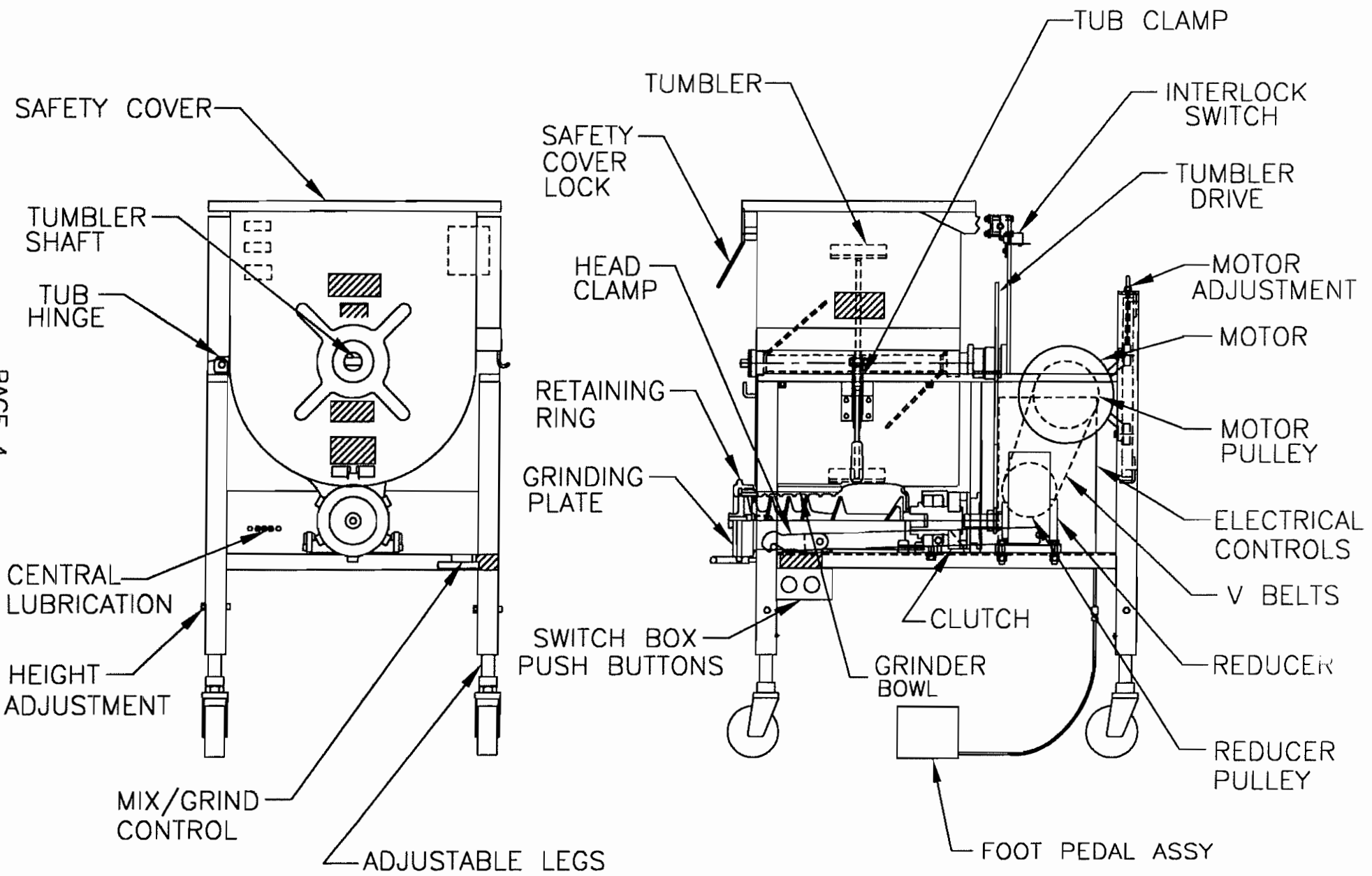
QTY.	PART NO.	DESCRIPTION
1	100-1374	TUB CAPACITY
1	100-1377	MIX AND GRIND
1	150-9012	PATENT
1	181-0650	NAMEPLATE, ELEC. SPEC'S, SERIAL NO.
1	181-0657	SERVICE LABEL
2	900-0103	WARNING-DO NOT OPERATE W/O GUARDS
1	900-0610	CAUTION-KEEP HANDS OUT OF HOPPER
1	900-1002	WARNING-UNPLUG POWER
1	900-1030	INSTRUCTIONS
2	900-1032	FUSE-1 AMP 200 V.
2	900-1033	FUSE-1 AMP 230 V.
2	900-1034	FUSE-1/2 AMP 460 V.
2	900-1035	PRIMARY FUSE
1	900-1037	DANGER-HAZARDOUS MOVING PARTS (GEMINI TUBS ONLY)
2	900-1038	DANGER-MOVING PARTS
1	900-1045	WARNING-MOVING PARTS
1	900-1046	CONNECT TO IND. BRANCH CIRCUIT
1	900-1047	WARNING-ROTATING KNIFE
2	900-1049	DANGER-HAZARDOUS MOVING PARTS
1	900-2003	MADE IN U.S.A.

### IMPORTANT:

NOTE: THOSE MACHINES EQUIPPED WITH A FOOT SWITCH HAVE LABELS WITH THE SWITCH SHOWING ADDITIONAL WARNINGS.

YOUR MACHINE WILL GIVE YEARS OF TOP PERFORMANCE IF OPERATED AND MAINTAINED PROPERLY. GET TO KNOW YOUR GMG 180A FOR TROUBLE-FREE OPERATION.

PAGE 4



# S P E C I F I C A T I O N S

HOPPER CAPACITY: 200 LBS.

PRODUCTION OUTPUT: UP TO 7200 LBS. PER HOUR  
 DEPENDING ON HEAD ASSEMBLY  
 GRINDER PLATE AND PRODUCT.

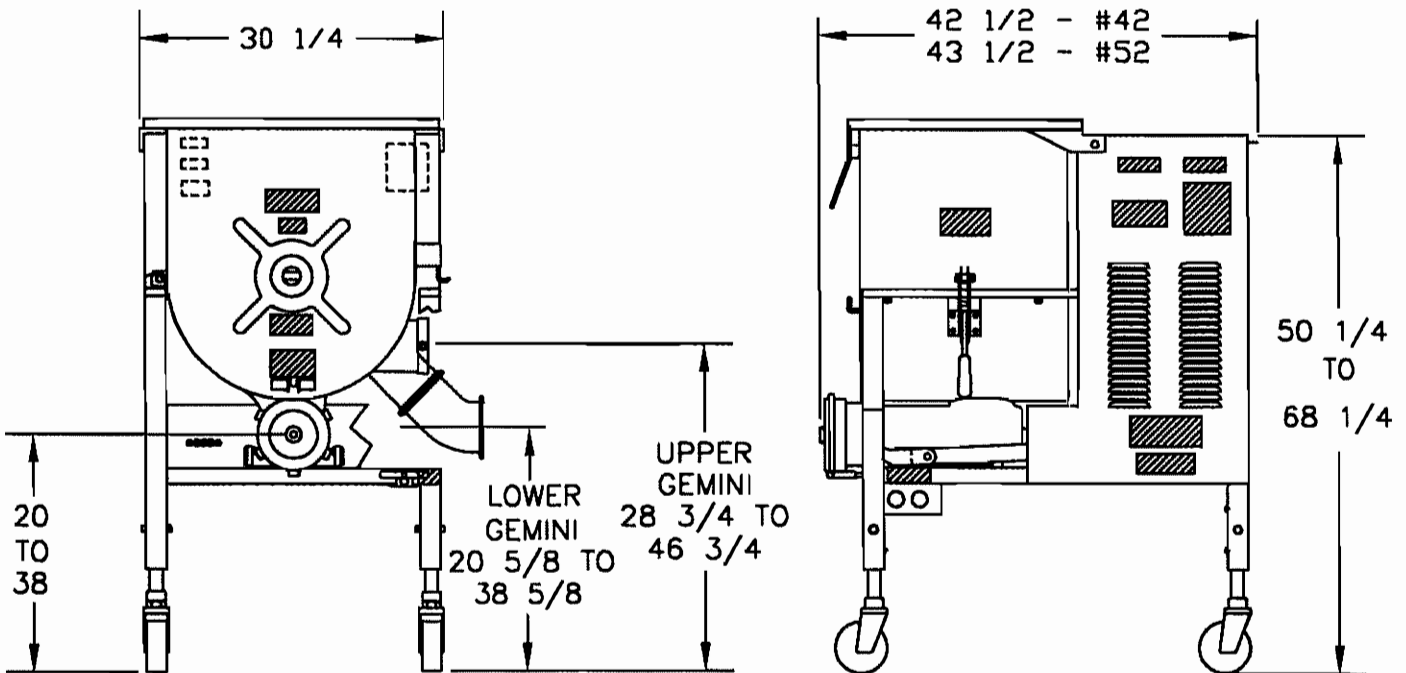
- OPTIONS:
- #42 BOWL 3/8" PLATE - P/N 900-0210
  - 1/8" PLATE - P/N 900-0211
  - #42 KNIFE - P/N 900-0212
  - #52 BOWL 3/8" PLATE - P/N 900-0213
  - 1/8" PLATE - P/N 900-0214
  - #52 KNIFE - P/N 900-0215

UPPER/LOWER GEMINI INTERFACE FOR TWO GRINDERS  
 FOOTSWITCH  
 RIGHT OR LEFT HAND CONTROLS

MATERIAL: 300 SERIES STAINLESS STEEL (HOPPER, FRAME & COVERS)

- MOTOR:
- 7.5HP, 200V, 60 HZ, 3PH, 25A
  - 7.5HP, 230/460, 60HZ, 3PH, 22/11A
  - 7.5HP, 575V, 60HZ, 3PH, 88A
  - 10HP, 200V, 60HZ, 3PH, 31A
  - 10HP, 230/460V, 60HZ, 3PH, 28/14A
  - 10HP, 575V, 60HZ, 3PH, 11.2A
  - 10HP, 380V, 50HZ, 3PH, 17A
  - 10HP, 220/440V, 50HZ, 3PH, 27/13.5A

WEIGHT: 825 LBS.



# HEIGHT ADJUSTMENT

THE GMG 180A IS SHIPPED WITH ADJUSTABLE LEGS FULLY RETRACTED. THE LEGS ALLOW A HEIGHT INCREASE OF 17" IN 1" STEPS. SHOULD A CHANGE IN OPERATING HEIGHT BE DESIRED, FOLLOW THE PROCEDURE BELOW.

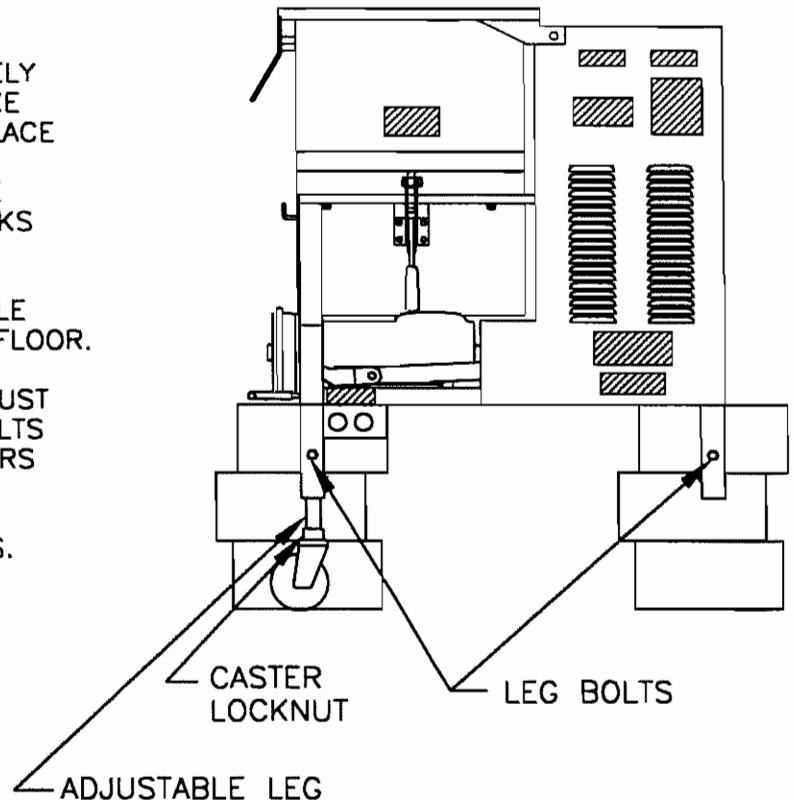
1. REMOVE STRAPS, SHIPPING BAG AND ALL EQUIPMENT INSIDE THE TUB. TAKE THE GMG 180A OFF SHIPPING PALLET.

2. THE GMG 180A WEIGHS APPROXIMATELY 800 POUNDS. TO AVOID ACCIDENTS MAKE CERTAIN THE MACHINE CANNOT SLIP. PLACE A JACK UNDER CENTER OF FRONT RAIL. JACK THE FRONT UP TO SLIGHTLY ABOVE DESIRED HEIGHT AND PLACE WOOD BLOCKS UNDER THE FRAME.

DISTANCE TO HEAD CENTER IS ADJUSTABLE FROM 20 1/2" TO 38 1/2" FROM THE FLOOR.

3. REMOVE FRONT LEG BOLTS AND ADJUST LEGS TO DESIRED HEIGHT. REPLACE BOLTS AND TIGHTEN SECURELY. INSTALL CASTERS ON FRONT LEGS.

4. REPEAT PROCEDURE FOR BACK LEGS.





# PREOPERATION CHECK OUT

BEFORE RUNNING THE GMG 180A THE FIRST TIME FOLLOW STEPS 1 THRU 6 TO PREVENT DAMAGE. THE GMG 180A WAS RUN AT THE FACTORY, BUT ELECTRICAL PHASING MAY NOT AGREE WITH YOUR ELECTRICAL SUPPLY. RATED VOLTAGE OF THE UNIT SHOULD BE THE SAME AS THE ELECTRICAL POWER SUPPLY VOLTAGE.

**NOTE:** READ THIS MANUAL COMPLETELY BEFORE GOING THROUGH THE PREOPERATION CHECK OUT.

1. THE GMG 180A COMES COMPLETELY ASSEMBLED EXCEPT FOR THE PLATE AND KNIFE. THE FACTORY HAS PLACED CARDBOARD IN THE HEAD TO RETAIN THE GRINDING SCREW. MAKE SURE THAT THE GRINDER BOWL IS SECURED WITH THE HEAD CLAMPS BEFORE MAKING THE ROTATION CHECK.

2. WIRE THE GMG 180A TO THE ELECTRICAL SUPPLY. PLACE THE GRINDING SCREW IN GRINDER BOWL SO LARGE SQUARE (DRIVE) END ENGAGES THE CLUTCH IN BEARING HOUSING. SAFETY COVER MUST BE CLOSED TO OPERATE THE MACHINE.

**NOTE:** SEE WIRING DIAGRAM ON PAGE 14.

3. WITH THE HANDLE IN THE MIX POSITION, JOG THE MACHINE BY FIRST PUSHING THE START BUTTON (GREEN) AND THEN IMMEDIATELY PUSH THE STOP BUTTON (RED) AND OBSERVE THE ROTATION OF THE GRINDING SCREW. THE ROTATION SHOULD BE COUNTERCLOCKWISE.

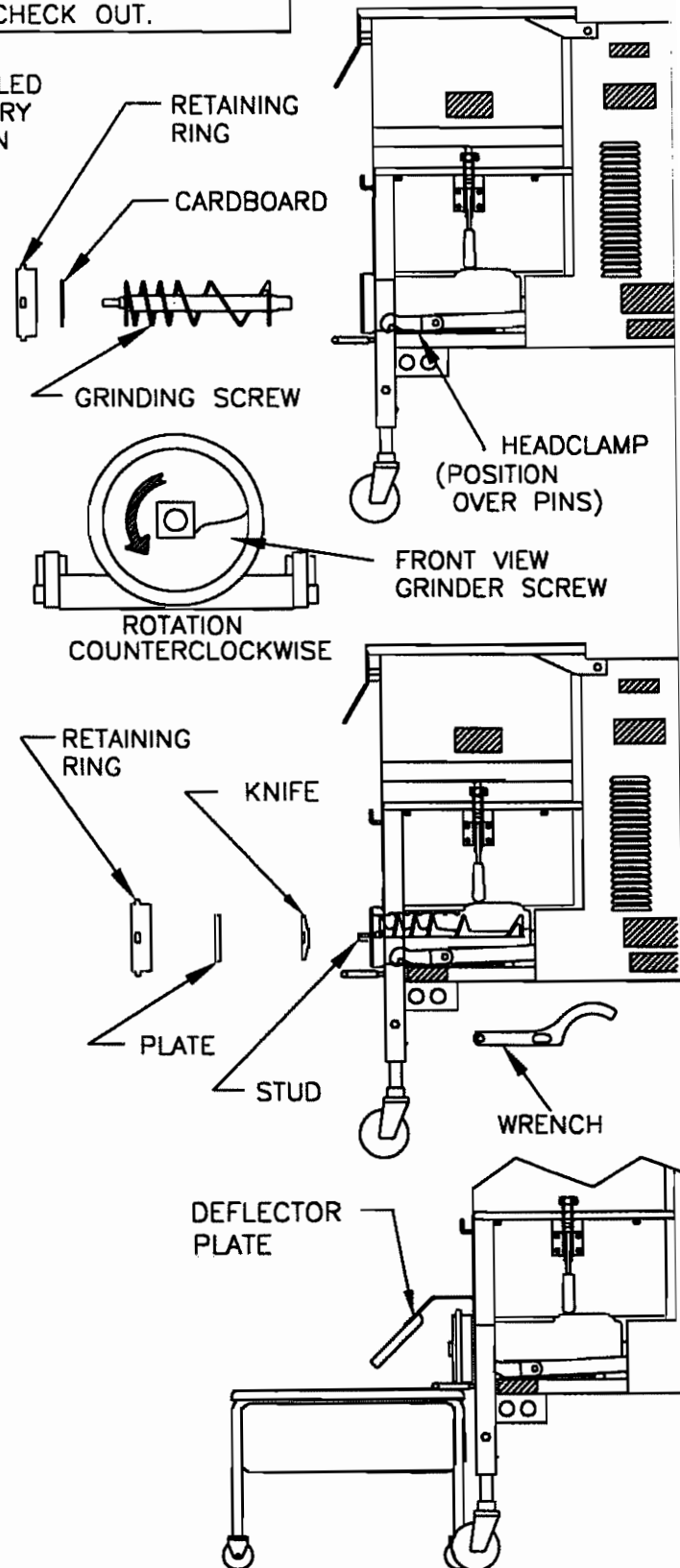
**WARNING:** DO NOT TOUCH MOVING PARTS.

4. IF THE SCREW RUNS CLOCKWISE, INTERCHANGE ANY TWO OF THE PHASE LINES IN THE PLUG OR RECEPTACLE.

**WARNING:** BE CERTAIN NOT TO CHANGE THE POSITION OF THE GROUNDING LEAD (GREEN).

5. SLIP KNIFE (SHARP EDGE OUT) ONTO SQUARE END OF GRINDING SCREW. THE PLATE SLIDES OVER END OF GRINDING SCREW STUD AND SEATS ON THE HEAD. INSTALL THE RETAINING RING AND TIGHTEN FIRMLY WITH RING WRENCH. (DO NOT OVERTIGHTEN).

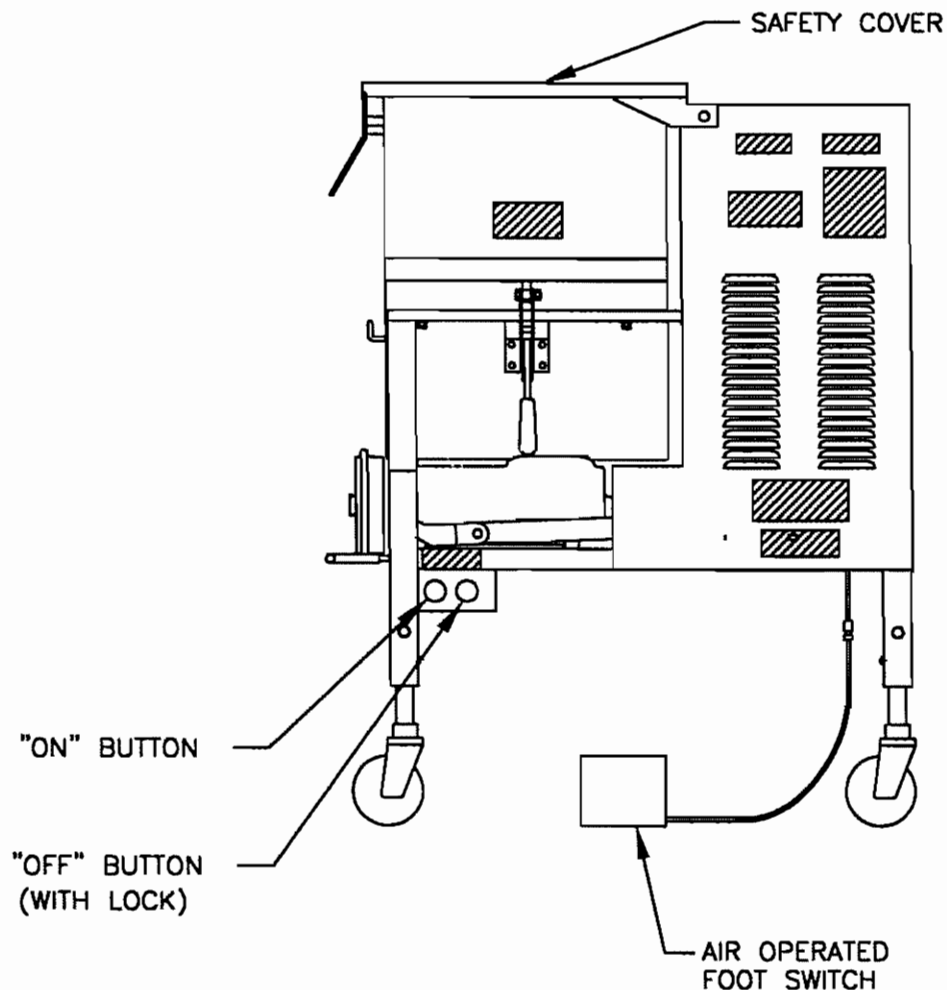
6. DROP DEFLECTOR PLATE INTO SLOT ON FRONT OF TUB. ALWAYS USE DEFLECTOR PLATE FOR FIRST GRIND TO AVOID SPLATTERING.



## CONTROLS—ELECTRICAL

THE GMG 180A CONTROLS CAN BE MOUNTED UPON REQUEST EITHER ON THE LEFT, OR ON THE RIGHT HAND SIDE OF THE MACHINE. THIS OPERATORS MANUAL SHOWS THE CONTROLS ON THE RIGHT HAND SIDE.

1. HAND OPERATION: PRESS GREEN BUTTON (ON) TO RUN THE GMG 180A, PRESS RED BUTTON (OFF) TO STOP. IF MOTOR SHOULD STOP DUE TO OVERLOAD, WAIT ABOUT A MINUTE AND OVERLOAD SWITCH WILL RESET AUTOMATICALLY, BUT THE ON BUTTON WILL HAVE TO BE PRESSED TO RESTART THE MACHINE.
2. TO USE THE FOOTSWITCH: PUSH THE LOCK OVER THE ("OFF") BUTTON. WITH THIS SETTING, PRESSURE ON THE FOOTSWITCH RUNS THE GMG 180A; RELEASE OF PRESSURE STOPS THE MACHINE.
3. THE GMG 180A IS EQUIPPED WITH A SAFETY COVER WHICH ACTUATES AN INTERLOCK SWITCH. WHEN THE COVER IS OPENED, THE ELECTRICAL START CIRCUIT IS INTERRUPTED TO PREVENT START-UP OF THE MACHINE WITH EITHER THE START BUTTON OR FOOT SWITCH. IF THIS SAFETY FEATURE IS FOUND TO BE INOPERATIVE FOR ANY REASON, CONTACT YOUR LOCAL HOLLYMATIC DEALER.



## CONTROL – MIX GRIND

THE MIX/GRIND CONTROL HANDLE IS LOCATED ON THE FRONT OF THE MACHINE. THIS HANDLE, WHEN PULLED OUT, DISENGAGES THE GRINDER SCREW SO THAT ONLY THE MIXER TUMBLER ROTATES. WHEN IT IS RELEASED AND MOVES INWARD THE GRINDER SCREW IS ENGAGED TO GRIND THE MIXED PRODUCT IN THE HOPPER. THE MEAT TUMBLERS WITHIN THE HOPPER ALWAYS ROTATE WHEN THE GMG 180A IS RUNNING.

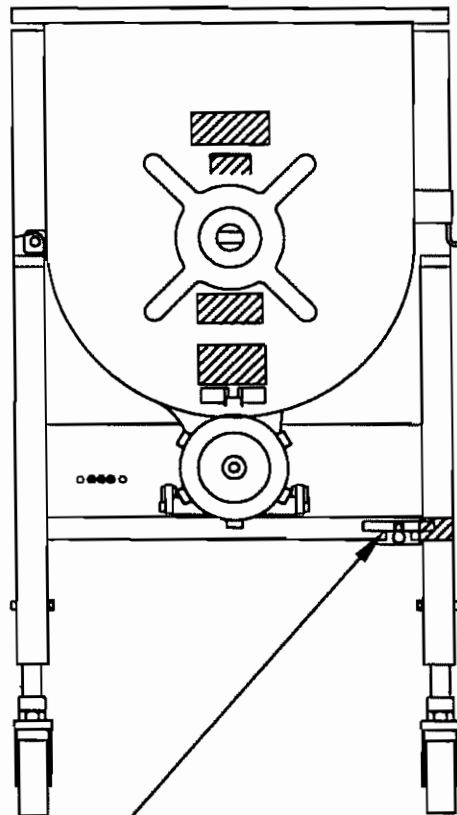
### MIX ONLY OPERATION

PULL AND MOVE HANDLE UP UNTIL IT LOCKS IN ITS (OUT POSITION). THIS DISENGAGES THE GRINDER SCREW.

**CAUTION:** DO NOT OPERATE GRINDER SCREW WITHOUT PRODUCT IN THE MACHINE.

### GRIND AND MIX OPERATION

PUSH THE HANDLE DOWN WHICH WILL RELEASE IT AND ENGAGE THE SCREW GRINDER.



MIX/GRIND HANDLE

# DISASSEMBLY & CLEANING

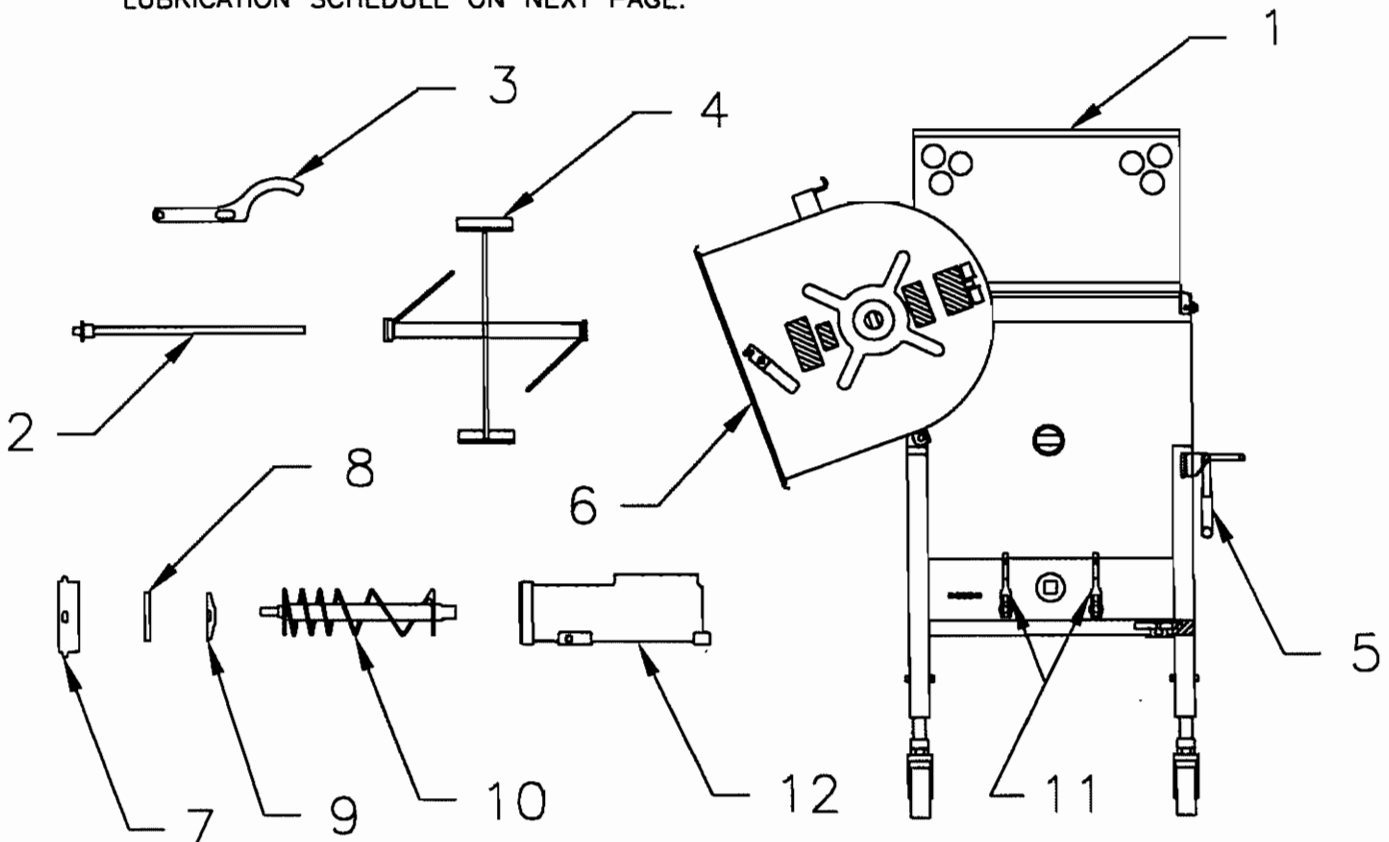
TO COMPLY WITH SANITATION REGULATIONS, THE GMG 180A SHOULD BE CLEANED AFTER EACH WORKING DAY.

**WARNING:** MAKE CERTAIN MACHINE IS TURNED OFF AND UNPLUGGED. FAILURE TO OBSERVE THIS SAFETY PROCEDURE MAY RESULT IN SERIOUS PERSONAL INJURY.

1. OPEN SAFETY COVER (1), UNSCREW PADDLE SHAFT DRAW BAR (2), USE HANDLE OF RING WRENCH (3), REMOVE PADDLE (4) FROM DRUM.

NOTE: IF PADDLE WILL NOT COME OUT, RELEASE TUB CLAMP AND PULL TAB FORWARD, THIS WILL FACILITATE PADDLE REMOVAL.

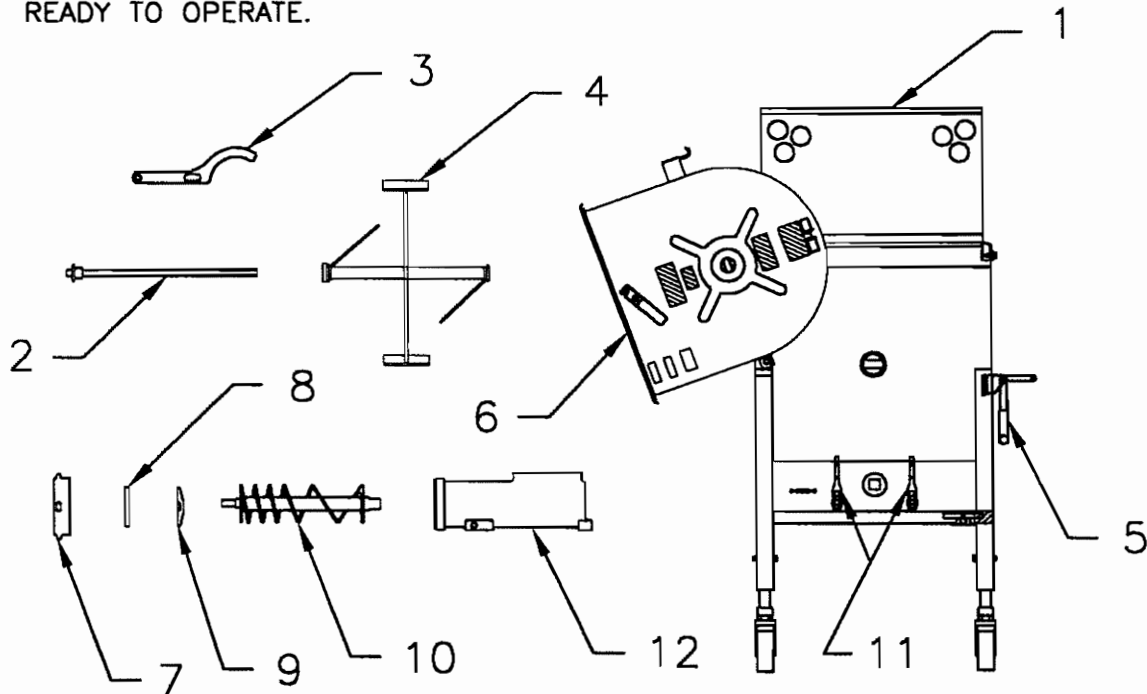
2. RELEASE TUB CLAMP (5), PULL TUB (6) FORWARD AND SWING OUT.
3. REMOVE RETAINING RING (7), GRINDING PLATE (8), KNIFE (9), AND SCREW (10). LIFT CLAMPS (11), AND SLIDE OUT GRINDER HEAD.
4. AFTER DISASSEMBLY WASH THE MACHINE FRAME, TUB, RETAINING RING, GRINDING PLATES, KNIVES, SCREW, HEAD AND PADDLE THOROUGHLY WITH HOT WATER AND DETERGENT.
5. AFTER CLEANING THE GMG 180A, WIPE EVERYTHING DRY. OIL THE PARTS IN THE FOOD ZONE (ITEMS 2, 4, 7, 8, 9, 10 AND 12 BELOW) WITH HOLLY-FLUID TO PREVENT ANY OVERNIGHT OXIDATION. FOLLOW LUBRICATION SCHEDULE ON NEXT PAGE.



# REASSEMBLY

FOR REASSEMBLING PROCEED IN REVERSE ORDER OF DISASSEMBLY.

1. PLACE THE GRINDING HEAD (12) ON THE MACHINE SHELF AND SLIDE IT BACK ONTO THE PINS EXTENDING FROM THE FRONT PANEL. DROP THE CLAMPS (11) OVER THE PINS AT THE FRONT END OF THE HEAD. INSTALL THE FEED SCREW (10), KNIFE (9) (CUTTING EDGES TOWARD THE GRINDING PLATE), GRINDING PLATE (8), RETAINING RING (7), AND TIGHTEN THE RETAINING RING FIRMLY WITH THE RING WRENCH (3). (DO NOT OVERTIGHTEN).
2. SWING THE TUB (6) BACK TO IT'S LOWER POSITION AND PUSH IT REARWARD. SECURE IT IN POSITION WITH THE TUB CLAMP (5).
3. PLACE THE PADDLE (4) INTO THE TUB AND MAKE CERTAIN THAT THE KEY OF THE PADDLE ENGAGES THE DRIVE SHAFT. (NOTE: IF YOU CANNOT ENGAGE THE PADDLE WITH THE KEYWAY, RELEASE THE TUB CLAMPS AND PULL THE TUB FORWARD. NOW INSTALL THE PADDLE AS YOU PUSH THE TUB REARWARD.) SCREW IN THE PADDLE SHAFT (20), USING THE SLOT IN THE HANDLE OF THE RING WRENCH (3), SECURE THE PADDLE IN PLACE AND CLOSE THE SAFETY COVER (1). THE GMG 180A IS NOW READY TO OPERATE.



## SUMMARY

1. ALWAYS USE A BREAKER PLATE (3/8" OR LARGER HOLES) FOR FIRST GRIND.
2. MAKE SURE GRINDING PLATE EXTENDS FROM THE FRONT SURFACE OF THE GRINDING HEAD AND IS RETAINED BY THE LOCATING PIN.
3. NEVER RUN THE GMG 180A MORE THAN A FEW SECONDS WITHOUT MEAT TO AVOID DAMAGE TO THE KNIFE AND PLATE.
4. NEVER OVERLOAD THE GMG 180A; CAPACITY IS 200 POUNDS.
5. GRINDING FROZEN MEAT IS NOT RECOMMENDED. THIS CAN CAUSE DAMAGE TO THE MACHINE.
6. ALWAYS USE KNIVES AND PLATES AS SETS FOR BEST RESULTS.
7. CLEAN OFF FAT, SINEW, ETC. FROM THE PLATE AND KNIFE IF OUTPUT SLOWS DOWN.
8. WASH YOUR GMG 180A AFTER EACH DAY'S USE.
9. LUBRICATE THE GMG 180A AS SHOWN ON PAGE 13.

# OPERATING THE GMG 180A

**CAUTION:** THE GMG 180A SHOULD BE REASSEMBLED PROPERLY BEFORE OPERATION (SEE PAGES 10 AND 11).

## FIRST GRIND

1. ALWAYS USE A GRINDING PLATE WITH HOLES 3/8 INCH DIAMETER OR LARGER FOR FIRST GRIND.
2. INSTALL THE KNIFE ON THE SQUARE END OF THE GRINDING SCREW. THE BREAKER PLATE SLIDES OVER THE GRINDING SCREW STUD AND IS LOCKED TO PREVENT ROTATION BY A PIN IN THE GRINDING BOWL. INSTALL THE RETAINING RING AND TIGHTEN WITH THE RING WRENCH. PLACE THE DEFLECTOR PLATE IN THE SLOT LOCATED ON THE FRONT OF THE TUB AND PLACE THE MIX/GRIND HANDLE IN THE MIX POSITION.
3. LOAD THE GMG 180A WITH 200 POUNDS OF MEAT CHUNKS ABOUT 12" X 2" SQUARE. DO NOT OVERLOAD THE TUB.

**CAUTION:** GRINDING FROZEN MEAT IS NOT RECOMMENDED AS STALLING OR DAMAGE CAN RESULT.

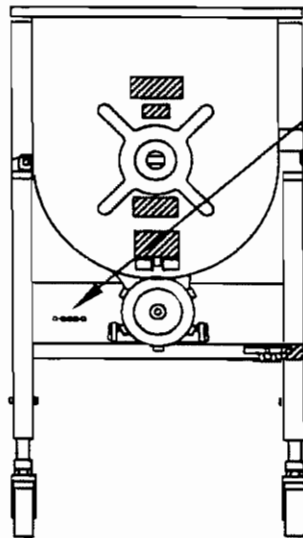
4. CLOSE THE SAFETY COVER AND TURN ON THE GMG 180A. WAIT A FEW SECONDS AND THEN PRESS DOWN ON THE MIX/GRIND HANDLE TO ENGAGE THE GRINDER SCREW. THE MACHINE WILL AUTOMATICALLY GRIND THE TUB EMPTY.
5. AFTER THE FIRST GRIND IS COMPLETED, PULL AND MOVE THE MIX/GRIND HANDLE UP UNTIL IT LOCKS IN PLACE. THIS DISENGAGES THE GRINDING SCREW.

## MIX/FINAL GRIND

6. UNPLUG THE MACHINE FROM THE POWER SOURCE. REMOVE THE FIRST GRIND PLATE, AND USING THE RING WRENCH, LOOSEN THE RETAINING RING. REMOVE SINEWS, GRISTLE, ETC. FROM THE KNIFE AND INSTALL THE FINAL GRIND PLATE (FOR INSTANCE 1/8 DIA. HOLES) AND KNIFE. REINSTALL THE RETAINING RING AND TIGHTEN FIRMLY.
7. PLACE THE PREGROUND MEAT, SPICES AND OTHER INGREDIENTS INTO THE TUB. CLOSE SAFETY COVER AND TURN ON THE GMG 180A. WATER CAN BE ADDED DURING MIXING THROUGH THE VIEWING HOLES IN THE SAFETY COVER. BLEND AN AVERAGE MIX OF FAT AND LEAN FOR APPROXIMATELY ONE MINUTE.
8. FOR FINAL GRIND, PRESS DOWN ON THE MIX/GRIND HANDLE TO ENGAGE THE GRINDER SCREW. THE GMG 180A WILL AUTOMATICALLY GRIND THE TUB EMPTY. AFTER THE FINAL GRIND IS COMPLETE, STOP THE MACHINE AND PLACE THE MIX/GRIND HANDLE IN THE MIX POSITION.
9. IF THE GMG 180A IS USED FOR THE FINAL GRIND ONLY, IT MAY DEVELOP FAT BUILD-UP ON THE GRINDER SCREW AND PLATE. TO CLEAN OUT THE FAT, SIMPLY DROP A FEW CHUNKS OF LEAN MEAT INTO THE TUB AND GRIND. THE LEAN MEAT AND GRINDING ACTION WILL CLEAN OUT FAT BUILD-UP.

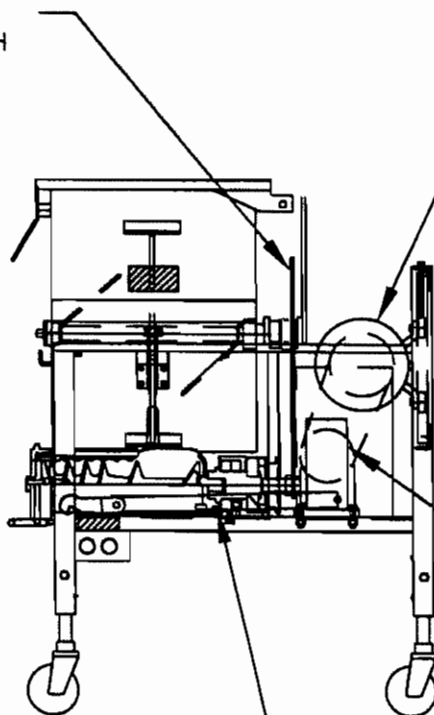
# LUBRICATION

YOUR GMG 180A HAS ONLY 5 PLACES WHERE LUBRICATION IS REQUIRED.  
IT IS IMPORTANT TO FOLLOW THE LUBRICATION SCHEDULE AS SHOWN.  
A WELL LUBRICATED MACHINE WILL OPERATE BETTER AND LONGER.



CENTRAL LUBRICATION FOR  
CLUTCH AND TUMBLER DRIVE  
HOLLYMATIC MULTILUBE

SPROCKET AND CHAIN  
OIL ONCE EACH MONTH  
LUBRIPLATE #8



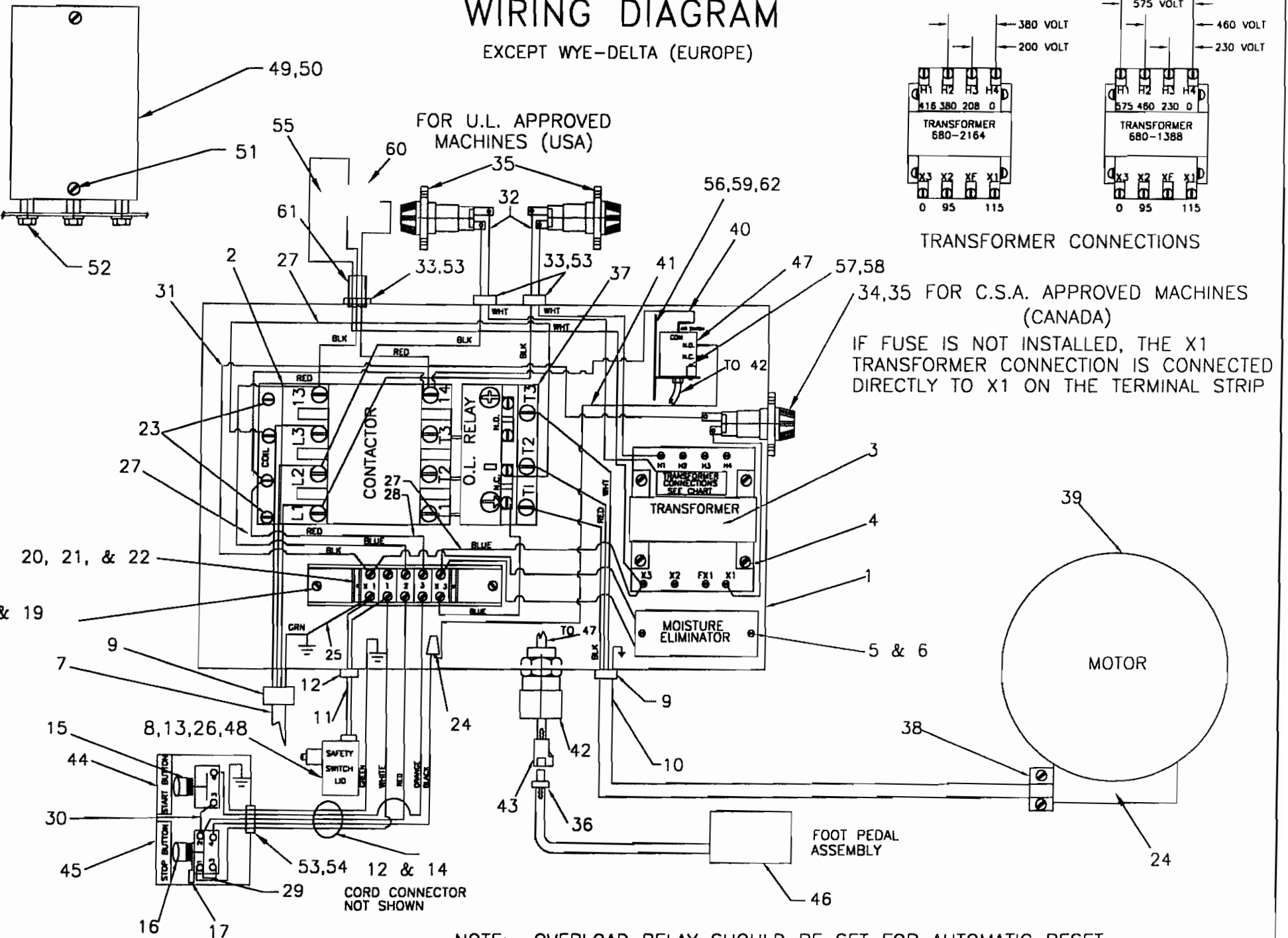
MOTOR - GREASE 2 FITTINGS  
EVERY 6 MONTHS 2 STROKES  
HOLLYMATIC MULTILUBE

REDUCER - CHECK MONTHLY  
CHANGE OIL EVERY 6 MONTHS  
LUBRIPLATE #8

CLUTCH, DRIVEN - REMOVE BOWL  
AND GREASE ONCE A MONTH  
2 STROKES HOLLYMATIC MULTILUBE

# WIRING DIAGRAM

EXCEPT WYE-DELTA (EUROPE)



34,35 FOR C.S.A. APPROVED MACHINES (CANADA)  
 IF FUSE IS NOT INSTALLED, THE X1 TRANSFORMER CONNECTION IS CONNECTED DIRECTLY TO X1 ON THE TERMINAL STRIP

NOTE: OVERLOAD RELAY SHOULD BE SET FOR AUTOMATIC RESET



# ELECTRICAL PARTS LIST

30	1	JUMPER S. & S. BUTTON	181-0390
29	1	JUMPER STOP BUTTON	181.0368
28	2	CONNECTING WIRE RED	181-0366
27	2	CONNECTING WIRE BLUE	181-0364
26	2	#6-32 HEX NUT	731005140
25	1	GROUND WIRE GREEN	181-0367
24	4	WIRE NUT	500-1264
23	4	#8-32 UNC PAN HEAD	712041640
22	2	CHANNEL CLAMP	8000-0990
21	1	TERMINAL B. END SECT.	8000-3355
20	5	TERMINAL BLOCK	8000-0989
19	2	8-32 X1/4 P. H.M.S.	712021623
18	1	MOUNTING CHANNEL	675-1534
17	1	PUSH BUTTON LOCK	100-1029
16	1	P. BUTTON STOP ASS'Y.	100-1028
15	1	P. BUTTON START ASS'Y.	100-1027
14	1	CORD PUSH BUTTON	181-0388
13	2	#6-32 X 1 1/2 HHMS	711141440
12	2	CORD CONNECTOR	100-0954
11	1	SAFETY SWITCH CORD	181-0382
10	1	CORD TO MOTOR	SEE CHART
9	2	CORD CONNECTOR	100-0845
8	1	INTERLOCK SWITCH	326671
7	A/R	CORD TO STARTER	SEE CHART
6	2	6-32 X 3/8 T. H.M.S.	711031640
5	1	MOISTURE ELIM. ASS'Y.	150-9190
4	4	10-32 X 1/2 T. H.M.S.	723041540
3	1	TRANSFORMER	SEE CHART
2	1	CONTACTOR	181-0321
1	1	ELECTRICAL PANEL	181-0328
ITEM	REQD	DESCRIPTION	PART NO.

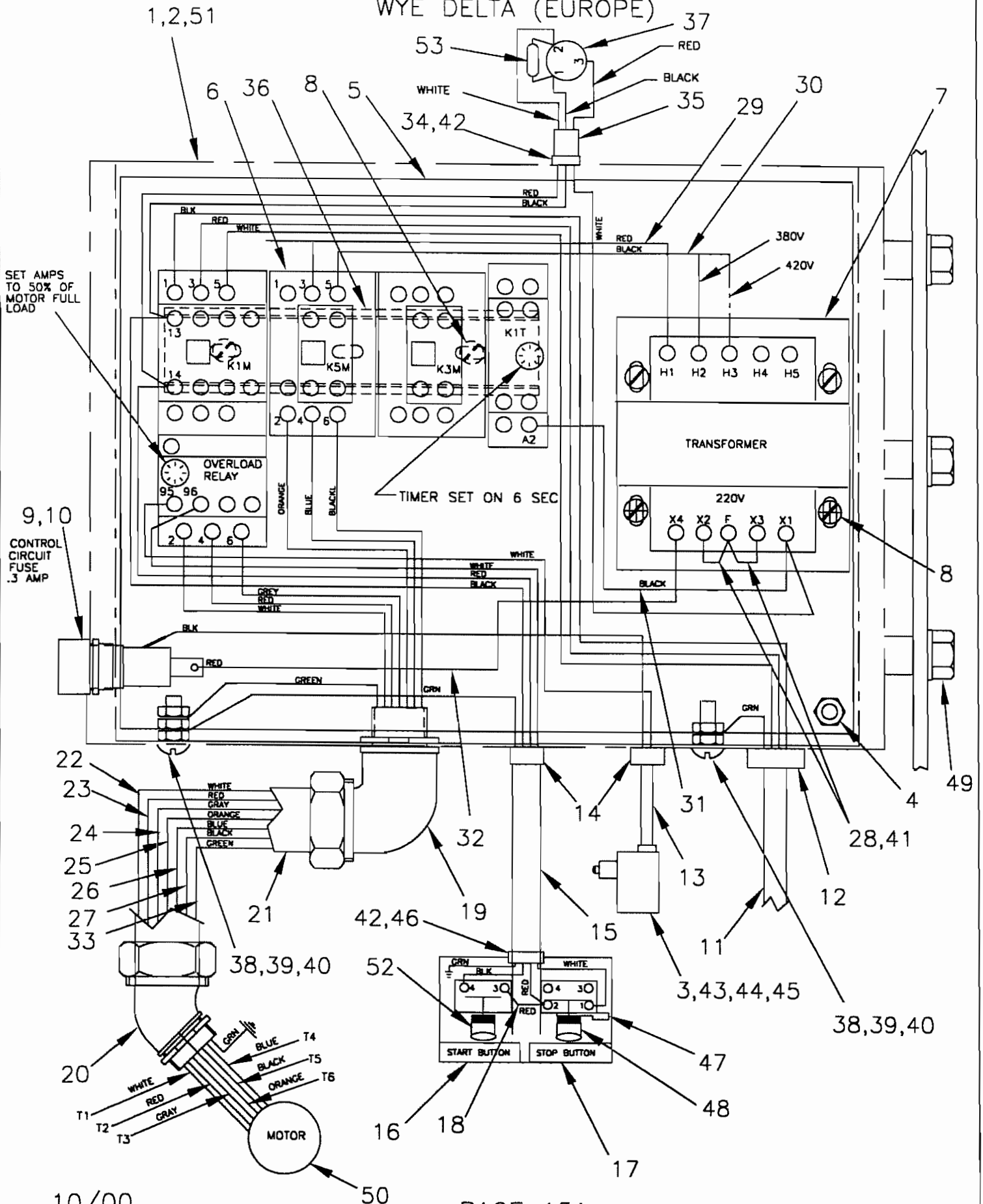
62	2	#6 INT TOOTH LOCKWASHER	751000640
61	1	CORD ASSY-HOUR METER	181-0045
60	1	HOUR METER	900-0220
59	2	#6-32 X 3/8 PHMS	711031640
58	1	NUT, HEX #4-40	120-0110
57	1	SCREW, RD. HD. #4-40	120-0118
56	1	BRACKET, FOOT SWITCH	181-0860
55	1	SURGE SUPPRESSOR	900-0221
54	1	CORD GRIP	580-8041
53	4	LOCKNUT	400-1150
52	3	BOLT ASSORTMENT	181-0646
51	2	BOLT ASSORTMENT-LID	181-0644
50	1	LID-ELECTRICAL BOX	181-0326
49	1	BOX-ELECTRICAL	181-0318
48	2	#6 EXTERNAL LOCKWASHER	751000740
47	1	AIR SWITCH WITH TUBING	181-0862
46	A/R	FOOT PEDAL ASSEMBLY	181-0863
45	1	LEGEND STOP PLATE	181-0803
44	1	LEGEND START PLATE	181-0802
43	1	COUPLING BODY	181-0816
42	1	CORD CONNECTOR	181-0818
41	1	WIRE-BLACK ASSEMBLY	181-0821
40	1	WIRE-WHITE ASSEMBLY	181-0822
39	1	MOTOR	SEE CHART
38	1	CORD CLAMP CONNECTING	180-8507
37	1	SOL. ST. OVERLOAD RELAY	SEE CHART
36	1	COUPLING INSERT	181-0817
35	A/R	FUSEHOLDER	SEE CHART
34	A/R	FUSE	SEE CHART
33	3	CORD CONNECTORS	860-0522
32	2	FUSE CORD ASS'Y.	181-0499
31	1	CONNECTING WIRE BLACK	181-0495

## COMPOSITE CHART

ASSEMBLY NO.	VOLTS	PH.	HP.	HZ	MOTOR NO.	MOTOR CORD	TRANSF.	POWER CORD ASSY.	OVERLOAD AMP SETTING (FLA)	FUSE	TO: NO.	FUSEHOLDER	O.L.RELAY
181-9101	200	3	7 1/2	60	181-0334	181-0380	680-2164	USA CAN	181-0378	25	190-0176 USA 2 181-0392 CAN 1	190-0175 500-1251	181-0319
181-9102	230	3	7 1/2	60	181-0336	181-0380	680-1388	USA CAN	181-0378	22	190-0176 USA 2 181-0392 CAN 1	190-0175 500-1251	181-0319
181-9103	380	3	7 1/2	60	181-0834	181-0380	680-2164	USA CAN	181-0378		190-0176 BZL 2	190-0175	181-0319
181-9104	460	3	7 1/2	60	181-0336	181-0380	680-1388	USA CAN	181-0376	11	190-0176 USA 2	190-0175	150-3277
181-9105	575	3	7 1/2	60	181-0338	181-0380	680-1388	USA CAN	181-0374	10	181-0392 CAN 1	500-1251	150-3277
181-9106	200	3	10	60	181-0340	181-0380	680-2164	USA CAN	181-0306	32	190-0176 USA 2 181-0392 CAN 1	190-0175 500-1251	181-0319
181-9107	230	3	10	60	181-0344	181-0380	680-1388	USA CAN	181-0378	28	190-0176 USA 2 181-0392 CAN 1	190-0175 500-1251	181-0319
181-9108	380	3	10	60	181-0835	181-0380	680-2164	USA CAN	181-0378	17.5	190-0176 BZL 2	190-0175	181-0319
181-9109	460	3	10	60	181-0344	181-0380	680-1388	USA CAN	181-0376	14	190-0176 USA 2	190-0175	181-0319
181-9110	575	3	10	60	181-0342	181-0380	680-1388	USA CAN	181-0374	11	181-0392 CAN 1	500-1251	150-3277
181-9111	230	3	10	50	181-0339	181-0380	680-1388	USA CAN	181-0378	28	181-0392 EUR 1	500-1251	181-0319

# WIRING DIAGRAM

## WYE DELTA (EUROPE)



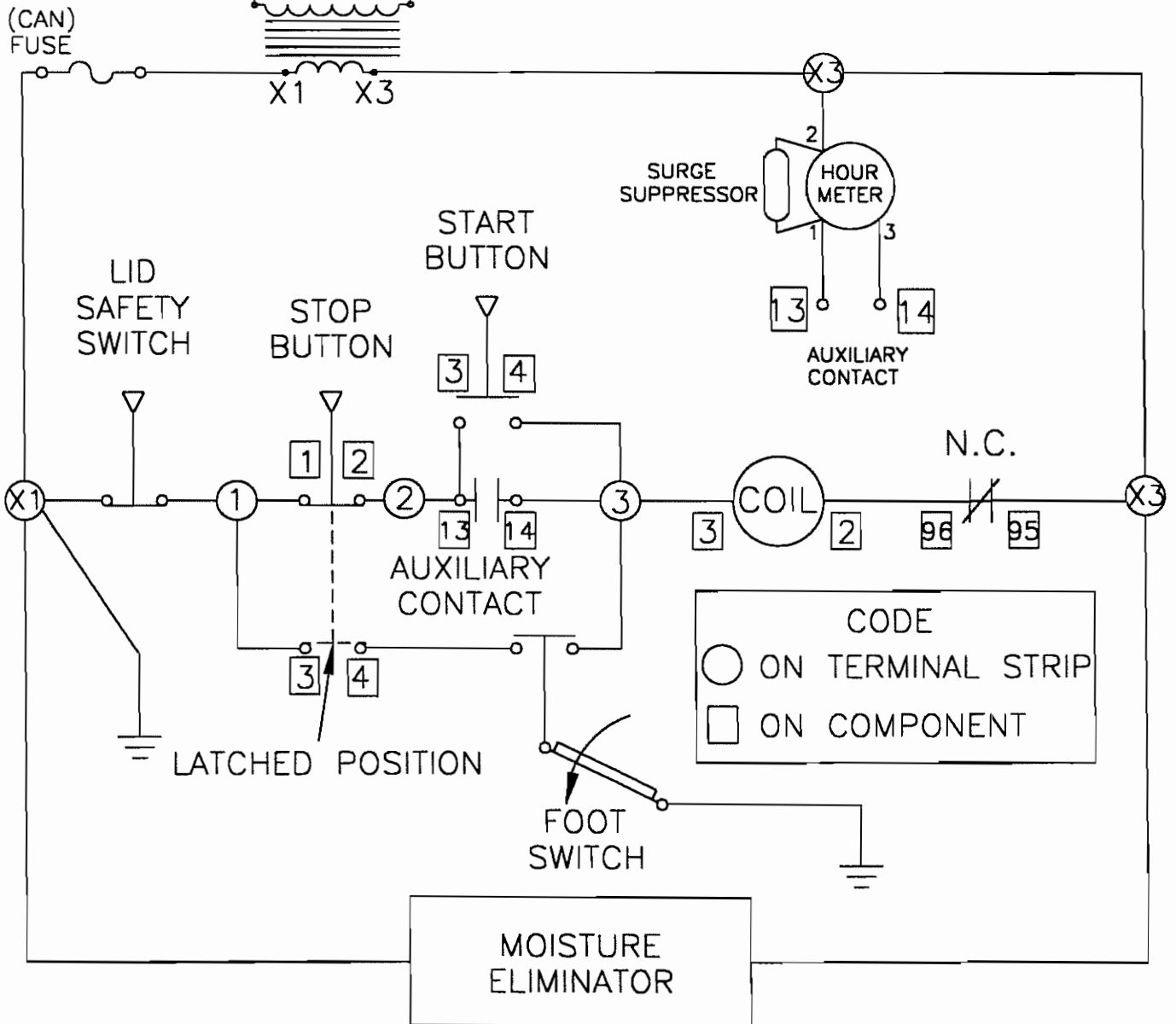
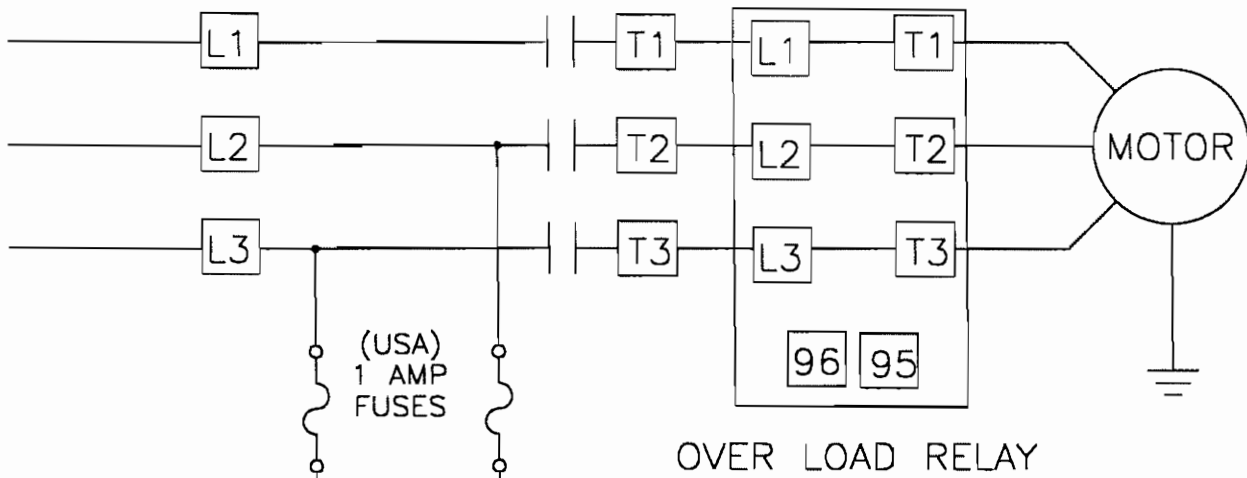
# ELECTRICAL PARTS LIST

## WYE DELTA (EUROPE)

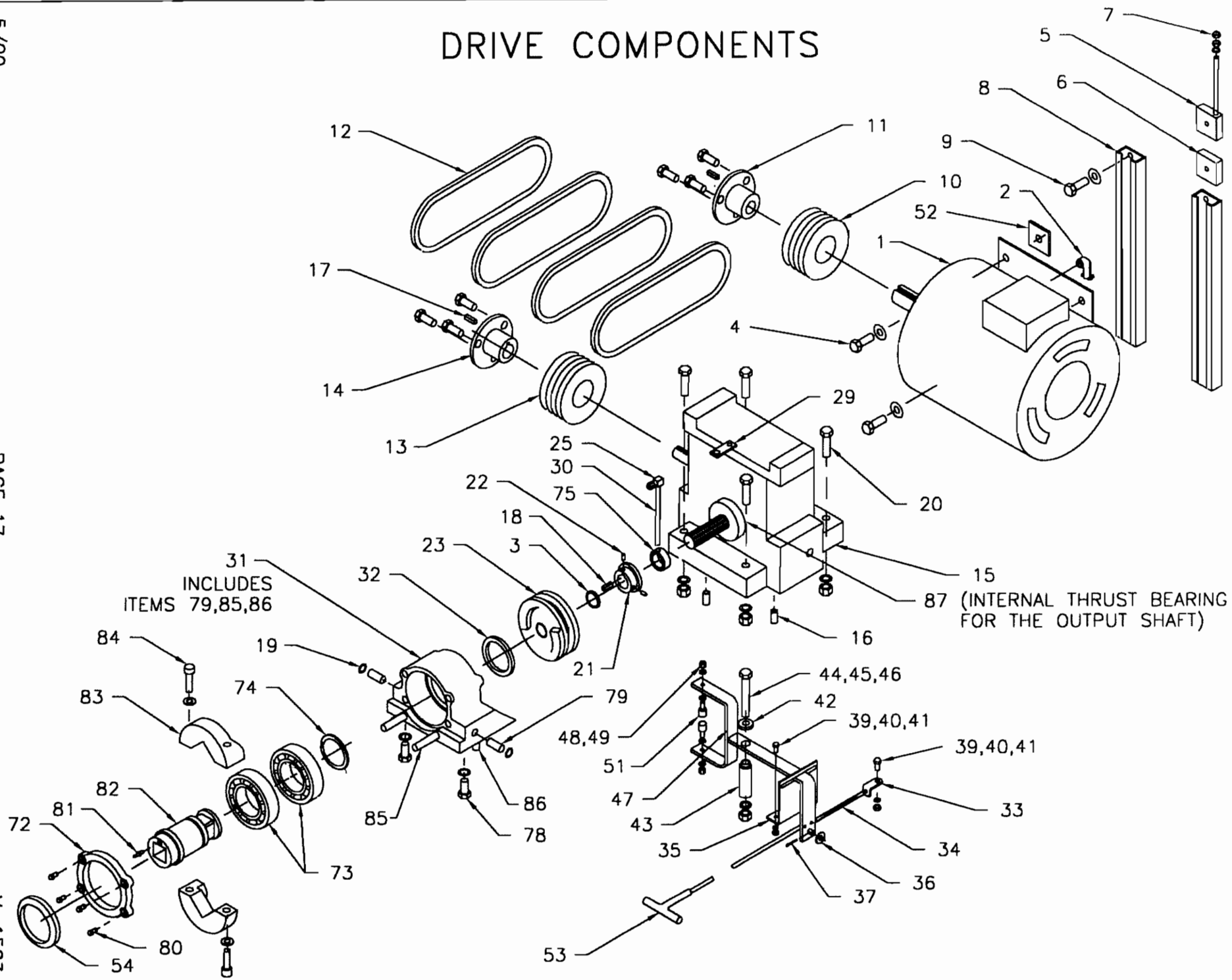
25	1	LEAD WIRE-ORANGE	181-0397
24	1	LEAD WIRE-GRAY	181-0396
23	1	LEAD WIRE-RED	181-0395
22	1	LEAD WIRE-WHITE	181-0394
21	1	ELECTRICAL CONDUIT	181-0303
20	1	45° CONNECTOR	8000-3365
19	1	90° CONNECTOR	8000-3362
18	1	JUMPER START/STOP BUTTON	181-0390
17	1	LEGEND STOP PLATE	181-0803
16	1	LEGEND START PLATE	181-0802
15	1	PUSH BUTTON CORD	181-0389
14	2	CORD CONNNECTOR	100-0954
13	1	SAFETY SWITCH CORD ASSY	181-0383
12	1	CORD CONNECTOR	100-0845
11	1	CORD STARTER TO SOURCE	181-0393
10	1	FUSE .3 AMP	181-0391
9	1	FUSE HOLDER	500-1251
8	6	#10-32X1/2 PHMS	723041540
7	1	TRANSFORMER	181-0329
6	1	STARTER ASSY-WYE DELTA	180-8474
5	1	ELECTRICAL PANEL-WYE DELTA	181-0331
4	8	HEX NUT 1/4-20	734005153
3	1	SAFETY SWITCH	326671
2	1	LID FOR ELECTRICAL BOX	181-0326
1	1	ELECTRICAL BOX	181-0318
ITEM	QTY	DESCRIPTION	PART NO.

53	1	SURGE SUPPRESSOR	900-0221
52	1	P.BUTTON START ASSY	100-1027
51	2	BOLT ASSORTMENT-LID	181-0644
50	1	MOTOR, 380V, 50CY, 3PH, 10HP	181-0341
	1	MOTOR, 420V, 50CY, 3PH, 10HP	181-0343
49	3	BOLT ASSORTMENT	181-0646
48	1	P.BUTTON STOP ASSY	100-1028
47	1	PUSH BUTTON LOCK	100-1029
46	1	CORD GRIP	580-8041
45	2	#6 EXT. LOCKWASHER	751000740
44	2	#6-32 HEX NUT	731005140
43	2	#6-32 X 1 1/2 HHMS	711141440
42	2	LOCKNUT	400-1150
41	4	SPADE LUG	879-2027
40	3	1/4 INT. LOCKWASHER	754000640
39	5	1/4-20 HEX NUT BRASS	734008260
38	2	1/4-20 x 1" RHMS BRASS	714101460
37	1	HOUR METER	900-0220
36	1	DIN MOUNTING RAIL	181-0857
35	1	CORD ASSY-HOUR METER	181-0045
34	1	CORD CONNECTOR	860-0522
33	1	WIRE ASSY-GRN	181-0858
32	1	WIRE ASSY-RED TRANSF TO FUSE	181-0357
31	1	WIRE ASSY-BLK TRANSF TO TIMER	181-0371
30	1	WIRE ASSY-BLK STARTER TO TRANSF.	181-0351
29	1	WIRE ASSY-RED STARTER TO TRANSF.	181-0355
28	2	JUMPER WIRE-TRANSFORMER	181-0390
27	1	LEAD WIRE-BLACK	181-0399
26	1	LEAD WIRE-BLUE	181-0398

# ELECTRICAL SCHEMATIC



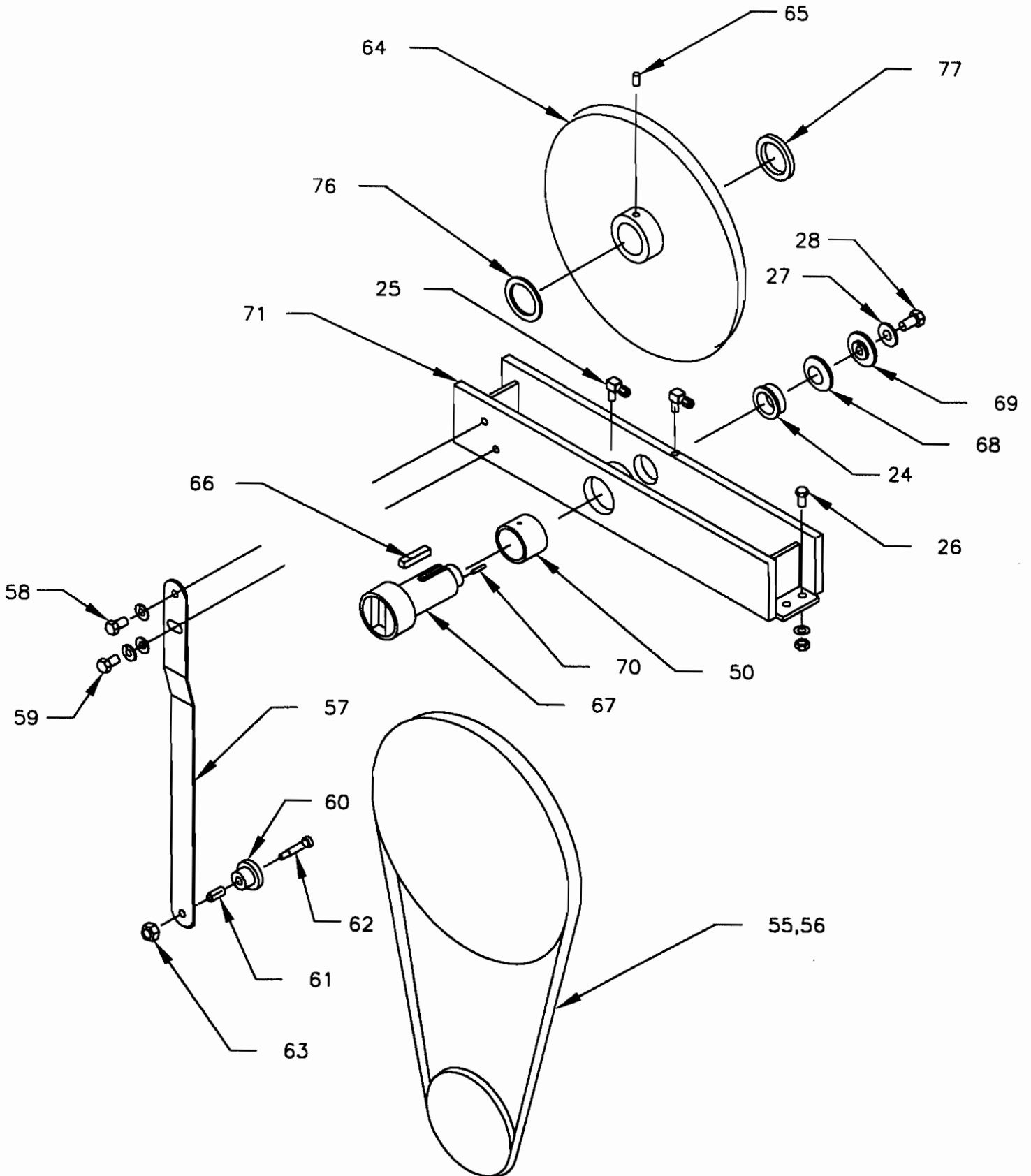
# DRIVE COMPONENTS



31  
INCLUDES  
ITEMS 79,85,86

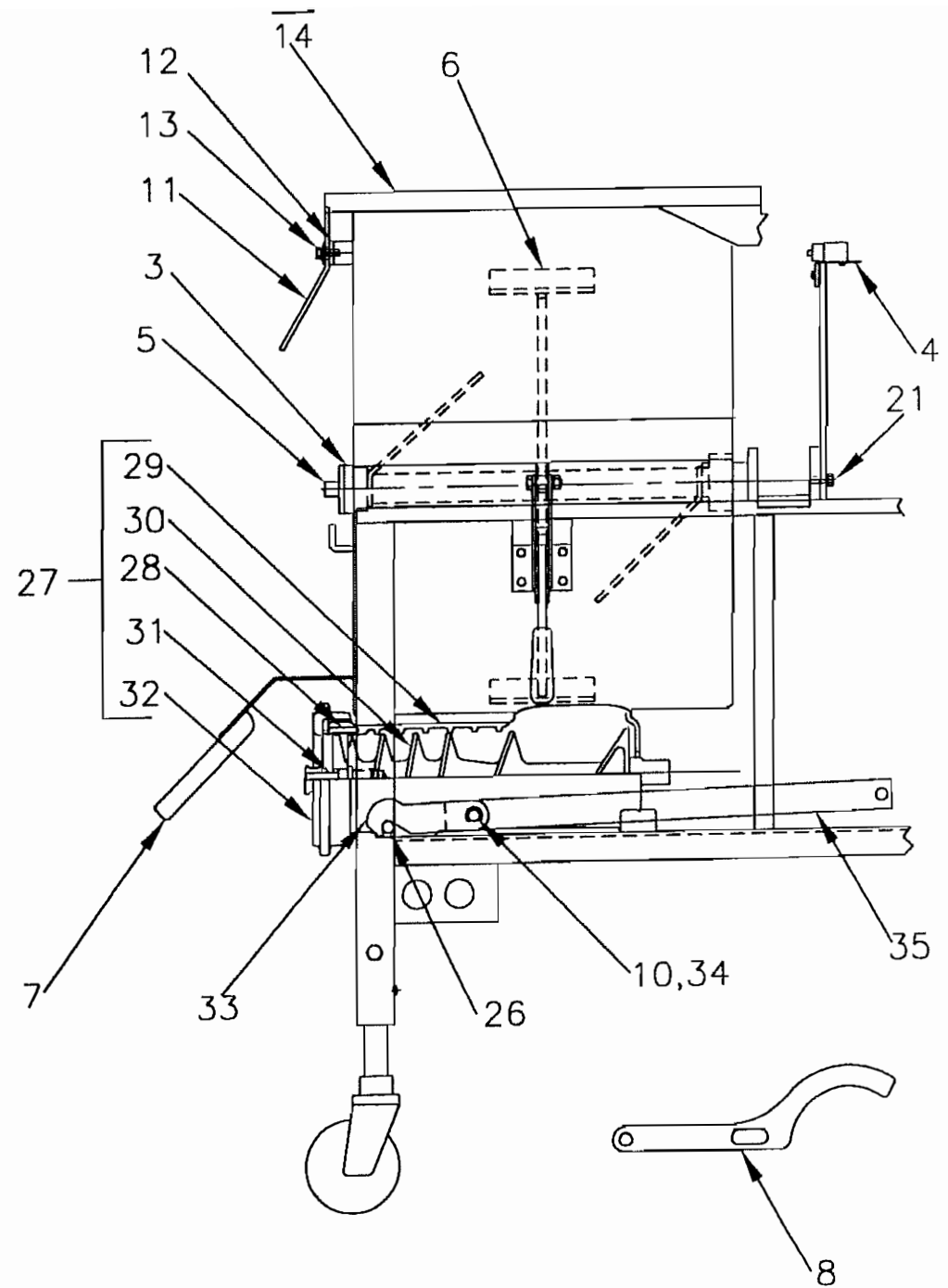
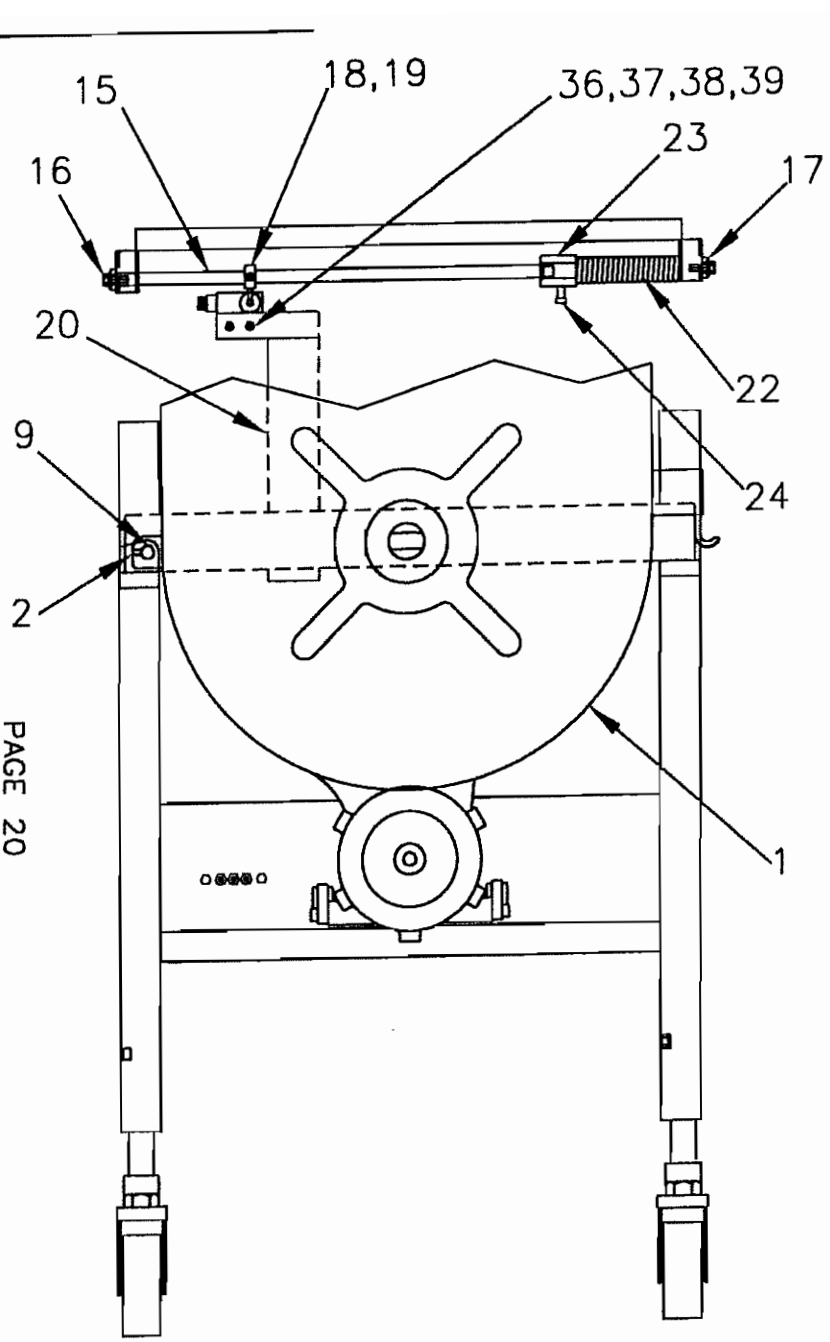
87  
(INTERNAL THRUST BEARING  
FOR THE OUTPUT SHAFT)

# DRIVE COMPONENTS



# DRIVE

ITEM	QTY	PART NO.	ITEM	QTY	PART NO.
1	MOTOR:				
	1	181 0334	40	8M SPLIT LOCKWASHER	3 11508000210
	1	181 0336	41	HEX HEAD CAP SCREW	3 11108202110
	1	181 0338	42	CAP SUPPORT POST	1 181 0241
	1	181 0340	43	SUPPORT POST	1 181 0242
	1	181 0344	44	3/8 HEX NUT	1 736005153
	1	181 0342	45	3/8 SPLIT LOCKWASHER	1 756000591
	1	181 0341	46	HEX HEAD CAP SCREW	1 716440253
	1	181 0339	47	SHIFTING FRONT WLDMT	1 181 0240
	1	181 0343	48	1/4 LOCK NUT	2 100 1295
2	1	180 8507	49	1/4 FLATWASHER	4 754000191
3	1	480 0918	50	BUSHING-TUMBLER	1 181 0112
4	4	180 8192	51	CAM FOLLOWER	2 120 0010
5	2	181 0768	52	SPACER, MOTOR MOUNT	4 180 8303
6	2	181 0767	53	CLUTCH HANDLE WLDMT.	1 181 0245
7	2	180 8194	54	SEAL-CLUTCH HOUSING	1 181 0762
8	2	180 8043	55	DRIVE CHAIN ASSEMBLY (INC. 56)	1 100 0425
9	4	181 0612	56	CONNECTING LINK ONLY	1 100 0428
10	PULLEY, MOTOR:				
	1	181 0554	57	BRACKET, IDLER	1 180 8097
	1	181 0552	58	BOLT ASSORTMENT	1 180 8196
11	1	181 0550	59	BOLT ASSORTMENT	1 180 8197
12	V BELT:				
	4	180 8402	60	IDLER SPROCKET	1 100 0391
	3	180 8402	61	IDLER SPROCKET BUSHING	1 100 0392
13	PULLEY, REDUCER:				
	1	181 0560	62	SHOULDER BOLT ASSY	1 100 0393
	1	181 0558	63	NUT	1 735008253
	1	181 0570	64	SPROCKET ASSY, DRIVEN	1 100 0410
	1	181 0568	65	SET SCREW	1 716033799
14	1	181 0556	66	KEY	1 100 0437
15	1	181 0152	67	DRIVE SHAFT, TUMBLER	1 181 0181
16	2	766061691	68	RING SPACER	1 180 8028
17	1	879-1101	69	WASHER	1 180 8027
18	1	181 0158	70	ROLL PIN	1 7630616910
19	2	773002093	71	BRACKET ASSY, DRIVE (INCL. ITEMS 24 & 50)	1 181 0110
20	4	100 0534	72	COVER-CLUTCH HOUSING	1 181 0799
21	1	100 0385	73	BEARING-ANGULAR CONTACT	2 181 0764
22	2	714033799	74	RETAINING RING	1 181 0765
23	1	180 8326	75	SPACER-REDUCER	1 181 0150
24	1	180 8025	76	SPACER-TUMBLER SPROCKET	1 181 0184
25	3	180 8102	77	SPACER-TUMBLER SPROCKET	1 181 0183
26	4	180 8143	78	BOLT ASSORTMENT	2 181 0775
27	1	11512000210	79	PIN	2 100 0322
28	1	11112202110	80	3/8-16 3/4 CAP SCREW	4 716060353
29	1	181 0169	81	GREASE FITTING	1 800 1075
30	1	181 0168	82	CLUTCH SHAFT	1 181 0757
31	1	181 0756	83	CLUTCH HALF (DRIVEN)	2 181 0760
	(INCL. ITEMS 79,85 & 86)				
32	1	181 0763	84	BOLT ASSORTMENT	2 181 0770
33	1	500 0560	85	DOWEL PIN	2 11612501130
34	1	100 0338	86	ROLL PIN	2 766101699
35	1	181 0247	87	THRUST BEARING	1 181-0166
36	1	756000240			
37	1	761104191			
38					
39	3	11308001110			

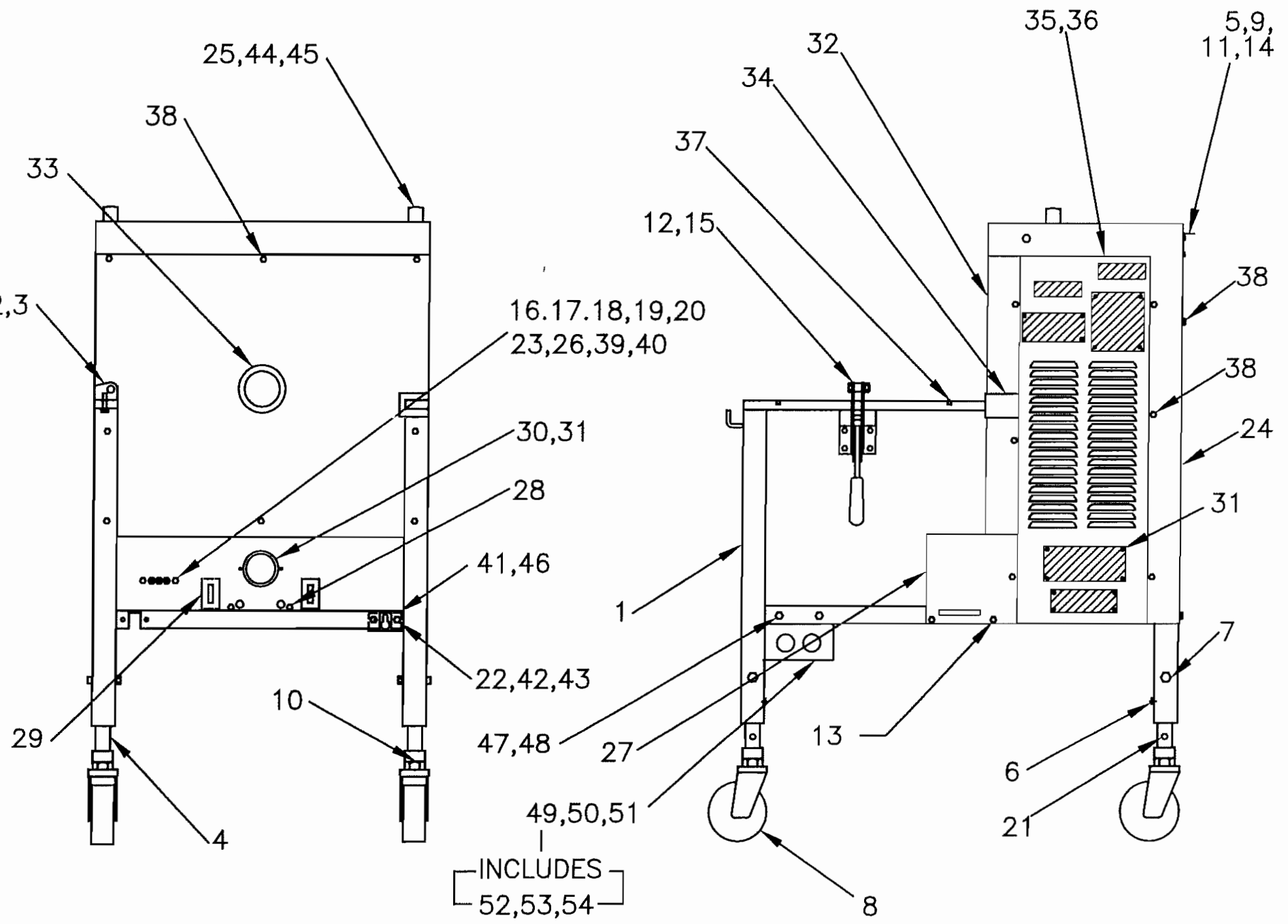


MIX/GRIND ASSEMBLY



# MIX/GRIND ASSEMBLY

ITEM	QTY	PART NUMBER
1	1	181 0058
	1	181 0056
2	1	180 8183
3	1	180 8076
4	1	181 0840
5	1	180 8109
6	1	181 0450
	1	<del>181 0474</del>
7	1	100 0229
8	1	100 0221
9	1	180 8062
10	2	181 0753
11	1	180 8095
12	1	180 8096
13	1	180 8186
14	1	180 8073
15	1	180 8287
16	2	21 8655
17	2	181 0844
18	1	715024599
19	1	150 9252
20	1	180 8018
21	1	40 6914
22	1	150 9039
23	1	150 9040
24	2	7161032830
25		
26	2	11616601130
27		
	1	180 8284
	1	180 8285
28	1	765142090
	3	100 0204
29		
	1	180 8136
	1	180 8134
30		
	1	180 8310
	1	180 8308
31	1	100 0199
	1	100 0237
32	1	180 8012
	1	180 8006
33	2	180 8106
34	2	180 8108
35	2	181 0761
36	2	752000140
37	4	751000740
38	2	731005140
39	2	711051623



# MAIN FRAME

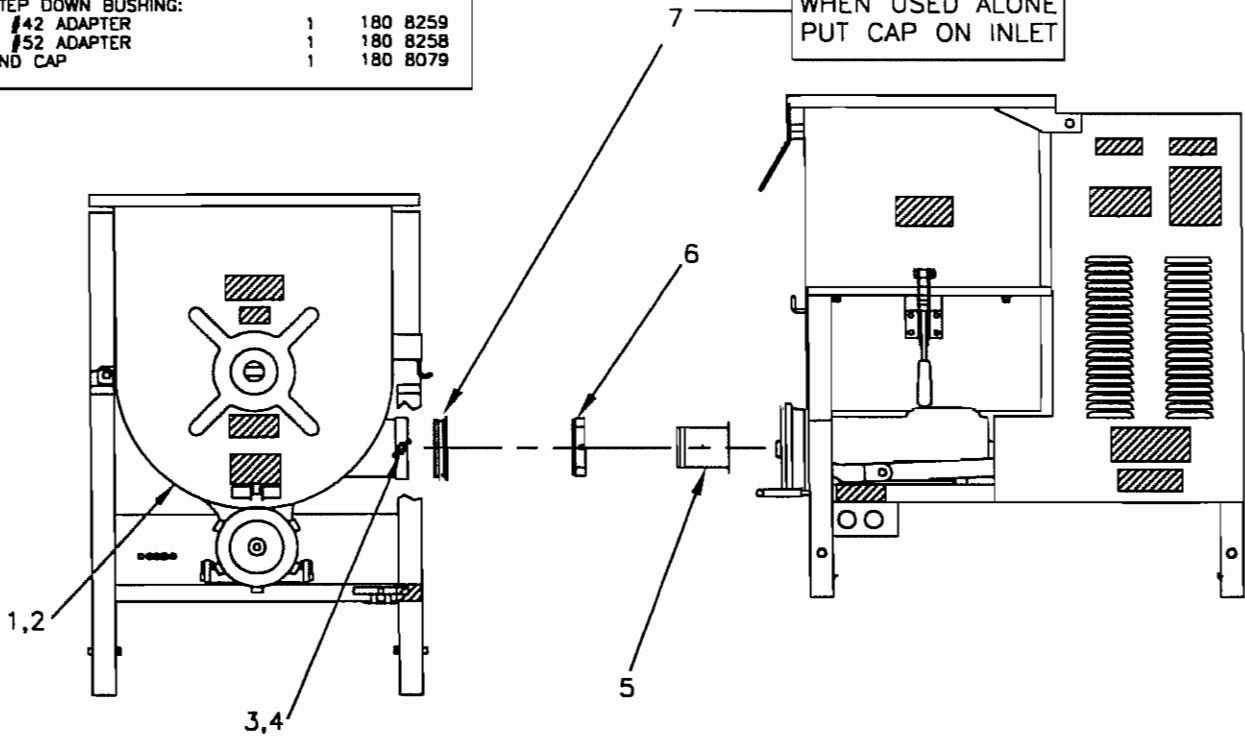
# MAIN FRAME

ITEM	QUANTITY	PART NO.
1	1	181 0250
2	2	180 8504
3	2	20 8851
4	4	181 0288
5	4	712041640
6		
BOLT ASSORTMENT		
SET SCREW	4	7140602530
ACORN NUT	4	7340051530
7	4	40 6629
8	4	181 0500
9	4	752000640
10	4	580 2022
11	4	732005140
12	1	181 0502
13	4	181 0690
14	1	181 0585
15	4	180 8188
16	1	181 0777
		(INCL. ITEMS 17,18,19,20)
17	1	181 0776
18	3	180 8100
19	2	180 8101
20	1	180 8102
21	24	100 1271
22	2	11308001110
23	3	180 8119
24	1	181 0538
25	2	181-0846
26	6	850 8595
27	1	181 0531
28	2	714030240
29	2	181 0682
30	1	180 8055
31	26	100 0149
32	1	181 0525
33	1	181 0182
34	2	181 0680
35	1	181 0523
36	1	181 0546
37	4	181 0704
38	25	181 0689
39	2	11106102110
40	2	1150600210
41	1	181 0249
42	2	11108252110
43	2	11508000210
44	2	716050240
45	2	756000540
46	AR	181-0237
47	2	715100240
48	2	755000540
49	1	181-0442
50	1	181-0312
51	4	753000791
52	1	181-0854
53	4	181-0852
54	4	181-0853

ITEM	DESCRIPTION	QTY	PART NO.
1	TUB-UPPER GEMINI INLET-LEFT	1	181 0060
2	TUB-UPPER GEMINI INLET-RIGHT	1	181 0062
3	WING NUT	2	100 1433
4	THUMB SCREW	2	181 0635
5	ADAPTER TUBE:		
	#42 FIRST GRIND OUTLET	1	100 0084
	#52 FIRST GRIND OUTLET	1	100 1416
	#56 FIRST GRIND OUTLET	1	100 1410
6	STEP DOWN BUSHING:		
	#42 ADAPTER	1	180 8259
	#52 ADAPTER	1	180 8258
7	END CAP	1	180 8079

## UPPER GEMINI

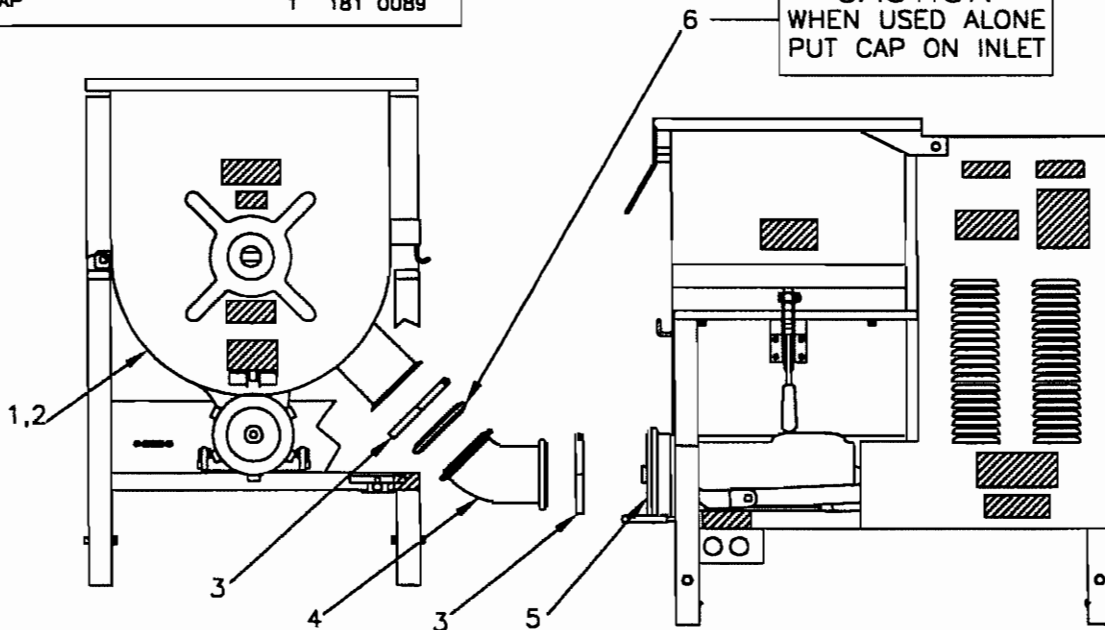
CAUTION  
WHEN USED ALONE  
PUT CAP ON INLET



ITEM	DESCRIPTION	QTY	PART NO.
1	TUB-LOWER GEMINI-LEFT	1	181 0085
2	TUB-LOWER GEMINI-RIGHT	1	181 0080
3	CLAMP RETAINER	2	120 0065
4	TRANSFER TUBE-LOWER GEMINI	1	181 0088
5	ADAPTER RING:		
	#42 HOLLYMATIC	1	120 0045
	#53 HOLLYMATIC	1	120 0046
	#42 BUTCHERBOY	1	120 1105
	#52 BUTCHERBOY	1	120 1106
	#42 BIRO	1	120 1107
	#52 BIRO	1	120 1108
	#42 HOBART	1	120 1109
	#52 HOBART	1	120 1110
6	END CAP	1	181 0089

## LOWER GEMINI

CAUTION  
WHEN USED ALONE  
PUT CAP ON INLET







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