



Fully Automatic Bun Divider  
BMBDF030  
BMBDF036



**Questions? Parts?**  
**Contact Us:**  
Toll Free: 1-800-565-2253  
Email: [Info@BakeMax.com](mailto:Info@BakeMax.com)

## Preface

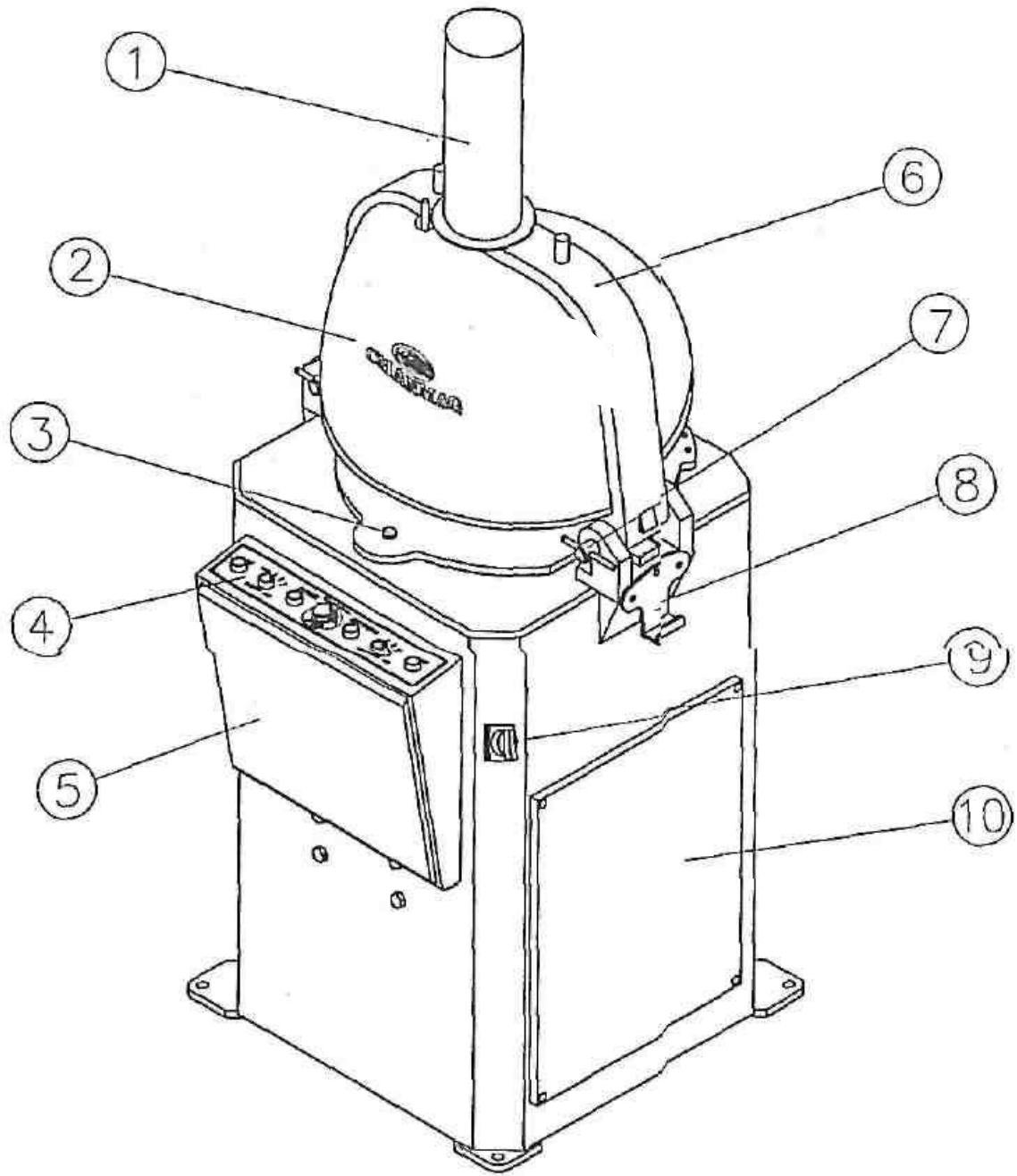
Welcome to your BakeMax® Automatic Dough Divider/ Rounder. It will be a very helpful partner. Please read and follow these instructions to obtain appropriate operation and maintenance. It will be the best tool to help you make bread efficiently for the next 10 years.

## Introduction

This machine was designed to round and divide dough automatically into small dough balls equal in size. It can help you to save time and it's easy to operate. It uses a Hydraulic system to control operation by program. Rounding pressure and rounding time can be adjusted at 3 stages. Increased rounding radius for better rounding quality. A larger base will help you to operate with more stability. A rounding tray is made of material with static electricity treatment and this machine is required to start running by 2 hands at the same time, to protect users from being cut by machine. We have 2 different types of machines, and their capacity is 30 and 36 divisions per tray.

## Specification & Components

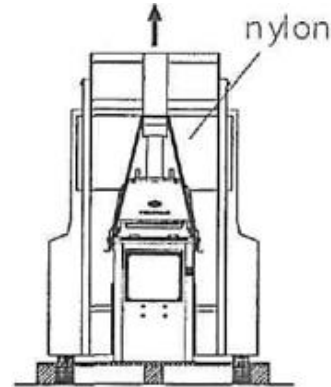
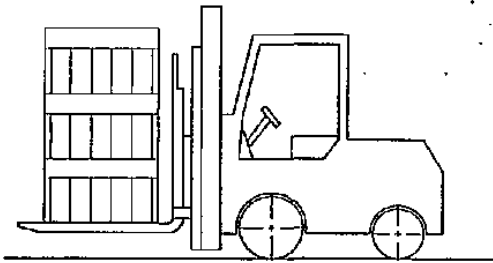
Model #	BMBDF30	BMBDF36
Divisions	30	36
Division Weight	40-120g / 1.41 – 4.55oz	30-100g / 1.06 – 3.53oz
Motor	750W	750W
Electrical Information	1 PH / 3 PH 50/60Hz	1 PH / 3 PH 50/60 Hz
Machine Weight	928lbs	928lbs
Machine Dimensions (W x D x H)	27.8” x 27.4” x 64.6”	27.8” x 27.4” x 64.6”
Crated Weight	1006lbs	1006lbs
Crated Dimensions	29” x 35” x 62”	29” x 35” x 62”



Number	Description	Number	Description
1	Cover	6	Strap Yoke
2	Front Cover	7	Plug
3	Rounding Tray	8	Hanger
4	Control Panel	9	Switch
5	Electric Box	10	Side Cover

## Transportation

1. Use a 1 Ton forklift to move the machine to an adequate position before unpacking.
2. Break wooden crate and left the bottom board. Loosen the 4 5/8" bolts, which are fixed on bottom board by wrench.
3. Use Nylon belts through the main body of machine. Lift the Nylon belts by forklift to take machine off the skid and fix the machine on the predicative position.



## Installation

**Note: The machine must be installed and tested by professional mechanics according to the instruction manual.**

Locate machine on flat, dry floor with enough space left around the machine.

Refer to the dimensions and distance to ensure there's enough space to operate and clean.

Put the (4) Rubber Feet on all 4 Corners, and then drill the 4 holes at 1/2" Diameter.

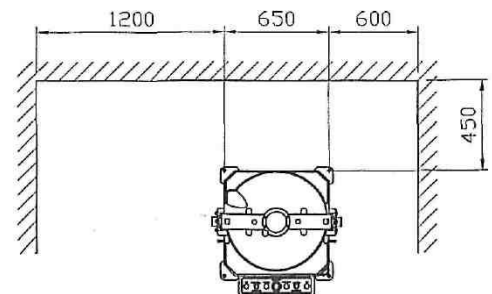
Put in the (4) 3/8" expanding screws and tighten up the screws.

Connect power supply with machine at correct voltage in coordination with specification.

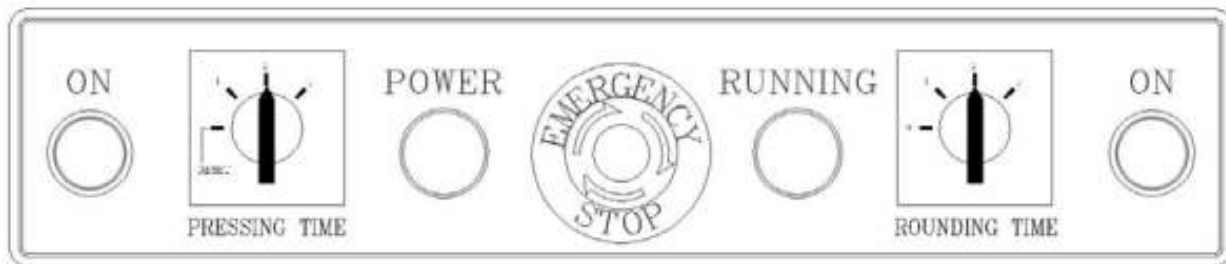
Turn on the machine and check if the knife is acting. If not, it means the motor is running in the wrong direction and changes any 2 phases of power supply to each other.

The machine had been oiled. In case of oil leakage occurring through transportation and please check height of oil. The procedure will be (1) taking off plug, (2) opening head of machine, (3) taking up rounding tray by two hands with stability. The height of oil should be higher than bulge places at 5mm.

**Note: It's very important to bolt the machine to the floor for the machine to work properly.**



## Instruction and Safety Guide



- ON BUTTON – Start running by pressing the two “ON” buttons on the left and right sides of the control panel at the same time.
- PRESSING TIME – Select (1) for 2 Second, (2) for 3 Seconds, (3) for 4 Seconds
- PRESSING TIME (RESET) – Used to retract the knives after cleaning.
- POWER – Indicator Light to inform the user that the machine is getting power (Main Power Switch is turned to the “ON” position).
- EMERGENCY STOP BUTTON – Used to stop the machine for cleaning & emergency.
- RUNNING – To indicate the machine has a batch in process/running, this light comes on after pressing & holding the two on buttons at the same time.
- ROUNDING TIME – Select (1) for 3 Second, (2) for 5 Seconds, (3) for 7 Seconds.
- ROUNDING TIME (0) – Used for Dividing without Rounding

### Operation Instructions

#### Cleaning before operation:

- Clean all oil out of head and rounding tray.
- Before formal production, make a trial running by 2KG of dough, to clean rounding and dividing parts, and ensure smooth operation.

#### Operation Procedure:

- Turn Main Power Switch to the “ON” position.
- Set up Pressing Time and Rounding Time.
- Prepare dough and practice putting plastic tray into rounding tray. Put dough in accordance with proper total weight for 30pcs and 60pcs onto plastic tray after mixing, fixing, and flabbiness for a period. Put plastic tray onto rounding tray with stability and fix the front tray without moving.
- Adjust rounding height by referring to the figures on adjusting screw according to dough weight (ex: 60 means 60g per division). Tighten up screw after adjusting to prevent loosening. Smaller figure creates flat dough with damaged surface, bigger figure makes bad rounding quality. Press dough tightly and evenly ensure equal dividing weight for each piece.
- Press both ON switches at the same time and let go of two hands when the running light comes on. The machine will start running automatically and stops after it is finished/
- Take out plastic tray and dough when the machine stops.

## Safety Guidelines

- While the machine is running, keep people away from the machine, and the operator is not allowed to lean against the machine.
- The machine allows only for total dough weight within 3KG or 6KG.
- Make sure the dough is without any metal or hard articles mixing inside. The articles will damage the knife during running.
- Do not modify the machine or parts without the manufacturer's permission.

## Cleaning

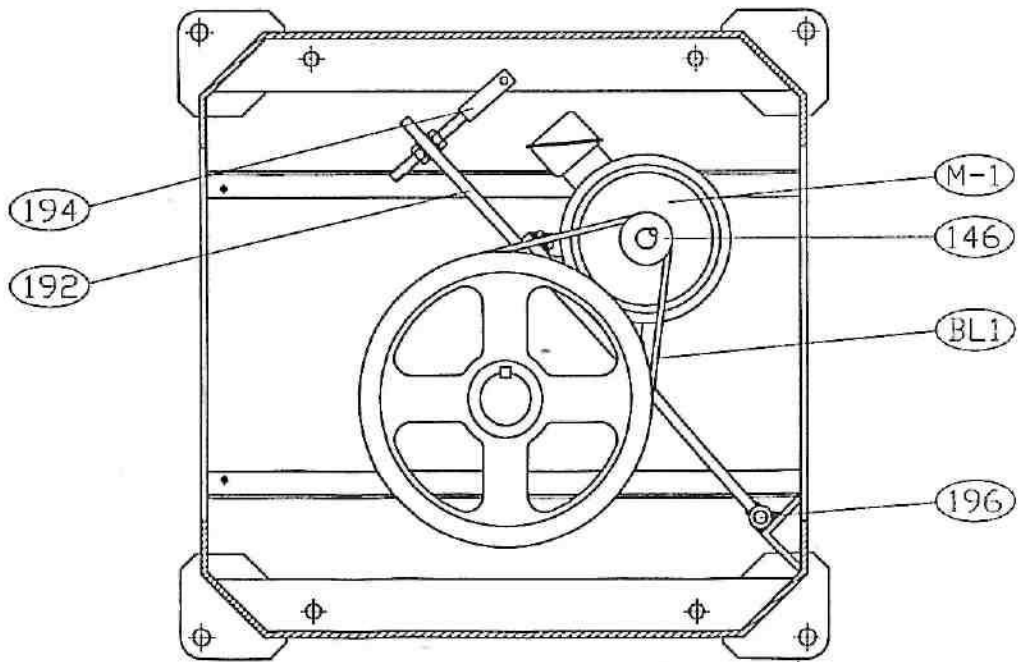
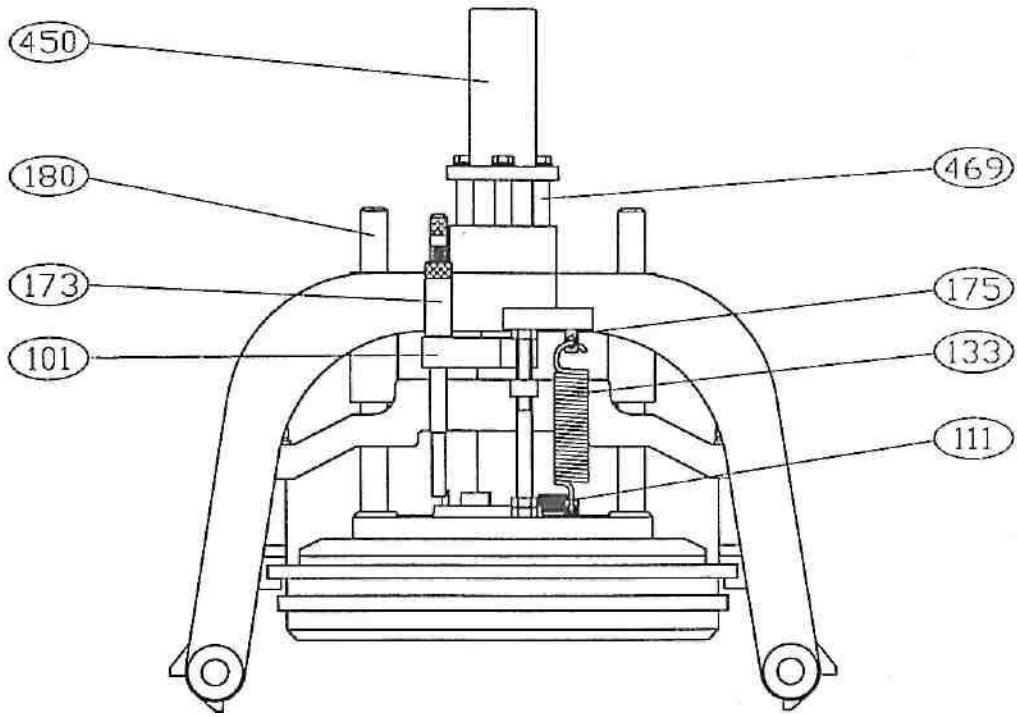
- After using the head and dividing equipment must be cleaned every day.
- Switch the machine on using both hands on the left & right "ON" buttons to let the knife go down and press emergency stop while the knives are down, then turn off the power using the main disconnect switch. Clean knives, stand, flour frame, rounding tray by brush and cloth. After cleaning, turn on the power, and turn the pressing switch to "Reset" to return the knives to their original position.

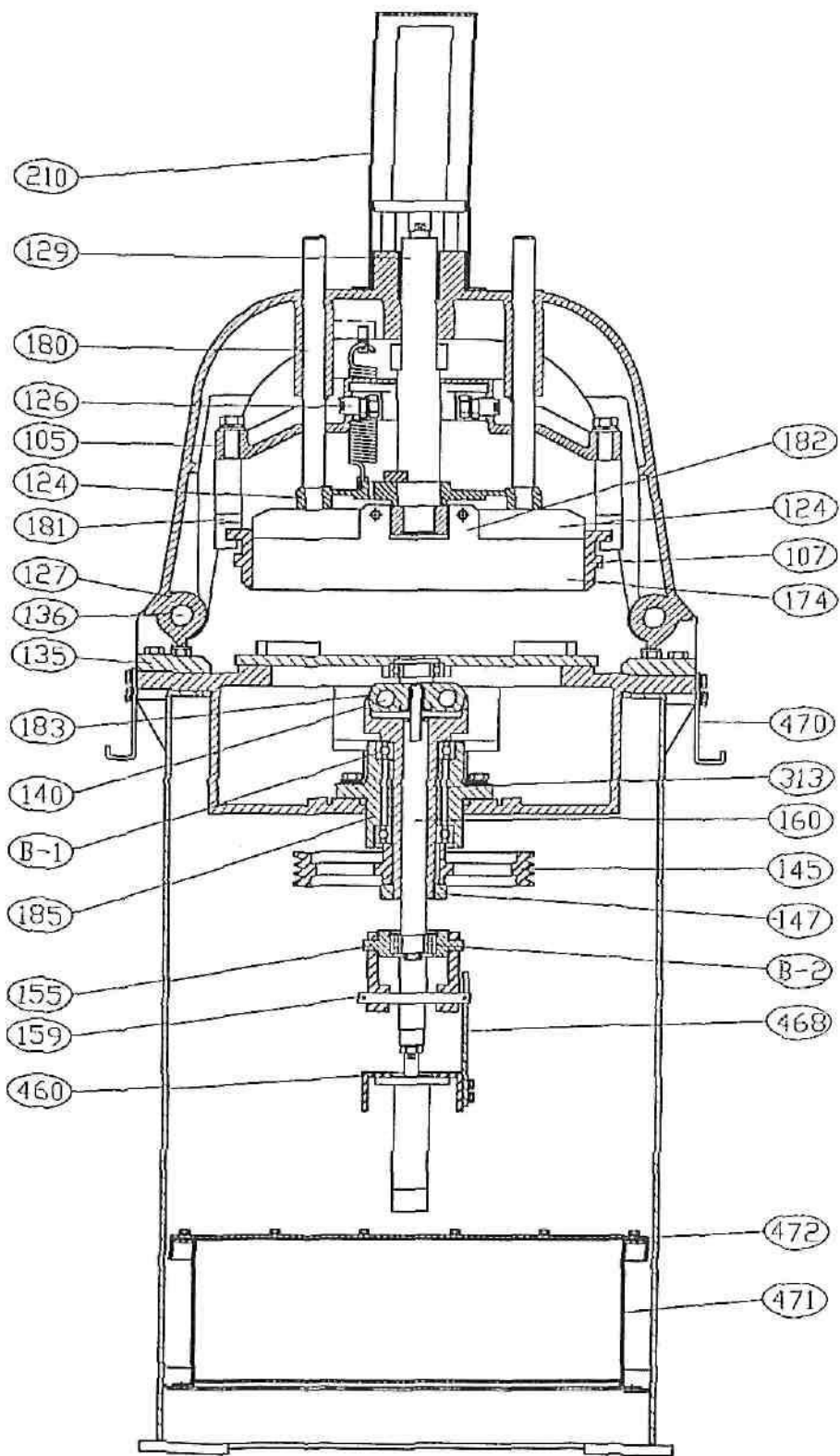
**Note: It is very important when cleaning the rounding tray and backside of plastic tray, use warm (not hot), otherwise the hot water can warp the plastic molding tray. Do not use a pan washer or dishwasher to clean.**

## Maintenance

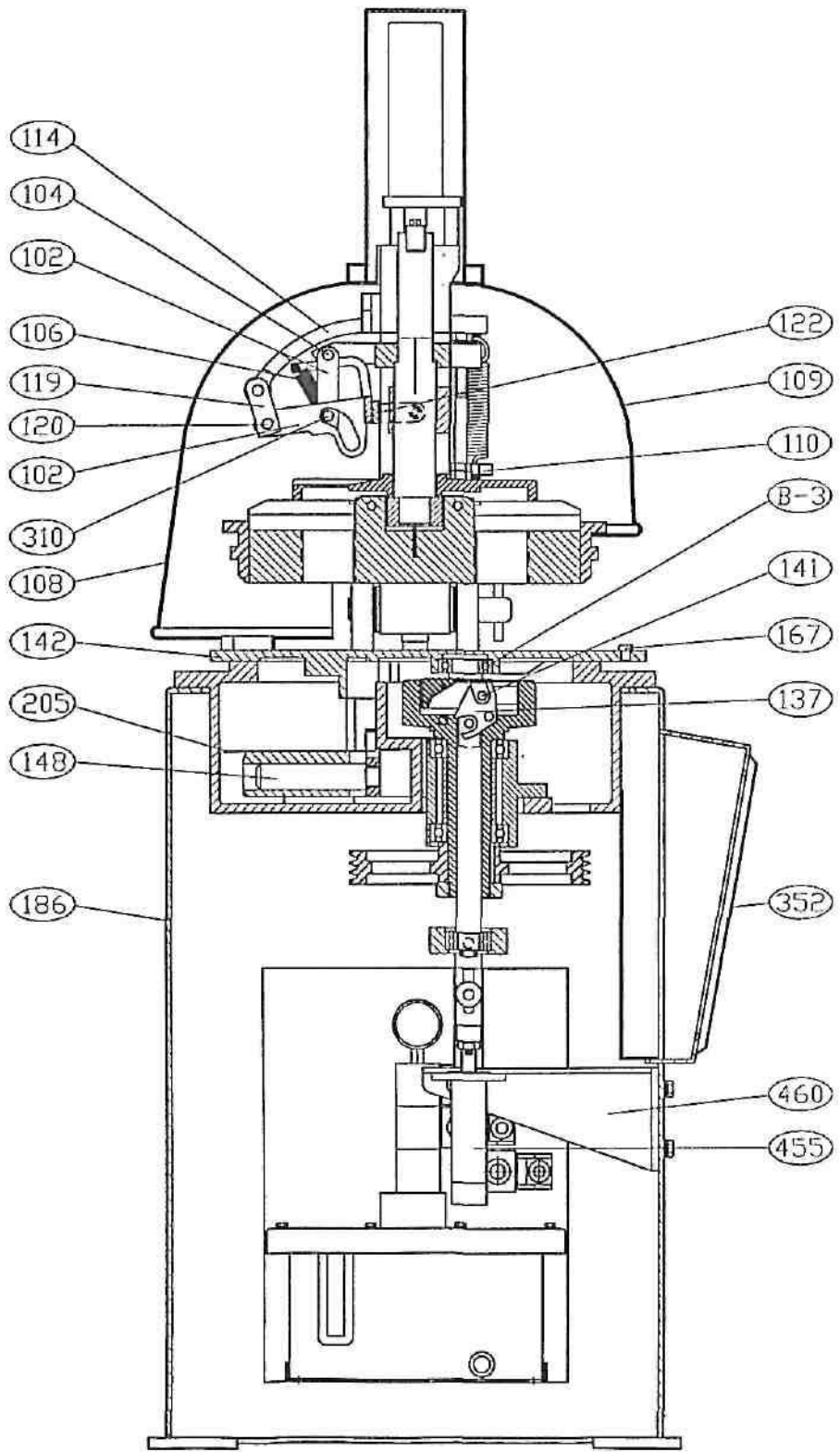
- Motor belt adjustment: After a period, in case that rounding movement gets slowly, check and tighten up screws on motor fixed stand. (Check once at every 3 months)
- Lubricant oil can't be used as ordinary oil, only edible A360B oil and Philip PF edible oil is allowed. Check oil on rounding moving axle stand every 3 months and add ISO 68 oil.

# Parts Breakdown





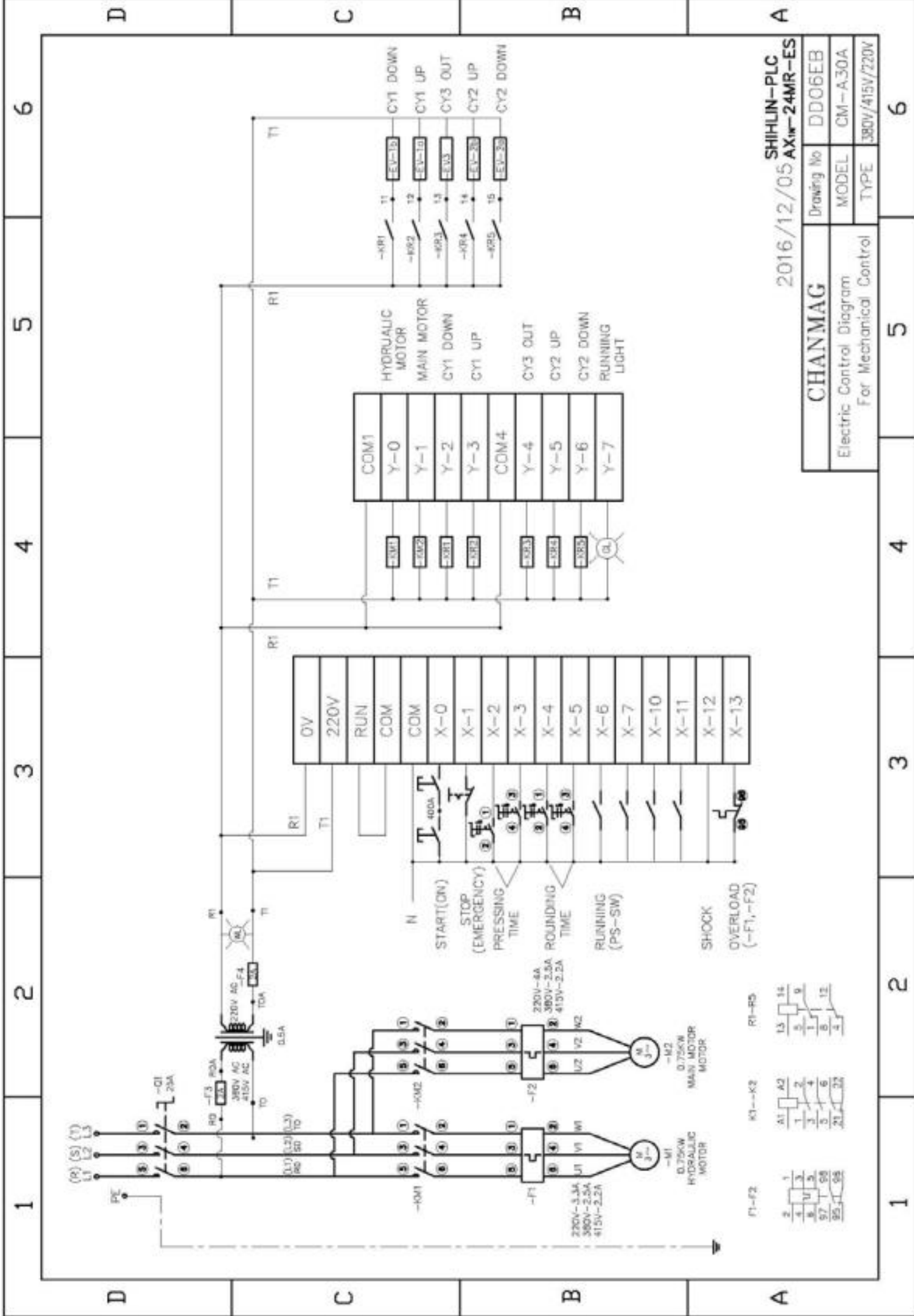




## 10. Circuit Diagram and Parts List

No.	Item	Description Ret. To Document	Technical Data
1	-Q1	Main Switch	3P-25A or same level product
2	-M1	Main Motor	1HP, 3PH, 220V/380V/415V
3	-M2	Hydraulic Motor	1HP, 3PH, 220V/380V/415V
4	-KM1	Magnetic Contactor	SC-03
5	-KM1	Magnetic Contactor	SC-03
6	-F1	Overload	220V-3.3A,380V-2.5A,415V-2.2A
7	-F2	Overload	220V-4A,380V-2.5A,415V-2.2A
8	-F3	Fuse	1A
9	-F4	Fuse	1A
10	-KR1-KR5	Relay	RU2S-C(2A2B)

No.	Description	No.	Description	No.	Description
101	Support Plate	137	Fish Shape Moving Block	192	Fixed Plate
102	Support Spring Block	140	Revolving Outer Stand	194	Screws
104	Support Stand	141	Plug	196	Fixed Plug
105	Arch Fixed Stand	142	Rounding Tray	205	Oil Cover Plate
106	Extension Spring	145	Transmission Belt Wheel	210	Top Hood
107	Flour Frame	146	Motor Belt Wheel	310	Sleeve
108	Back Hood	147	Nut for Revolving Stand	313	Bearing Stand Sleeve
109	Front Hood	148	Moving Sheet	352	Electric Box Cap
110	Stop Knife	155	Pendulum Stand	450	Hydraulic Cylinder ( Up )
111	Extension Spring	159	Axle of Lever Stand	455	Hydraulic Cylinder (Down)
114	Hanger	160	Up and Down Moving Rod	460	Fixed Plate
119	Connector	167	Ball Plug	468	Stop Plate
120	Connected Rod	173	Screw	469	Fixed Rod ( Up )
122	"U" block	174	Knife	470	Support Plate
124	Cover Plate	175	Extension Spring Screw	471	Oil Box
126	Knife Stand	180	Axle	472	Oil Box cap
127	Neck Screw	181	Frame	M-1	Motor
129	Main Shaft	182	Cross Frame	BL1	Belt
133	Extension Spring	183	Leading Axle Center	B-1	Bearing
135	Setting Stand	185	Down Moving bearing Stand	B-2	Bearing
136	Plug	186	Button Body	B-3	Bearing



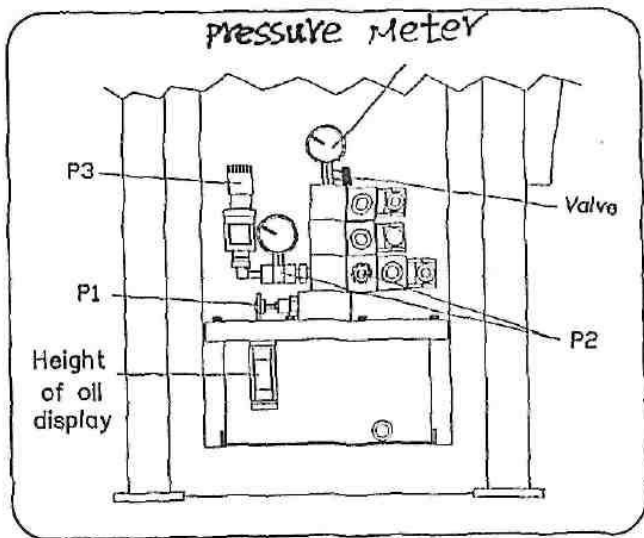
2016/12/05 SHIHLIN-PLC AX1R-24MR-ES

<b>CHANMAG</b>		Drawing No	DD06EB
Electric Control Diagram		MODEL	CM-A.30A
For Mechanical Control		TYPE	380V/415V/220V

1 2 3 4 5 6

# Oil Diagram

In case of different power voltage, frequency in different area, adjust pressure figure in accordance with the drawings.



P1 is pressure-adjusted switch, original setting

BMBDF30: 90kg/cm<sup>2</sup>

BMBDF36: 90kg/cm<sup>2</sup>

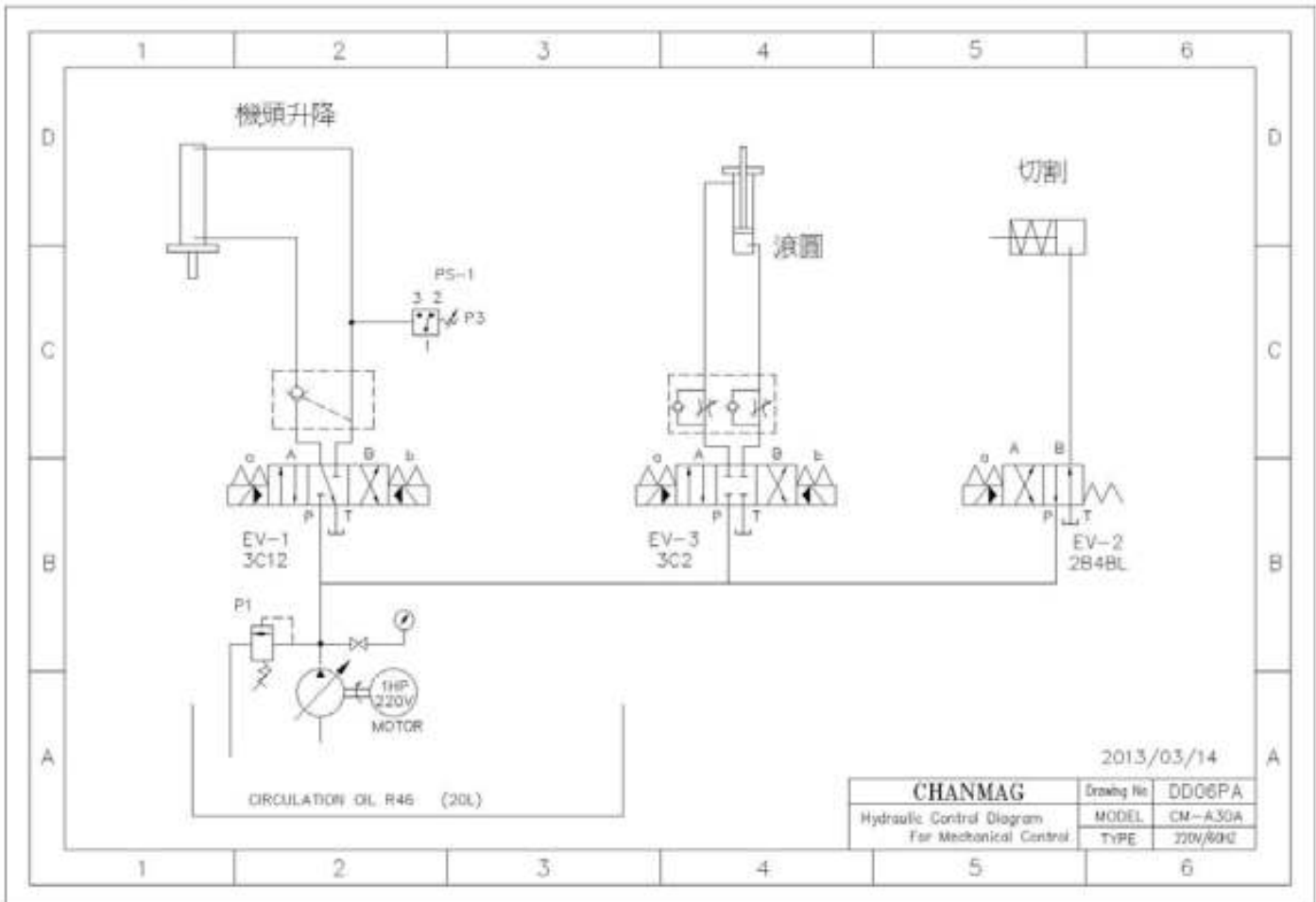
P2 is up hydraulic cylinder, pressure adjusted switch

BMBDF30: 80kg/cm<sup>2</sup>

BMBDF36: 80kg/cm<sup>2</sup>

P3 is rounding self-protection switch to be set at 60kg.

Check oil of oil pressure unit set once monthly, and add CPC R46 cycle oil or ISO NUTO-46 cycle oil when oil is insufficient. Change oil after running 3000 hours.



# Warranty & Service

BakeMax provides a 1-Year Limited Parts and Labor warranty on most items, there are select items which carry a Limited 2-Year Warranty. Extended Warranty is available on some products. Please contact us for details. The Warranty is not transferable and is limited to original installation of equipment sold by BakeMax for the original user.

For all Warranty Claims, Proof of Purchase and/or Serial Number is required. Once the machine is approved, BakeMax will provide our customers with on-site Warranty Coverage on all equipment more than 100lbs. BakeMax assumes no responsibility for down time or loss of product. Repairs must be Pre-Authorized by BakeMax and have a Service Authorization Number issued prior to commencing Warranty Service.

Warranty begins 10-Days after shipping from warehouse; delays in installation which would extend the Warranty must be Approved. All equipment must be installed and connected by Qualified Professionals in accordance with the Manual Specification. Products shipped are to be inspected at time of delivery, the receiver is responsible for inspection.

Any abuse or improper use of the equipment will void the warranty. This includes failure to follow all cleaning instructions, improper installation, improper maintenance, failure to follow capacity charts, improperly wired electrical connections. The Warranty does not apply to abuse, willful or accidental damage, or to products used for other than their intended purpose. Normal wear parts such as Accessories, Attachments, or Electrical Components such as Fuses, Bulbs, Elements, and Switches carry a 90-Day Warranty only.

**Bench Warranty (Machines Weighing 100 lb. or less)**

Once the machine is Approved for Warranty Service, if the machine requires Warranty work in less than 30 days of purchase date, BakeMax will pay all shipping charges. Once the machine is received and repaired it will be returned to the user at BakeMax expense. Freight Damages during return shipping is the responsibility of the owner of the machine.

The following is not covered under the BakeMax Warranty:

1. Overtime Labor Rates are not covered by BakeMax.
2. All parts will be shipped via Ground Courier only; If Express Shipping is required, it will be the responsibility of the Customer or Dealer.
3. Travel for Warranty Service is covered up to 100 Miles /160 Km Roundtrip, any further mileage will be the responsibility of the Customer or Dealer.
4. There is no on-site Warranty Service for Residential Addresses or addresses outside of the contiguous United States (Lower 48) or Canada.

*\*\*BakeMax machines sold outside of the contiguous United States (Lower 48), or Canada will carry 1-Year Parts Warranty only.*

# Terms & Conditions

## Terms

Net 15 days subject to Credit Approval. All past due Accounts are subject to 2% per month Service Charge as per Credit Application. We accept Visa, MasterCard, and Discover Credit Cards. We also accept E-Transfer & Wire Transfer, additional fees may apply.

## Pricing

All prices are subject to change without notice. All prices are Sales Tax Extra, should you be claiming Tax Exemption, Tax Exempt Forms must accompany your Purchase Order. BakeMax products are sold in Canadian and US Dollars. BakeMax is not responsible for specifications errors or printing errors.

## Shipping

Free shipping to Canada and the U.S. Minimum order \$6,000 for BakeMax and \$10,000 for BakeMax America Cooking Line. Tailgate Delivery is \$90.00 minimum. All checks made Payable to Titan Ventures International Inc. BakeMax is not responsible for goods damaged during shipping. BakeMax is not responsible for any delays in delivery once product has left our Warehouse and is in the carrier's possession. Products shipped are to be inspected at time of delivery, the receiver is responsible for inspection. Damaged Freight Claims are to be claimed with the carrier. BakeMax assumes no responsibility for Damaged Freight. Shipping Insurance available by request. By signing your name on the delivery receipt without noting any damages, you are stating that you have received your shipment in Acceptable Condition.

## Return Policy

Returns will not be Approved unless in Writing. Returns must be made within 30-Days of Purchase and must have a Return Authorization Number issued before returning. The purchase order number, reason for return, and the serial number(s) of the unit are required for the Return Authorization Number. Minimum return amount of \$100.00.

Returns are subject to a minimum restocking fee of 30%. The cost of any repairs or re-crating required will be charged back to the dealer. If there is a manufacturer's defect BakeMax® will pay standard freight returned and prepaid shipping back to the customer.

Special Order Items, Clearance / Discontinued Equipment, Parts, Refurbished/Demo Equipment, or Non-Standard items are not Returnable.

## Ordering Information

Send purchase orders to BakeMax via e-mail [orderdesk@bakemax.com](mailto:orderdesk@bakemax.com) or Fax (506-859-6929). Use Model or Part number when ordering including Voltage Requirements, and Product Description. Please include the Dealer, Name, Address, terms, special delivery, or instructions required or attention names to be applied to packaging. Please notify BakeMax should you need order confirmation or tracking numbers, by calling 1-800-565-2253 or email [orderdesk@bakemax.com](mailto:orderdesk@bakemax.com).

## Special Terms and Conditions

BakeMax reserves the right to make improvements or equipment changes without prior permission. Setup and Installation are the end user's Responsibility. Failure to properly Install or Maintain Equipment may Void Warranty.

## Catalog, Spec Sheets and Website

BakeMax is not liable for incorrect information found in our Catalog, Spec Sheets or Website. Please contact us to confirm specifications. Pictures and specifications are for general purposes only. Product may not be exactly as shown. Prices and availability may change at any time without notice. Dimensions shown may change at any time without notice.