



www.BakeMax.com

Soft Dough
Divider Rounder Combo
Model BMDDM24
Operations Manual



Questions? OEM Parts?

Contact Us:

Toll Free: 1-800-565-2253

Email: Info@BakeMax.com

www.BakeMax.com

GENERAL INFORMATION AND SAFETY SPECIFICATIONS

The BMDDM24 rounder has been designed and manufactured to cut and round pizza and some types of bread dough portions (at room temperature).

BMDDM24 is a semi-industrial machine, for continuous dough process.

The dough is extruded through an auger, cut by a knife, and then rounded.

👉 **This machine must be used ONLY after having carefully read this manual.**

- The appliance must not be used for processing other substances or objects.
- Only use the appliance with approved genuine parts and accessories.
- Never use the accessory parts for other appliances.

👉 **Read and follow the instruction manual carefully and keep it for later reference. Enclose these instructions if the appliance is given to others.**

👉 **Failure to comply with these instructions for the correct use of the appliance will exclude the manufacturer's liability for any resulting damage.**

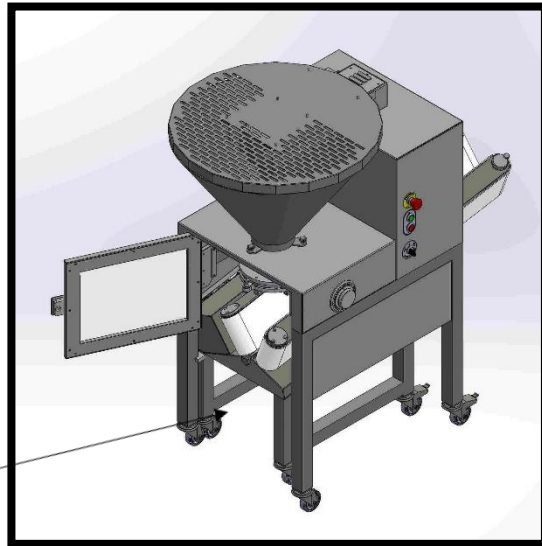
INDICATION OF DANGEROUS POINTS, OF RESIDUAL RISKS AND OF THE PRECAUTIONS TO BE TAKEN

This appliance must be used by adults who have been instructed in its safe use and who have understood the hazards involved.

The protection covers and doors of the BMDDM24 prevent any possibilities of reaching dangerous or moving parts, but please be careful!

- **Do not put your hands between the conveyor belts while the machine is running.**
- **Through the dough exit hole you can reach a dangerous part of the machine with your hand, i.e., the knife.**

DO NOT introduce your hand in this hole!!!

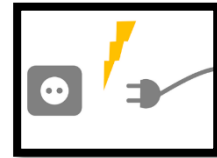


- Always place the machine on a clean and even (level) flooring.
- To ensure correct ventilation of the motors which are at the back, make sure to leave at least twenty centimeters clearance between the machine and the wall or other equipment.
- Before using this appliance for the first time, it must be fully unpacked, cleaned, and checked. Check that all parts are present and that they do not show visible damage.

FORBIDDEN USES AND REASONABLY FORESEEABLE INCORRECT USES

Connect the appliance in accordance with the specifications on the data plate. Do not operate with a damaged cord or if the appliance has been damaged.

- Never connect the appliance to timers or remote-controlled sockets. Never leave the appliance unattended during operation. **Never start a damaged appliance!**
- Do not place the appliance near hot surfaces, such as hobs. The power cord must not encounter hot parts or pulled over sharp edges.
- Do not leave the appliance running longer than necessary to process pizza or bread dough.
- **Do not introduce into the machine frozen, half frozen dough or other products which are not foreseen in this manual.** Should there be one or more dough balls accumulated on the tray, thus blocking the dough exit hole, do not take them away while the machine is on.
- Turn off the machine before proceeding.
- After each use, when left unattended, prior to assembly, disassembly, or cleaning and in case of failure, you need to disconnect the appliance from power. Do not wash the machine with water jets, do not wash parts of the machine in dishwasher. Do not clean with steam. Do not use the appliance with wet hands.
- Trained personnel must perform cleaning and maintenance.



TRANSPORT, LIFTING AND INSTALLATION

The machine will arrive on a wooden pallet, fixed onto it with iron angles and plastic band.

The cardboard box is taped at the top, without bottom and strapped to the pallet.

Each cardboard box contains a complete machine, its operating and maintenance manual with declaration of conformity.

Before using the appliance for the first time, it must be fully unpacked, cleaned, and checked.

To extract the machine out of its packing, you need to cut the straps and lift the cardboard box up.

It is necessary for two people to take away the dough rounder (lower part of the machine) from the pallet.

These two persons can then take away the upper part of the machine (dough divider) from the pallet.

- They should wear gloves and get hold tightly of the machine.
- Check that all parts are present and that they show no visible damage.
- Wash all the parts that encounter food with a dish sponge, warm water, and non-abrasive liquid detergent.
- To ensure correct ventilation of the motors which are placed at the back, make sure to leave at least twenty centimeters clearance between the machine and the wall or other equipment.

Put the dough rounder again under the dough divider and plug it into the socket of the divider.

Before connecting the machine, plug the dough rounder into the divider socket (Ref.18) placed at the back.

The machine is provided with three motors and a standard NEMA 5-15P Plug.

Make sure that the tension and the frequency correspond to those indicated on the machine data plate and that the intake is grounded and properly protected against overloading. **The protection grade is I.P.55.**

Note: The dough rounder must be correctly coupled with the divider.

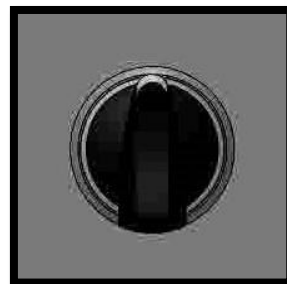
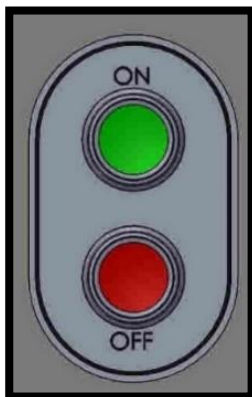
Place the machine far from any heat sources, the temperature around the machine should never be higher than 55° C.

DESCRIPTION OF THE CONTROL DEVICES AND OF THEIR FUNCTION

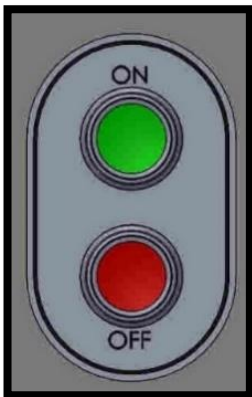
The machine has an emergency push button (Ref.34), a start push button (Ref.35), a stop push button (Ref.36), a selector (Ref.37), a weight regulation knob (Ref.36), and a black push button (Ref. 32).



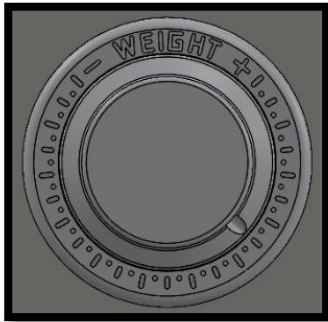
To start the machine, press on the green start push button and turn the selector to position 1 (towards right) to operate.



To stop the machine, press on the red push button.



The weight regulation knob (Ref.38) is used to increase or decrease the portions weight.



The emergency push button (Ref.34) must be used ONLY in case of emergency. If activated, it must be unblocked turning it clockwise.



The rear black push button (Ref.32) works as a “reset” device: the shutter is brought back to its original position, if displaced.



USE

BMDDM24 is a semi-industrial machine, for continuous dough process (**with hydration from 65% to approx. 78%**).

Before using the machine for the first time, wash all the parts that encounter food with a sponge, warm water and non-abrasive liquid detergent **excluding the rounder belts that must never be cleaned with liquids.**

 **Connect the appliance to the mains and follow the instructions below:**

1. Prepare the dough with a normal spiral mixer.
2. IMMEDIATELY place the dough just prepared into the divider hopper without adding flour or oil.

3. Begin at once the cutting and rounding operation of the dough without stopping the machine until the dough hopper is empty. DO NOT leave part of the dough inside the hopper.
The above suggestions are to prevent the rising process of the dough.
4. Press on the green push button to connect the machine. Turn the black selector to start the machine.
5. Take the portions from the chute and place them into their proving drawers.
6. Stop the machine turning the black selector and disconnect it completely pushing on the red push button.

REGULATION

The BMDDM24 cuts and rounds pizza and some types of bread **high hydrated dough** (from approx. 65 to 78%), automatically producing round portions perfectly closed, ready to rise.

The best regulation for the BMDDM24 is done by steps since it should suit several types of dough.

The BMDDM24 can prepare dough portions **from 250 to 550 grams**.

For more accuracy in the regulation of the weight, use the knob (ref.38).

- Weigh the first dough balls, if they are smaller than foreseen, turn the knob "Weight" towards +.
- if they are bigger, turn the knob towards (-).

Repeat this operation until you get the required weight.



By pressing the rear black push button (Ref.32) the shutter is repositioned (Ref.6-7-8-9).



Do not introduce into the machine frozen, half frozen dough or other products which are not foreseen in this manual.

Always switch off the machine before cleaning.

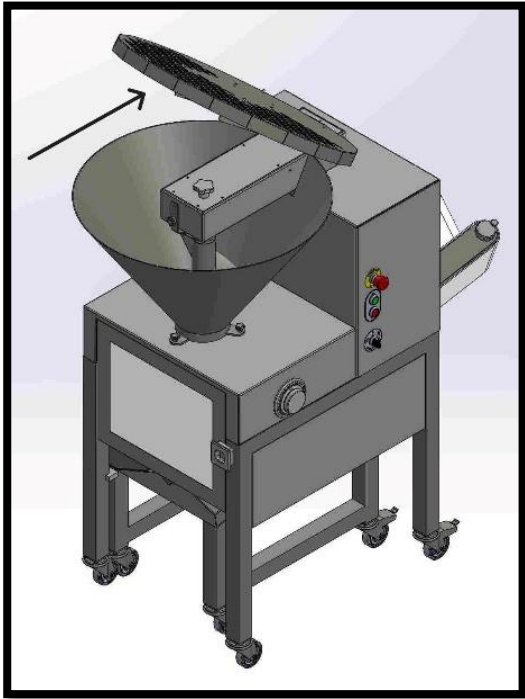
DISASSEMBLY AND CLEANING

To disassemble the machine, please proceed as follows:

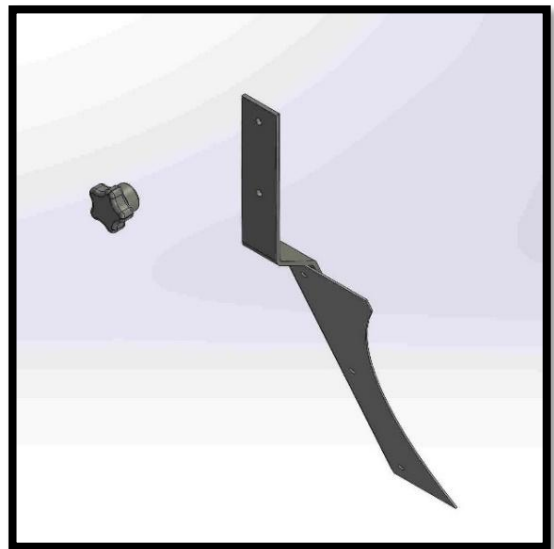
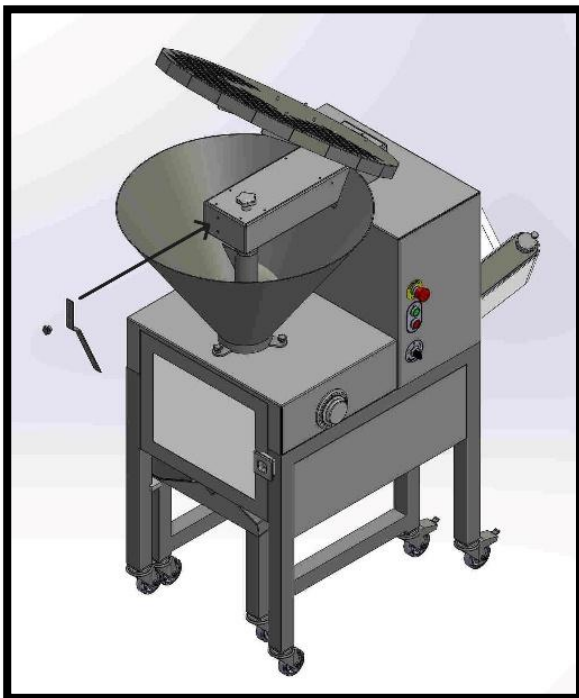
DOUGH DIVIDER

⚠ WARNING: before opening any part of the machine, switch the machine off and unplug it. Before opening or disassembling any part of the machine, be sure that the motors are off.

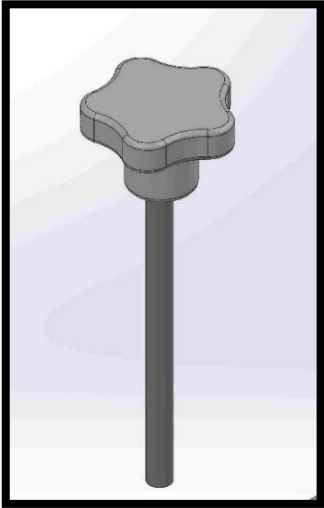
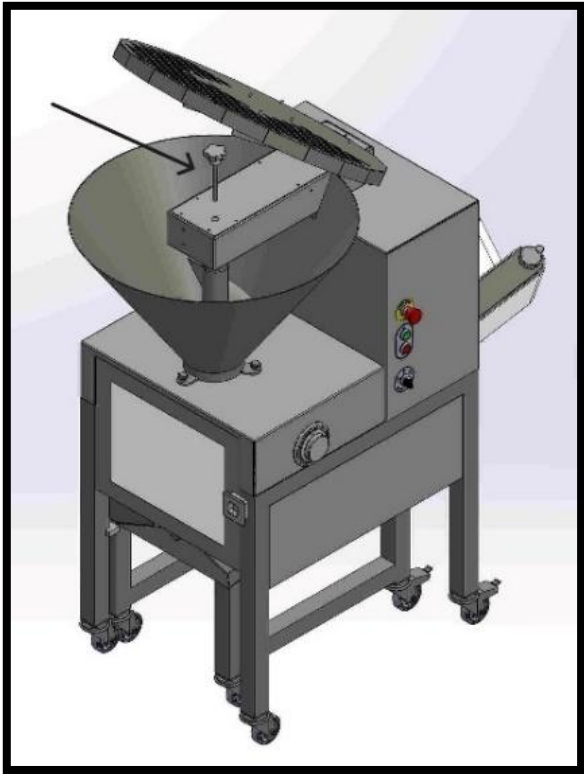
1. Lift the cover (Ref.5).



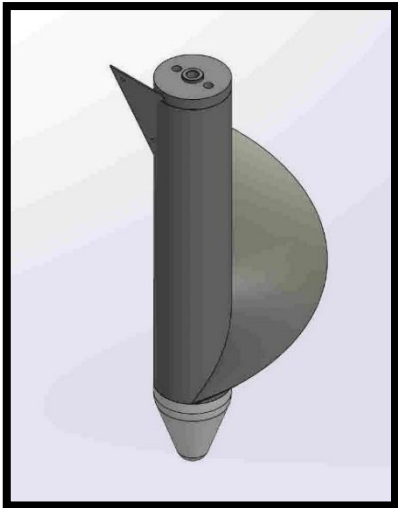
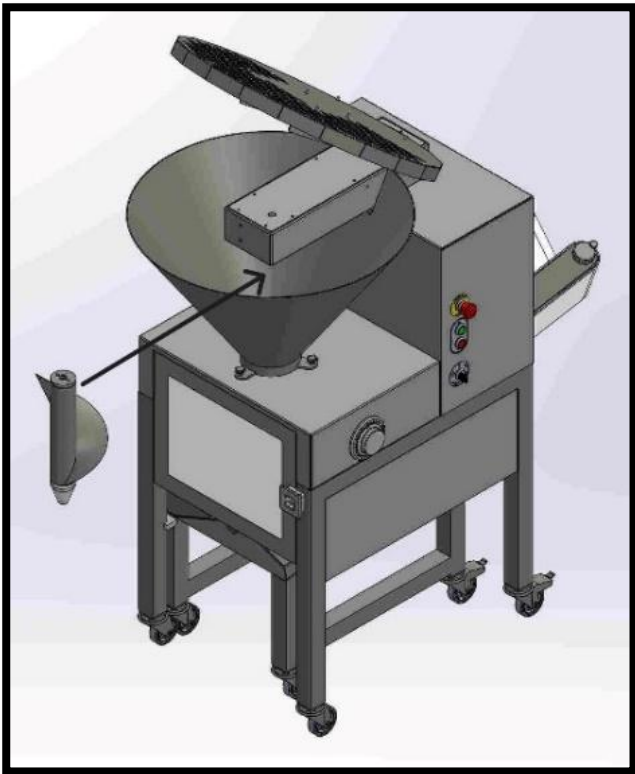
2. Unscrew the knob (Ref.3) and remove the dough scraper with its support (Ref.15).



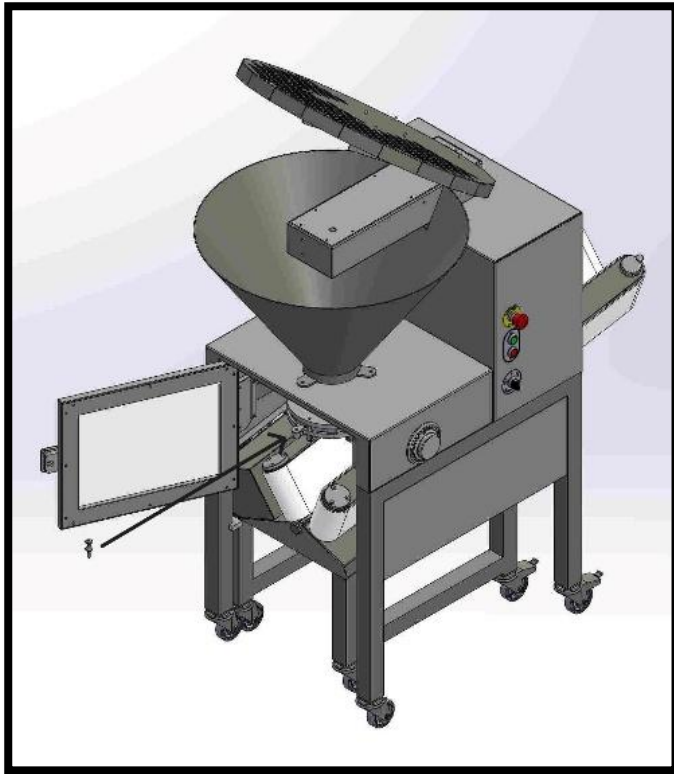
3. Loosen and remove the main auger knob (Ref.19).



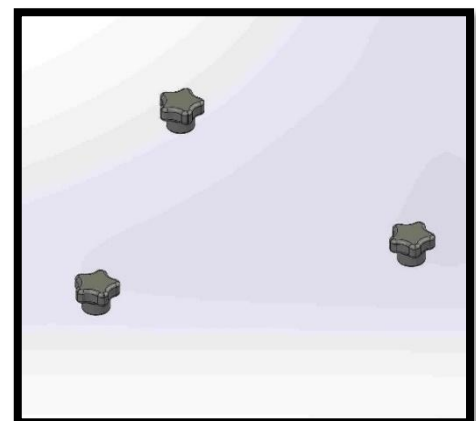
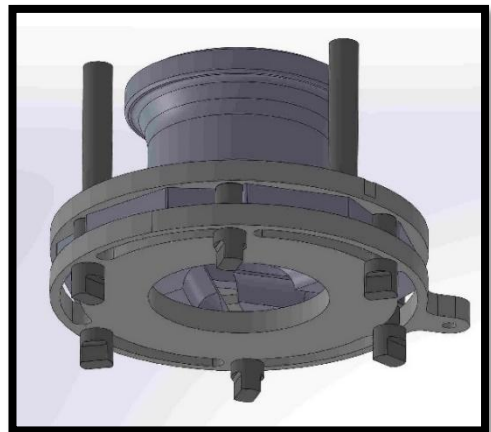
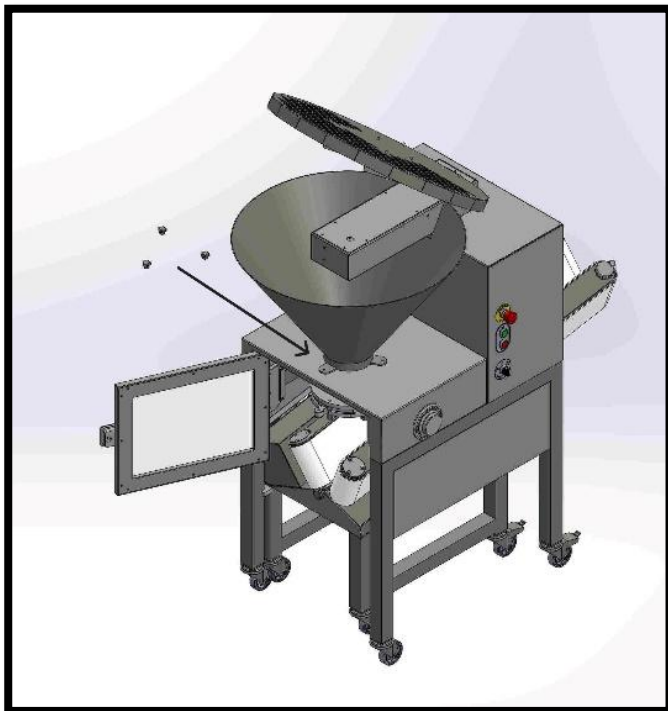
4. Remove the auger body (Ref.13).



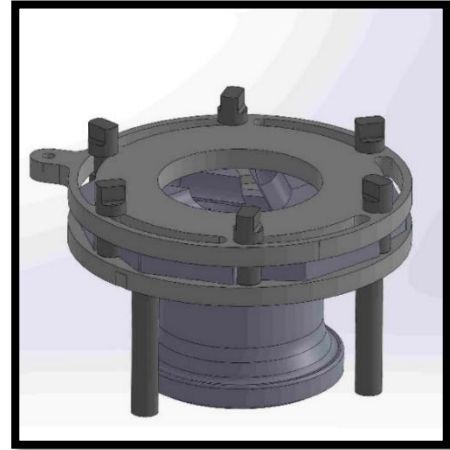
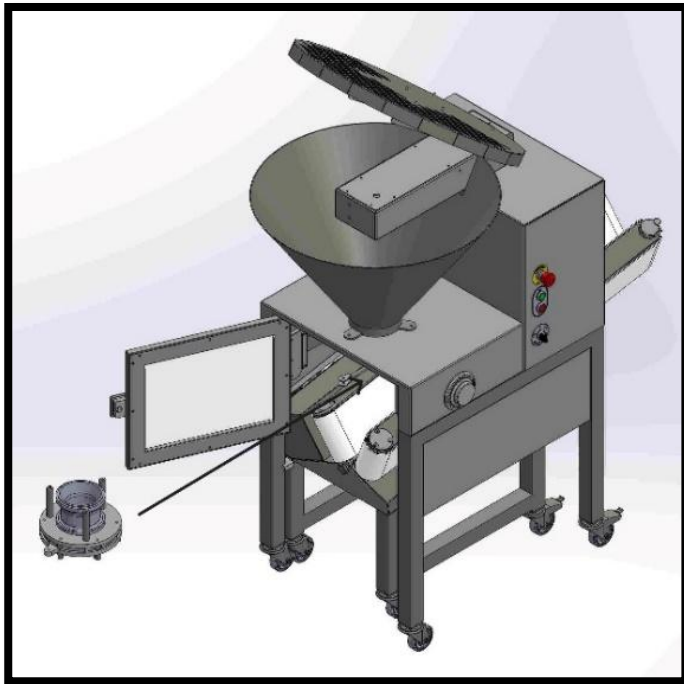
5. Open the front door (Ref.1-2).
6. Pull out the shutter rod blocking pin (Ref. 11).



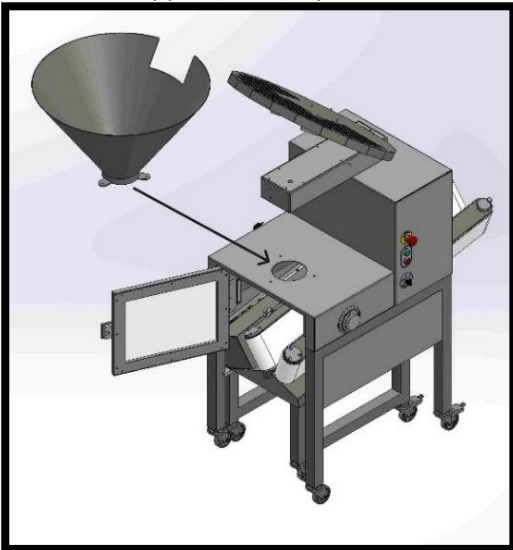
7. Hold the shutter assembly and the cone firmly with your hand and unscrew the three knobs on the hopper (Ref.3).



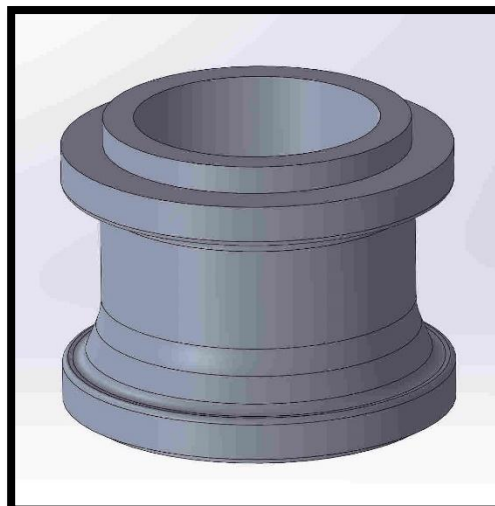
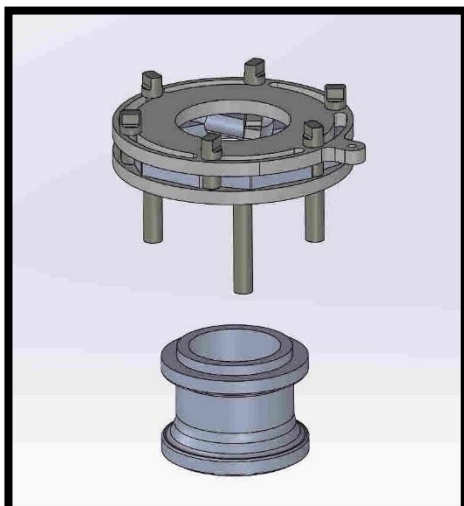
8. Extract the shutter (Ref.6, 7, 8, 9) and the cone (Ref.12) and rotate them to proceed with disassembly.



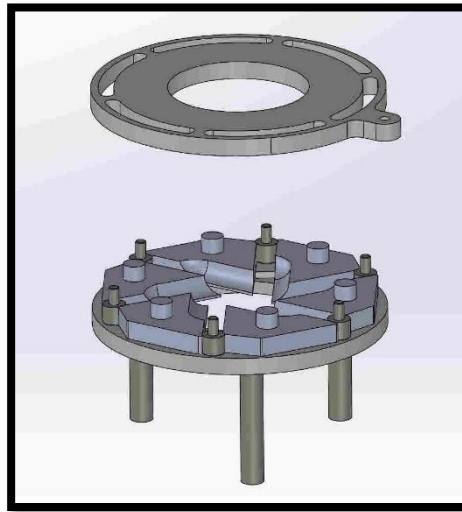
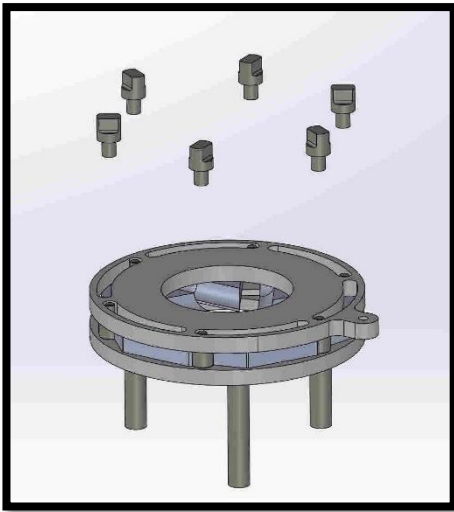
9. Lift the hopper (Ref.4) upwards to remove it.



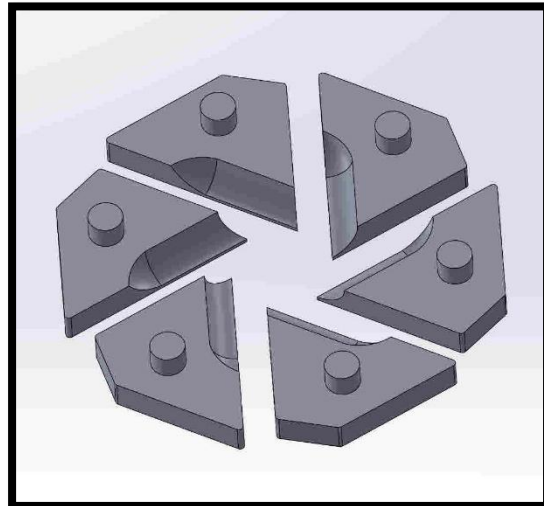
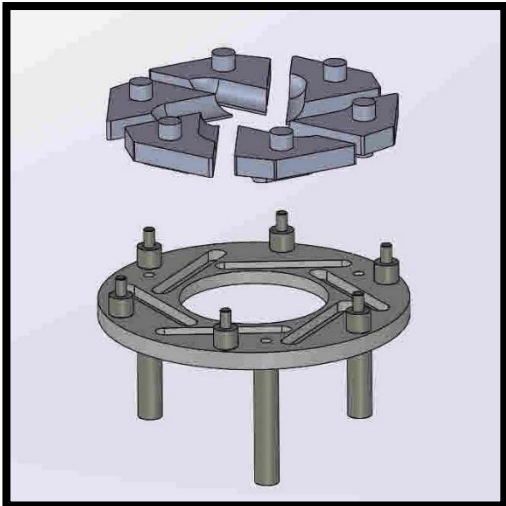
10. To disassemble the shutter, remove the cone (Ref.12).



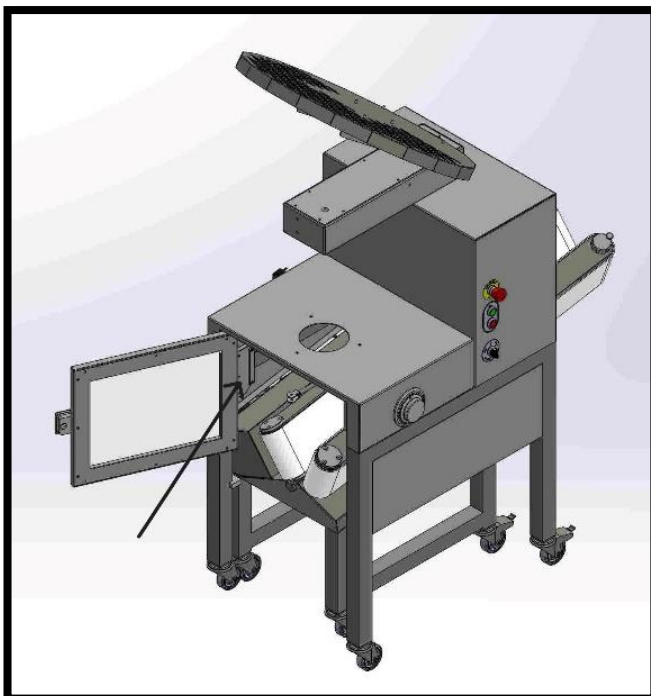
11. Unscrew the knobs (Ref.6) and remove the lower flange (Ref.7).



12. Remove then the shutter sectors (Ref.8) from the upper flange (Ref.9).



13. Clean the sensor (Ref.21) with a soft cloth.

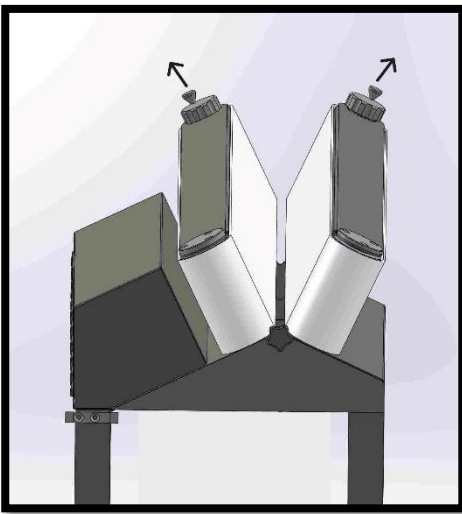


Clean everything and before reassembling, remove dough remains from the interlocking areas.

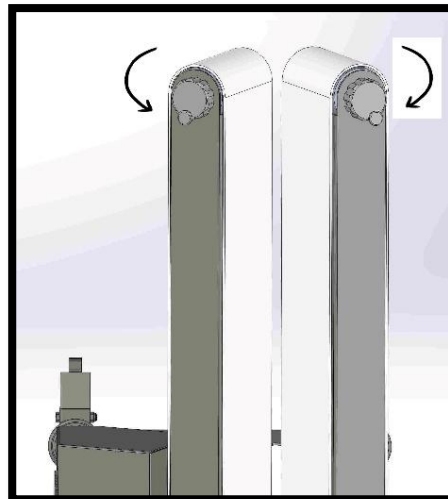
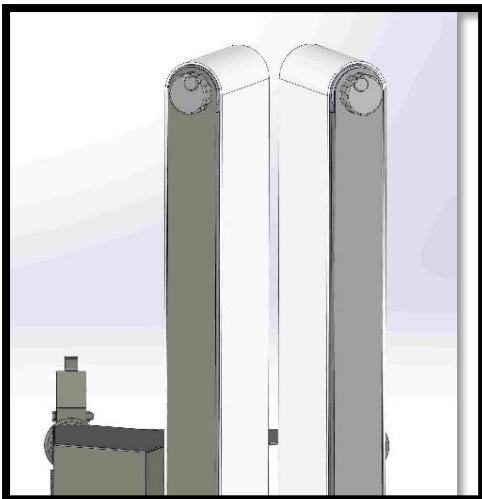
- ☞ Do not clean use any sharp, pointed or metal objects.
- ☞ Do not use abrasive cloths or detergent.
- ☞ Do not wash in dishwasher.
- ☞ Do not clean with steam.
- ☞ Do not wash the machine with water jets.

DOUGH ROUNDER

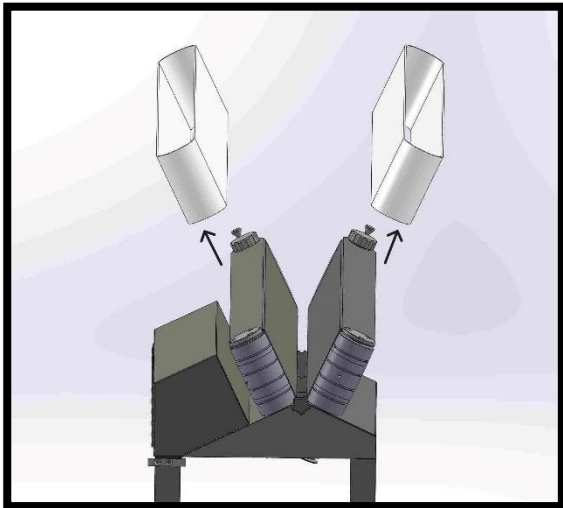
1. Pull the plug (Ref.18).
2. Loosen the belt tensioning knobs (Ref.15) by lifting them upwards.



3. Rotate the knobs (Ref.15) to loosen the belts.

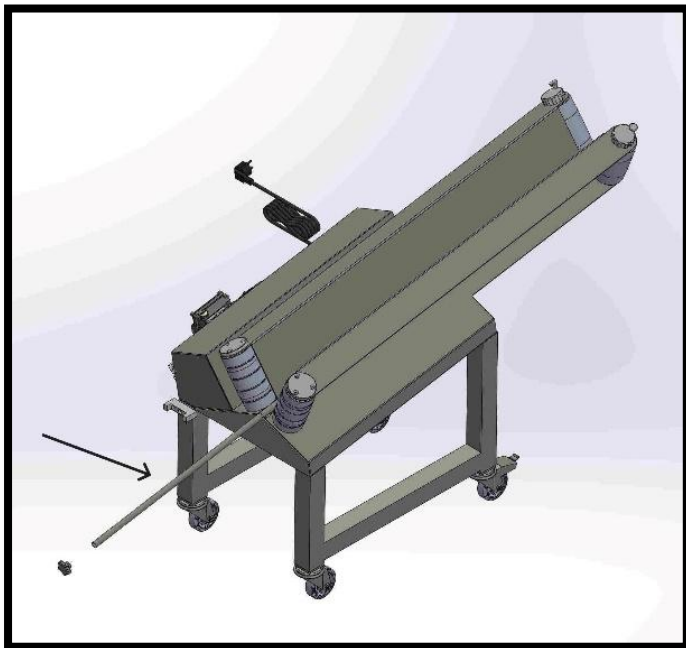


4. Remove the two conveyor belts (Ref.15).



The conveyor belts (Ref.16) must NEVER be cleaned with liquids. Once they are dry, use only a brush with plastic bristles to remove any dried dough remains.

5. Unscrew the knob and remove the sliding bar (Ref.30).



The machine does not need any peculiar lubrications and maintenance.

- ☞ Regularly check the good state of the mains cable.
- ☞ As far as the cleaning of the housing is concerned, daily dry cleaning of all dough and flour remains is sufficient.
- ☞ We remind you that the housing of the machine should NEVER be washed with sodium hypochlorite-based solutions or with abrasive detergents since these could damage the external parts of the machine.
- ☞ Do not wash in dishwasher.
- ☞ Do not clean with steam.

Do not wash the machine with water jets.

We recommend using organic or biodegradable detergents that respect health and the environment.



After cleaning, dry all parts and reassemble them in reverse order.

Remember that thorough cleaning daily will guarantee a long service life.

REPAIR

For repairs, controls, or replacement of damaged parts, we suggest you apply directly to the manufacturer or to replace the damaged parts with equivalent materials, especially as far as safety is concerned:

- power cord with plug (2 phases + ground)
- switch (push button)

Before any mechanical or electrical maintenance, it is compulsory to switch the machine off and to pull the plug.

WARNING: the repairs are to be conducted by qualified people.

Regularly check that the emergency push button is correctly working and check the good conditions of the power cord and plug.

LOUDNESS

The pondered equivalent continuous level of acoustic pressure A produced by the machine while operating under load is under seventy decibels(A) and that the maximum pondered instantaneous value of acoustic pressure C is under 130 decibels.

ESSENTIAL REQUIREMENTS

All our machines have been designed and manufactured strictly in compliance with the current national and international norms, more particularly:

UNI EN ISO 7010 : 2015.

UNI EN ISO 12100 : 2010.

UNI EN ISO 13849-1 : 2016.

UNI EN ISO 13857 : 2008 + EC1 : 2010.

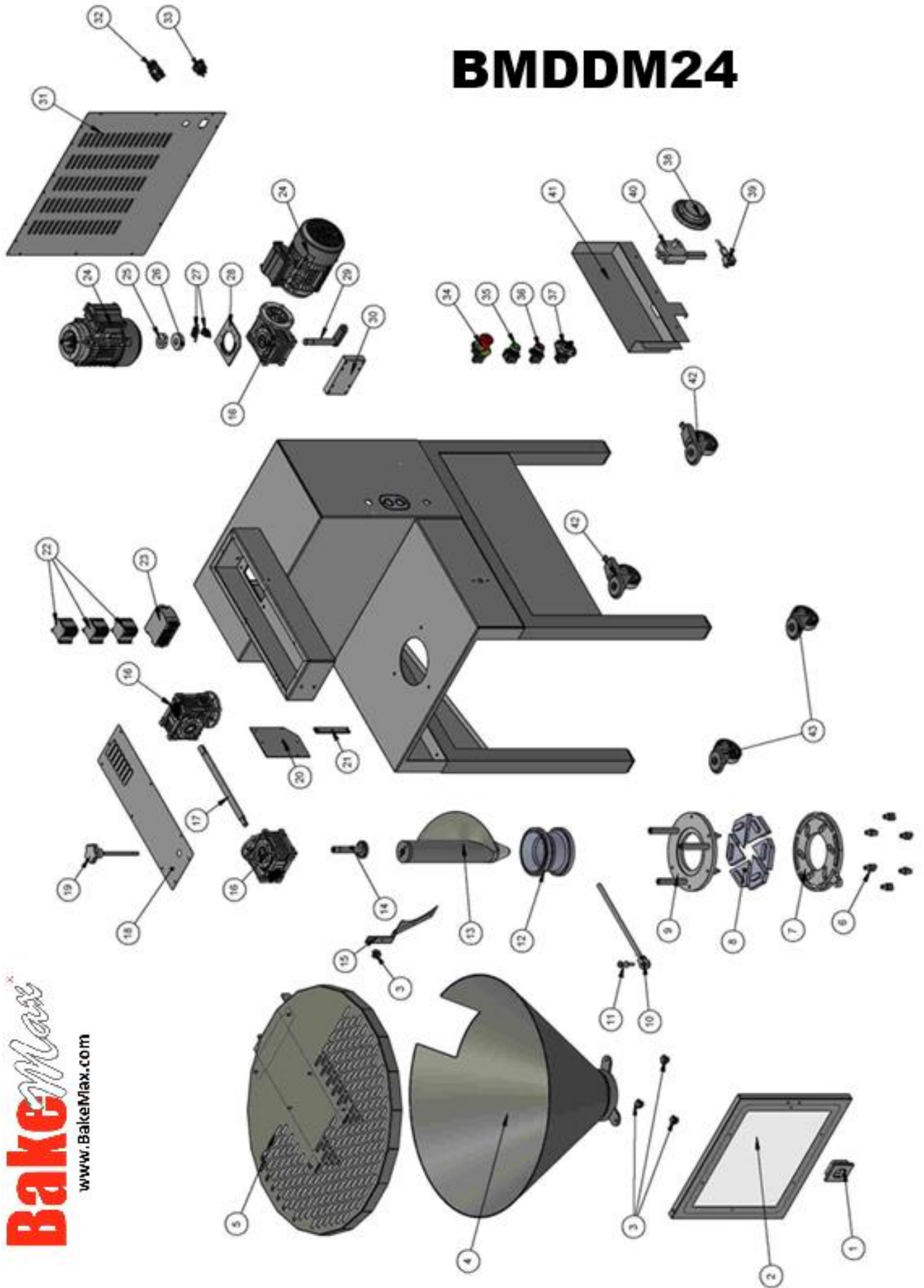
UNI EN ISO 14119 : 2013.

UNI EN ISO 14120 : 2015.

CEI EN 60204-1 : 2006 + EC1 : 2010.

UNI EN 1672-2 : 2009.

BMDDM24



REFERENCE	CODE	BakeMax Part #	DESCRIPTION	QUANTITY
1	A.602.409.2	DDM24/001	DOOR HANDLE	1
2	C.700.028.1 + C.700.029.1 + A.900.003.2	DDM24/002	DOOR ASSEMBLY	1
3	E.602.207.0	DDM24/003	KNOB	4
4	A.200.016.0	DDM24/004	HOPPER	1
5	C.700.530.0 + C.700.534.0	DDM24/005	COVER	1
6	C.700.024.0	DDM24/006	FLANGE SHUTTER	6
7	C.700.512.0	DDM24/007	LOWER FLANGE	1
8	C.700.511.0	DDM24/008	SHUTTER SECTOR	6
9	C.700.510.0	DDM24/009	UPPER FLANGE	1
10	C.700.022.1 + C.700.032.0	DDM24/010	FORK + SHUTTER ROD	1
11	C.700.033.0	DDM24/011	BLOCK ROD LOCK PIN	1
12	C.700.538.0	DDM24/012	CONE Ø88	1
13	A.200.017.0	DDM24/013	AUGER TIP POM +AUGER + SPACER + AUGER SUPPORT SHAFT WASHER	1
14	C.700.016.0	DDM24/014	AUGER REDUCER SHAFT	1
15	C.700.045.0 + C.700.044.0	DDM24/015	DOUGH SCRAPER + DOUGH SCRAPER SUPPORT	1
16	X.802.0172	DDM24/016	REDUCER	3
17	C.700.015.0	DDM24/017	AUGER GEAR MOTOR DRIVE SHAFT	1
18	C.700.025.0	DDM24/018	AUGER SUPPORT BODY COVER	1
19	A.602.412.0 + C.700.049.0	DDM24/019	KNOB	1
20	C.700.041.0	DDM24/020	REFLECTOR SUPPORT	1
21	X.803.0150	DD005/020	REFLECTOR	1
22	X.803.0050	DDM24/022	REMOTE CONTROL SWITCH	3
23	X.803.0168	DDM24/023	FEEDER	1
24	R.005.001.0	DDM24/024	KNIFE MOTOR 115V 60 HZ	2
25	C.700.043.0	DDM24/025	CAM	1

26	C.700.046.0	DDM24/026	CAM	1
27	X.803.0020	DDM24/027	MICRO	2
28	A.602.118.0	DDM24/028	MICRO SUPPORT	1
29	C.700.019.0 + C.700.520.0	DDM24/029	REDUCER SHAFT + SHUTTER ROD CONTROL PLATE	1
30	C.700.506.0	DDM24/030	GEAR MOTOR SPACER	1
31	C.700.026.1	DDM24/031	MAIN COVER	1
32	X.900.0006	DDM24/032	BLACK PUSH BUTTON	1
33	X.803.0124	DD005/047	IEC SOCKET	1
34	X.900.0001	DD005/051 + DD005/051B	EMERGENCY STOP BUTTON	1
35	X.900.0003	DD005/052 + DD005/052B	GREEN ON BUTTON	1
36	X.900.0004	DD005/053 + DD005/053B	RED OFF BUTTON	1
37	X.900.0005	DD005/054 + DD005/054B	BLACK SELECTOR	1
38	A.602.407.0 + A.602.406.0	DDM24/038	WEIGHT REGULATION KNOB + GRADUATED RING	1
39	X.803.0165	DD005/45	PHOTOCELL NPN	1
40	A.200.011.0	DDM24/040	PHOTOCELL SUPPORT	1
41	C.700.533.0	DDM24/041	PHOTOCELL COVER	2
42	X.802.0183	DBR03/023	WHEEL WITH BRAKE	2
43	X.802.0182	DBR03/022	WHEEL	2

Reference	Code	BakeMax Part #	Description	Quantity
1	X.802.0500	DBR30/001	FOOT	4
2	R.600.319.0	DBR30/002	PULLEY PROTECTION GRID	1
3	R.600.321.0	DBR30/003	BELT TENSION PULLEY	2
4	R.600.322.0	DBR30/004	BELT TENSIONER PULLEY SUPPORT	1
5	R.600.314.0	DBR30/005	BELT GUIDE SHEET	1
6	R.600.307.0	DBR30/006	PULLEY Ø70	3
7	R.600.304.0	DBR30/007	LOWER BEARING SUPPORT	2
8	X.801.0013	DBR30/008	BEARING	4
9	R.600.312.0	DBR30/009	DRIVE ROLLER SHAFT	1
10	R.600.308.0	DBR30/010	BELT DRIVE ROLLER	2
11	R.600.305.0	DBR30/011	UPPER BEARING SUPPORT	2
12	R.600.220.0	DBR30/012	ECCENTRIC SHAFT WASHER	2
13	R.600.313.0	DBR30/013	ROLLER ECCENTRIC SHAFT	2
14	R.600.309.0	DBR30/014	BELT DRIVEN ROLLER	2
15	R.600.203.0+ R.600.216.0	DBR30/015	BELT TENSION KNOB + KNOB	2
16	R.600.401.0	DBR30/016	BELT NA160 2T8 VO-O 1620X110	2
17	R.600.301.0+ R.600.302.0+ R.600.317.0+ R.600.318.0 + R.600.327.0	DBR30/017	BODY ASSEMBLY	1
18	X.803.0010	DBR03/029	CABLE WITH US PLUG	1
19	X.803.0019	DBR30/019	PG10	1
20	R.600.215.2	DBR30/020	ELECTRICAL SYSTEM COVER	1
21	R.005.001.0	DBR30/021	MOTOR 115 V	1
22	X.802.0172	DBR30/022	GEARBOX NMRV040 1:20	1

23	R.600.211.0	DBR30/023	ROLLER SHAFT	1
24	R.600.310.0	DBR30/024	DRIVE SHAFT	1
25	R.600.306.0	DBR30/025	PULLEY \varnothing 104	1
26	R.600.402.0	DBR30/026	BELT \varnothing 6x356	2
27	S.602.115.0	DBR30/027	M8 KNOB	1
28	R.600.328.0	DBR30/028	BLADE PROTECTION	1
29	A.500.002.0	DBR30/029	NAMEPLATE	1
30	R.600.323.0	DBR30/030	DOUGH SUPPORT ROD	1
31	X.900.0003	DD005/052 + DD005/052B	GREEN ON BUTTON	1
32	X.900.0004	DD005/053 + DD005/053B	RED OFF BUTTON	1

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.*



www.BakeMax.com

Questions? OEM Parts, Contact Us:

Toll Free: 1-800-565-2253

Email: Service@BakeMax.com

www.BakeMax.com