













# B 75

## DOUGH DIVIDER

This B 75 type is a robust and very solid machine, which can be incorporated into every dough-make up plant. The machine, which divides the doughpieces very exactly, consists of the following main parts:

- dough hopper
- suction chamber
- dividing pockets:
  - 2 pockets B 7520
  - 3 pockets B 7530
  - 4 pockets B 7540
  - 2-4 pockets B 7524
  - 6 pockets B 7560
- discharge conveyor in square direction, left or right
- driving.

### Dough hopper

The conically shaped hopper, made of stainless steel, ensures a smooth supply of the dough to the suction chamber. The hopper has a contents of about 70 kgs. dough.

### Suction chamber

The suction chamber consists of a horizontally moving knife and a big piston, which are moved forward and backward with a very accurate tolerance in the suction chamber. In the suction chamber is sucked a quantity of dough. This quantity is regulable.

### Dividing chamber

The dividing chamber is located in an up- and downwards moving slide and is provided with adjustable pistons. As soon as the knife has closed the suction chamber, the piston will be moving forwards and the slide upwards, so that the dividing chamber is released. Under pressure of the big piston the dividing chamber is filled with dough, while the dividing pistons are pushed against the stop. Due to the adjusting possibility of the dividing pistons the weight of the final dough piece can be controlled exactly. The big piston is moved backward and forward by means of a special crank mechanism. In this transmission is used a heavy spiral spring. When the piston has almost come at the end of its stroke, and when the dividing chamber is filled, the dough is kept under pressure for some time by the spring. Thus will be obtained a reliable and uniform filling of the dividing chamber.

### Dough discharge conveyor

The slide goes down when the dividing chamber is completely filled, so that simultaneously the suction chamber is closed. The horizontal knife and the piston move backwards and a new cycle will be starting. When the slide has reached its lowest position, the doughpieces are brought on the discharge conveyor and then taken over by a plastified belt, which lays the pieces at distance and conveys them to the Rounder. The exact distance of the dough pieces can be regulated by an incorporated variator disc, located in the conveyor driving.

### Driving

The machine is driven by a 3,0 kW motor 1400 cycles/min. The various parts are driven by V-rope and chain transmissions and by a reduction box. The motor is thermally secured against overloading. The machine is executed with a speed regulator, which is equipped with a V-rope.

### Lubrication and maintenance

The machine is provided with dustproof and for lifetime greased ballbearings, which do not need any maintenance. The dividing mechanism has to be greased continuously and is equipped for this with a lubrication device and oilpump. From a reservoir of plexiglass the lubrication is conducted with plastic lines to the respective sliding surface. The greasing occurs automatically. The bottomside of the knife and the suction chamber are greased by means of nozzles. Air consumption:  $\pm 0,6 \text{ M}^3$  per hr. of 1 Atm. and 20° C. (operating pressure 6 Atm.). The dividing mechanism is easy removable for maintenance purposes. The main chain is provided with a greasing device, which has an effective operating time of six months.



#### Mechanical electr. safety

The machine is provided with mechanical electr. safety. In case an object should come into the machine or if a pollution causes an overloading, a set of springs (adjustable) will be practised, so that the motor is switched off by an electr. switch. Replacement of shear pins or other parts will not be necessary then.

Type	Weightrange in grs.	Capacity per hour in dough pieces
B 7520	400 - 2300	1200 - 2400
B 7530	250 - 1500	1800 - 3600
B 7540	200 - 1100	2400 - 4800
B 7524	2 pockets 400 - 2300	2 pockets 1200 - 2400
	4 pockets 200 - 1100	4 pockets 2400 - 4800
B 7560	150 - 750	3600 - 7200

It is understood that the weightranges always depend on composition and structure of the doughs.

#### Execution

By reversing a ratchet, the machine can divide and discharge per stroke 2 or 4 dough pieces.

- The doughweight is adjustable by means of a handwheel. The machine is equipped with a scale division indicator.
- The process is practically noiseless.
- All driving parts are easily accessible.
- Easy maintenance.
- The machine meets the highest security requirements (cover security).
- The machine is movable (the third wheel is the steering wheel).

Weight of the divider B 75:  $\pm$  1250 kgs.

**MODIFICATIONS RESERVED**