
MOFFAT

VERSATILE 2 MOULDER
with Lightspeed Guard Mouth

VM404

VM704

SERVICE MANUAL





Warning:

All Installation and Service Repair work must be carried out by Qualified Persons Only.

CONTENTS

This manual is designed to take an in depth look at the Moffat Versatile 2 Moulder for the purpose of making the units more understandable to service technicians.

There are settings explained in this manual that should never require adjustment, but for completeness and in special cases where these settings are required to be changed, this manual gives a full explanation of how to change these settings and what the effects of these changes will be.

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Important:
Making alterations may void Warranties and Approvals.

1. SPECIFICATIONS

MODEL: VERSATILE 2 MOULDER

ELECTRICAL SUPPLY SPECIFICATION

Australia / New Zealand;

400 - 415 Volt, 3P + E, 50Hz, 1.0kW.

Canada;

208 - 220 Volt, 3P + E, 60Hz, 1.0kW.

POWER CORD / PLUG SPECIFICATIONS

Australia / New Zealand;

Supplied with fitted power cord, 56PA410 (4 pin, 3P + E, 10 Amp) plug.

Canada;

Supplied with fitted power cord, SOOW, 4C, 16AWG, NEMA L15 20P (250V, 20A, 4 Pin) Plug.

PRODUCT CAPABILITY

Recommended weight range: 30-1200 grams.

OVERALL CONSTRUCTION

- Galvanised steel main body, stainless steel finish.
- Fibreglass mouldings.
- Curling Chain, stainless steel construction (removable for cleaning).
- Sheeting Rollers, non stick PVC material.

OPERATION

- Light Beam Safety Guard.
- Four piecing blades activated by front lever.
- Loaf guides fitted with width adjustment lever.
- Fully adjustable sheeting roller settings.
- Operation and Emergency stop buttons front mounted.

2. INSTALLATION



Warning:

All Installation and Service Repair work must be carried out by qualified persons only.

2.1 COMMISSIONING

The following commissioning checks must be carried out before the moulder is handed over for use, to ensure that the unit operates correctly and the operator(s) understand correct operation.

- Ensure that the moulder belts turn in the correct direction. If incorrect then swap over two of the phases to the motor, to give correct rotation
- With the machine running, test the operation of the emergency stop button. The machine must stop immediately.
- Each operator must be instructed in the correct usage of the machine.

Please consult the supplied Installation and Operation Manual for full operation and safety information.

2.2 RATING PLATE LOCATION

The rating plates for the Versatile Moulder are located at the rear of the moulder as shown below, as viewed from the rear of the appliance;

- **Primary Rating Plate** - Inside of the left hand frame
- **Secondary Rating Plate** - On the cross-rail at the rear of the appliance.

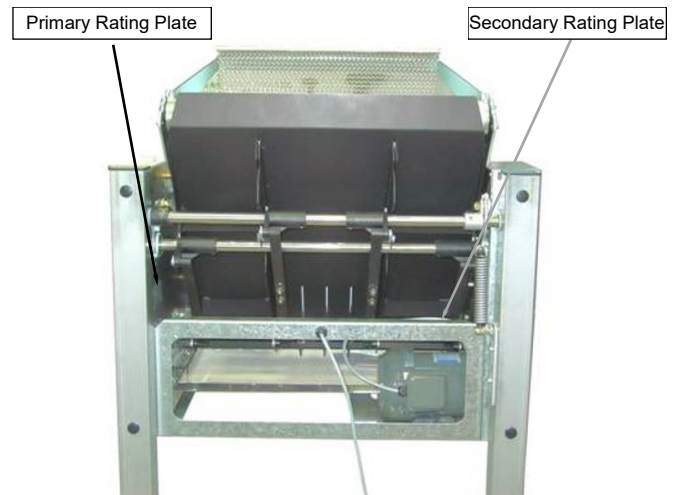


Figure 2.2

3. OPERATION

NOTE: A full user's Installation and Operation Manual is supplied with the product and can be used for further referencing of installation, operation and service information.

Operating the Versatile Moulder;

NOTE: For detailed instructions on the operation of the Versatile 2 Moulder, refer to the Installation and Operation manual supplied with the equipment.

- Set sheeting roller gap to required product setting.
- Set rear belt to required product setting.
- If using the optional splitter attachment, the width guide attachment should now be lowered into the machine, and set to the desired width.
- Pull out the catch tray.
- For small dough pieces, lower guide roller assembly into place. This assembly keeps dough pieces centred during the moulding process. Mainly for 4 piecing of bread and sandwich loaves.
- Press the green START button.
- Feed dough into the roller assembly.
- Follow the recommended workplace procedures for the desired product.
- Observe the action of the dough pieces under the curling chain. Dough should curl upwards and not deviate to the sides.
- Check the resultant end product against workplace standard for shape, size and consistency.
- Repeat the process.

4. MAINTENANCE



Warning:

- ENSURE ALL ELECTRICAL POWER TO THE APPLIANCE IS SWITCHED 'OFF' BEFORE COMMENCING CLEANING.
- THIS UNIT IS NOT WATERPROOF, DO NOT USE A WATER JET SPRAY TO CLEAN THE INTERIOR OR EXTERIOR OF THIS UNIT.

4.1 CLEANING

- Brush off all external surfaces, working from top to bottom.
- Clean the mouth assembly with a damp cloth.
- Open the moulder feed mouth.
- Open the sheeting rollers to maximum (15) and wipe down with a damp cloth.
- To remove curling chain, lift out the assembly.
- Check for build up and wash if needed in warm water.
- Check the rear belt for signs of old dough. Clean with a plastic scraper if necessary and brush lightly.

NOTE: Never use a metal scraper to clean the rear belt.

- Clean attachment arms and rollers with a plastic scraper and damp cloth.
- Brush flour dust from the electrical motor intake.
- Clean splitter blades with a plastic scraper and a damp cloth.
- Re-assemble the machine.

4.2 ROUTINE PROCEDURES

DAILY

- Clean machine as detailed in Section 4.1.

MONTHLY

- Remove side panels and remove any old dough and flour build up.
- Brush the motor to remove any flour dust.
- Check motor drive belt for any wear or stretching. Adjust or replace as necessary.

YEARLY

- Lubricate the drive chains.

5. FAULT FINDING GUIDE



Warning:

All Installation and Service Repair work must be carried out by Qualified Persons Only.

Problem	Possible Cause	Remedy
THE MOULDER DOES NOT OPERATE / START.	<p>Not plugged in to socket at main switch.</p> <p>The main switch is 'Off'.</p> <p>Fuse or circuit breaker at the power board is tripped.</p> <p>Emergency stop button locked in down position.</p> <p>Emergency stop button faulty.</p> <p>A microswitch or safety key switch has been activated or is faulty.</p> <p>Start switch faulty. (Refer Fault Diagnosis 6.1.1).</p> <p>Stop switch faulty. (Refer Fault Diagnosis 6.1.1).</p> <p>Contactor faulty. (Refer Fault Diagnosis 6.1.1).</p> <p>Motor overload faulty. (Refer Fault Diagnosis 6.1.1).</p> <p>Circuit Breaker tripped (Canada Only). (Refer Fault Diagnosis 6.1.1).</p>	<p>Plug in and turn 'On' main switch.</p> <p>Turn 'On' main switch.</p> <p>Check for electrical fault.</p> <p>Release by pulling firmly.</p> <p>Replace the emergency stop button. (Refer Service Section 6.3.11).</p> <p>Check all switches (safety key switch, front guard switch, rear guard switch).</p> <p>Replace left hand lightspeed horn. (Refer Service Section 6.3.10).</p> <p>Replace right hand lightspeed horn. (Refer Service Section 6.3.10).</p> <p>Replace contactor. (Refer Service Section 6.3.12).</p> <p>Replace motor overload. (Refer Service Section 6.3.12).</p> <p>Check Circuit Breaker is switched 'On'.</p> <p>Check 24V Power tripping fault.</p>
THE MOULDER STARTS AND THEN STOPS.	<p>Moulder overload has been activated.</p> <p>Motor overload incorrectly set.</p> <p>Motor overload faulty. (Refer Fault Diagnosis 6.1.1 and 6.1.2).</p> <p>Motor faulty. (Refer Fault Diagnosis 6.1.2).</p>	<p>Motor Overload resets automatically after 10mins.</p> <p>Set Motor overload to 2.0 A.</p> <p>Replace motor overload. (Refer Service Section 6.3.12).</p> <p>Replace motor. (Refer Service Section 6.3.2).</p>
THE MOULDER BELTS OPERATE IN THE WRONG DIRECTION.	<p>Electrical phase rotation incorrect.</p>	<p>Swap two phases to ensure belts rotate in the correct direction.</p>
CHAIN JUMPING NOISES.	<p>Broken idler gear tensioning spring.</p> <p>Motor operating in wrong direction (phase rotation incorrect).</p>	<p>Replace idler gear tensioning spring. (Refer Service Section 6.3.4).</p> <p>Swap two phases to ensure belt rotates in the correct direction. (Refer Service Section 6.3.1 and Fig 6.3.1a).</p>
THE MOULDER LABOURS UNDER LOAD / DRIVE BELT SLIPPING.	<p>Dough too stiff / tight.</p> <p>Stretched or loose drive belts.</p>	<p>Review and adjust the dough consistency or adjust the rear belt settings to a wider gap.</p> <p>Re-tension or replace drive belts. (Refer Service Section 6.3.1 & 6.4.3).</p>
MOTOR OPERATES BUT BELTS DO NOT TURN.	<p>Machine has been started in the wrong direction causing the chain to jump off the sprockets.</p>	<p>Refit chain and check electrical phase rotation.</p>
BELT EDGES FRAYING.	<p>Tracking of belts is incorrect.</p>	<p>Adjust belt tracking. (Refer Service Section 6.4.2).</p>
DOUGH STICKING TO SHEETING ROLLERS.	<p>Scrapers out of alignment.</p> <p>Scraper spring broken.</p>	<p>Check alignment of scrapers. (Refer Service Section 6.4.5 & 6.4.6).</p> <p>Replace scraper spring. (Refer Service Section 6.3.8 & 6.3.9).</p>

6. SERVICE PROCEDURE



Warning:

- ALL INSTALLATION AND SERVICE REPAIR WORK MUST BE CARRIED OUT BY QUALIFIED PERSONS ONLY.
- ENSURE ALL ELECTRICAL POWER TO THE APPLIANCE IS SWITCHED 'OFF' BEFORE COMMENCING SERVICING.

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6. SERVICE PROCEDURE

6.1 FAULT DIAGNOSIS

6.1.1 MOULDER DOES NOT OPERATE

START Switch Faulty

The green START switch has normally open switch contacts. Check that there is no continuity through the switch when it is not depressed, and that there is continuity while the switch is depressed.

STOP Switch Faulty

The red STOP switch has normally closed switch contacts. Check that there is continuity through the switch when it is not depressed, and that there is no continuity while the switch is depressed.

Microswitch or Limit Switch Faulty

The microswitch(es) and limit switch have normally open switch contacts. Check that there is continuity through the switch when it is activated, and no continuity when it is de-activated.

Motor Overload Faulty

Check for continuity through terminals 95 and 96 of the motor overload. If there is no continuity then the overload has tripped or is faulty. Check also for continuity through terminals 1-2, 3-4, and 5-6. If there is no continuity then the overload is faulty.

Contactors Faulty

With the start switch held in check for voltage (415V ac) across terminals A1 and A2 of the contactor. If there is voltage but the contactor will not activate then the contactor is faulty - replace.

If there is no voltage to the contactor then check wiring.

Contact Breaker (Canada Only)

Check that the contact breaker protecting the 24V power supply is switched 'On'.

If the circuit breaker has tripped, check the 24V power supply for fault.

6.1.2 MOULDER STARTS THEN STOPS

Motor Faulty

With the motor running, check the current draw of each phase. This should be approximately 1.1A. If the current draw is well in excess of this then the motor may have stalled (check motor and linkages) or else the motor is faulty.

Overload Faulty

The overload is set to trip at a current of 2.0A. If the current is less than this, and the overload is repeatedly tripping, then the overload is faulty - replace.

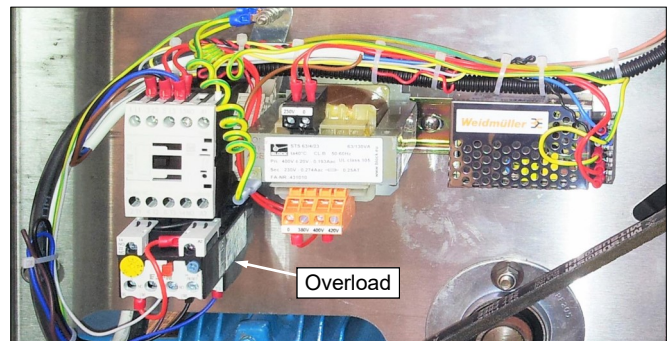


Figure 6.1.2

6. SERVICE PROCEDURE

6.2 ACCESS

6.2.1 SIDE COVER PANELS

- 1) To remove the LH and RH side panels, remove one screw at the rear and one screw on the underside of the side panel.
- 2) Slide the side panel away from the moulder.

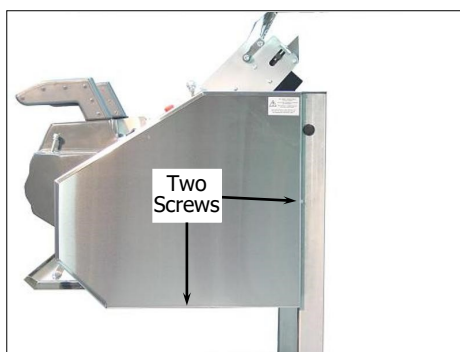


Figure 6.2.1

6.2.2 LIGHTSPEED MOUTH GUARD ASSEMBLY

- 1) Unhook the securing catch and tilt the Lightspeed Mouth Guard Assembly forward to access the rollers.

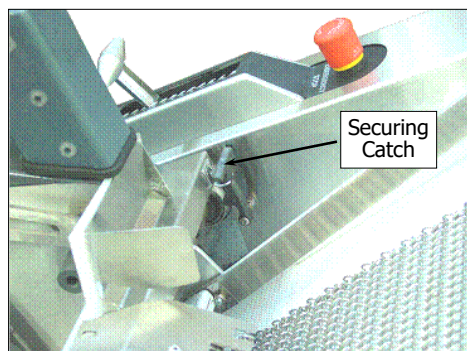


Figure 6.2.2

6.2.3 FRONT COVER

- 1) Remove Lightspeed Horns as shown at Section 6.3.10.
- 2) Remove Sheeting Roller Handle and Locknut.

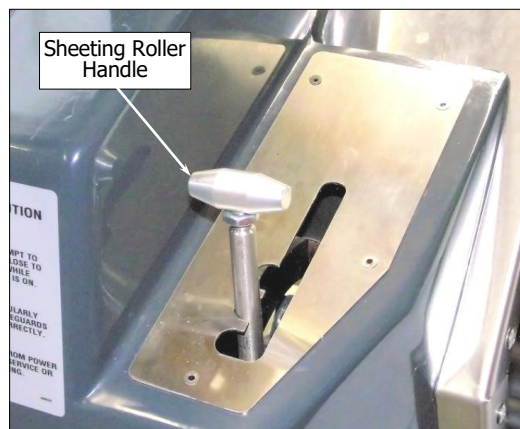


Figure 6.2.3a

- 3) Slacken the 2 bolts (fitted with large washers) on either side of the feed mouth.

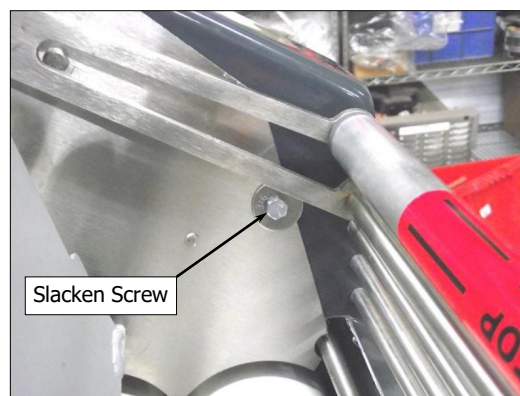


Figure 6.2.3b

- 4) Open the feed mouth and remove the 2 screws securing the front cover to the feed mouth.
- 5) Carefully remove front cover.



Figure 6.2.3c

6. SERVICE PROCEDURE

6.3 REPLACEMENT

6.3.1 VEE BELT

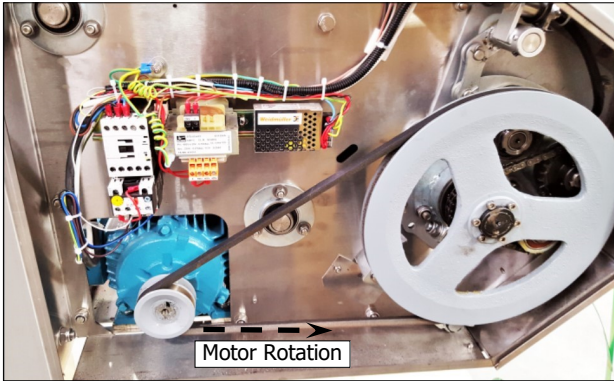


Figure 6.3.1a

- 1) Remove left hand cover panel (refer 6.2.1).
- 2) Slacken Vee belt by loosening four bolts securing motor to mounting bracket on the underside of unit.

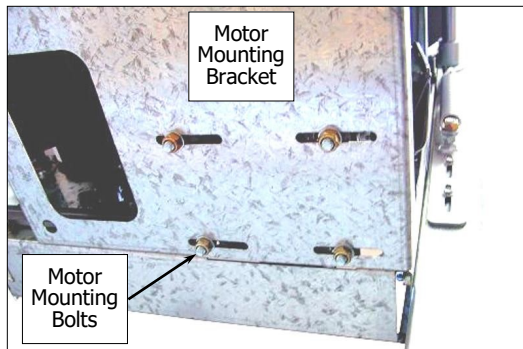


Figure 6.3.1b

- 3) Remove the vee belt from the pulleys.
- 4) Replace belt and re-assemble. Ensure belt is correctly tensioned. Refer to Figure 6.4.3b.

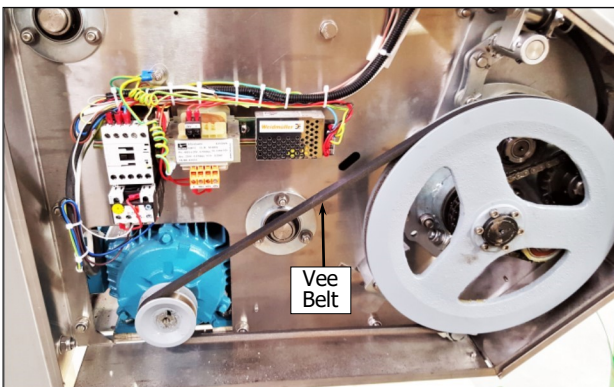


Figure 6.3.1c

6.3.2 MOTOR

- 1) Remove Vee belt (refer 6.3.1).
- 2) Remove electrical cover from motor and undo wiring connections.
- 3) Undo four bolts securing motor to mounting plate. Refer to Figure 6.3.1b.
- 4) Lift motor out of moulder.
- 5) Replace motor and re-assemble in reverse order. Ensure phase rotation of motor is correct after re-assembly (motor pulleys should rotate anti-clockwise when viewed from left hand side of unit).

6.3.3 DRIVE PULLEY AND DRIVE CHAIN

- 1) Remove left hand side cover panel (refer 6.2.1).
- 2) Remove vee belt from pulleys (refer 6.3.1).
- 3) Unscrew and remove 2 grub screws from pulley.
- 4) Unscrew the grub screw retaining the woodruff key.

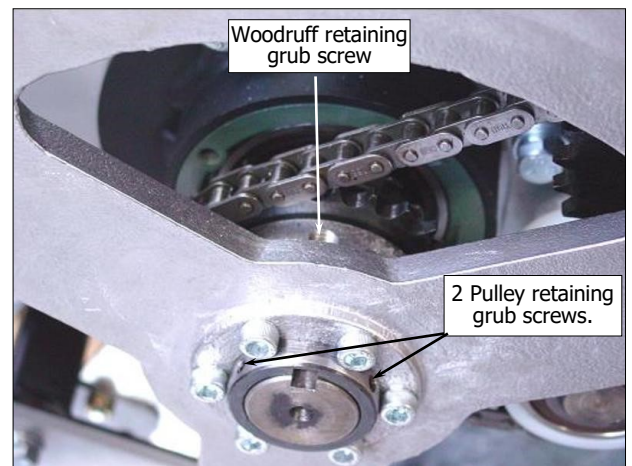


Figure 6.3.3a

- 5) Remove joining link from chain.
- 6) Unthread chain from sprockets.
- 7) Carefully withdraw pulley from shaft, taking care not to lose woodruff key.

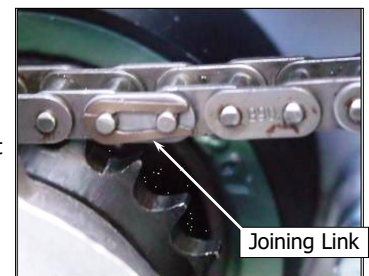


Figure 6.3.3b

6. SERVICE PROCEDURE

- Slacken off the chain tensioning roller adjustment screws and fit new chain.

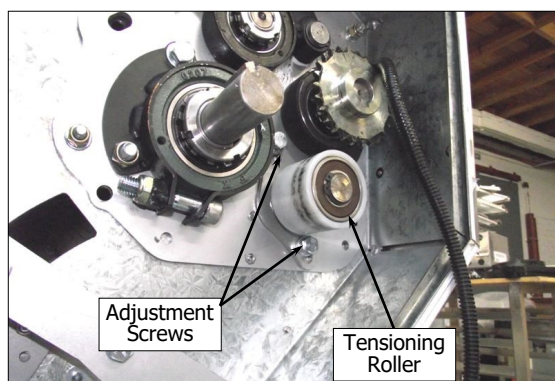


Figure 6.3.3c

- Ensure the joining link is re-fitted to the chain with open end of link facing opposite way to direction of drive.
- Refit drive pulley in reverse order.

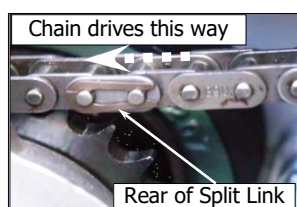


Figure 6.3.3d

6.3.4 RIGHT HAND DRIVE CHAIN

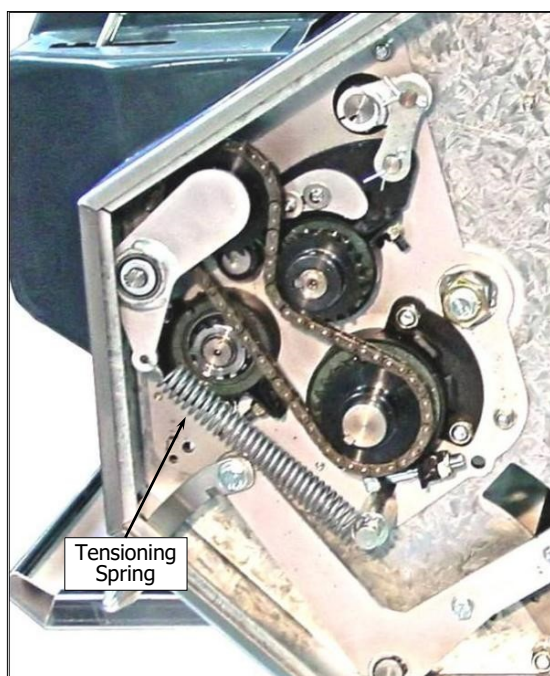


Figure 6.3.4

- Remove the RH side panel (refer 6.2.1).
- Unhook the tensioning spring.

- Remove the joining link from the chain.
- Unthread the chain from the sprockets.
- Fit new chain and re-assemble.
- Ensure that the joining link is re-fitted to the chain with the open end of link facing the opposite way to direction of drive. Refer figure 6.3.3d.
- Connect up the tensioning spring.

6.3.5 STOP BAR MICROSWITCH

- Remove the Lightspeed Horns (refer 6.3.10) and front cover panel (refer 6.2.3).
- Disconnect the tensioning spring.
- Undo nuts securing microswitch to mounting bracket.
- Unscrew cable clamp screw and disconnect wires from the microswitch.
- Transfer wires to new microswitch and re-assemble.
- Ensure new microswitch is adjusted so that it open circuits when the stop bar is pressed.

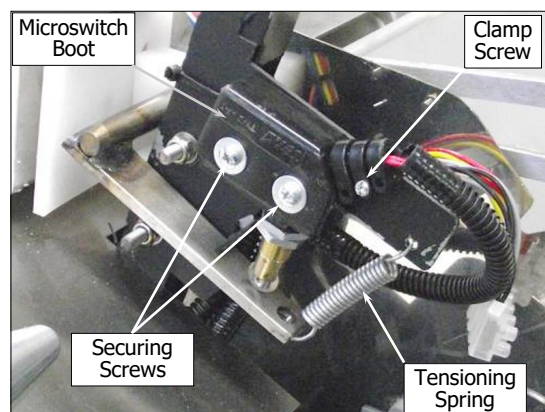


Figure 6.3.5

6. SERVICE PROCEDURE

6.3.6 LIGHTSPEED MOUTH GUARD MICROSWITCH

- 1) Remove the RH side cover panel. Refer to 6.2.1.
- 2) Remove the Catch Tray.
- 3) Remove the split pin from the Microswitch Operating Rod and disconnect the rod.

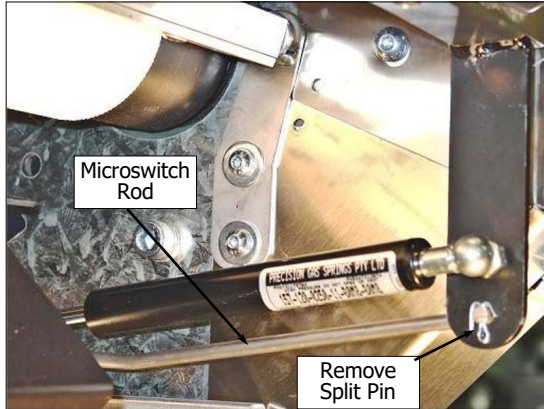


Figure 6.3.6a

- 4) From the rear of the machine remove microswitch cover and microswitch rod.

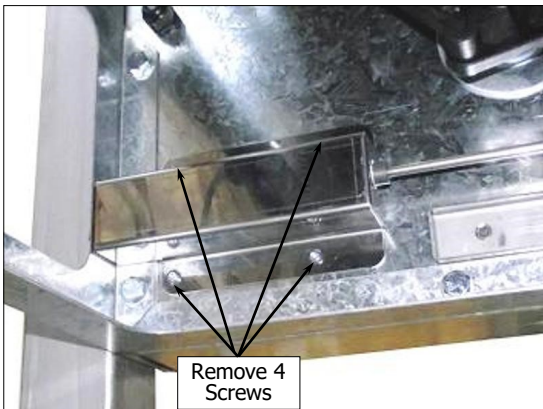


Figure 6.3.6b

- 5) Unscrew microswitch and remove.
- 6) Unscrew the cable clamp screw and disconnect the wires from the microswitch.



Figure 6.3.6c

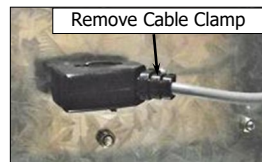


Figure 6.3.6d

- 7) Transfer wires to new microswitch and re-assemble.
- 8) Ensure new microswitch is adjusted so that it open circuits when lightspeed mouth guard is opened.

6.3.7 TOP SHEETING ROLLER SCRAPER

- 1) Remove the LH and RH side panels.
- 2) Open up the feed mouth and disconnect the top scraper tension spring.
- 3) Remove the vee belt and pulley (refer 6.3.1 & 6.3.3).

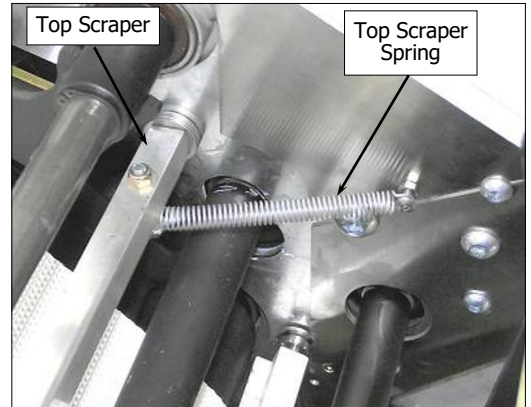


Figure 6.3.7a

- 4) Remove 2 screws on either side of moulder securing hinge pin adjustment plates and remove the plates.
- 5) Remove the scraper and replace.

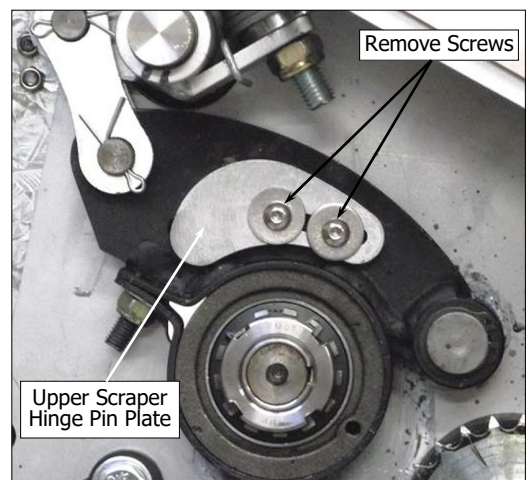


Figure 6.3.7b

- 6) Re-assemble in reverse order.
- 7) When re-fitting the hinge pin adjustment plates, ensure that they are adjusted so that the scraper is level across the roller.

6. SERVICE PROCEDURE

6.3.8 BOTTOM SHEETING ROLLER SCRAPER

- 1) Remove the tray from the underside of the appliance.
- 2) Remove the bottom scraper tension spring on the LH side of the bottom scraper.
- 3) Undo the two screws securing each of the bottom scraper mounting plates to the moulder.

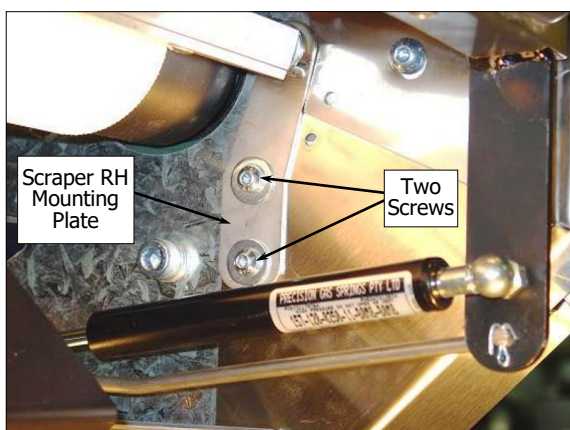


Figure 6.3.8a

- 4) Withdraw the scraper with the mounting plates.

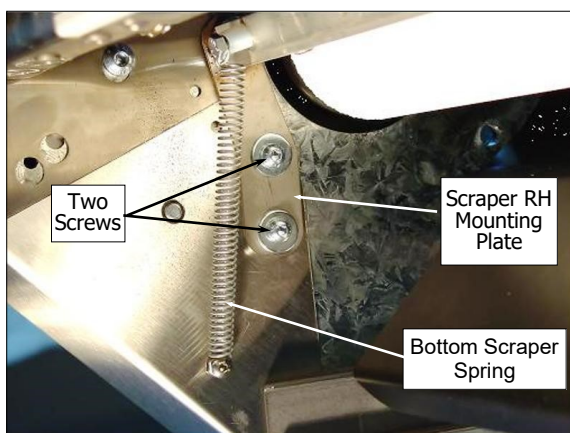


Figure 6.3.8b

- 5) Replace the scraper and re-assemble in reverse order.
- 6) When re-fitting the mounting plates, ensure that they are adjusted such that the scraper is level across the roller.

6.3.9 FEEDER MOUTH ROLLER SCRAPERS

- 1) Remove the Lightspeed Horns (refer 6.3.10) and front cover panel (refer 6.2.3).
- 2) Remove the tension spring on the RH side of the scrapers.
- 3) Undo the two screws securing each of the feeder mouth scrapers to the moulder.
- 4) Withdraw the scrapers.

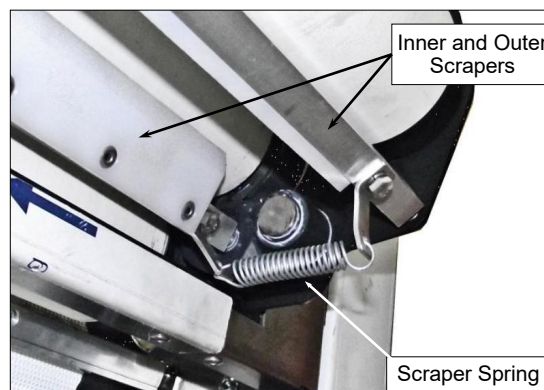


Figure 6.3.9

- 5) Replace the scrapers and re-assemble in reverse order.
- 6) Refit the tension spring to the scrapers.

6. SERVICE PROCEDURE

6.3.10 LIGHTSPEED HORNS

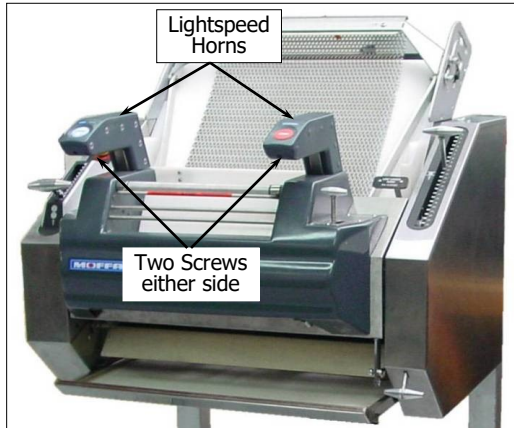


Figure 6.3.10a

- 1) To remove LH and RH Lightspeed Horns, remove 2 screws from underside of either horn.
- 2) Carefully lift up horn to reveal connector at rear underside of horn.
- 3) Disconnect the connector and remove the Lightspeed Horn.

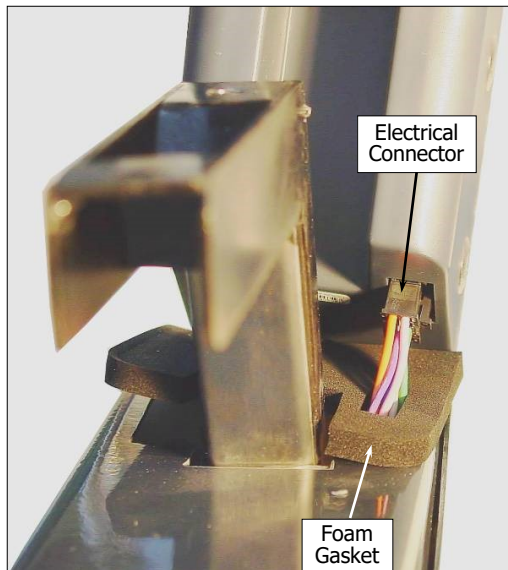


Figure 6.3.10b

- 4) Ensure that the foam gasket is not damaged.
- 5) Fit replacement Lightspeed Horn and re-assemble in reverse order ensuring that the foam gasket remains properly seated when tightening the two securing screws.

6.3.11 EMERGENCY STOP SWITCH



Figure 6.3.11a

- 1) Remove LH side cover panel (refer 6.2.1).
- 2) On underside of LH control panel, use a small electrical screwdriver to unlock base of switch from main body and pull off the switch base.

Use screwdriver here to unlock

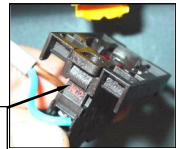


Figure 6.3.11b

- 3) Disconnect electrical wires from switch base.
- 4) Remove switch contact block from underneath switch.

Contact Block

Unscrew Connections here

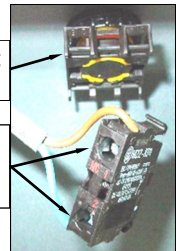


Figure 6.3.11c

Locking Ring

- 5) Unscrew locking ring from underside of switch main body and remove switch.
- 6) Replace and re-assemble in reverse order.

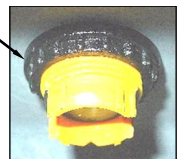


Figure 6.3.11d

6. SERVICE PROCEDURE

6.3.12 MOTOR CONTACTOR / OVERLOAD

- 1) Remove right hand side cover panel (refer 6.2.1).
- 2) Replace faulty component (din rail mounted), ensuring all wires are fitted correctly, and are firm, (refer to Electrical Wiring Diagrams - Section 7).

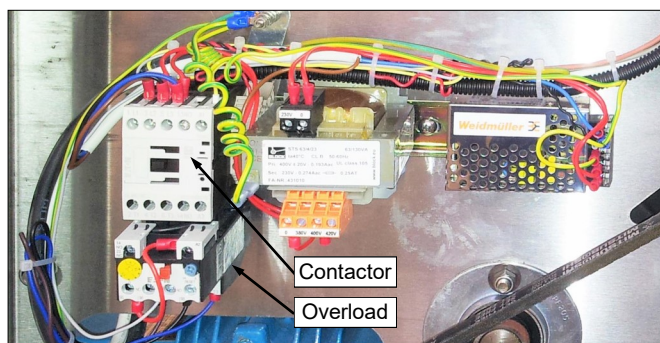


Figure 6.3.12

NOTE: When replacing overload, ensure range is set to 2A, and reset is set to 'A' (automatic).

6. SERVICE PROCEDURE

6.4 ADJUSTMENT / CALIBRATION

6.4.1 MOULDING BELT TENSION

- 1) To adjust tension on moulding belt, turn adjustment screws located at top rear of belts. Turn screws clockwise to increase tension, or anticlockwise to decrease tension.

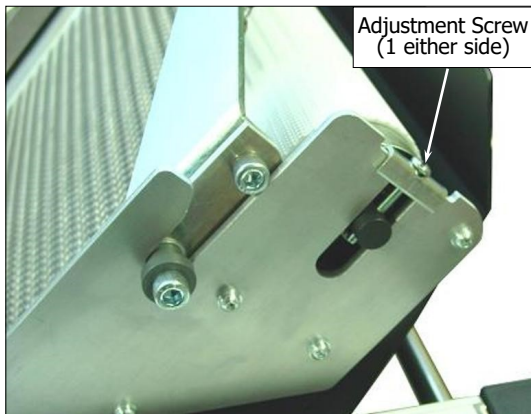


Figure 6.4.1

6.4.2 MOULDING BELT TRACKING

- 1) Viewed from rear of machine, to adjust tracking (left to right) of moulding belt, turn adjustment screws located at top rear of belt.

To track belt towards left of machine (drive side), slacken left adjustment screw and tighten right adjustment screw.

To track belt towards right of machine, tighten left adjustment screw and slacken right adjustment screw.



Figure 6.4.2

6.4.3 DRIVE BELT TENSION

- 1) Remove left hand side cover panel from moulder (refer 6.2.1).
- 2) Loosen four motor mounting bolts at rear of machine and adjust position of motor so that belt is correctly tensioned.
- 3) Tighten securing bolts.

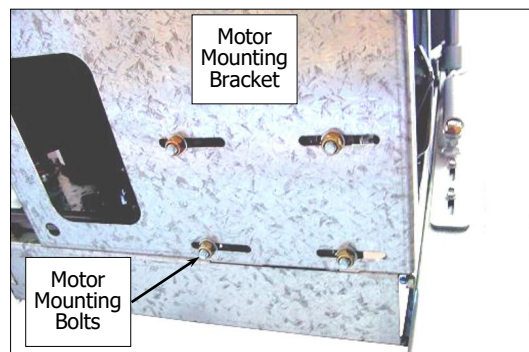


Figure 6.4.3a

NOTE: A correctly adjusted Vee - belt has a 6mm deflection when pushed mid way between both pulleys.

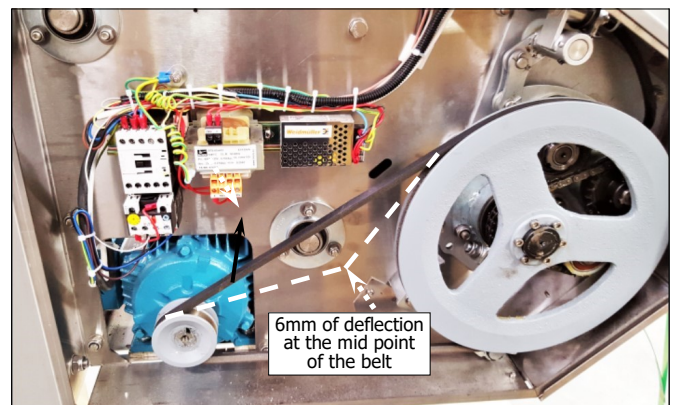


Figure 6.4.3b

6.4.4 MICROSWITCH POSITION - ADJUSTING

- 1) Gain access to the microswitch.
- 2) The Stop Bar Microswitch is accessed by removing front cover panel (refer 6.3.5).
- 3) The Lightspeed Mouth Guard Microswitch is accessed by removing the right hand side panel and microswitch cover (refer 6.3.6).
- 4) Loosen nuts securing micro switch to it's mounting bracket, and adjust it's position.
- 5) Tighten micro switch nuts and test it's operation.

6. SERVICE PROCEDURE

6.4.5 TOP SHEETING ROLLER SCRAPER POSITION

- 1) Remove left hand and right hand side panels (refer 6.2.1), and front cover (refer 6.2.3).
- 2) Adjust position of scraper by slackening 2 screws on either side. Adjust scraper until it is positioned parallel with sheeting roller, tighten 2 screws on either side.

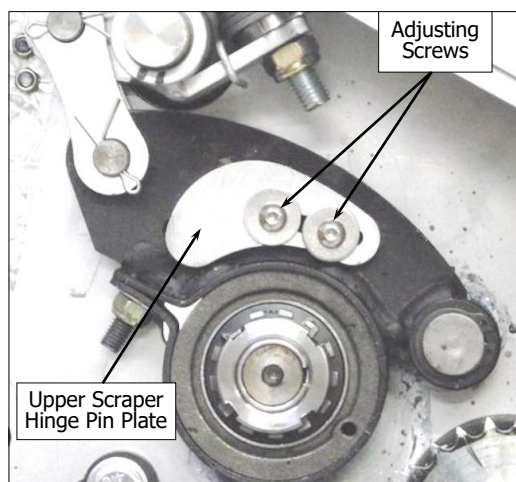


Figure 6.4.5

6.4.6 BOTTOM SHEETING ROLLER SCRAPER POSITION

- 1) Remove tray from underside of appliance.
- 2) Disconnect bottom scraper tension spring on LH side of bottom scraper.
- 3) Loosen two screws securing each bottom scraper mounting plate.

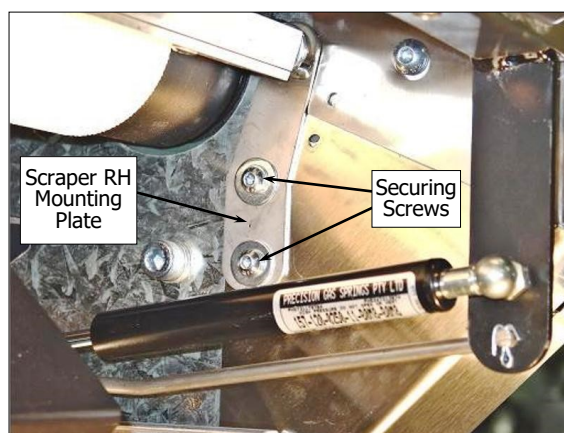


Figure 6.4.6a

- 4) Adjust position of scraper by adjusting mounting plates. When scraper is positioned parallel with sheeting roller, tighten screws.

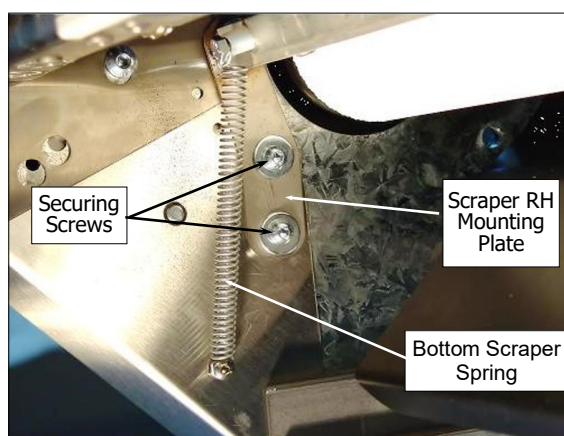
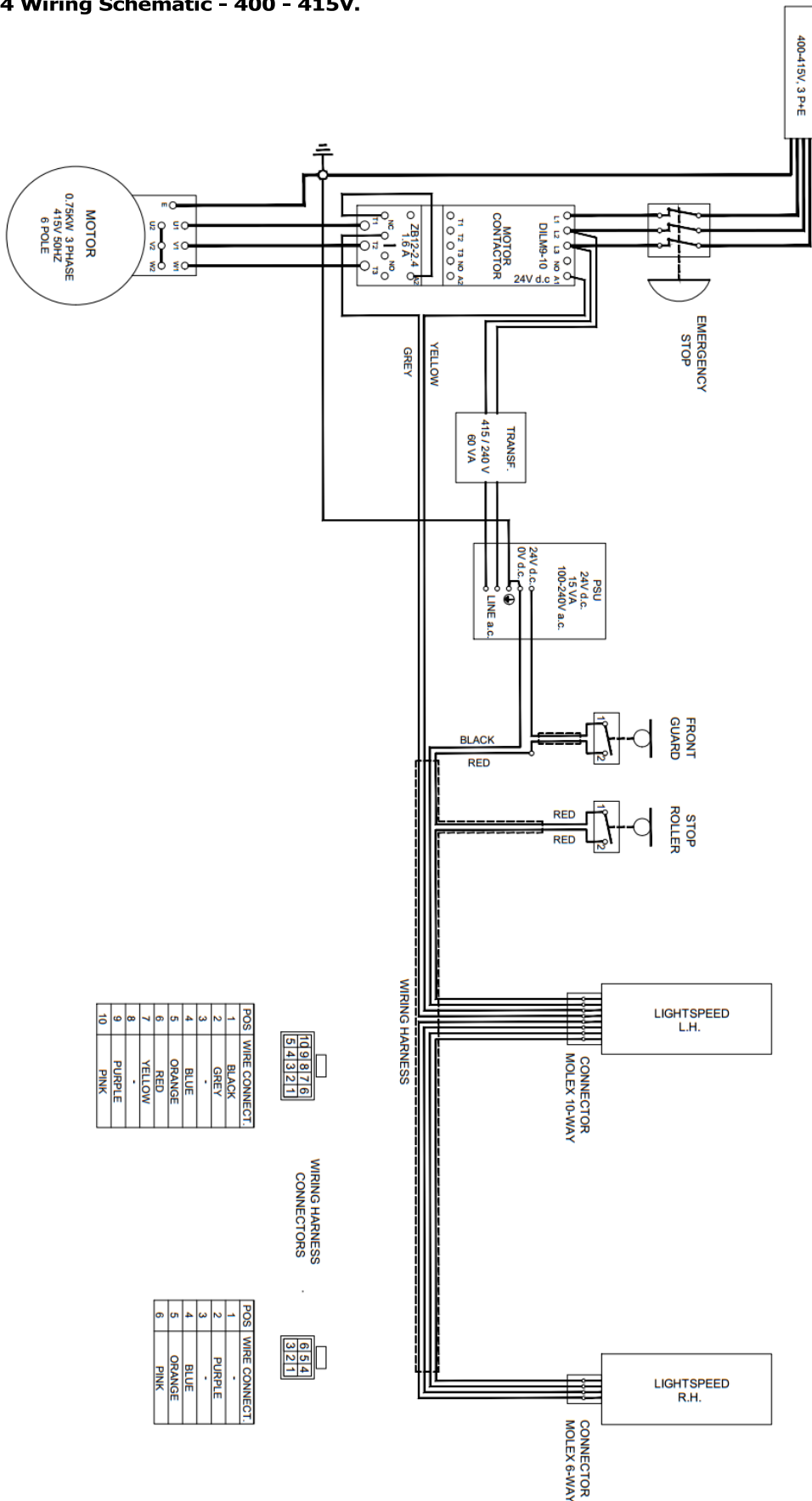


Figure 6.4.6b

- 5) Re-connect bottom scraper tension spring to attachment point on LH side of bottom scraper.
- 6) Refit tray to underside of appliance.

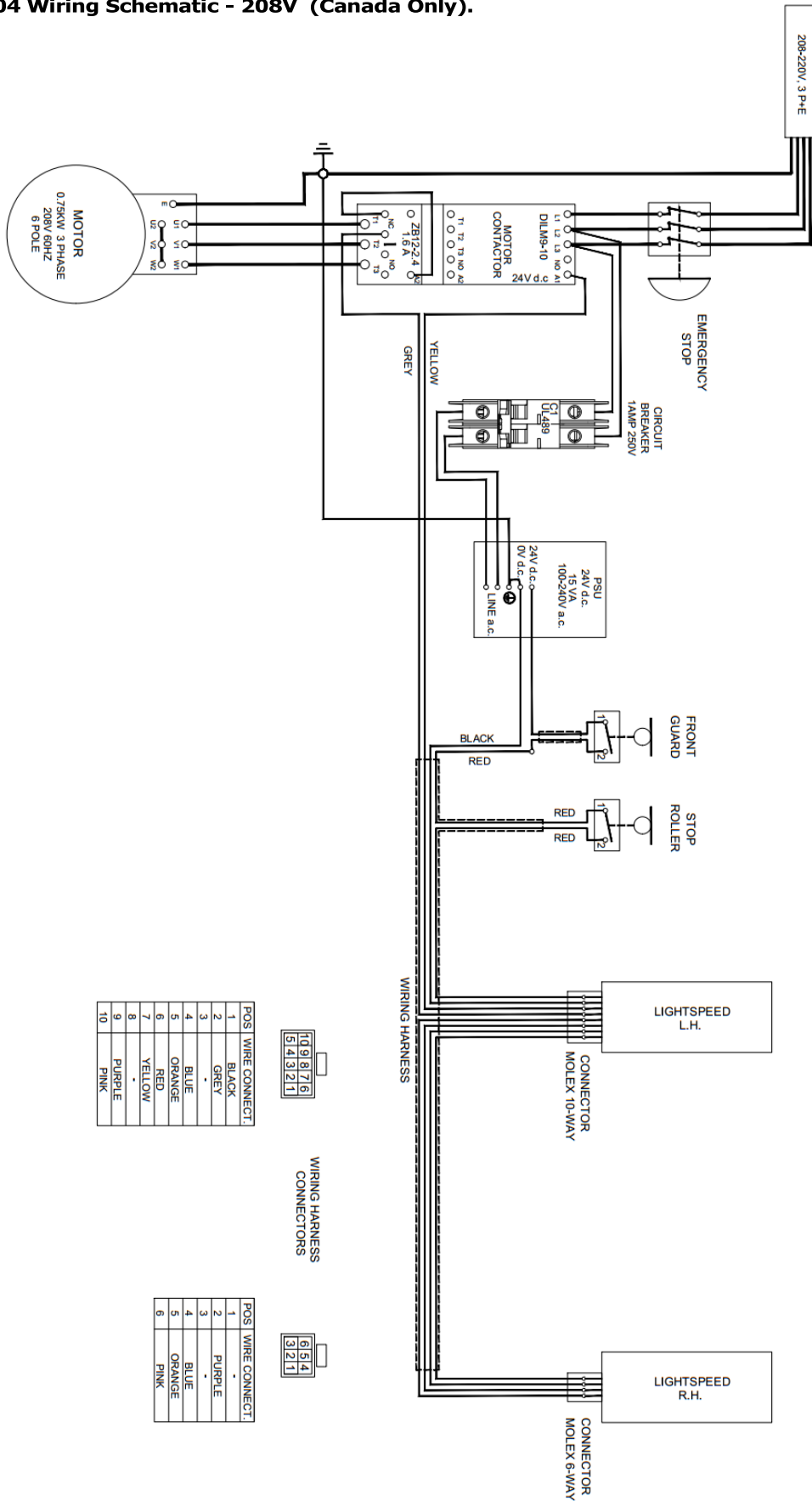
7. ELECTRICAL WIRING DIAGRAM

VM404 / VM704 Wiring Schematic - 400 - 415V.



7. ELECTRICAL WIRING DIAGRAM

VM404 / VM704 Wiring Schematic - 208V (Canada Only).



8. PARTS DIAGRAMS

8.1 MOULDER MAIN ASSEMBLY



8. PARTS DIAGRAMS

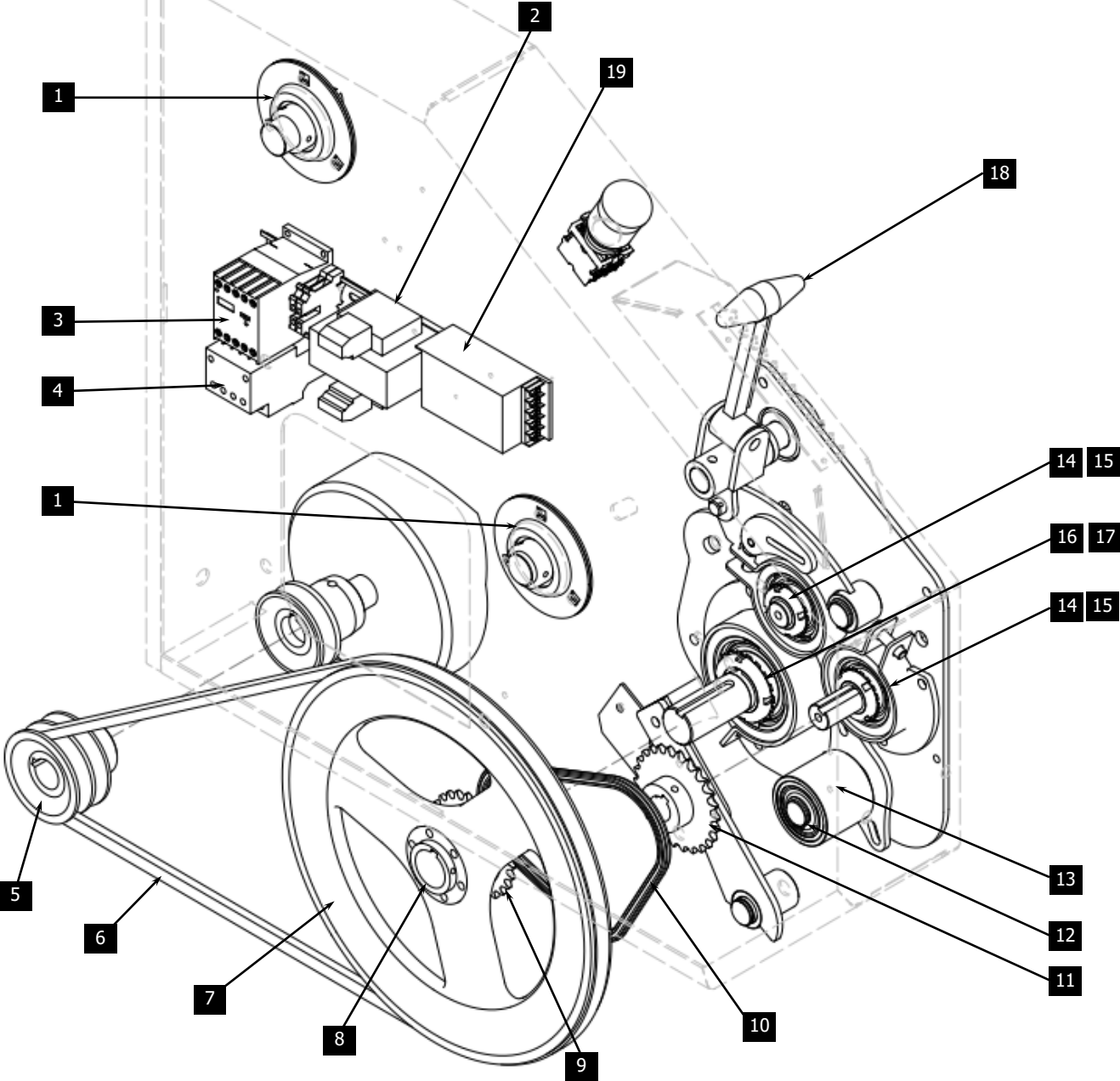
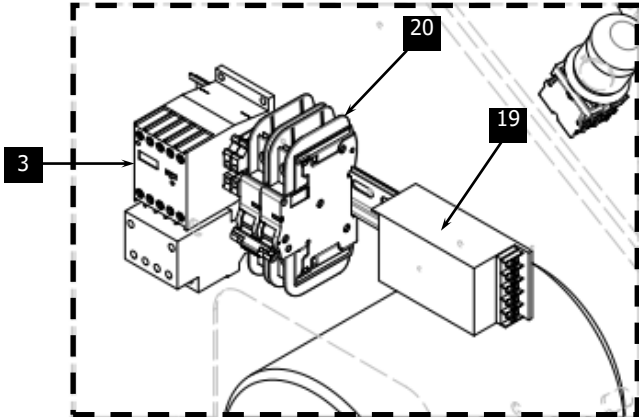
8.1 MAIN ASSEMBLY - PARTS LIST

Item No.	Part No.	Description	VM404	VM704
1	307696	CURLING CHAIN 305mmW x 735mmL 404 VERS 2	•	
	307451	CURLING CHAIN 500mmW x 740mmL 704 VERS 2		•
2	307549	CASTOR SWIVEL 100mm GREY VERS 2	•	•
3	307550	CASTOR SWIVEL 100mm GREY BRAKE VERS 2	•	•
4	307713	CATCH TRAY 404 VERSATILE 2	•	
	307623	CATCH TRAY 704 VERSATILE 2		•
5	306902	BELT 355 x 1660mm 404 VERSATILE 2	•	
	302956	BELT 680 x 1660mm 704 VERSATILE 2		•
6	307627	CATCH TRAY RUNNER VERSATILE 2	•	•
7	308498	FELT 300 x 600 CATCH TRAY 404 VERS 2	•	
	308497	FELT 415 x 740 CATCH TRAY 704 VERS 2		•
8	307516	SAFETY POD LH ATBDSCRXU START SW VERS 2	•	•
	241679	START BUTTON FOR SAFETY POD 307516	•	•
9	307519	SAFETY POD RH ATBDSCTXU STOP SW VERS 2	•	•
	241680	START BUTTON FOR SAFETY POD 307519	•	•
10	308453	GASKET SAFETY POD 6mm EPDM FOAM VERS 2	•	•
11	233865	BADGE MOFFAT	•	•
12	228132	TUBE CLIP	•	•

8. PARTS DIAGRAMS

8.2 MOULDER LEFT HAND SIDE

Canada Only



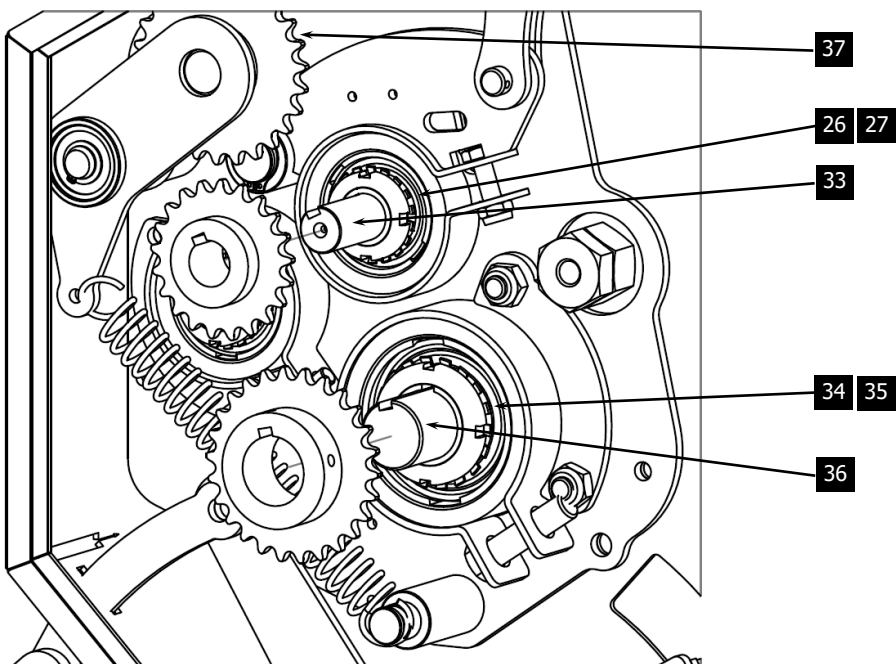
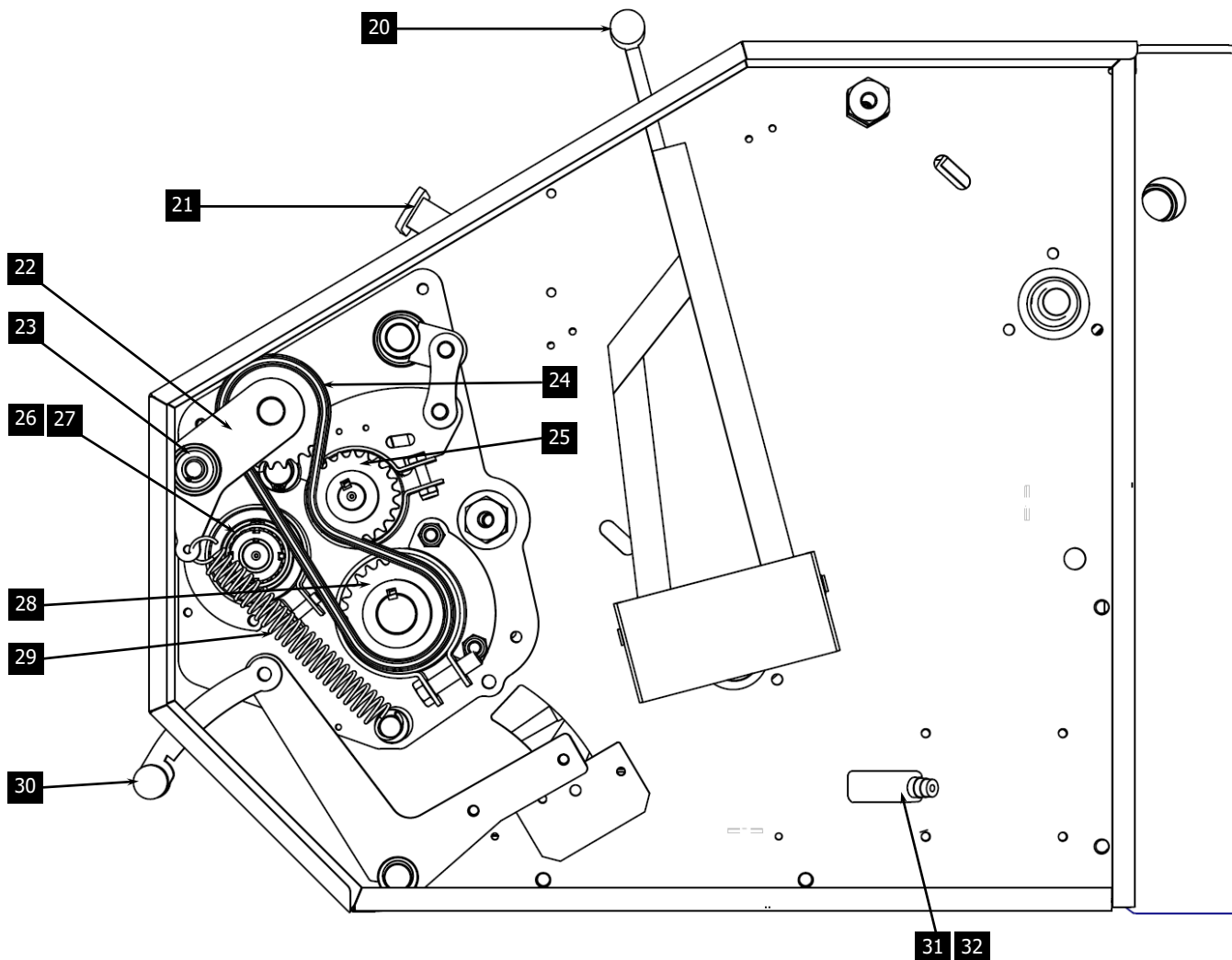
8. PARTS DIAGRAMS

8.2 MOULDER LEFT HAND SIDE - PARTS LIST

Item No.	Part No.	Description	VM404	VM704
1	303043	BEARING UC205 2NS	•	•
2	300508	TRANSFORMER ISOLATING 60VA, 415-240V (up to Ser No. 1690688)	•	•
	16BYQ-ST563	TRANSFORMER ISOLATING 63VA, 415-240V (from Ser No. 31501001)		•
3	306364	CONTR AUX N/O 24V DC DILM9-10	•	•
4	306927	MOTOR OVERLOAD RELAY ZB12 2.4	•	•
5	300199	PULLEY 2-1/2" x 2A 24mm KEYED MR/VM/VERS 2	•	•
	300502	PULLEY 1A 24mm KEYWAY 60Hz (Canada Only)		•
6	308439	V-BELT A56 VERSATILE 2	•	•
7	307448	PULLEY 12-1A c/w SPROCKET (Items 8 & 9)	•	•
8	308432	<i>PULLEY DRIVE 12-1A AL MACHINED VERS 2</i>	•	•
9	308405	<i>SPROCKET 3/8" BS 26T C BLACK PHOS VERS 2</i>	•	•
10	308441	CHAIN 3/8BS 53 PITCH+JOINR DSIDE	•	•
11	308404	SPROCKET 3/8" BS 26T B	•	•
12	300222	BEARING 6204 2NS	•	•
13	362396	ROLLER CHAIN TENSIONER VM M620	•	•
14	303004	BEARING UK205 2NS	•	•
15	308447	BEARING HSG C205 MACHINE OD 69	•	•
16	307639	BEARING UK207	•	•
17	307638	BEARING HSG C207	•	•
18	307442	HANDLE SHEETING ROLLER VERS 2	•	•
---	308468	SPRING - 31mm ID, 2.5mm COIL (Holds Item 18, Handle Sheeting Roller in Gate)	•	•
19	305582	POWER SUPPLY 24V 25W VERS2	•	•
----	308511	WIRING HARNESSLEEX11-ATBDSC VERS 2 (Not Shown)	•	•
20	309553	CIRCUIT BREAKER C1 2P UL489 (Canada Only)		•

8. PARTS DIAGRAMS

8.3 MOULDER RIGHT HAND SIDE



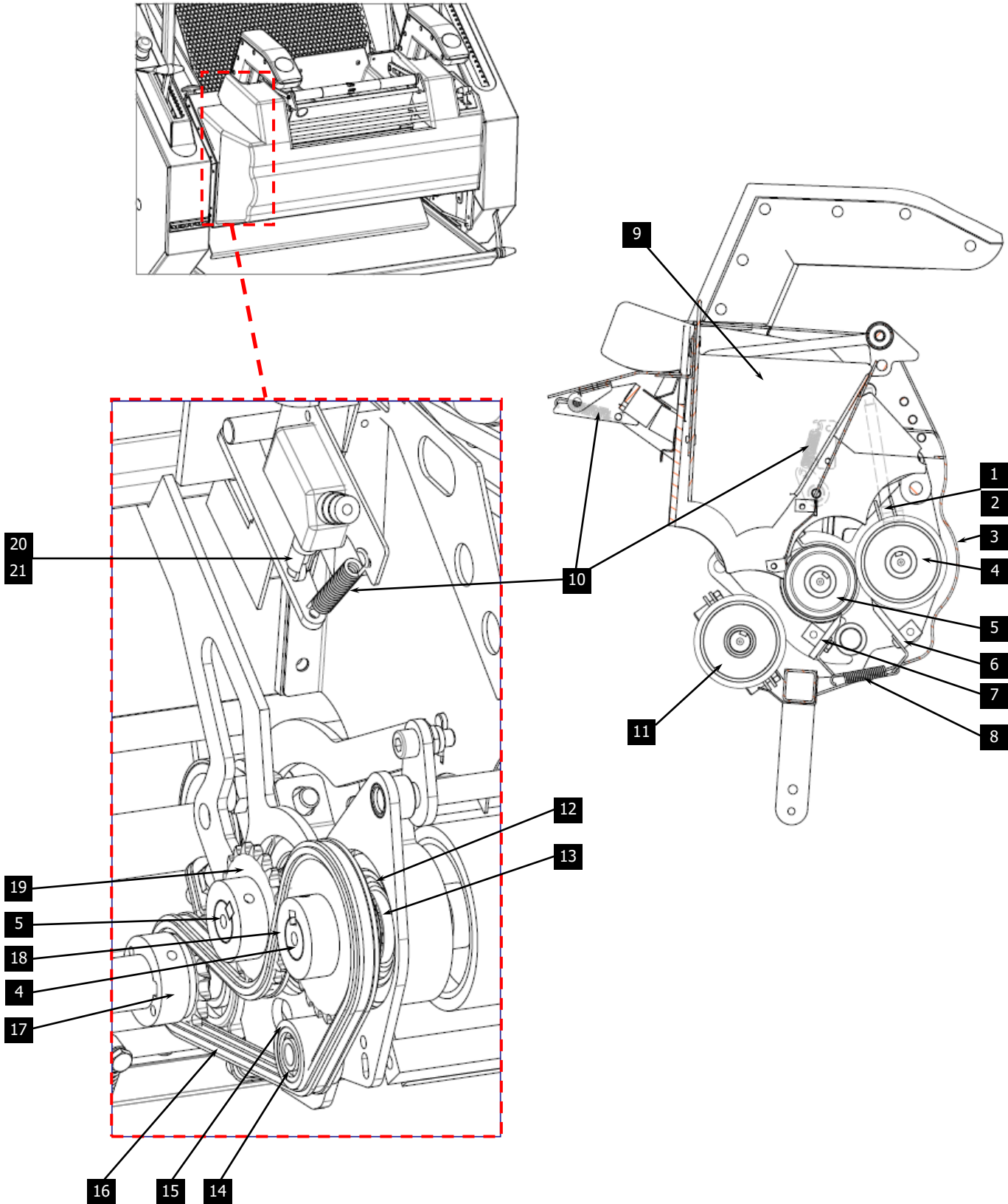
8. PARTS DIAGRAMS

8.3 MOULDER RIGHT HAND SIDE - PARTS LIST

Item No.	Part No.	Description	VM404	VM704
20	307512	HANDLE BACKBOARD OFFSET MOUNT VERS 2	●	●
21	307650	HANDLE WA SIDE GUIDE 704		●
22	307472	CHAIN TENSIONER ARM WA	●	●
23	300221	BEARING 6201 2NS	●	●
24	308442	CHAIN 3/8 BS 65 PITCH+JOINER	●	●
25	308403	SPROCKET 3/8 BS 21T A	●	●
26	308447	BEARING HSG C205 MACHINE OD 69	●	●
27	303004	BEARING UK205 2NS	●	●
28	308407	SPROCKET 3/8 BS 26T E	●	●
29	300337	TENSION SPRING 11mm x 60mm	●	●
30	307513	HANDLE 4-PIECE OPERATOR VERS 2	●	●
31	300273	BOOT LIMIT SWITCH VAP-Y	●	●
32	300274	LIMIT SW ROLLER ARM TM/VM1308	●	●
33	307412	ROLLER WA SHEETING SMALL 704		●
	308414	ROLLER WA 404	●	
34	307639	BEARING UK207	●	●
35	307638	BEARING HSG C207	●	●
36	307411	ROLLER WA BAP LARGE 704		●
	308416	ROLLER WA BAP 404	●	
37	308406	SPROCKET 3/8 BS 26T D Black Phos Vers 2	●	●

8. PARTS DIAGRAMS

8.4 GUARD AND ROLLER ASSEMBLY - VM704 ONLY



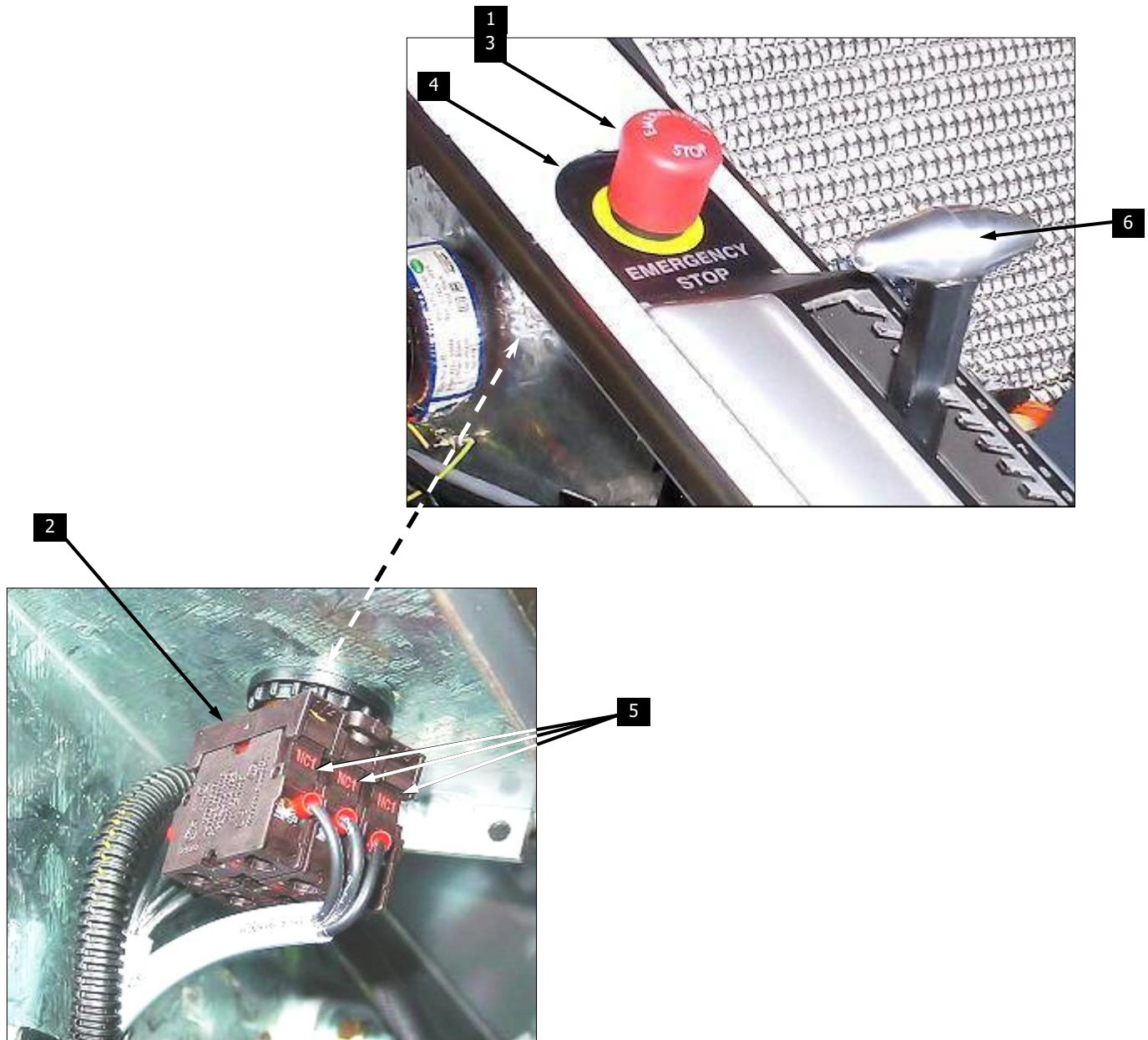
8. PARTS DIAGRAMS

8.4 GUARD AND ROLLER ASSEMBLY - VM704 ONLY - PARTS LIST

Item No.	Part No.	Description	VM704
1	308482	BOSS BAP HANDLE VERS 2 TECHNOBAKE	•
2	307607	SPRING TORS BAP HANDLE VERS 2	•
3	368800	COVER MUOLDER 704 BAP F/GLASS VERS 2	•
4	308413	ROLLER WA BAP LARGE 704	•
5	308412	ROLLER WA BAP SMALL 704	•
6	308426	SCRAPER MACHINED BAP LGE VM704	•
7	308411	SCRAPER MACHINED BAP SMALL VM704	•
8	300514	SPRING TEN BAP SCRAPER 704 VERS 2	•
9	309360	INLET CHUTE MOLDED WHITE 704	•
10	300509	SPRING TENS SAFETY GUARD VERS 2	•
11	307413	ROLLER WA BAP LARGE 704	•
12	308447	BEARING HSG C205 MACHINE OD 69	•
13	303004	BEARING UK205 2NS	•
14	303036	BEARING 6000 2 Contact Seal	•
15	308842	ROLLER IDLER BAP 704	•
16	308464	CHAIN 3/8 BS 59 PITCH+JOINER VERS 2	•
17	307646	SPROCKET 3/8 BS 16T 25mm BORE VERS 2	•
18	308404	SPROCKET 3/8 BS 26T B	•
19	308403	SPROCKET 3/8 BS 21T A	•
20	300274	LIMIT SW ROLLER ARM TM/VM1308	•
21	300273	BOOT LIMIT SWITCH VAP-Y	•

8. PARTS DIAGRAMS

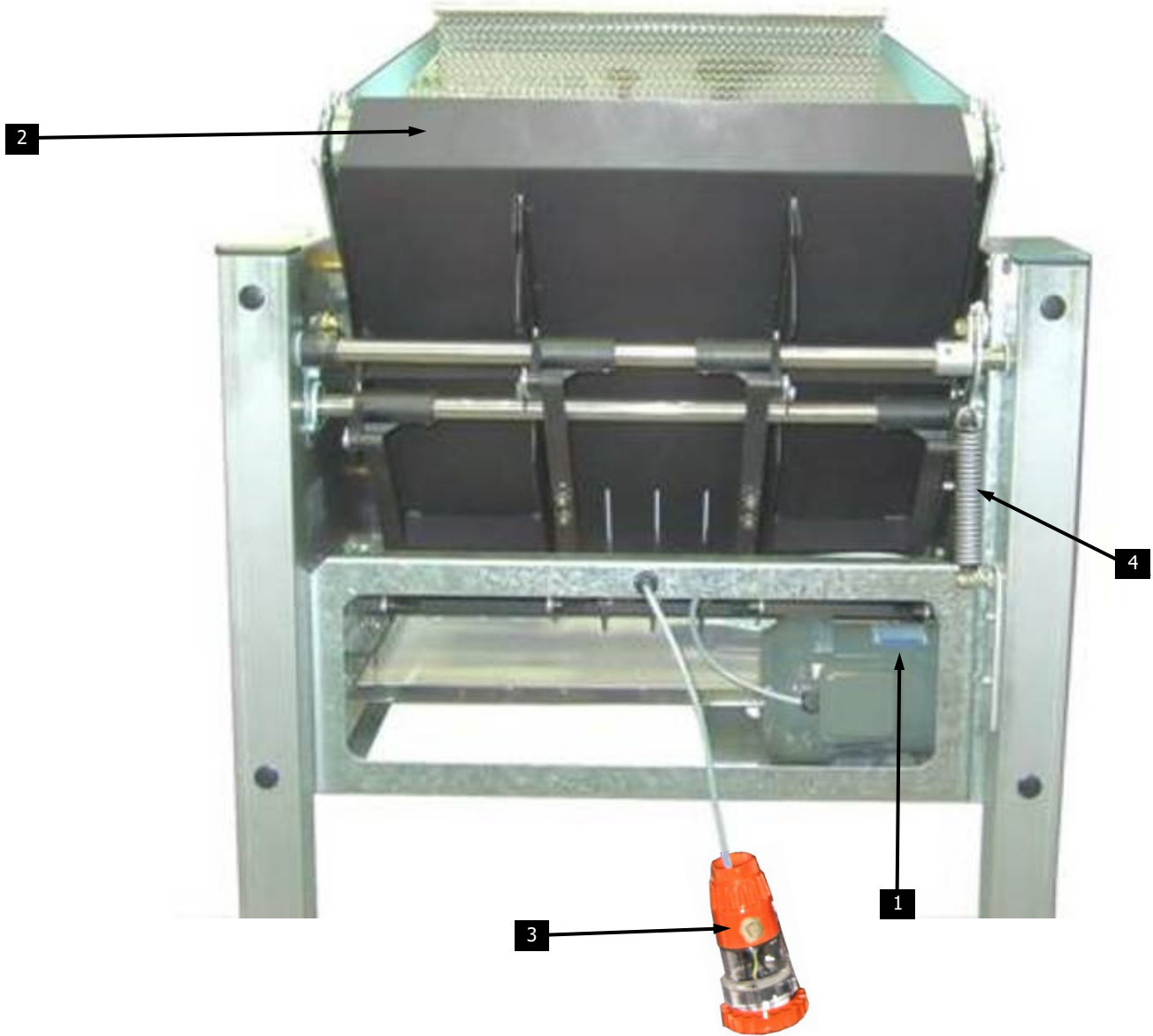
8.5 EMERGENCY STOP - PUSH BUTTON



Item No.	Part No.	Description	VM404	VM704
1	302649	PUSH BUTTON EMERG STOP M22-PV	•	•
2	302644	PUSH BUTTON ADAPTOR M22-A	•	•
3	306333	PUSH BUTTON EMERG STOP STAMPED	•	•
4	308863	DECAL E-STOP VERS 2	•	•
5	302645	CONTACT ELEMENT N/C M22-K01	•	•
6	307442	HANDLE SHEETING ROLLER VERS 2	•	•

8. PARTS DIAGRAMS

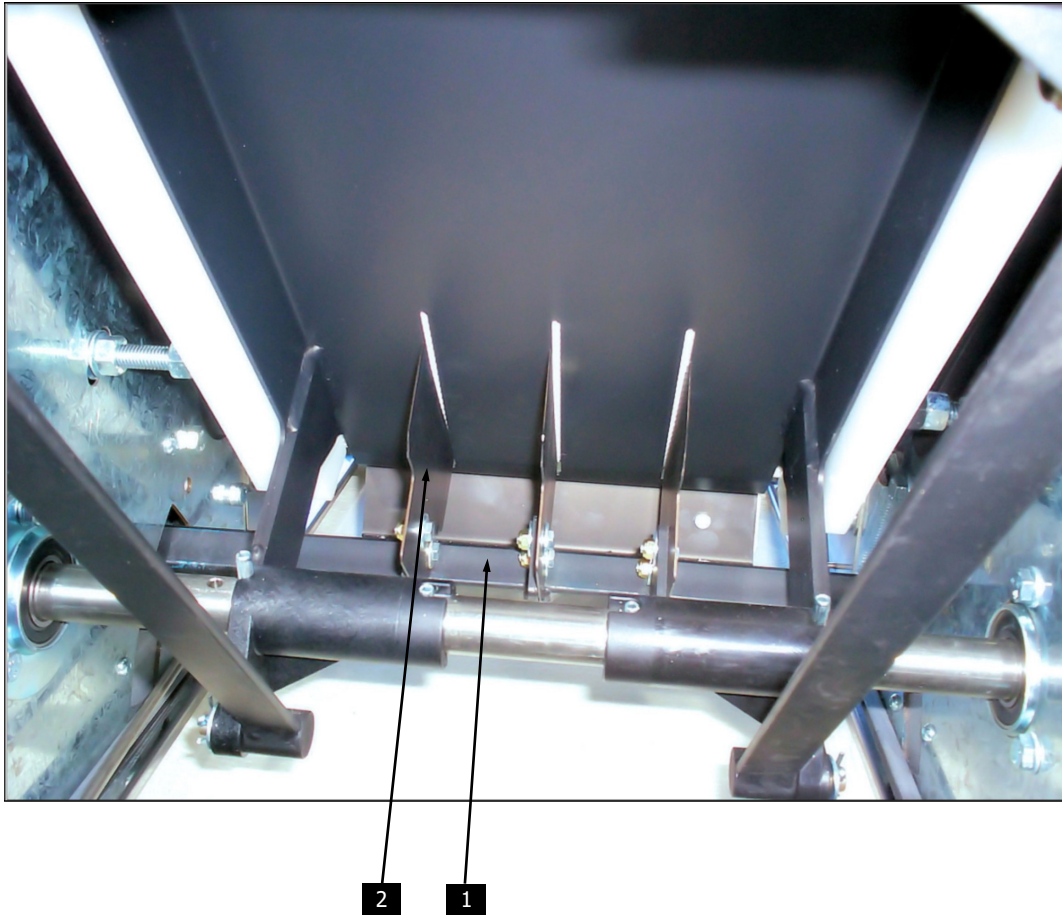
8.6 REAR OF MOULDER



Item No.	Part No.	Description	VM404	VM704
1	300495	MOTOR 0.75kW 6 POLE MOLDER (Up to Serial No. 1690688).	•	•
	16MDLVM704-01	(From Serial No. 31501001).	•	•
	305271	MOTOR 0.75kW 3P, 208V, 60Hz MOLDER 6 POLE (Canada Only)		•
2	307692	BACKBOARD WA 404 MOLDER TEFLON BLACK	•	
	307599	BACKBOARD WA 704 MOLDER TEFLON BLACK		•
	309547	BACKBOARD WA 704, 70mm TEFLON BLACK (Canada Only)		•
3	300484	PLUG 4 PIN 10A 3PH	•	•
	309554	PLUG NEMA L15 20P, 250V, 20A, 3P + GND (Canada only)		•
4	305478	SPRING	•	•

8. PARTS DIAGRAMS

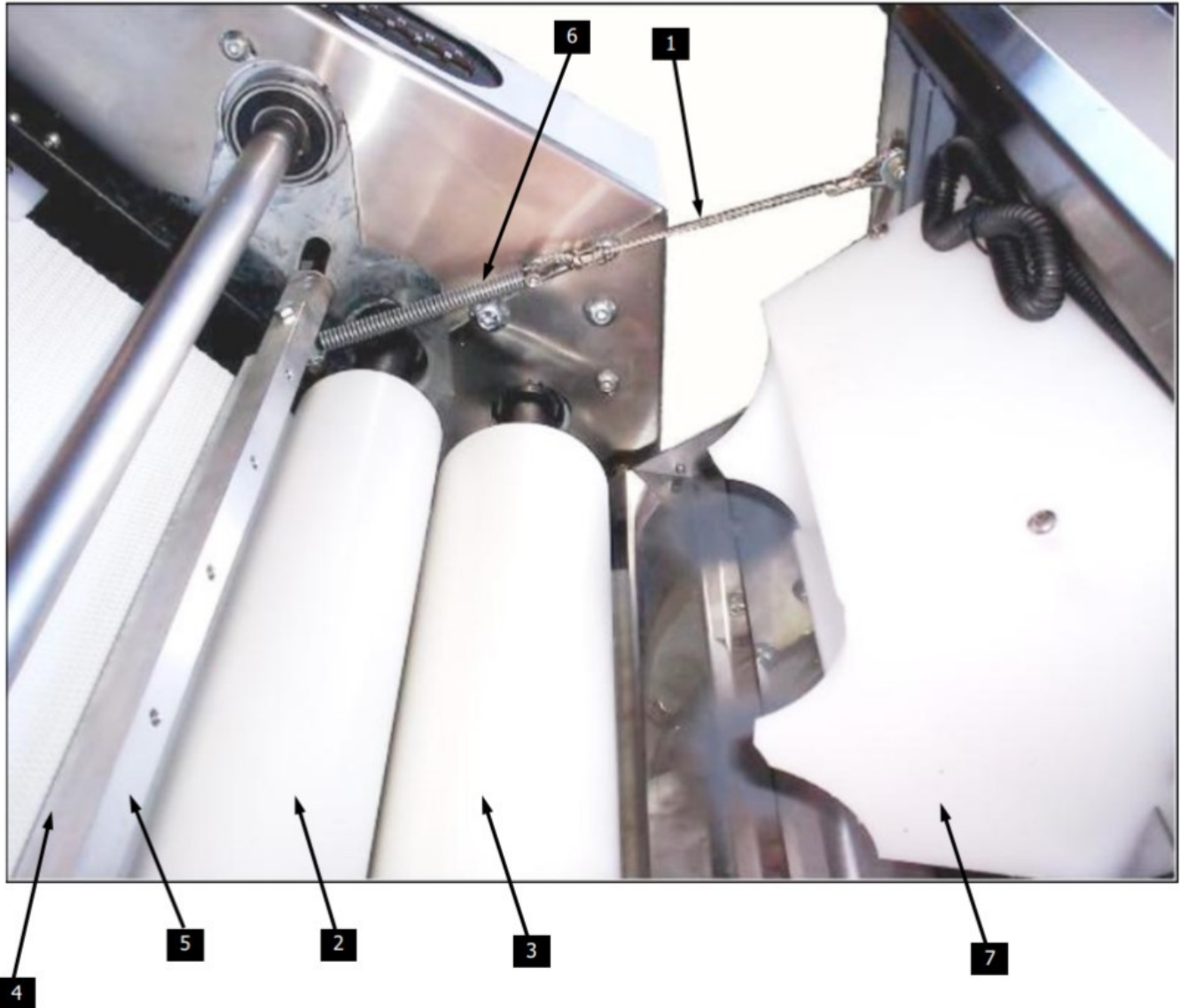
8.7 FOUR PIECE BLADES ASSY



Item No.	Part No.	Description	VM404	VM704
1	307697	BLADE HOLDER WA 4-PIECE 404 VERS 2 (Up to Ser No. 1690688)	•	
	307526	BLADE HOLDER WA 4-PIECE 704 VERS 2 (Up to Ser No. 1690688).		•
	S307526-2	BLADE HOLDER (From Ser No. 31501001).	•	•
	309551	BLADE HOLDER (Canada Only) .		•
2	307455	BLADE 4-PIECE TEFLON COAT BLACK VERS 2	•	•

8. PARTS DIAGRAMS

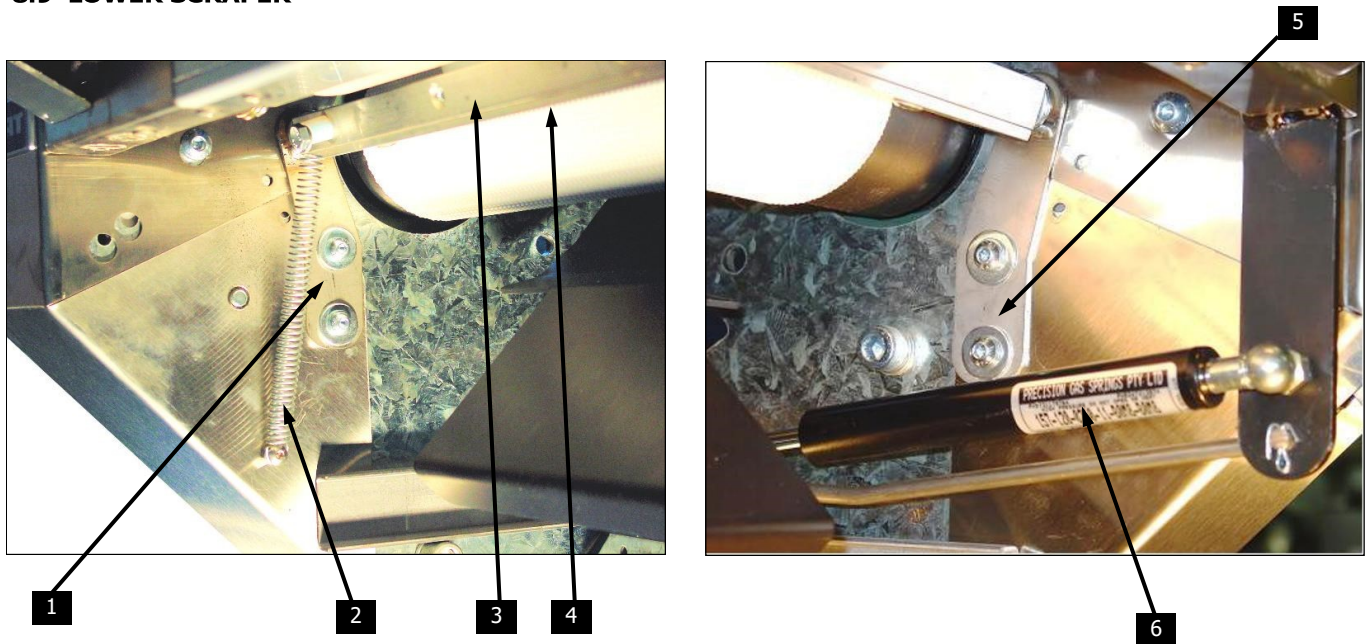
8.8 SHEETING ROLLERS and UPPER SCRAPER



Item No.	Part No.	Description	VM404	VM704
1	308543	LANYARD 3.2mm SS VERSATILE 2	•	
2	308414	ROLLER WA SHEETING SMALL 404 VERS 2	•	
	307412	ROLLER WA SHEETING SMALL 704 VERS 2		•
3	308415	ROLLER WA SHEETING LARGE 404 VERS 2	•	
	307413	ROLLER WA SHEETING LARGE 704 VERS 2		•
4	307715	SCRAPER ASSY TOP COMPLETE 404 VERS 2	•	
	307663	SCRAPER ASSY TOP COMPLETE 704 VERS 2		•
5	308642	SCRAPER TOP UHMWPE 40 x 6 x 300 MACHINED	•	
	300367	SCRAPER TOP UHMWPE 40 x 6 x 500 MACHINED		•
6	300332	TENSION SPRING 11mm x 60mm	•	•
7	368849	CHEEK PLATE LH - Stainless Steel		•
	368850	CHEEK PLATE RH - Stainless Steel		•
	308860	BACK PANEL - UHMWPE		•

8. PARTS DIAGRAMS

8.9 LOWER SCRAPER



Item No.	Part No.	Description	VM404	VM704
1	307670	SCRAPER ADJUSTMENT ARM WA LH VERS 2	•	•
2	300332	TENSION SPRING 11mm x 60mm	•	•
3	307716	SCRAPER ASSY BTM COMPLETE 404 VERS 2	•	
	307664	SCRAPER ASSY BTM COMPLETE 704 VERS 2		•
4	306261	SCRAPER BTM UHMWPE 50x20x300 MACHINED	•	
	302504	SCRAPER BTM UHMWPE 50x20x500 MACHINED		•
5	307671	SCRAPER ADJUSTMENT ARM WA RH VERS 2	•	•
6	302048	GAS STRUT 157-120 0250-11-B0M8-B0M8		•
7	307625	PUSH ROD SWITCH VERSATILE 2	•	•

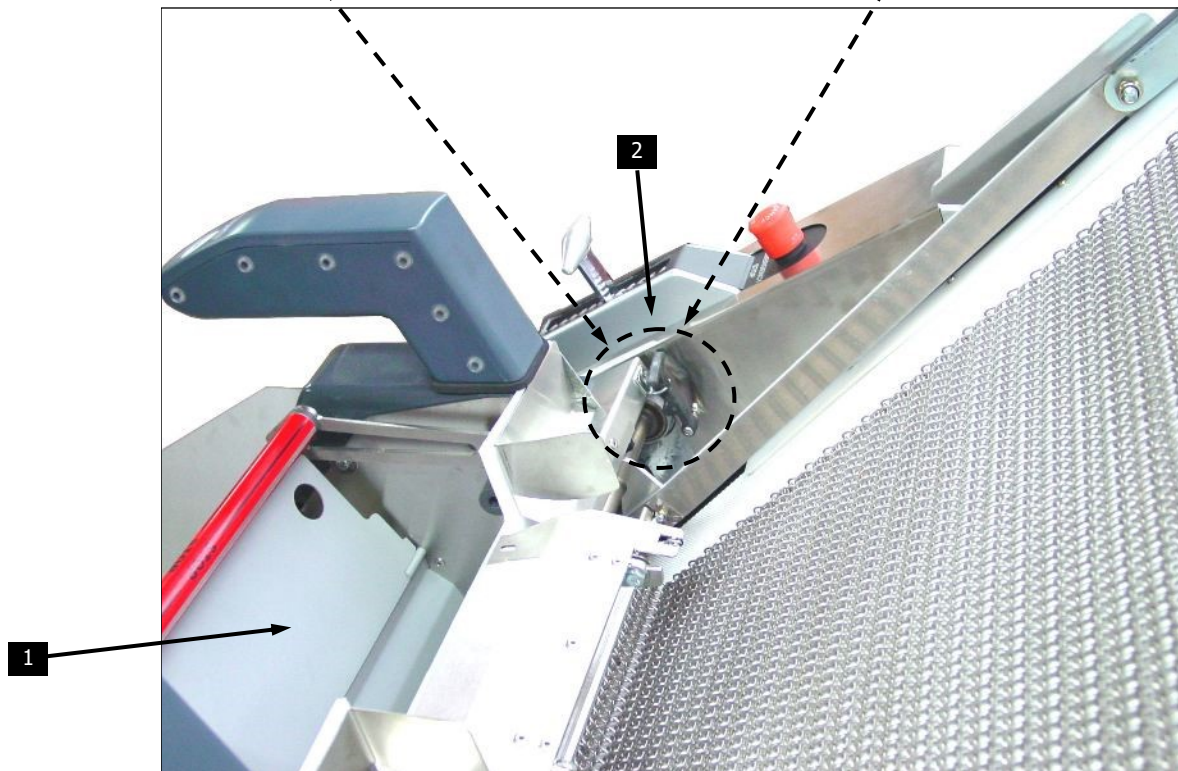
8. PARTS DIAGRAMS

8.10 BAP FLAP (VM704 Only)

Up To Ser. No. 1690688.



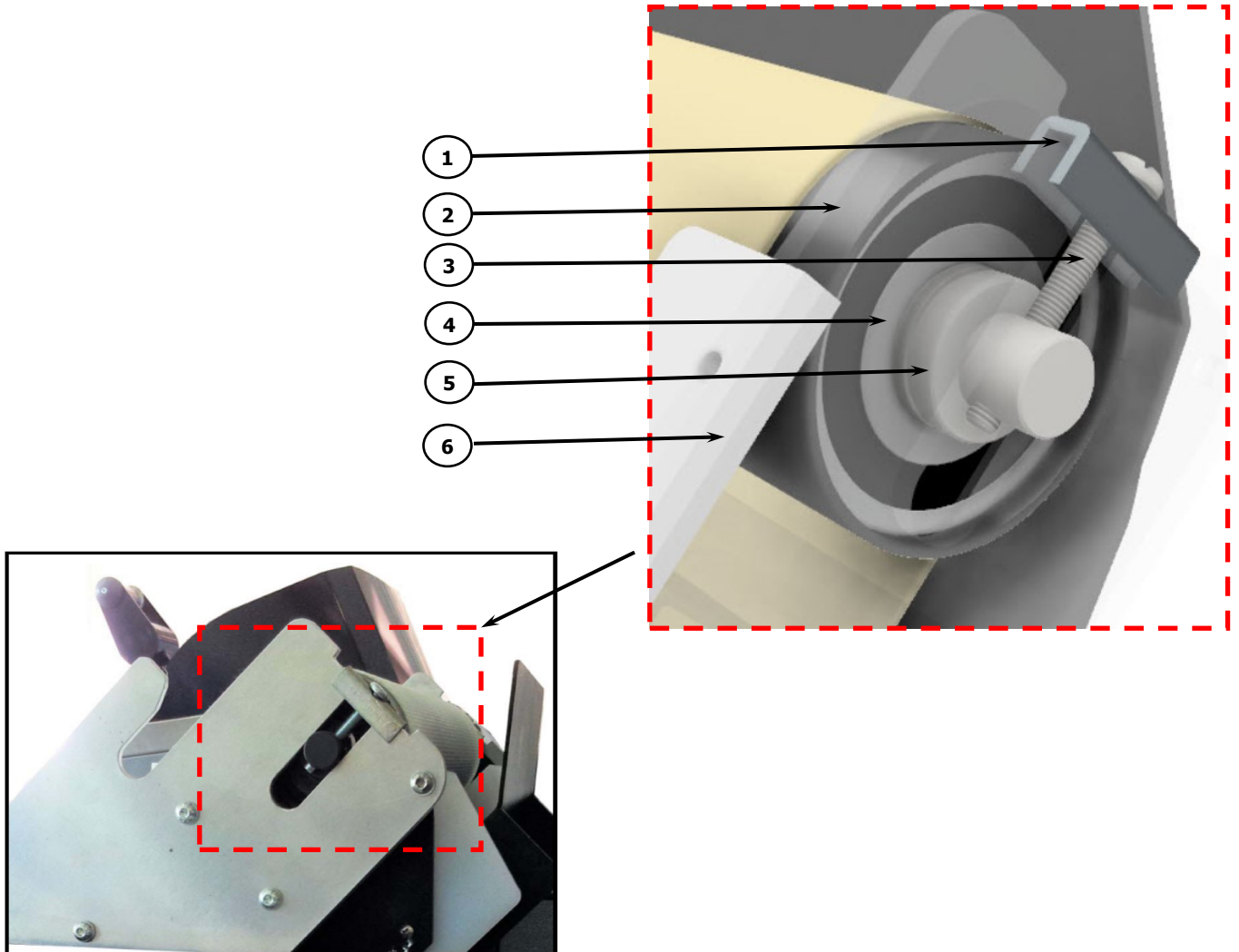
From Ser. No. 31501001.



Item No.	Part No.	Description	VM404	VM704
1	308834	BAP FLAP WA 375x138 704-7 SS VERS 2	--	•
2	305563	'T' HANDLE & CATCH PLATE (Up To Ser. No. 1690688.	•	•
	15BSL70R	GUARD CATCH & CATCH PLATE (From Ser. No. 1501001.	•	•

8. PARTS DIAGRAMS

8.11 TOP BELT ROLLER (VM404 and VM704)



Item No.	Part No.	Description	VM404	VM704
1	300411	CAP SHAFT ADJUSTER - MOULDER ZP	•	•
2	307597	ROLLER CASSETTE IDLER ZP - 704		•
	308417	ROLLER CASSETTE IDLER ZP - 404	•	
3	470110	SCREW PAN HD M6 x 50 ZP	•	•
4	300233	BEARING 6360 2NS	•	•
5	377598	SHAFT CASSETTE IDLER ROLLER - 704		•
	378466	SHAFT CASSETTE IDLER ROLLER - 404	•	
6	307481	BELT GUIDE UHMWPE - 404 / 704	•	•

9. SERVICE CONTACTS

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