

# THE ATWOOD ROTARY KNIFE DIVIDER

AUTOMATIC BAGEL DIVIDING

MODEL: RK2001

(INCLUDES RK2100 SERIES MACHINES)

## OPERATIONS AND SAFETY MANUAL

INCLUDING PARTS CATALOG  
AND MAINTENANCE INSTRUCTIONS

MODEL No. BD-BF250

SERIAL No.                     

### CAUTION:

Do not operate, clean or service this machine until you read this manual, and are familiar with the safety instructions in this manual and those on the labels on the machine. Keep this manual and other materials delivered with the machine, accessible to the operators for easy reference during use...

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IF YOU SHOULD HAVE ANY (?) QUESTIONS ABOUT GUARDS  
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# OWNERS RESPONSIBILITY

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TO MAINTAIN MACHINE AND USER SAFETY, THE RESPONSIBILITY OF THE OWNER IS TO READ AND FOLLOW THESE INSTRUCTIONS:

- FOLLOW ALL INSTALLATION INSTRUCTIONS.
- MAKE SURE INSTALLATION CONFORMS TO ALL APPLICABLE LOCAL, STATE, AND FEDERAL CODES, RULES AND REGULATIONS SUCH AS STATE AND FEDERAL OSHA REGULATIONS AND ELECTRICAL CODES.
- CAREFULLY CHECK THE UNIT FOR CORRECT INITIAL FUNCTION.
- READ AND FOLLOW THE SAFETY INSTRUCTIONS. KEEP THEM READILY AVAILABLE FOR MACHINE OPERATORS.
- MAKE CERTAIN ALL OPERATORS ARE PROPERLY TRAINED, KNOW HOW TO SAFELY AND CORRECTLY OPERATE THE UNIT AND ARE PROPERLY SUPERVISED.
- ALLOW UNIT OPERATION ONLY WITH ALL PARTS INCLUDING SAFETY EQUIPMENT, IN PLACE AND OPERATING SAFELY.
- CAREFULLY INSPECT THE UNIT ON A REGULAR BASIS AND PERFORM ALL MAINTENANCE AS REQUIRED.
- SERVICE AND MAINTAIN THE UNIT ONLY WITH AUTHORIZED OR APPROVED REPLACEMENT PARTS.
- KEEP ALL INSTRUCTIONS PERMANENTLY WITH THE UNIT ALONG WITH ALL DECALS AND WARNING LABELS ON THE UNIT CLEAN AND VISIBLE.

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ONLY USE FACTORY SUPPLIED REPLACEMENT PARTS TO MAINTAIN MACHINE SAFETY, PERFORMANCE AND SANITARY CONDITIONS. USE OF NON-APPROVED PARTS MAY VOID MANUFACTURERS WARRANTY. KNOW YOUR UNIT. COMPARE DIAGRAMS IN THIS MANUAL WITH THE UNIT BEFORE STARTING SERVICE TO OBTAIN MAXIMUM SAFETY AND PERFORMANCE.

#### TO ORDER REPLACEMENT PARTS:

TURN TO PAGE (28) OF THIS MANUAL FOR FURTHER INSTRUCTIONS....

### WARNING

THIS MANUAL CONTAINS CRITICAL SAFETY INSTRUCTIONS. READ AND FOLLOW THEM CAREFULLY. FAILURE TO FOLLOW WARNINGS AND INSTRUCTIONS MAY LEAD TO SERIOUS PERSONAL INJURY. THE OWNER IS RESPONSIBLE FOR MAINTAINING THE UNIT, ITS INSTRUCTIONS AND DECALS FOR OPERATOR REFERENCE. FOR ADDITIONAL COPIES CONTACT A.M. MANUFACTURING: (800) 342-6744....

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# OPERATIONS AND SAFETY MANUAL

## INCLUDING PARTS CATALOG

READ AND FAMILIARIZE YOURSELF WITH THIS MANUAL  
BEFORE OPERATING THIS MACHINE...

## INTRODUCTION

THE MODEL RK-2001 FROM A.M. MANUFACTURING IS A SINGLE BANK, ROTATING KNIFE DIVIDER. IT CAN ACHIEVE OUTPUT SPEEDS OF UP TO 4800 PIECES PER HOUR (DEPENDING ON SIZE), ALLOWING GREATER BAGEL PRODUCTION. ITS VERSATILE YET SIMPLE DESIGN MAKE IT BOTH LABOR SAVING AND COST EFFECTIVE. STUDY THIS OPERATION AND SAFETY MANUAL FOR FULL BENEFITS.

NOTE:

ALL OPERATORS SHOULD BE FULLY TRAINED BEFORE BEGINNING PRODUCTION.

## SPECIFICATIONS

PRODUCTION RATE.....	225 TO 400 DOZEN PER HOUR (DEPENDING ON SIZE)
HEIGHT.....	64"
LENGTH.....	71" (WITH STANDARD INFEED CONVEYOR)
WIDTH.....	18-1/2"
SHIPPING WEIGHT.....	500 lbs.
STANDARD INFEED CONVEYOR LENGTH.....	48"
HEIGHT OF INFEED CONVEYOR LENGTH..... (TO BOTTOM OF CONVEYOR)	37"
ELECTRICAL REQUIREMENTS.....	208/220 VOLT - SINGLE PHASE. (1 H.P. DIVIDER MOTOR)

### OPTIONAL EQUIPMENT

INFEED CONVEYOR LENGTH.....	72"
BF100 BAGEL FORMER	

ALL MOVING PARTS, WITH EXCEPTION OF NECESSARY CONVEYING SURFACES  
ARE COVERED AND GUARDED...

## INSTALLATION INSTRUCTIONS

### LOCATION

SELECT LOCATION CAREFULLY. THE AREA SHOULD PROVIDE THE OPERATOR WITH ENOUGH SPACE TO USE THE EQUIPMENT IN A SAFE MANNER. THE FLOOR AREA SELECTED SHOULD BE EASY TO CLEAN AND SHOULD BE AWAY FROM OIL, GREASE, ETC. AVOID AREAS WHERE BYSTANDERS AND CUSTOMERS MAY BE PRESENT.



### CAUTION

PROPER UNIT INSTALLATION IS NECESSARY FOR SAFE USE AND EFFICIENT OPERATION. PROPER INSTALLATION ALSO HELPS PROTECT THE UNIT FROM DAMAGE AND MAKES SERVICE EASIER.

# SAFETY

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This machine is designed to provide for safe operation if normal operating procedures and safety messages located on the machine and in this manual are followed...



This is a safety alert symbol. You will find it on various safety labels on the machine and it will also appear in this manual wherever safety messages are given...

## GET FAMILIAR WITH SIGNAL WORDS:

### CAUTION, WARNING & DANGER

**CAUTION:** INDICATES A POTENTIALLY HAZARDOUS SITUATION WHICH, IF NOT AVOIDED, MAY RESULT IN MINOR OR MODERATE INJURY. IT MAY ALSO BE USED TO ALERT AGAINST UNSAFE PRACTICES.

**WARNING:** INDICATES A POTENTIALLY HAZARDOUS SITUATION WHICH, IF NOT AVOIDED, COULD RESULT IN DEATH OR SERIOUS INJURY.

**DANGER:** INDICATES AN IMMINENTLY HAZARDOUS SITUATION WHICH, IF NOT AVOIDED, WILL RESULT IN DEATH OR SERIOUS INJURY. THIS SIGNAL WORD IS TO BE LIMITED TO THE MOST EXTREME SITUATIONS.

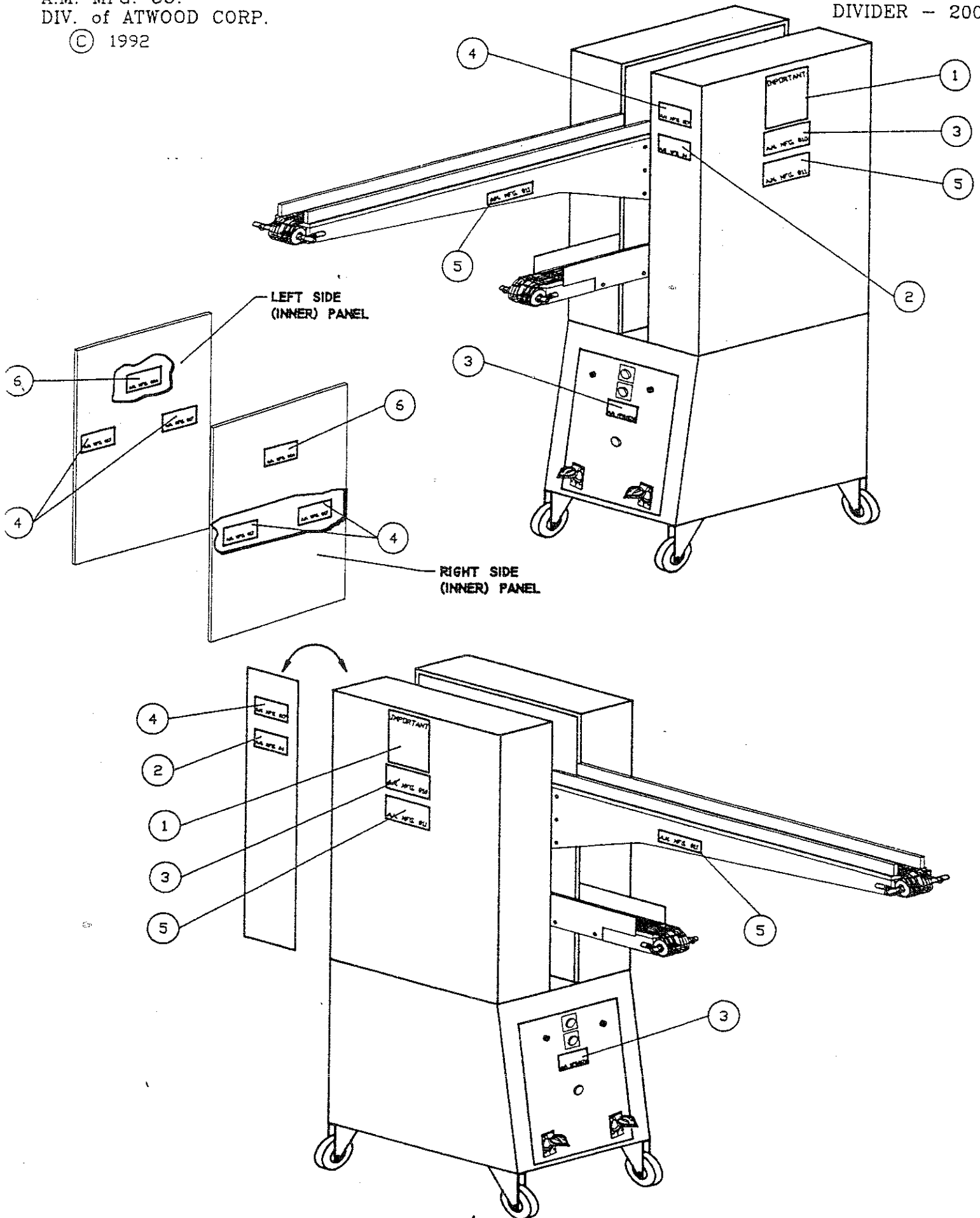
**NOTE:** A NOTE PROVIDES KEY INFORMATION TO MAKE PROCEDURES EASIER AND CLEARER.

# TYPICAL WARNING LABEL LOCATIONS

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ROTARY KNIFE  
DIVIDER - 2001



# WARNING LABELS

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TYPICALLY FOUND ON THE RK2001 KNIFE DIVIDER.

## LOCATION OF WARNING LABELS.

**IMPORTANT SAFETY INFORMATION**

- DO NOT OPERATE THIS MACHINE BEFORE YOU HAVE READ AND UNDERSTAND THE OPERATIONS AND SAFETY MANUAL.
- NEVER LEAVE THIS MACHINE RUNNING UNATTENDED
- NEVER OPERATE THIS MACHINE IF SAFETY GUARDS ARE NOT IN PLACE
- NEVER REMOVE ANY SAFETY GUARDS AND NEVER MAKE ANY OTHER SAFETY EQUIPMENT INOPERATIVE
- NEVER OPERATE THIS MACHINE IF YOU HAVE NOT BEEN TRAINED
- NEVER OPERATE THIS MACHINE IF YOU ARE TIRED, ILL, OR IF YOU ARE ON MEDICATION THAT MAKES YOU TIRED, OR IF YOU ARE UNDER THE INFLUENCE OF ALCOHOL OR DRUGS
- WEAR TIGHT FITTING CLOTHES AND MAKE SURE THAT LONG HAIR OR NECKLACES OR OTHER LOOSE PERSONAL ITEMS DO NOT GET CAUGHT IN THE MACHINE
- MAKE SURE YOU CAN EASILY REACH THE CONTROLS
- ALWAYS DISCONNECT THE MAIN ELECTRICAL POWER SOURCE BEFORE YOU CLEAN, MAINTAIN OR SERVICE THIS MACHINE
- IF YOU HAVE ANY QUESTIONS ABOUT SAFETY, TALK TO YOUR SUPERVISOR OR CALL

A.M. MANUFACTURING  
TOLL FREE 1-(800) 342-6744

(2) QTY.

LEFT SIDE/RIGHT SIDE  
CABINET CASE.

LEFT REAR SIDE/RIGHT FRONT  
OF CABINET CASE.

2

**WARNING**

DO NOT PUT YOUR FINGERS NEAR THE DOUGH CUTTING KNIFE AREA WHILE THE MACHINE IS OPERATING. YOUR FINGER(S) COULD BE SEVERED. THE MACHINE MUST BE DISCONNECTED FROM ALL ELECTRICAL SOURCES BEFORE ANY WORK OR ADJUSTMENTS ARE MADE.

A.M. MFG.#4

(2) QTY.

4

LEFT REAR SIDE/RIGHT FRONT  
SIDE OF CABINET CASE.

LEFT SIDE/RIGHT SIDE  
INNER PANELS (ABOVE)  
DISCHARGE CONVEYOR.

**DANGER**

ROTATING BLADE HAZARD  
CAN CUT OFF FINGERS OR  
CAUSE SERIOUS INJURIES.  
STAY CLEAR OF BLADE AREA  
WHEN OPERATING.  
DISCONNECT POWER WHEN  
SERVICING UNIT.

(6) QTY.

**DANGER**

HAZARDOUS VOLTAGE.  
WILL SHOCK, BURN,  
OR CAUSE DEATH

DISCONNECT ALL ELECTRICAL POWER  
BEFORE REMOVING PROTECTIVE SHIELDS  
OR TOUCHING ELECTRICAL EQUIPMENT  
WHILE SERVICING OR CLEANING THIS  
MACHINE.

(2) QTY.

FRONT ELECTRICAL PANEL

LEFT SIDE/RIGHT SIDE  
CABINET CASE.

6

LEFT SIDE/RIGHT SIDE  
INNER PANELS ON SPROCKET  
SIDES OF PANEL

**DANGER**

EXPOSED CHAIN AND  
GEARS. CAN CAUSE SERIOUS  
INJURIES.  
STAY AWAY WHEN CHAIN IS  
MOVING.

(2) QTY.

5

**WARNING**

ALL GUARDS AND SAFETY SHIELDS MUST BE IN PLACE  
BEFORE STARTING MACHINE. NEVER OPERATE THIS  
MACHINE WITHOUT SAFETY SHIELDS IN PLACE. DO  
NOT CHANGE THIS MACHINE IN ANY WAY TO INTERFERE  
WITH OR ELIMINATE THESE ESSENTIAL SAFETY FEATURES.

A.M. MFG.#13

(4) QTY.

LEFT SIDE/RIGHT SIDE  
CABINET CASE.

LEFT SIDE/RIGHT SIDE  
INFEED CONVEYOR

NOTE:

MACHINE DESIGN AND SPECIFICATIONS MAY  
VARY. ACTUAL LABEL DESIGN AND PLACEMENT  
SUBJECT TO CHANGE WITHOUT NOTICE AND  
MAY VARY FROM THIS ILLUSTRATION.

IF ANY SAFETY LABELS ARE MISSING,  
THEY MUST BE REPLACED!

CONTACT YOUR DEALER OR A.M. MFG. FOR  
REPLACEMENT. CALL (708) 841-0959....

# SAFETY RULES



**IMPORTANT:** Read and follow these safety rules. They are for your protection and the protection of those working with you

- DO NOT operate this machine before you read and understand the Operations and Safety Manual
- Follow all instructions during use of the machine
- Leave all guards in place. Install all guards if they were removed for cleaning, maintenance, repair or other reasons
- NEVER operate the machine with any SAFETY guard(s) missing
- NEVER operate the machine if you have NOT been trained to operate the machine properly
- NEVER operate the machine if you are tired, ill, on medication, or under the influence of alcohol or drugs
- Wear tight fitting clothes. Make sure that long hair, jewelry, or loose personal items are secured so they cannot get caught in the machine. This can lead to serious injuries
- Make sure you can easily reach all controls. If not, a stable and safe elevated platform or other work-aid must be provided
- ALWAYS disconnect the main electrical power source before cleaning, if maintenance or service is performed, or if the machine is out of service
- NEVER clean bagel forming belt on machine, always remove belt from machine to clean or service (WHEN APPLICABLE)
- NEVER leave this machine running unattended

**IMPORTANT:** If you have any questions about these safety rules, see your supervisor or call A.M. Manufacturing Co. toll free: (800) 342-6744



# OPERATING INSTRUCTIONS

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DIVIDER - 2001

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## ! WARNING:

UNIT MUST BE PROPERLY OPERATED AND MAINTAINED TO PREVENT MACHINE DAMAGE OR PERSONAL INJURY. REVIEW INSTRUCTIONS WITH ALL EMPLOYEES BEFORE USE...

## IMPORTANT:

### MAGNETIC REED SWITCH (PART No. K505ES).

THESE PARTS ARE LOCATED ON (3) THREE AREAS OF THE MACHINE, AS DESCRIBED ON PAGES 16, 17 & 25. THE LOCATIONS ARE AS FOLLOWS: RIGHT AND LEFT SIDES OF BASE CABINET FRAME, INSIDE RIGHT AND LEFT SIDE CASES / BASE OF REAR CABINET DOOR AND FRAME.

THESE SWITCHES ARE LOCATED AT POINTS ON THE MACHINE WHERE EASY ACCESS IS KNOWN. IF THE CONTACT BETWEEN THE (2) TWO REED SWITCHES IS BROKEN OR DISRUPTED IN ANY WAY, THIS WILL AUTOMATICALLY DISCONNECT POWER TO THE MACHINE AND THE MACHINE WILL NOT RUN. TO AVOID THIS PROBLEM, LEAVE SIDE PANELS ON THE MACHINE AND KEEP REAR DOOR CLOSED AT ALL TIMES WHILE MACHINE IS RUNNING.

## I PRELIMINARY START-UP PROCEDURE

1. PLUG POWER CORD INTO PROPER RECEPTACLE.
2. INSPECT MACHINE FOR ANY DAMAGES.

## II OPERATION OF DIVIDER

1. SET WEIGHT AND SPEED CONTROLS TO 50% (SEE FIGURE 2).
2. HAVE YOUR DOUGH READY NEXT TO MACHINE AND COVER TO AVOID SURFACE SKIN. THIS CAN CAUSE DOUGH TO SLIDE THRU FORMER.
3. HAVE DOUGH ALREADY CUT INTO STRIPS OF APPROXIMATELY 3" DIAMETER, BY A MAXIMUM OF 4 FT. LONG. MAKE SURE THERE IS ABOUT 1/4" OF SPACE BETWEEN THE STRIPS OF DOUGH AND THE SIDE WALLS OF THE CONVEYOR, SO DOUGH DOES NOT CATCH AND BIND.
4. REPEAT STEP 3 AND REPEAT PROCESS.

NOTE:  
FOR MORE ACCURATE RESULTS MAKE SURE THE STRIPS CUT WILL BE PLACED SO THAT THE END OF THE FRONT STRIP IS OVERLAPPING BY THE FRONT OF THE TRAILING STRIP. SEE FIGURE 1.

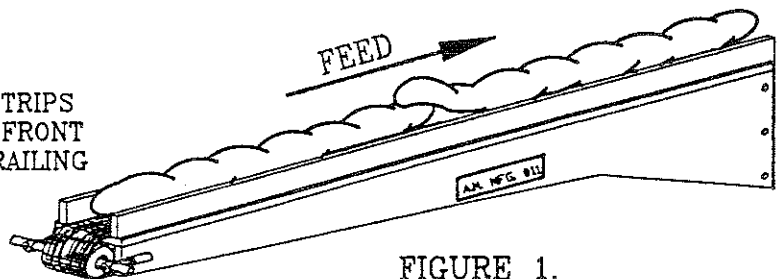


FIGURE 1.

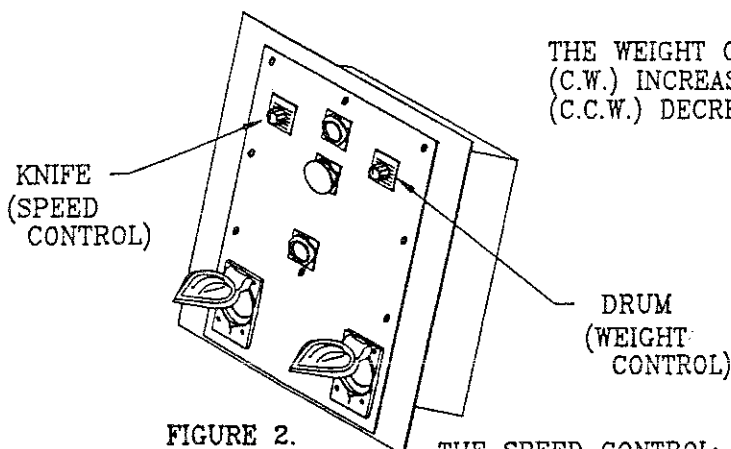


FIGURE 2.

THE WEIGHT CONTROL: TURNING THIS SWITCH CLOCKWISE (C.W.) INCREASES WEIGHT; TURNING IT COUNTER-CLOCKWISE (C.C.W.) DECREASES THE WEIGHT. SEE FIGURE 2.

THE SPEED CONTROL: TURNING THIS SWITCH CLOCKWISE (C.W.) INCREASES PRODUCTION RATE; TURNING IT COUNTER-CLOCKWISE (C.C.W.) DECREASES PRODUCTION RATE. SEE FIGURE 2.

# CLEANING PROCEDURES

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DIVIDER - 2001

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THESE PROCEDURES ARE VERY IMPORTANT TO MAINTAIN  
PRODUCT QUALITY AND MACHINE PERFORMANCE...

## A MESSAGE FROM THE MANUFACTURER:

ALL A.M. MANUFACTURED MACHINES ARE TESTED WITH DOUGH DURING  
THE IN-HOUSE RUN-IN AND QUALITY AUDIT PROCEDURE. ALTHOUGH  
THE MACHINE HAS BEEN CLEANED, SOME EVIDENCE OF DOUGH ON AND  
IN THE MACHINE MAY BE DETECTED. THIS IS NORMAL...

## I DIVIDER



1. DANGER: ALWAYS DISCONNECT ELECTRICAL POWER SOURCE WHEN  
CLEANING, MAINTAINING OR REPAIRING THIS MACHINE...
2. USING A SOAP SOLUTION WIPE DOWN OUTSIDE OF CABINET TO  
EXPOSE ALL WARNING LABELS TO ALERT ALL EMPLOYEES OF ANY  
POSSIBLE HAZARDS.



WARNING: CONVEYOR MAINTENANCE SHALL BE PERFORMED ONLY  
WHEN CONVEYOR IS STOPPED, AND ALL POWER IS  
OFF AND LOCKED OUT...

3. CONTINUE TO WIPE DOWN BOTH CONVEYORS ENTIRELY. THIS IS  
TO REMOVE ANY DOUGH BUILD-UP THAT OCCURS UNDER THE BELTS  
AND ON THE INTERIOR WALLS OF THE CONVEYORS.

NOTE: THIS ALSO HELPS PREVENT BELT SLIPPAGE THAT MAY OCCUR.

4. OPEN REAR INSPECTION DOOR
5. USING A SOAP SOLUTION WIPE DOWN THE DRUM SCRAPER AND  
KNIFE FROM THE EXCESS DOUGH BUILD-UP THAT OCCURS.

NOTE: YOU MAY HAVE TO ACTUALLY SCRAPE SOME DOUGH FROM  
THE DRUM SCRAPER AND KNIFE BY HAND TO THOROUGHLY  
CLEAN THESE COMPONENTS.



### PRACTICE SAFETY FIRST

ALWAYS DISCONNECT ELECTRICAL SERVICE WHEN CLEANING  
OR MAINTAINING THIS MACHINE, THUS AVOIDING CHANCE OF  
SERIOUS INJURIES. MACHINES ARE NOT DANGEROUS IF COMMON  
SENSE IS APPLIED AND THE INSTRUCTIONS ARE CAREFULLY  
FOLLOWED. THINK AND PRACTICE SAFETY FIRST.

# MAINTENANCE PROCEDURES

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THESE PROCEDURES ARE VERY IMPORTANT TO MAINTAIN  
PRODUCT QUALITY AND MACHINE PERFORMANCE...



## PRACTICE SAFETY FIRST

ALWAYS DISCONNECT ELECTRICAL SERVICE WHEN CLEANING OR MAINTAINING THIS MACHINE, THUS AVOIDING CHANCE OF SERIOUS INJURIES. MACHINES ARE NOT DANGEROUS IF COMMON SENSE IS APPLIED AND THE THE INSTRUCTIONS ARE CAREFULLY FOLLOWED. THINK AND PRACTICE SAFETY FIRST.

READ and FOLLOW MAINTENANCE INSTRUCTIONS BELOW TO HELP KEEP THE UNIT IN GOOD OPERATING CONDITION. REFER TO OTHER MATERIALS RECEIVED WITH THE UNIT AND TO SERVICE AND SAFETY BULLETINS FROM THE MANUFACTURER FOR ADDITIONAL INSTRUCTIONS FOR PROPER MAINTENANCE AND SERVICE. REGULAR INSPECTIONS AND PROPER MAINTENANCE ARE ESSENTIAL TO HELP PREVENT ACCIDENTS AND INJURIES.

## II DIVIDER



### DANGER:



**WARNING:** BEFORE MAKING ANY INSPECTION, ADJUSTMENT OR REPAIR, BE CERTAIN POWER SOURCE IS DISCONNECTED AND ALL MOVING PARTS ARE BLOCKED OUT TO PREVENT INJURY. WEAR PROTECTIVE CLOTHING.

- A - MAKE CERTAIN THAT ALL GUARDS AND COVERS ARE IN PLACE.
- B - CHECK FOR WORN, DAMAGED OR MISSING PARTS INCLUDING: BELTS, SAFETY GUARDS AND PROTECTIVE COVERS.
- C - MAKE SURE THAT ALL FASTENERS ARE TIGHTENED SECURELY.
- D - THE TABLE TOP AND OTHER WORKING SURFACES SHOULD BE CLEANED REGULARLY.
- E - ON A DAILY BASIS INSPECT THE UNIT AND CHECK TO BE CERTAIN THAT ALL SYSTEMS ARE OPERATING NORMALLY. DETAILED INSPECTION AND TESTING PROCEDURES ARE SPECIFIED FOR VARIOUS COMPONENTS AT REGULAR INTERVALS. SET UP A CHART AND ASSIGN RESPONSIBILITY FOR THESE ITEMS.



**CAUTION:** REPLACE ANY DAMAGED OR MISSING SAFETY LABELS. THEY ARE AVAILABLE FROM THE MANUFACTURER.

### IMPORTANT:

MAINTENANCE FOR THE ROTARY KNIFE DIVIDER - 2001 ALWAYS BEGINS WITH KEEPING THE MACHINE CLEAN. PROPER CLEANING PROCEDURES CAN BE FOUND ON PAGE ( ) OF THIS MANUAL. STANDARD LONG-TERM MAINTENANCE CONSISTS OF LUBRICATING MAIN WEAR POINTS OF THE MACHINE WITH AN ALL-PURPOSE LITHIUM BASE GREASE. A GREASE GUN WITH A FLEXIBLE HOSE IS NEEDED.

### NOTE:

ALL RECOMMENDATIONS FOR MAINTENANCE, BASED ON A 7 DAY, 8 HR. PER DAY WORK SCHEDULE. HEAVIER WORK SCHEDULES WILL REQUIRE MORE FREQUENT MAINTENANCE.

# MAINTENANCE PROCEDURES

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**! DANGER:** ALWAYS DISCONNECT ELECTRICAL POWER SOURCE WHEN CLEANING, MAINTAINING OR REPAIRING THIS MACHINE...

THE FIRST STEP IS TO REMOVE THE TWO (2) CABINET COVERS (PART# K609C). ONCE YOU HAVE COMPLETED THIS STEP YOU SHOULD BE ABLE TO VIEW ALL FOUR (4) CHAIN DRIVES OF THE MACHINE. TWO (2) CHAINS ON THE LEFT SIDE OF THE MACHINE, ONE (1) ON THE RIGHT SIDE AND ONE (1) FROM THE MAIN DRIVE MOTOR (PART# K502ES).

RIGHT SIDE ASSEMBLY

LOCATE THE RIGHT SIDE OF THE MACHINE (FIGURE 1.). THIS SIDE WILL HAVE THE SINGLE DRIVE CHAIN. YOU WILL NOTICE THE NINE (9) BEARING FLANGES, EIGHT (8) TWO (2) HOLE FLANGES AND ONE (1) FOUR (4) HOLE FLANGE. WITH A GREASE GUN APPLY A SMALL AMOUNT OF GREASE TO THE FITTINGS. YOU WILL ALSO NOTICE A GREASE FITTING COMING OFF (PART# K203RS) NEAR THE MIDDLE OF THIS PANEL. THIS MAKES A TOTAL OF TEN (10) GREASE FITTINGS FOR THE RIGHT SIDE.

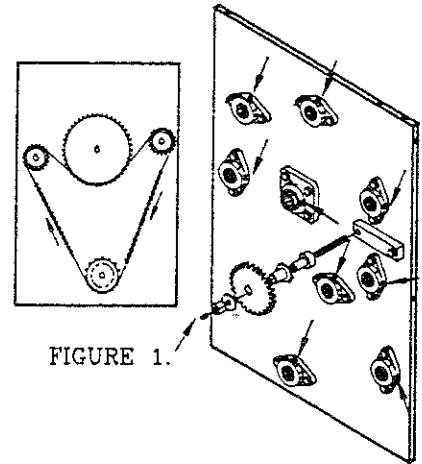


FIGURE 1.

LEFT SIDE ASSEMBLY

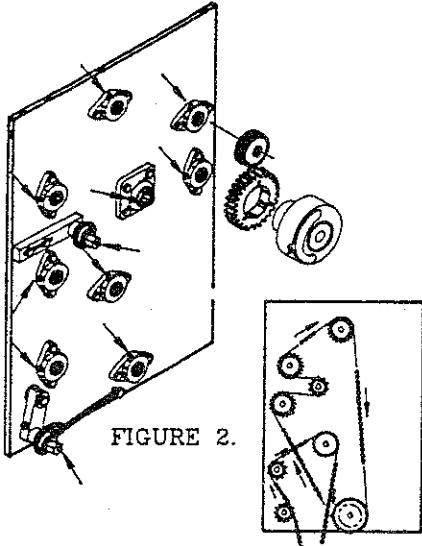
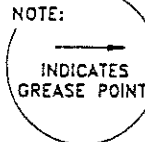


FIGURE 2.



LOCATE THE LEFT SIDE OF THE MACHINE (FIGURE 2.). THIS SIDE WILL HAVE TWO (2) DRIVE CHAINS. REPEAT THE ABOVE STEP FOR ALL FLANGE BEARINGS SINCE THEY ARE IDENTICAL TO THE RIGHT SIDE OF THE MACHINE. ONLY ON THIS SIDE THERE WILL BE TWO (2) MORE GREASE FITTINGS. ONE (1) COMING OFF (PART# K203RS) AND THE OTHER GREASE FITTING COMING OFF (PART# K104LS), THESE ARE BOTH TENSION BARS.

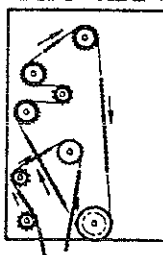
ALL GREASE FITTINGS SHOULD BE GREASED ONCE A WEEK.

THE ROTARY KNIFE DIVIDER - 2001, HAS FOUR (4) DRIVE CHAINS (PART#S K124LS/K125LS/K212RS/K332RA). THESE PARTS MUST BE OILED REGULARLY WITH A LIGHT WEIGHT MACHINE OIL TO PROLONG LIFE OF THE SPROCKETS AS WELL AS THE DRIVE CHAINS. THOROUGHLY LUBRICATE EACH DRIVE CHAIN. THE NORMAL OPERATION OF THE MACHINE WILL EVENLY DISTRIBUTE THE OIL OVER THE ENTIRE CHAIN AND SPROCKETS. THIS PROCEDURE MUST BE REPEATED ONCE A WEEK.

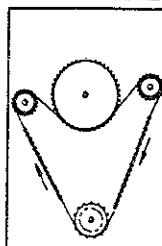
NOTE:

CHAIN CONDITION AND TENSION SHOULD BE CHECKED WHEN OILING PROCEDURE IS ACCOMPLISHED.

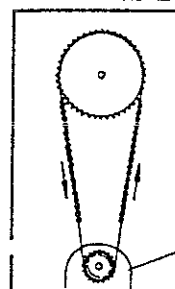
LEFT SIDE



RIGHT SIDE



MAIN DRIVE



MAIN DRIVE MOTOR

# MAINTENANCE PROCEDURES

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## BELT REPLACEMENT

**⚠ WARNING:** CONVEYOR MAINTENANCE SHALL BE PERFORMED ONLY WHEN THE POWER SUPPLY HAS BEEN DISCONNECTED AND LOCKED OUT AND THE CONVEYOR HAS STOPPED.

### DISCHARGE CONVEYOR BELT REPLACEMENT:

TO REPLACE THE DISCHARGE CONVEYOR BELT UNPLUG THE MACHINE FROM ITS PROPER RECEPTACLE TO ENSURE ALL POWER IS OFF.

1. TO LOOSEN THE BELT FOR REMOVAL FIND (PART# 600SC) ROLLER SUPPORT BOLTS WITH (PART# F0601HN) ADJUSTING HEX NUT. TURN ADJUSTING HEX NUT COUNTER CLOCK-WISE. THIS INTERN WILL BRING IN THE ROLLER AND LOOSEN THE BELT. THIS PROCEDURE MUST BE DONE TO BOTH SIDES OF THE BELT. (SEE FIGURE 2.)

FIGURE 1.

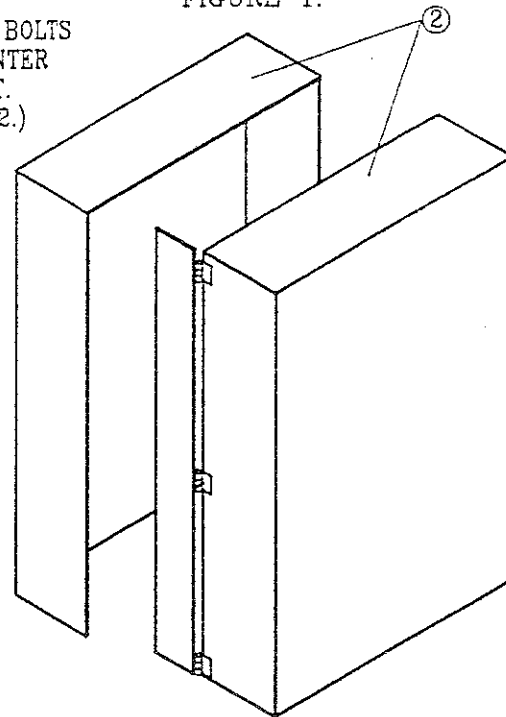
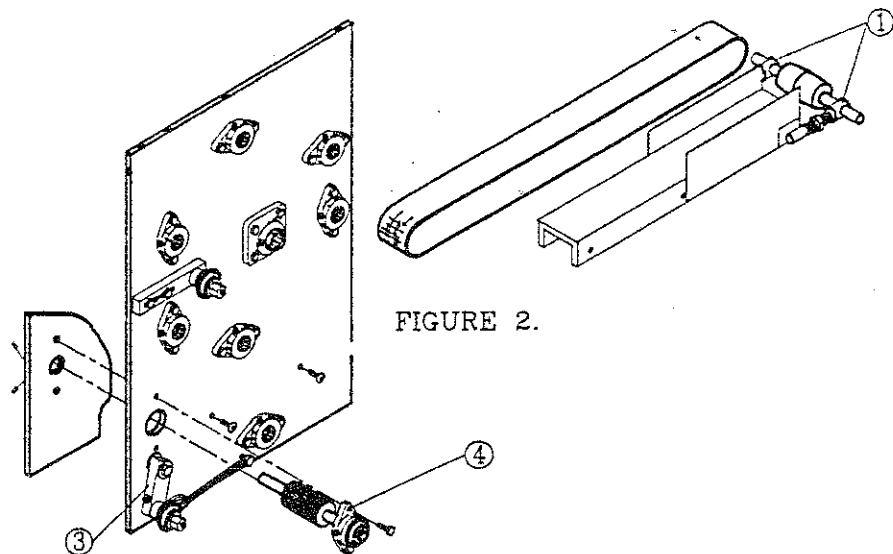


FIGURE 2.



2. REMOVE CABINET COVERS (PART# K609RC) FROM MACHINE TO EXPOSE INNER PANELS OF THE DIVIDER. (SEE FIGURE 1.)

3. LOCATE (PART# K203RS) TENSION BLOCK (ITEM #18) ON LEFT SIDE ASSEMBLY. RELEASE RELEASE TENSION SPRING (PART# K120LS)(SEE FIGURE 2.). THIS WILL ALLOW SLACK IN THE CHAIN (PART# K125LS) (ITEM #43) ON LEFT SIDE ASSEMBLY. NOW LOCATE MASTERLINK IN CHAIN, REMOVE AND REMOVE CHAIN FROM AROUND SPROCKETS. (SEE FIGURE 3.)

4. LOCATE THE FLANGE BEARING (PART# VF2S-212) (ITEM #12) ON LEFT SIDE ASSEMBLY THAT THE DISCHARGE CONVEYOR END SHAFT (PART# K307RA) (ITEM #5) ON DISCHARGE CONVEYOR ASSEMBLY IS GOING THRU. REMOVE THE TWO (2) HEX HEAD BOLTS THAT HOLD THE FLANGE BEARING TO THE LEFT SIDE PANEL. (SEE FIGURE 2.)

SWITCH TO THE RIGHT SIDE PANEL AND DIRECTLY ACROSS IS THE OTHER FLANGE BEARING THAT THE END SHAFT (PART# K307RA) IS GOING THRU. (SEE FIGURE 2.) LOOSEN THE TWO (2) SET SCREWS ON THE BEARING (NOT THE TWO (2) HEX BOLTS!!!). NOW TAKE A RUBBER Mallet AND GENTLY HIT THE END OF THE SHAFT TO PUSH IT THRU TO THE LEFT SIDE. REMOVE ENTIRE ROLLER ASSEMBLY AND PLACE IT NEXT TO MACHINE IN A CLEAN AREA.

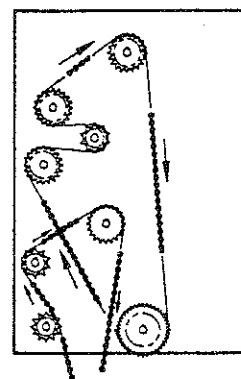


FIGURE 3.

5. LOCATE (PART# F0405SH) THIS WILL BE (ITEM #43) ON THE LEFT SIDE ASSEMBLY AND (ITEM #22) ON THE RIGHT SIDE ASSEMBLY. THERE WILL BE FOUR (4) TOTAL TWO (2) ON EACH SIDE. WITH AN ALLEN WRENCH AND A REGULAR WRENCH TO HOLD THE HEX NUTS ON THE INSIDE, REMOVE THESE (4) BOLTS. NOW YOU CAN REMOVE THE DISCHARGE CONVEYOR. REMOVE BELT (PART# K414CADC).

TO REASSEMBLE THE DISCHARGE CONVEYOR, REPLACE THE NEW BELT AROUND THE CONVEYOR AND PLACE THE CONVEYOR BACK BETWEEN THE PANELS. NOW REVERSE THE ABOVE PROCEDURE FOR EASY ASSEMBLY.

# MAINTENANCE PROCEDURES

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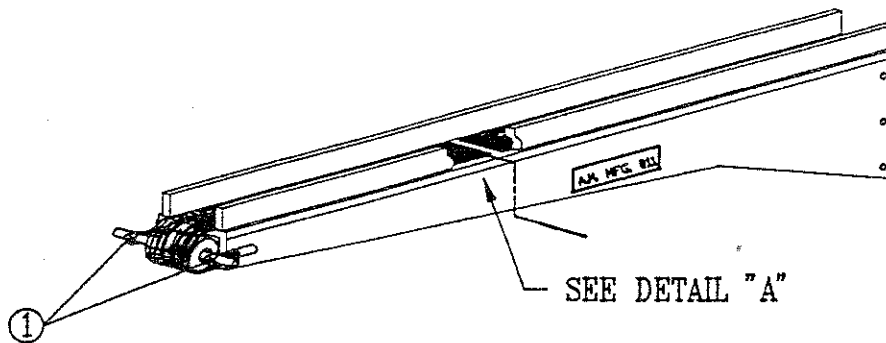
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## BELT REPLACEMENT

**⚠ WARNING:** CONVEYOR MAINTENANCE SHALL BE PERFORMED ONLY WHEN THE POWER SUPPLY HAS BEEN DISCONNECTED AND LOCKED OUT AND THE CONVEYOR HAS STOPPED.

### INFEEED CONVEYOR BELT REPLACEMENT:

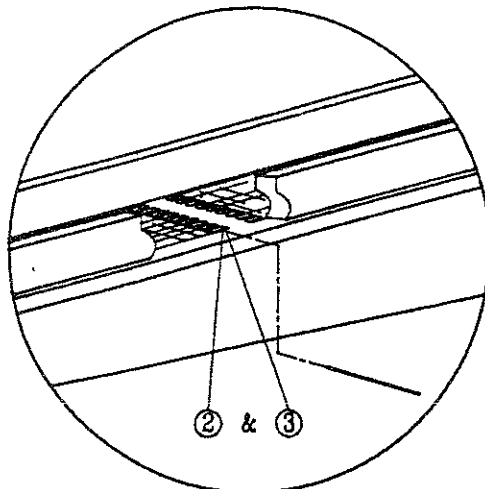
TO REPLACE THE INFEEED CONVEYOR BELT UNPLUG THE MACHINE FROM ITS PROPER RECEPTACLE TO ENSURE ALL POWER IS OFF.



1. TO LOOSEN THE BELT FOR REMOVAL FIND (PART# 600SC) ROLLER SUPPORT BOLTS WITH (PART# F0601HN) ADJUSTING HEX NUT. TURN ADJUSTING HEX NUT COUNTER CLOCK-WISE. THIS INTERN WILL BRING IN THE ROLLER AND LOOSEN THE BELT. THIS PROCEDURE MUST BE DONE TO BOTH SIDES OF THE BELT.

2. TO REMOVE THE BELT FROM THE CONVEYOR, FIRST LOCATE THE ALLIGATOR LACING OR HINGE. YOU WILL SEE A PIN GOING THRU THE LACING. WITH PLIERS PULL THE PIN OUT. THE BELT WILL THEN COME APART, REMOVE BELT FROM MACHINE.

3. TO REPLACE CONVEYOR BELT, FEED THE NEW BELT DOWN THE CONVEYOR AND AROUND BOTH ROLLERS. FIND THE ALLIGATOR LACING OR HINGE, INTERTWINE THE LACING AND SLIDE PIN THROUGH. TO TIGHTEN THE BELT, TURN THE ADJUSTING HEX NUTS (PART# F0601HN) CLOCK-WISE TO RETIGHTEN THE BELT.



DETAIL "A"

# INFEED CONVEYOR ASSEMBLY

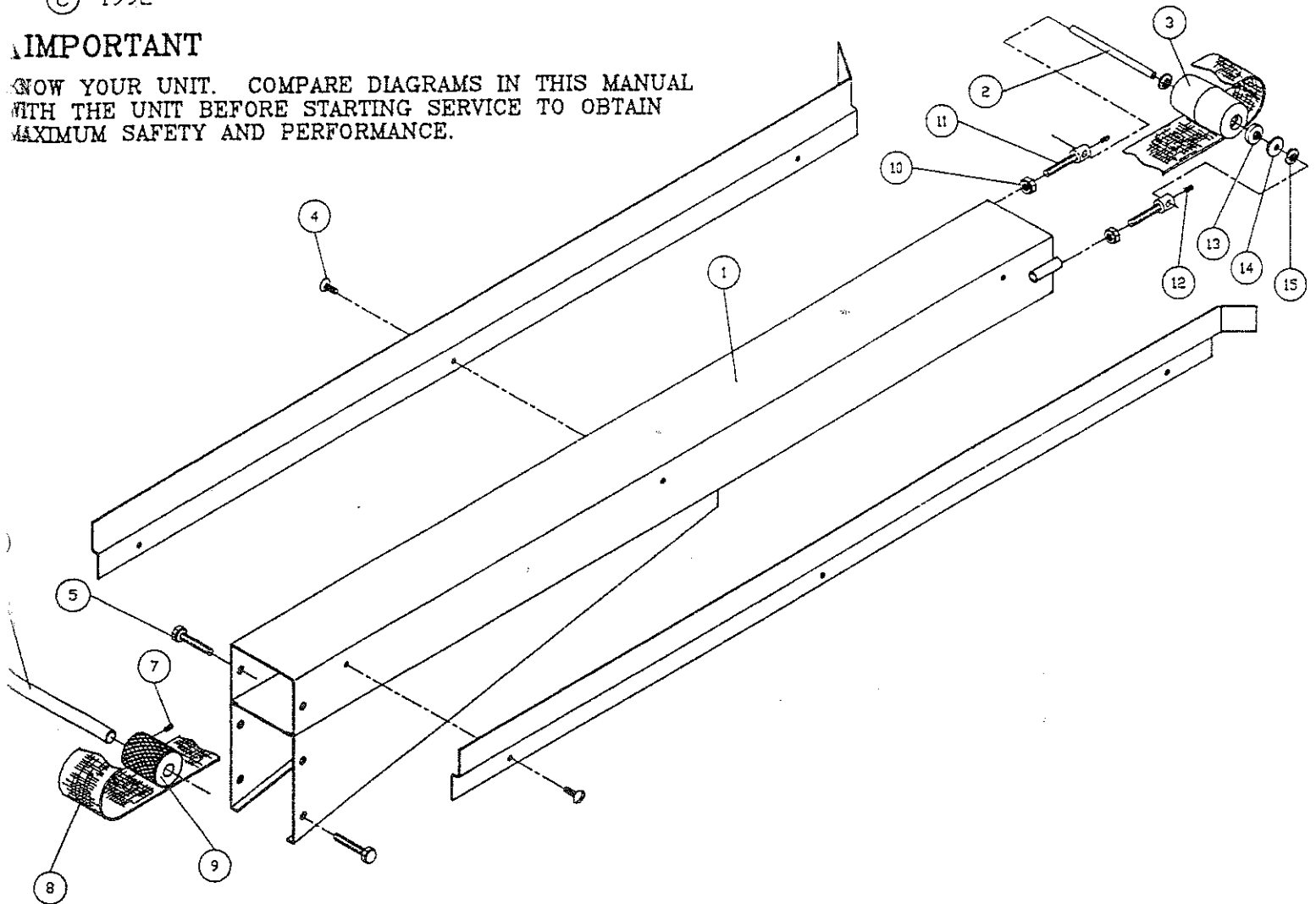
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## IMPORTANT

KNOW YOUR UNIT. COMPARE DIAGRAMS IN THIS MANUAL  
WITH THE UNIT BEFORE STARTING SERVICE TO OBTAIN  
MAXIMUM SAFETY AND PERFORMANCE.



ITEM	PART No.	DESCRIPTION	No. REQ'D.
1	K420CA	INFEED CONVEYOR w/ R & L SIDE RAILS	1
2	K401CAIF	ROLLER CENTER ROD	1
3	K404CAIF	INFEED CONVEYOR ROLLER	1
4	F0402RH	BOLT	6
5	F0503HH	BOLT	6
6	K308RA	INFEED CONVEYOR SHAFT	1
7	F0502SS	SET SCREW	1
8	K415CA	STD. INFEED CONVEYOR BELT	1
9	K412CAIF	INFEED CONVEYOR DRIVE ROLLER	1
10	F0600LN	LOCK NUT	2
11	600SC	ROLLER SUPPORT BOLT	2
12	F0401SS	SET SCREW	2
13	641SC2	BEARING	2
14	F0600FW	FLAT WASHER (NYLON)	2
15	F0600RW	RETAINING WASHER	2

# 6 FT. INFEED CONVEYOR ASSEMBLY (OPTIONAL)

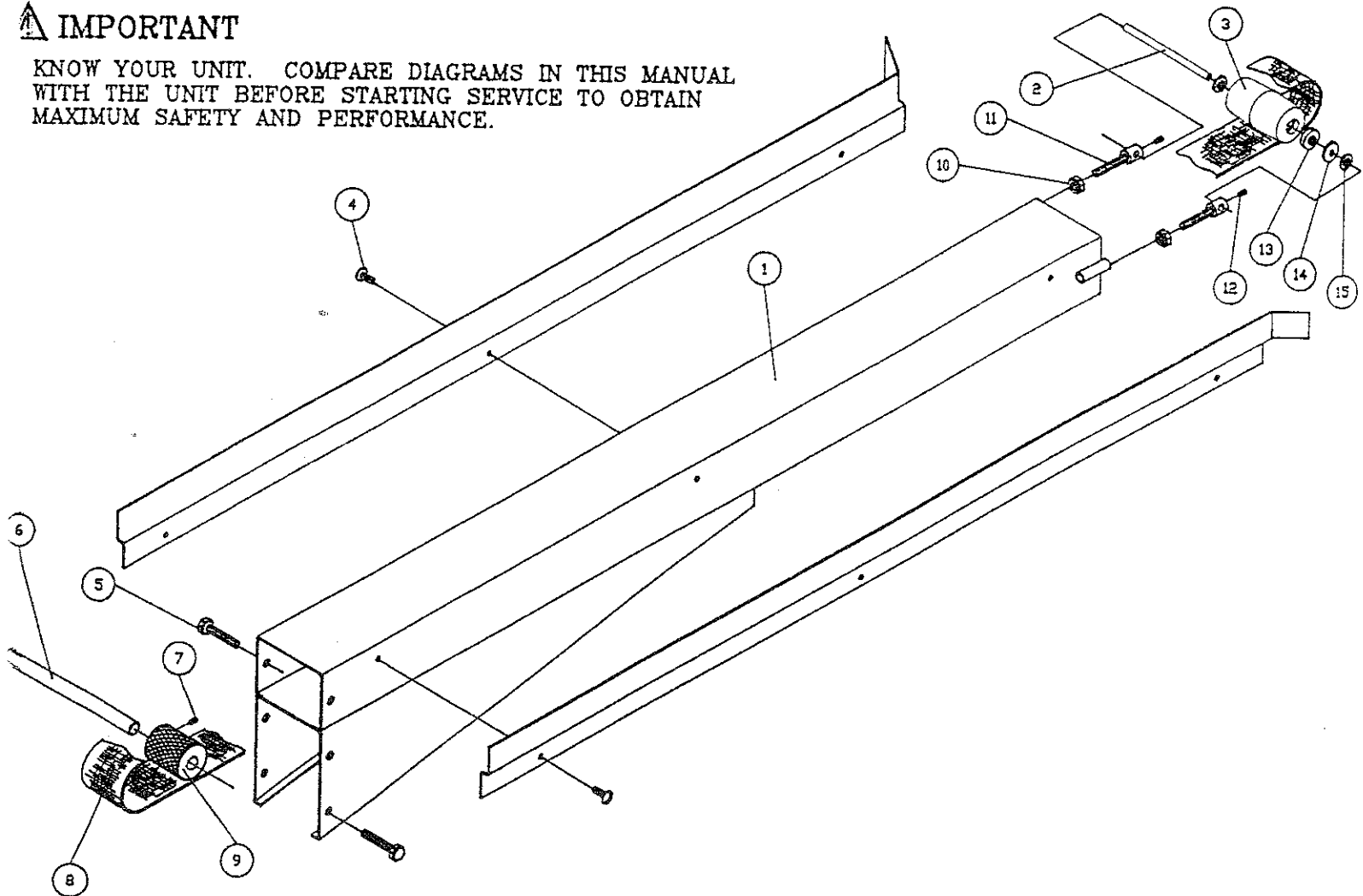
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ITEM	PART No.	DESCRIPTION	No. REQ'D.
1	K421CA	INFEED CONVEYOR w/ (R&L) SIDE RAILS	1
2	K401CAIF	ROLLER CENTER ROD	1
3	K404CAIF	INFEED CONVEYOR ROLLER*	1
4	F0402RH	BOLT	6
5	F0503HH	BOLT	6
6	K308RA	INFEED CONVEYOR SHAFT	1
7	F0502SS	SET SCREW	1
8	K415CA6	STD. (6') INFEED CONVEYOR BELT	1
9	K412CAIF	INFEED CONVEYOR DRIVE ROLLER	1
10	F0600LN	LOCK NUT	2
11	600SC	ROLLER SUPPORT BOLT	2
12	F0401SS	SET SCREW	2
13	641SC2	BEARING	2
14	F0600FW	FLAT WASHER (NYLON)	2
15	F0600RW	RETAINING WASHER	2



# ASSEMBLY INSTRUCTIONS

THE RK200I KNIFE DIVIDER REQUIRES SOME ASSEMBLY BEFORE OPERATING.  
THE INFEED CONVEYOR HAS BEEN REMOVED FOR SHIPPING PURPOSES.

**CAUTION:** FOR SAFE ASSEMBLY, AT LEAST (2) TWO PEOPLE ARE REQUIRED. SOME PARTS ARE HEAVY AND MAY CAUSE STRAIN TO AN INDIVIDUAL.

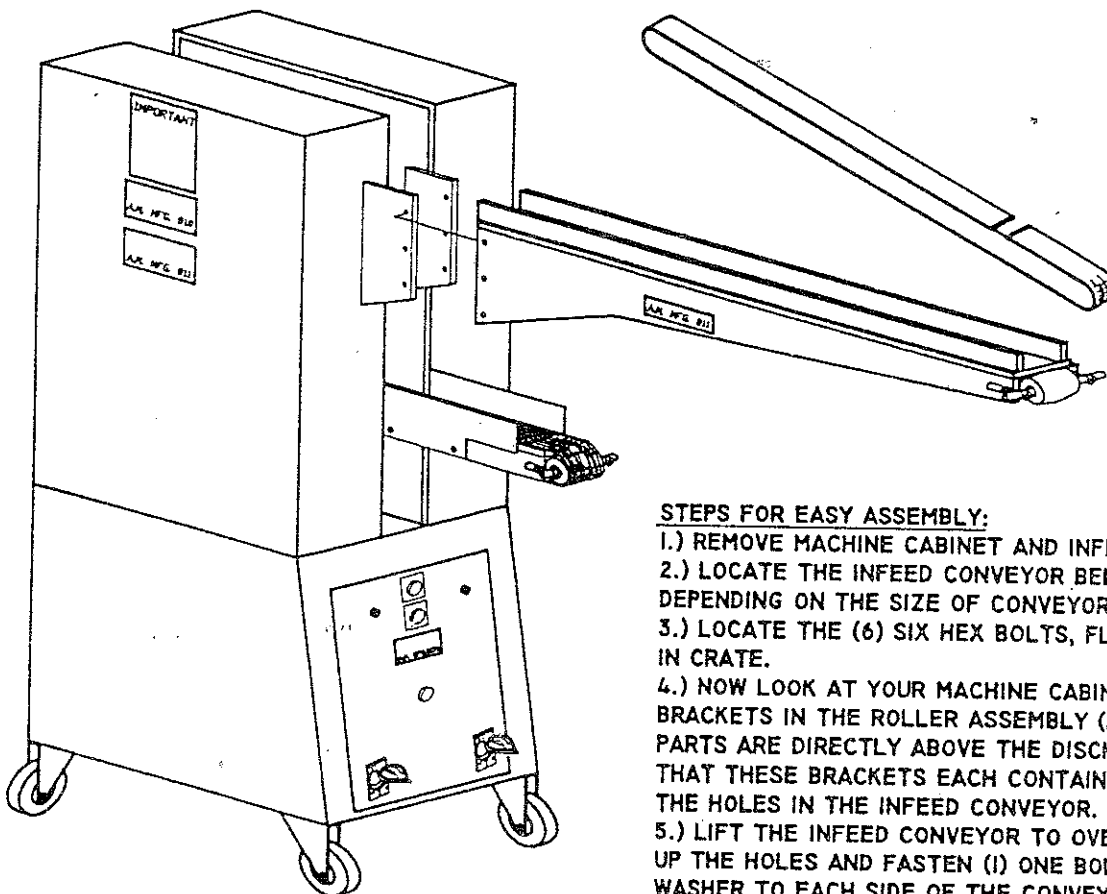


FIGURE 1

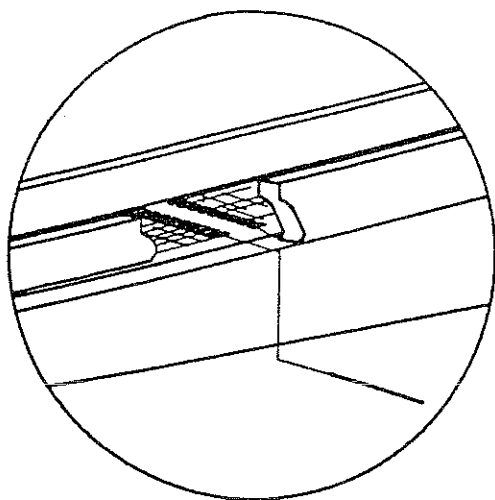


FIGURE 2

## STEPS FOR EASY ASSEMBLY:

- 1.) REMOVE MACHINE CABINET AND INFEED CONVEYOR FROM CRATE.
- 2.) LOCATE THE INFEED CONVEYOR BELT (PART No. K415CA / K415CA6) DEPENDING ON THE SIZE OF CONVEYOR ORDERED.
- 3.) LOCATE THE (6) SIX HEX BOLTS, FLAT AND LOCK WASHERS IN CRATE.

4.) NOW LOOK AT YOUR MACHINE CABINET, LOCATE THE SUPPORT BRACKETS IN THE ROLLER ASSEMBLY (PART No. K317RA). THESE PARTS ARE DIRECTLY ABOVE THE DISCHARGE CONVEYOR. NOTICE THAT THESE BRACKETS EACH CONTAIN (3) THREE HOLES THAT MATCH THE HOLES IN THE INFEED CONVEYOR.

- 5.) LIFT THE INFEED CONVEYOR TO OVERLAP THESE BRACKETS, LINE UP THE HOLES AND FASTEN (1) ONE BOLT, LOCKWASHER AND FLAT WASHER TO EACH SIDE OF THE CONVEYOR AS SHOWN IN FIGURE (1).
- 6.) NOW GO BACK AND ASSEMBLE THE REMAINING (4) FOUR BOLTS AND WASHERS.

7.) TO INSTALL CONVEYOR BELT, FEED THE NEW BELT DOWN THE CONVEYOR AND AROUND BOTH ROLLERS (PART No.'s K404CA / K412CA)

NOTE: THAT BELT DOES NOT GO AROUND THE SUPPORT BRACKETS WELDED UNDERNEATH THE CONVEYOR.

FIND THE ALLIGATOR LACING OR HINGE, INTERTWINE THE LACING AND SLIDE PIN THROUGH. SEE FIGURE (2). TO TIGHTEN THE BELT, TURN THE ADJUSTING HEX NUTS (PART No.F0600LN) CLOCK-WISE TO TIGHTEN THE BELT. SEE FIGURE (1)

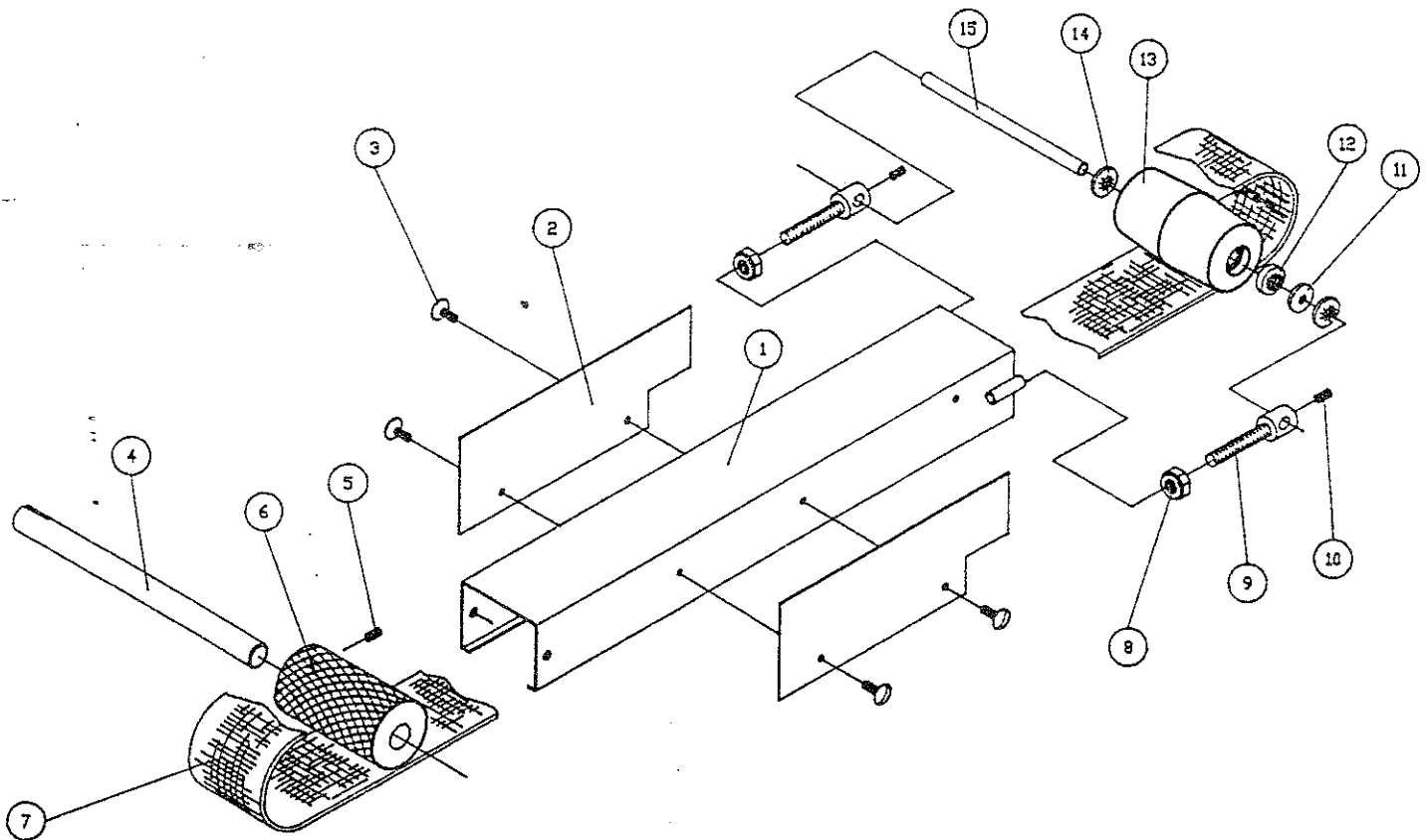
NOTE: SEE ROLLER ASSEMBLY AND INFEED CONVEYOR ASSEMBLY FOR DETAILS AND PART No's.

# DISCHARGE CONVEYOR ASSEMBLY

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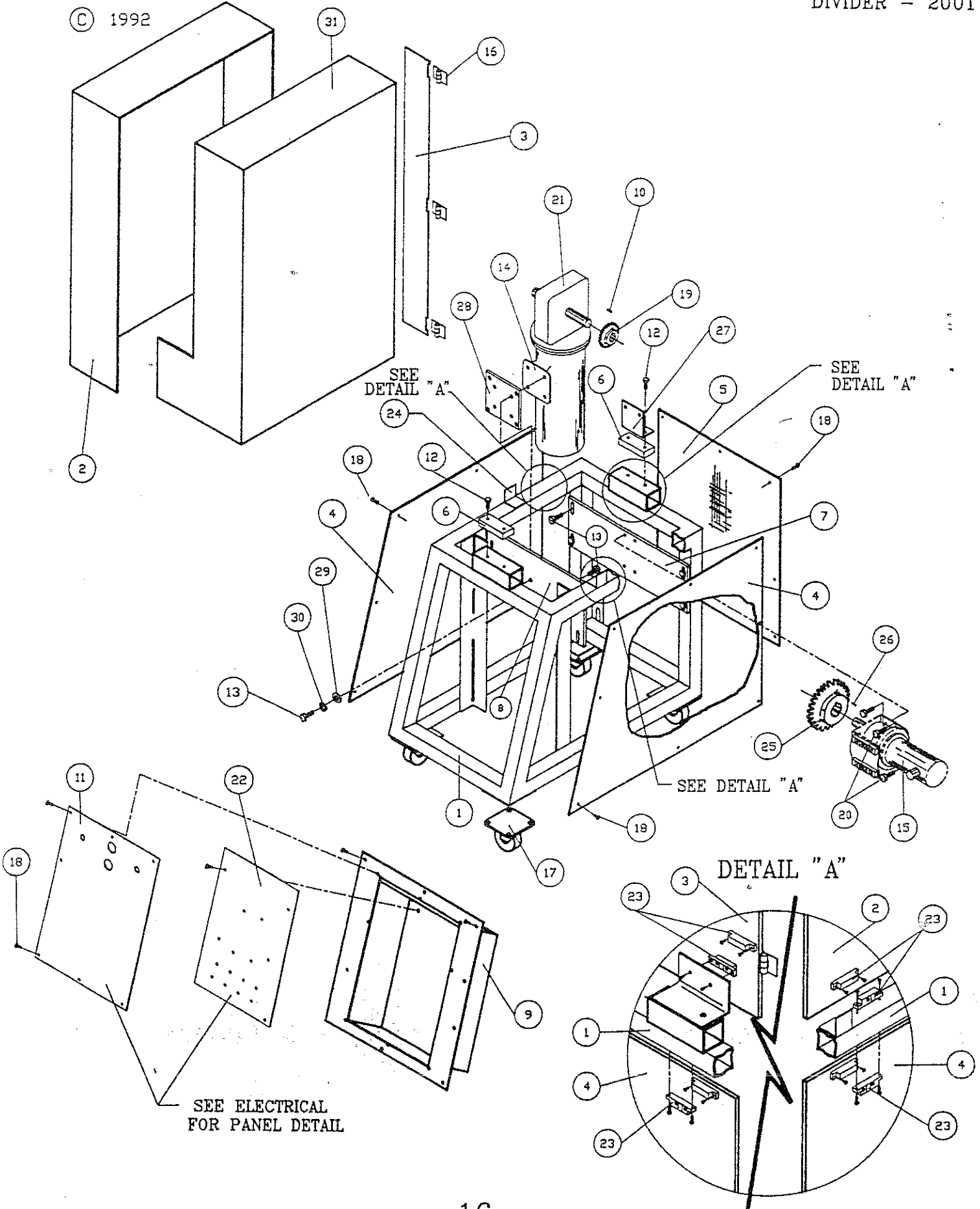
<u>ITEM</u>	<u>PART No.</u>	<u>DESCRIPTION</u>	<u>No. REQ'D.</u>
1	K425CA	DISCHARGE CONVEYOR FRAME	1
2	K417CADC	DISCHARGE CONVEYOR SIDE PLATE	2
3	F0402RH	BOLT	4
4	K307RA	DISCHARGE CONVEYOR DRIVE SHAFT	1
5	F0502SS	SET SCREW	1
6	K413CADC	DISCHARGE CONVEYOR ROLLER	1
7	K414CADC	STD. DISCHARGE CONVEYOR BELT	1
8	F0600LN	LOCK NUT	2
9	600SC	ROLLER SUPPORT BOLT	2
10	F0401SS	SET SCREW	2
11	F0600FW	FLAT WASHER (NYLON)	2
12	641SC2	BEARING	2
13	K405CADC	DISCHARGE CONVEYOR ROLLER	1
14	F0600RW	RETAINING WASHER	2
15	K401CADC	ROLLER CENTER SHAFT	1

# CABINET ASSEMBLY

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# CABINET ASSEMBLY

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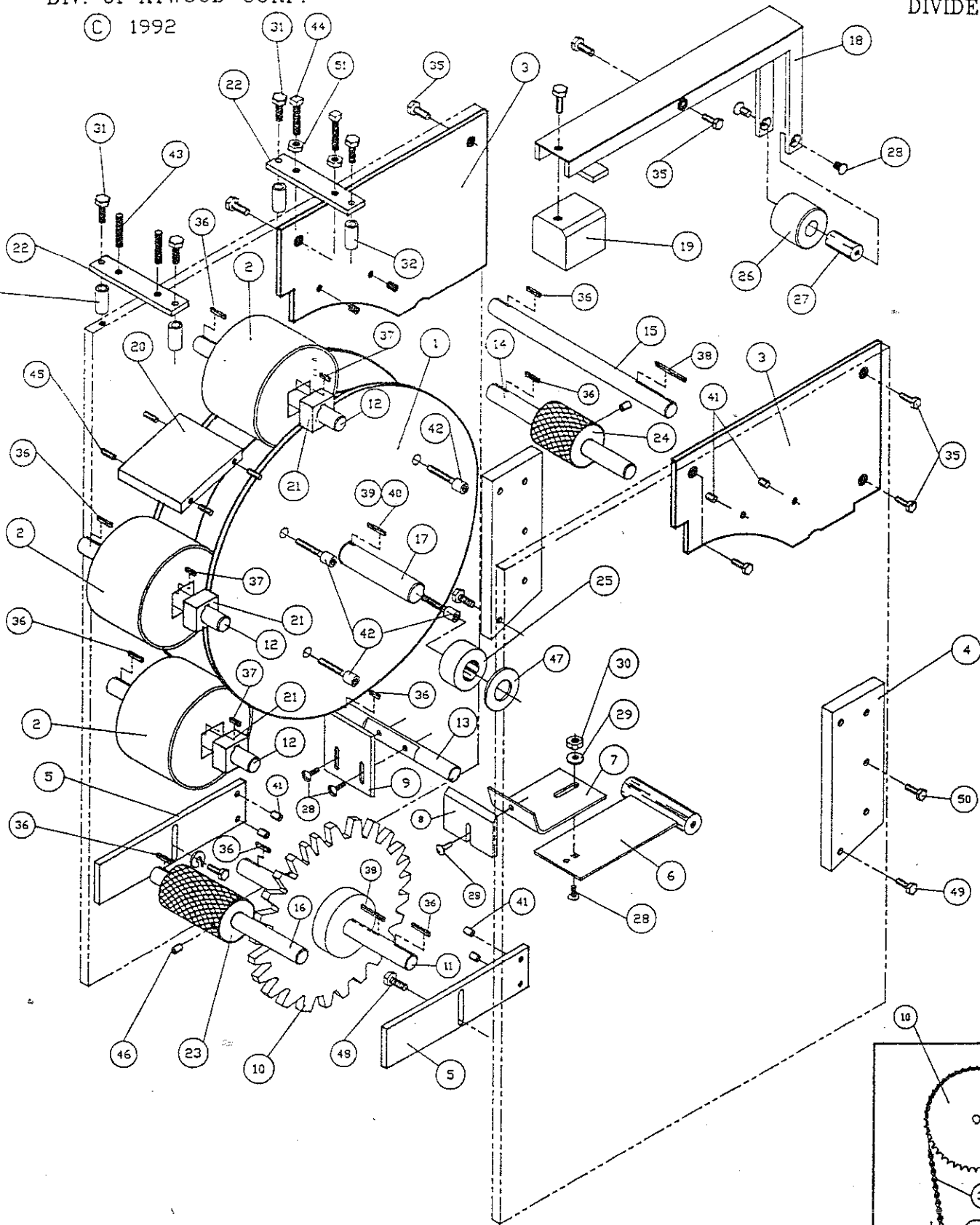
<u>ITEM</u>	<u>PART No.</u>	<u>DESCRIPTION</u>	<u>No. REQ'D.</u>
1	K602C	CABINET FRAME	1
2	K609AC	CABINET CASE (LEFT SIDE)	1
3	K610C	CABINET DOOR	1
4	K605C	CABINET FRAME SIDE PANEL	2
5	K608C	CABINET FRAME BACK PANEL	1
6	K611C	SIDE PANELS SPACER BAR	2
7	K606C	KNIFE/DISCHARGE CONV. MTR. DRIVE PLATE	1
8	K607C	MAIN DRIVE MOTOR MOUNT PLATE	1
9	K603C	ELECTRICAL BOX	1
10	F0403KY	SHAFT KEY	1
11	K612C	PUSH BUTTON PANEL (RK2001 <u>ONLY</u> )	1
	K612C-1	PUSH BUTTON PANEL (RK2100 <u>ONLY</u> )	1
12	F0504HH	BOLT	4
13	F0606HH	BOLT	12
14	K502ES	ELECTRIC MAIN DRIVE MOTOR	1
15	K503ES	ELECTRIC KNIFE/DISCHARGE MOTOR	1
16	K614C	HINGE	3
17	621CA1	CASTER ROLLER	4
18	F0402TH	BOLT	46
19	K620C	REDUCER SPROCKET	1
20	F0404HH	BOLT	4
21	K504ES	REDUCER	1
22	K613C	CONTROL PANEL PLATE	1
23	K505ES	MAGNETIC REED SWITCH	6
24	K616C	1 x 1' x 16 ga. ANGLE IRON	2
25	K617C	MAIN DRIVE MOTOR SPROCKET	1
26	F0303KY	SHAFT KEY	2
27	K619C	MAGNETIC REED SWITCH ANGLE BRACKET	1
28	K502ES-1	ELECTRIC MAIN DRIVE MOTOR PLATE	1
29	F0600FW	FLAT WASHER	8
30	F0600LW	LOCK WASHER	8
31	K609C	CABINET CASE (RIGHT SIDE)	1

# ROLLER ASSEMBLY

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MAIN DRIVE MOTOR

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# ROLLER ASSEMBLY

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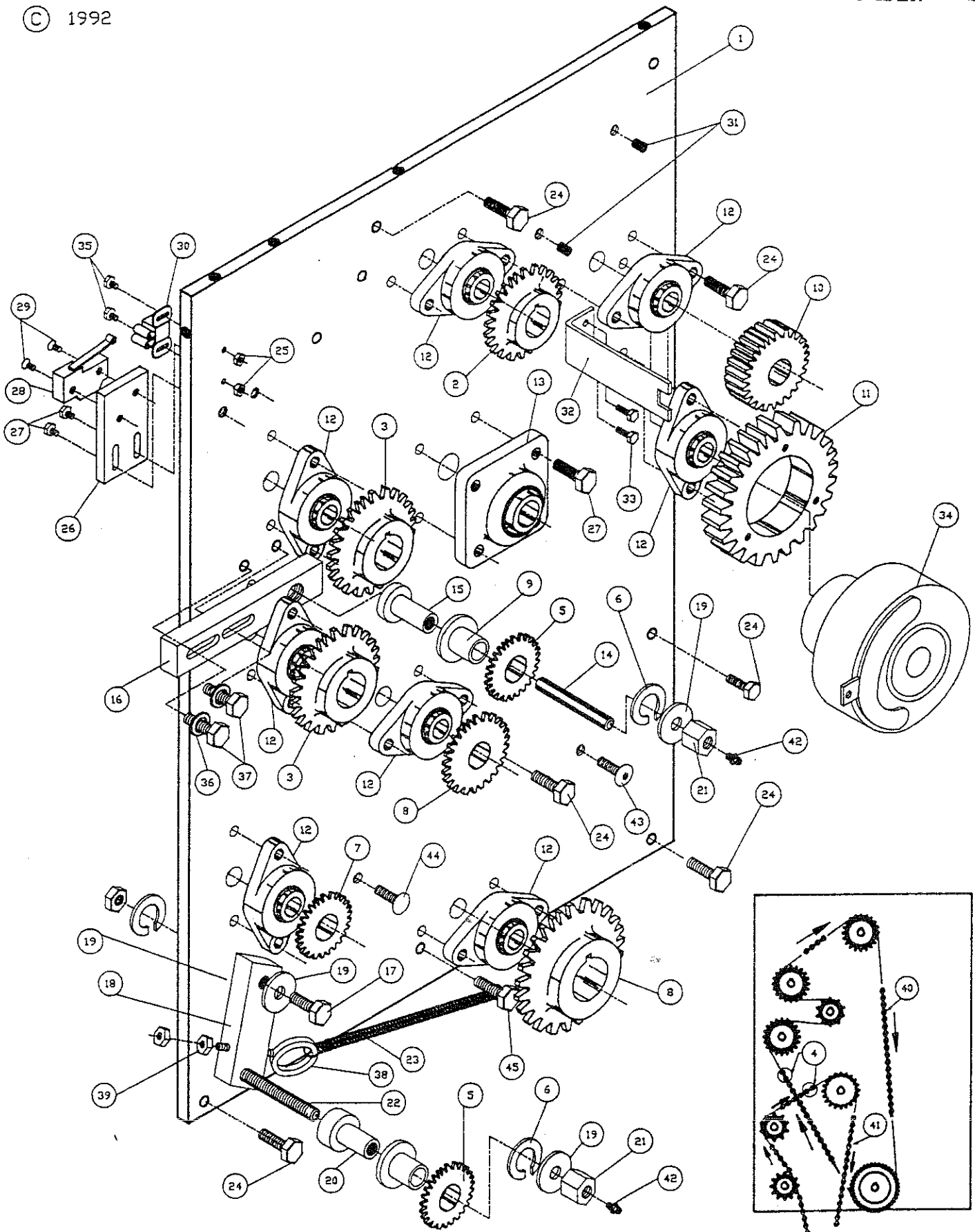
<u>ITEM</u>	<u>PART No.</u>	<u>DESCRIPTION</u>	<u>No. REQ'D.</u>
1	K326RA	DRUM ROLLER	1
2	K314RA	FEED ROLLER	3
3	K310RA	DRUM GUIDE	2
4	K317RA	SUPPORT BRACKET	2
5	K321RA	GUIDE BRACKET (DISCHARGE CONV.)	2
6	K311RA	DRUM SCRAPER BASE	1
7	K312RA	DRUM SCRAPER EXTENTION	1
8	K313RA	DRUM SCRAPER BLADE	1
9	K309RA	KNIFE	1
10	K327RA	SPROCKET	1
11	K305RA	COUNTER SHAFT	1
12	K304RA	SIZING ROLLER SHAFT	3
13	K306RA	KNIFE SHAFT	1
14	K308RA	INFEED CONVEYOR SHAFT	1
15	K303RA	CLUTCH SHAFT	1
16	K307RA	DISCHARGE CONVEYOR SHAFT	1
17	K302RA	DRUM ROLLER SHAFT	1
18	K318RA	ACTUATOR ARM ASSEMBLY	1
19	K338RA	COUNTER WEIGHT	1
20	K328RA	SIZING ROLLER GUARD	1
21	K315RA	DRIVER PLUG	3
22	K320RA	ACTUATOR DOUGH RESTRICTION BAR	2
23	K413CA	DISCHARGE CONVEYOR DRIVE ROLLER	1
24	K412CA	INFEED CONVEYOR DRIVE ROLLER	1
25	K331RA	DRUM SPACER	2
26	K322RA	ACTUATOR ROLLER	1
27	K322RA-1	ACTUATOR ROLLER SHAFT	1
28	F0502CB	BOLT	8
29	F0400LN	LOCK NUT	1
30	F0400FW	FLAT WASHER	1
31	F0406HH	BOLT	4
32	K330RA	5/16 I.D. x 1/2 LG. SPACER	2
33	K337RA	# 40 CHAIN	1
34	K118LS	# 40 MASTER LINK	1
35	F0405HH	1/4-20 x 1.250 LG. HEX HD. BOLT	20
36	K332RA	3/16 x 3/16 X 0.875 KEY	7
37	K333RA	3/16 x 3/16 x 0.500 KEY	1
38	K334RA	3/16 x 3/16 X 1.875 KEY	2
39	K335RA	1/4 x 1/4 x 1.062 KEY	1
40	K336RA	1/4 x 1/4 x 1.125 KEY	1
41	F0401SS	1/4-20 x 0.625 SET SCREW	8
42	F0609SH	3/8-16 x 2-1/4 S.H. CAP SCREW	4
43	F0508SS	SET SCREW	2
44	F0508SQ	SQ. HD. BOLT	2
45	F0402SS	SET SCREW	4
46	F0501SS	SET SCREW	2
47	F1600FW	FLAT WASHER (NYLON)	2
48	F0402HH	BOLT	2
49	F0504HH	BOLT	4
50	F0502HH	BOLT	6
51	F0500NC	HEX NUT	2

# LEFT SIDE ASSEMBLY

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ITEM	PART No.	DESCRIPTION	No. REQ'D.
1	K110LS	LEFT SIDE PANEL	1
2	K111LS	SIZING ROLLER-SPROCKET	2
3	K112LS	SIZING ROLLER SPROCKET	1
4	K118LS	No. 40 CHAIN MASTER LINK	1
5	K113LS	TENSION SPROCKET W/ BUSHING	2
6	F0800LW	LOCK WASHER	1
7	K115LS	DISCHARGE SPROCKET	1
8	K116LS	COUNTER / KNIFE SPROCKETS	2
9	BBT15	BRONZE BUSHING	2
10	K109LS	INFEED CONVEYOR DRIVE GEAR	1
11	K108LS	GEAR (DRIVER/CLUTCH)	1
12	VF2S-212	(2) HOLE BEARING FLANGE	8
13	VF4S-216	(4) HOLE SQ. BEARING FLANGE	1
14	K104LS-3	1/2-13 x 3.0 THRD. ROD	1
15	K104LS-2	TENSION SPROCKET SHAFT	1
16	K104LS-1	TENSION ASSEMBLY PLATE	1
17	F0808HH	BOLT	1
18	K203RS-1	TENSION BAR	1
19	F0808FW	WASHER	2
20	K203RS-2	TENSION SPROCKET SHAFT	1
21	F08NC	HEX NUT	2
22	K203RS-3	1/2-13 x 3.50 THREADED ROD	1
23	K120LS	TENSION SPRING (56) COILS	1
24	F0504HH	BOLT	18
25	F96NF	No. 6 HEX NUT	2
26	K107LS	LIMIT SWITCH MOUNTING PLATE	1
27	F0404HH	BOLT w/ FLAT & LOCK WASHERS	10
28	K512ES	LIMIT SWITCH	1
29	F9604BH	No. 6 x 1" SCREW	2
30	K122LS	DOOR HINGE ASSEMBLY	1
31	F0401SS	SET SCREW	4
32	K102LS	ANTI-ROTATION BRACKET	1
33	F0402HH	BOLT	2
34	K511ES	CLUTCH	1
35	F9703TH	BOLT	2
36	F9703FW	WASHER	2
37	F0505HH	BOLT	2
38	F0508EB	EYEBOLT	1
39	F0400NF	HEX NUT	2
40	K124LS	No. 40 CHAIN (DRIVES SIZING ROLLERS)	1
41	K125LS	No. 40 CHAIN (DRIVES DISCHARGE & KNIFE)	1
42	3038-B	GREASE FITTING	2
43	F0405SH	SCREW	2
44	F0404CB	BOLT w/ NUT & WASHER	2
45	F0604HH	BOLT	8

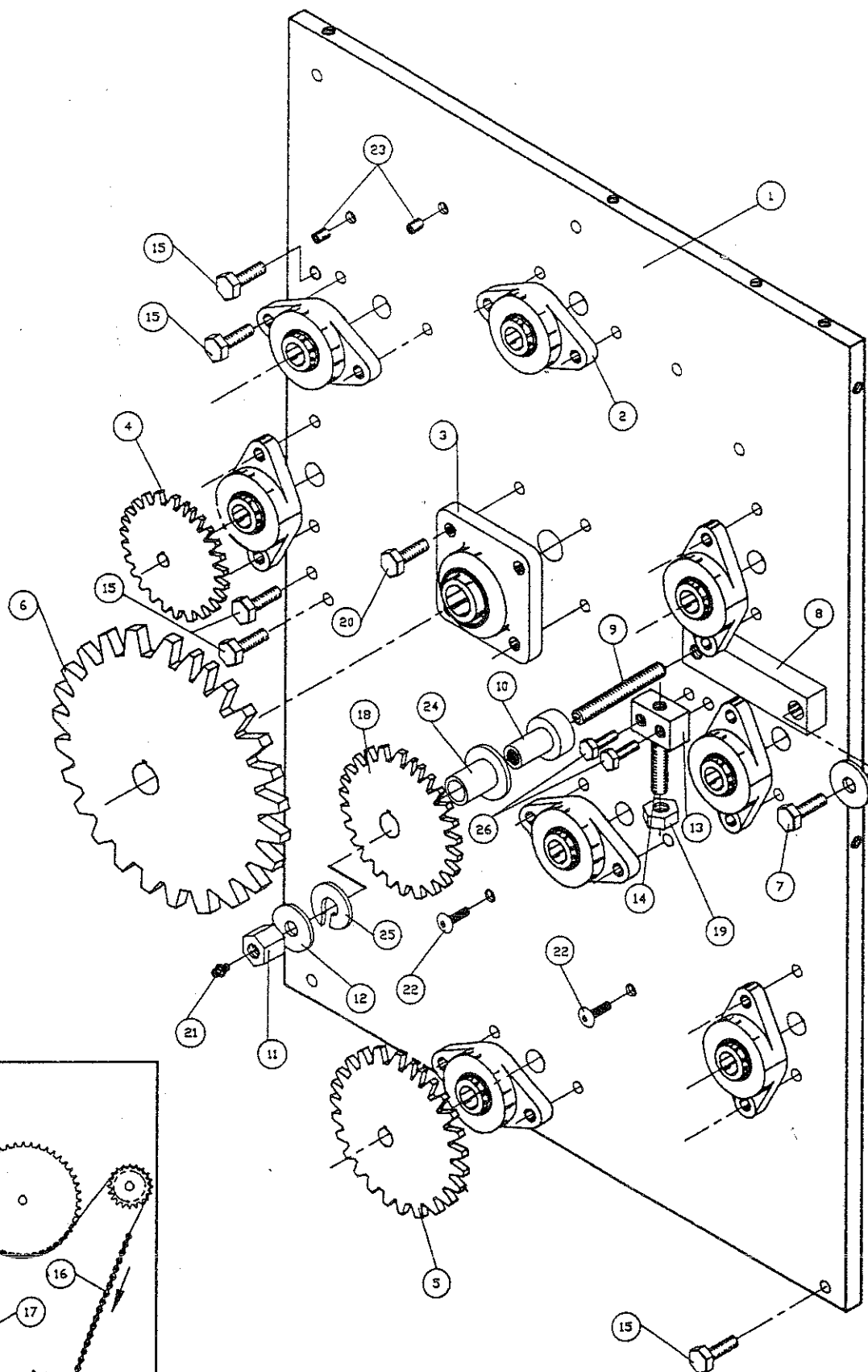


# RIGHT SIDE ASSEMBLY

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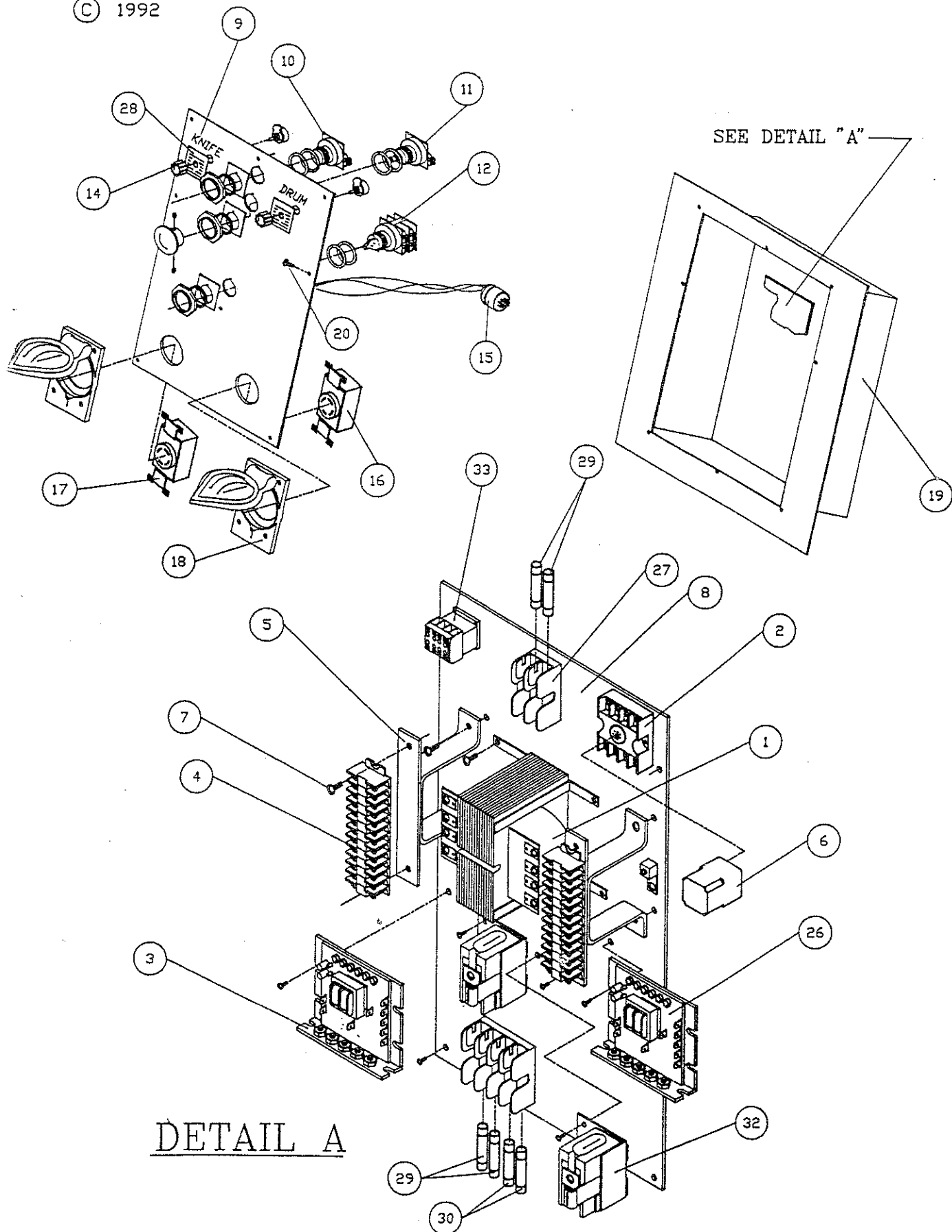
<u>ITEM</u>	<u>PART No.</u>	<u>DESCRIPTION</u>	<u>No. REQ'D.</u>
1	K210RS	RIGHT SIDE PANEL	1
2	VF2S-212	(2) HOLE BEARING FLANGE	8
3	VF4S-216	(4) HOLE BEARING FLANGE	1
4	K206RS	INFEED CONVEYOR SPROCKET	1
5	K207RS	COUNTER SPROCKET	1
6	K208RS	DRUM ROLLER SPROCKET	1
7	F08-05HH	BOLT	1
8	K203RS-1	TENSION BAR	1
9	K203RS-3	1/2-13 THREADED ROD	1
10	K203RS-2	SPROCKET TENSION SHAFT	1
11	F08NC	1/2-13 HEX NUT	1
12	F0800FW	WASHER	2
13	K204RS	TENSION ADJUSTMENT BLOCK	1
14	K211RS	SET SCREW	1
15	F0405HH	BOLT w/ LOCK WASHERS	21
16	K209RS	No. 50 CHAIN	1
17	K212RS	No. 50 CHAIN MASTER LINK	1
18	K213RS	TENSION SHAFT SPROCKET	1
19	F0504HN	HEX NUT	1
20	F0604HH	BOLT w/ LOCK WASHERS	4
21	3038-B	GREASE FITTING	4
22	F0405BH	SCREW	2
23	F0401SS	SET SCREW	2
24	BBT15	BRONZE BUSHING	1
25	F0800LW	LOCK WASHER	1
26	F0405HH	BOLT w/ FLAT & LOCK WASHERS	2

# ELECTRICAL SYSTEM

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# ELECTRICAL SYSTEM

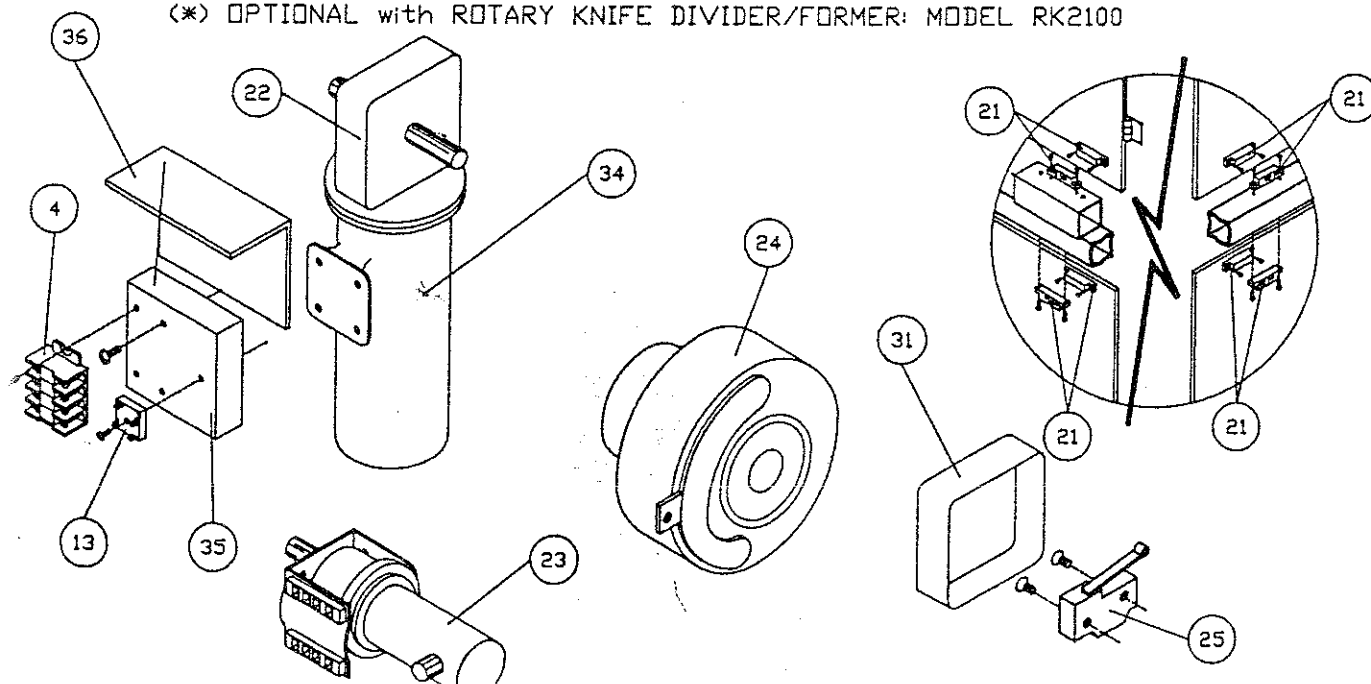
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<u>ITEM</u>	<u>PART No.</u>	<u>DESCRIPTION</u>	<u>No. REQ'D.</u>
1	K506ES	TRANSFORMER	1
2	K507ES	RELAY SOCKET (8) PIN	2
3	K508ES	1/8 hp. MOTOR CONTROL	1
4	K523ES	TERMINAL BLOCK	2
5	K509ES	"U" BRACKET	2
6	K529ES	RELAY	1
7	F97-02TH	#8-32 TRUSS HEAD BOLT	20
8	K613C	CONTROL PANEL	1
9	K612C	PUSH BUTTON PANEL	1
10	K522ES	START PUSH BUTTON (BLACK)	1
11	K519ES	EMERGENCY STOP PUSH BUTTON (RED)	1
12	K518ES	MANUAL SELECTOR SWITCH	1
13	K521ES	BRIDGE RECTIFIER	1
14	K515ES	KNIFE / DRUM SELECTORS	2
15	K520ES	DCTAL PLUG	1
(*)16	K516ES	20A-125/250V RECEPTICAL	1
(*)17	K517ES	20A-250V3Ø RECEPTICAL	1
(*)18	K514ES	ALUM. WALL PLATE w/ LIFT COVER	1
19	K603C	ELECTRICAL BOX	1
20	F04-02TH	1/4-20 x 0.500 TRUSS HEAD BOLT	8
21	K505ES	MAGNETIC REED SWITCH	6
22	K504ES	REDUCER MOTOR	1
23	K503ES	ELECTRIC KNIFE / DISCHARGE MOTOR	1
24	K511ES	CLUTCH	1
25	K512ES	LIMIT SWITCH	1
26	K513ES	1.0 hp. MOTOR CONTROL	1
27	K524ES	FUSE BLOCK	2
28	K525ES	LEGEND PLATE	2
29	K526ES	FUSE (5 AMP.)	4
30	K527ES	FUSE (8 AMP.)	2
31	K528ES	LIMIT SWITCH COVER	1
32	K530ES	OVER LOAD	2
33	K531ES	CONTROL RELAY	1
34	K502ES	MAIN DRIVE MOTOR	1
35	K532ES	BRIDGE RECTIFIER BLOCK	1
36	K533ES	BRIDGE RECTIFIER BLOCK GUARD	1

(\*) OPTIONAL with ROTARY KNIFE DIVIDER/FORMER: MODEL RK2100

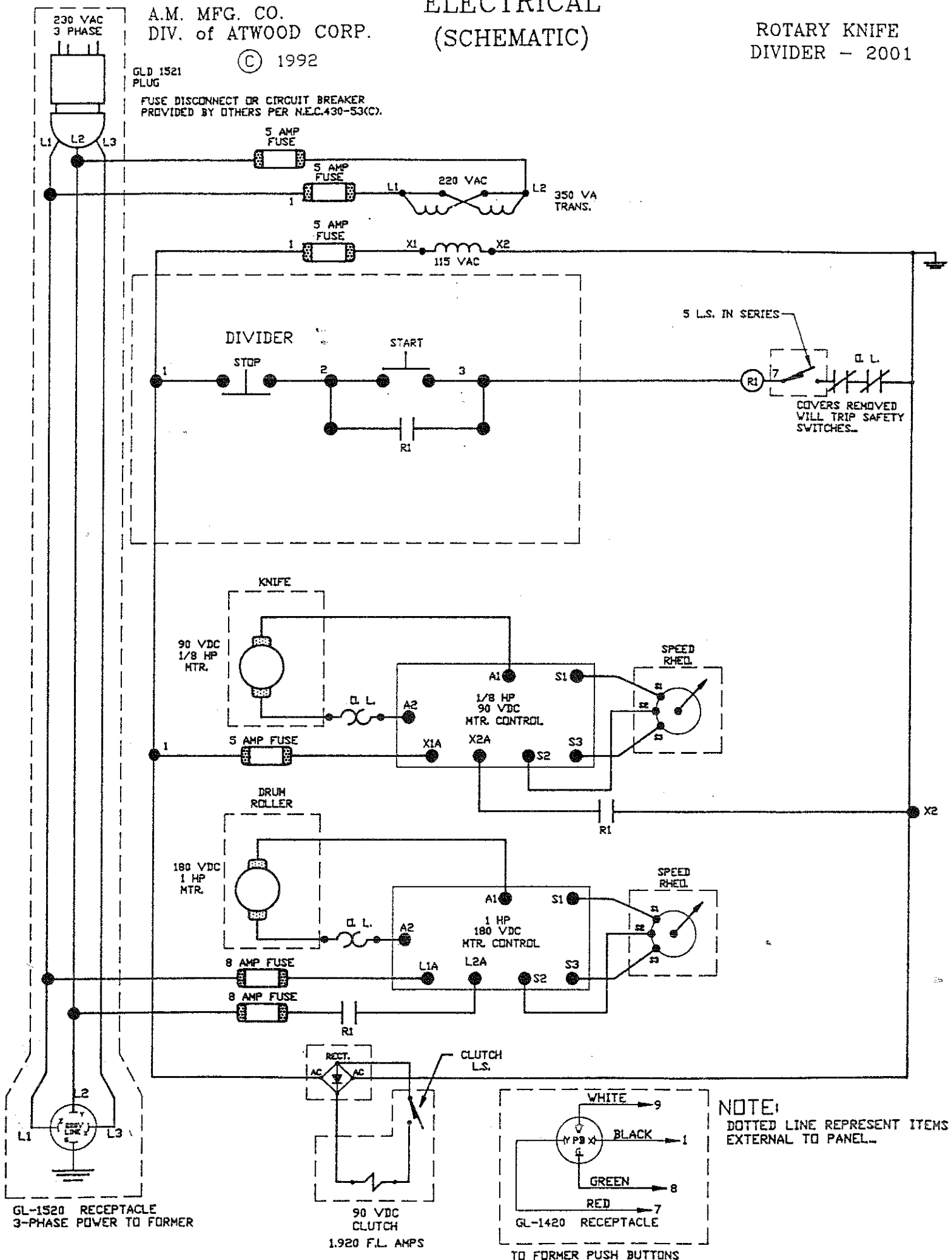


A.M. MFG. CO.  
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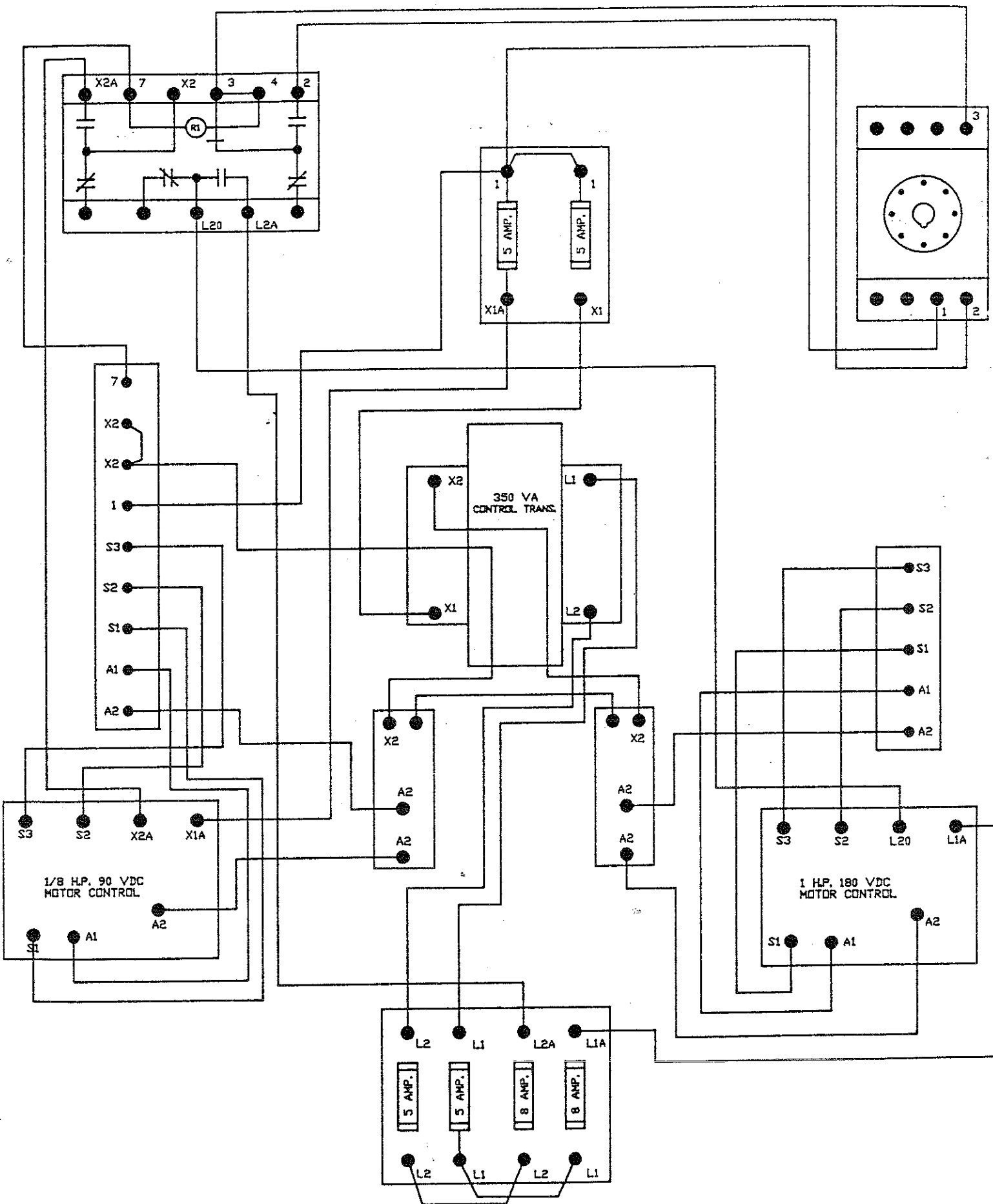
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# ELECTRICAL (SCHEMATIC)

ROTARY KNIFE  
DIVIDER - 2001



# ELECTRICAL (HARD WIRE)



# ORDERING REPLACEMENT PARTS

A.M. MFG. CO.  
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ROTARY KNIFE  
DIVIDER - 2001

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## IMPORTANT:

ONLY USE FACTORY SUPPLIED REPLACEMENT PARTS  
TO MAINTAIN MACHINE SAFETY, PERFORMANCE AND  
SANITARY CONDITIONS.

USE OF NON-APPROVED PARTS MAY VOID MANUFACTURERS  
WARRANTY.

## TO ORDER REPLACEMENT PARTS ALWAYS:

- 1.) CHECK THE MACHINE TO IDENTIFY MISSING, DAMAGED  
OR NON-FUNCTIONAL PARTS INCLUDING GUARDS, WARNING  
LABELS AND INSTRUCTIONS.
- 2.) COMPARE THE LIST WITH THE PARTS DIAGRAMS  
SUPPLIED.
- 3.) RECORD THE COMPLETE MODEL AND SERIAL NUMBER  
OF THE UNIT.
- 4.) CALL A.M.MANUFACTURING (800) 342-6744 AND PROVIDE  
ALL INFORMATION NOTED ABOVE TO EXPEDITE ORDER PROCESSING  
AND HELP REDUCE SHIPPING COSTS.
- 5.) PROVIDE COMPLETE DETAILS FOR (SHIP TO) AND (BILL TO)  
INFORMATION. TO ASSIST PROMPT DELIVERY, SPECIFY TYPE OF  
CARRIER PREFERRED IN SHIPMENT.
- 6.) ALL MAJOR CREDIT CARDS ACCEPTED.

# SAFETY RULES



**IMPORTANT:** Read and follow these safety rules. They are for your protection and the protection of those working with you

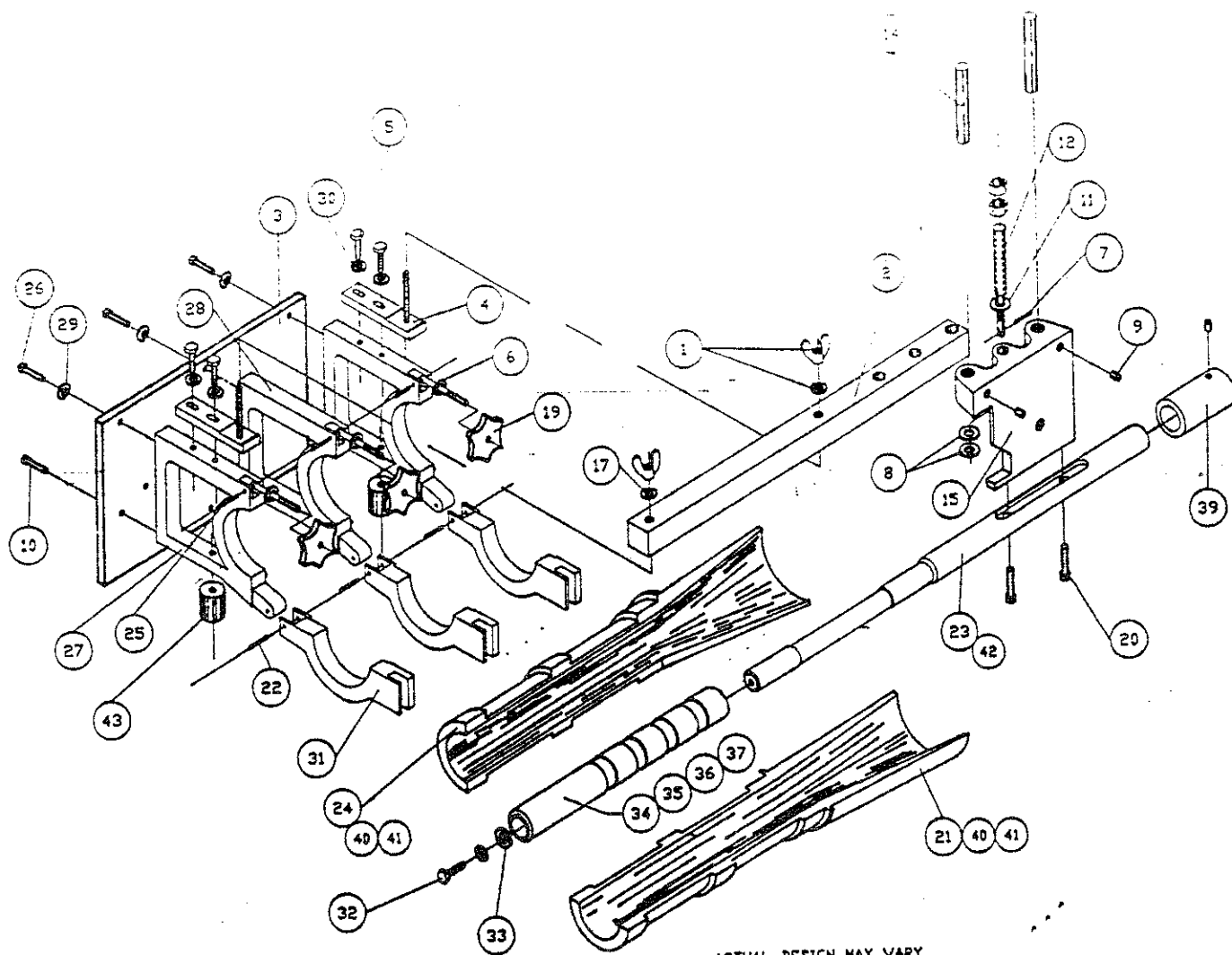
- DO NOT operate this machine before you read and understand the Operations and Safety Manual
- Follow all instructions during use of the machine
- Leave all guards in place. Install all guards if they were removed for cleaning, maintenance, repair or other reasons
- NEVER operate the machine with any SAFETY guard(s) missing
- NEVER operate the machine if you have NOT been trained to operate the machine properly
- NEVER operate the machine if you are tired, ill, on medication, or under the influence of alcohol or drugs
- Wear tight fitting clothes. Make sure that long hair, jewelry, or loose personal items are secured so they cannot get caught in the machine. This can lead to serious injuries
- Make sure you can easily reach all controls. If not, a stable and safe elevated platform or other work-aids must be provided
- ALWAYS disconnect the main electrical power source before cleaning, if maintenance or service is performed, or if the machine is out of service
- NEVER clean bagel forming belt on machine, always remove belt from machine to clean or service (WHEN APPLICABLE)
- NEVER leave this machine running unattended

**IMPORTANT:** If you have any questions about these safety rules, see your supervisor or call A.M. Manufacturing Co. toll free: (800) 342-6744



ITEM	PART NO.	DESCRIPTION	NO. REQ'D.
1	BFM1	HEX HEAD BOLT	2
	BFM1	HEX HEAD BOLT (OBSOLETE)	2
	BFM1B	WING NUT w/ WASHER	2
2	BFM2	MANDREL MOUNT BAR	1
3	BFM3	ADJUSTING MOUNT PLATE	1
4	BFM4	HORIZONTAL ADJUSTING BLOCK ASSEMBLY w/ 2-BFM14 BOLT 2-BFM1B WING NUT	2
5	BFM5	H.H. SCREW	7
6	BFM6	STUD-LOCKING RINGED	3
7	BFM7	ROLL PIN	1
8	BFM8	WASHER	2
9		SET SCREW	2
10		S.H. BOLT	2
11	BFM11	LOCK NUT	1
12	BFM12	VERTICAL ADJUSTING SCREW w/ 2-BFM13 HEX NUT	1
			2
14	BFM14	VERTICAL SLIDE PIN	2
15	BFM15	MANDREL SUPPORT ADJUSTING ASSEMBLY w/ BFM16 VERTICAL PLATE	1
17	BFM17	WASHER	2
19	BFM19	STAR KNOB	3
20	BFM20	S.H. SCREW	2
21	BFM21	FORMING TUBE, RIGHT OUTER	
22	BFM22	HINGE PIN	3
23	BFM23	MANDREL- ADAPTOR SUPPORT	
24	BFM24	FORMING TUBE, LEFT INNER	
25	BFM25	ROLL PIN	3
26	BFM26	H.H. SCREW	3
27	BFM27	FORMING TUBE HOLDER OUTER, STATIONARY	2
28	BFM28	FORMING TUBE HOLDER INNER, STATIONARY	1
29	BFM29	LOCK WASHER	3
30	BFM30	PLAIN WASHER	4
31	BFM31	FORMING TUBE CLAMP	3
32	BFM32	HEX NUT	1
33	BFM33	WASHER 1-3/8 O.D. x 3/8 I.D. x 1/8	1
34	BFM34	MANDREL SLEEVE 1-1/2' DIA.	
35	BFM35	MANDREL SLEEVE 1-7/8' DIA.	
36	BFM36	MANDREL SLEEVE 1-3/4' DIA.	
37	BFM37	MANDREL SLEEVE 2.0' DIA.	
	BFM37A	MANDREL SLEEVE 2-1/8' DIA.	
38	BFM38	LOCK WASHER	2
39	BFM39	MANDREL BRIDGE w/ SET SCREW	1
40	BFM40	MINI FORMING TUBES INNER & OUTER	1
41	BFM41	BULL FORMING TUBES INNER & OUTER	1
42	BFM42	COMBINED MINI MANDREL & SUPPORT BAR	1
43	BFM43	Ø 1.0' x 2.0' LG. ALUM. SPACER	2
<hr/>			
BFM1AS	STANDARD COMP. BFM ASSEMBLY FROM MINI TO STANDARD SET-UP INCLUDES: 1-BFM2 MANDREL MOUNT BAR 2-BFM14 VERTICAL SLIDE PIN 1-BFM15 MANDREL SUPPORT ADJUSTING ASSB. w/ 1-BFM16 VERTICAL PLATE 2-BFM7 ROLL PIN 2-BFM8 WASHER 1-BFM35 MANDREL SLEEVE 1-7/8' 1-BFM32 WASHER 1-BFM33 NUT 2-BFM20 SOCKET HEAD SCREW 1-BFM23 MANDREL ADAPTOR SUPPORT 1-BFM12 VERTICAL ADJUSTING SCREW 1-BFM21 FORM TUBE RIGHT, OUTER 1-BFM24 FORM TUBE LEFT, INNER 1-BDP21 STANDARD BAGEL CONV. w/ BELT 9' WIDE 1-BFM39 MANDREL BRIDGE 1-BFM11 HEX NUT		
BFM2A	STANDARD COMP. BFM ASSEMBLY FROM BULL SET-UP TO STANDARD INCLUDES: 1-BFM21 FORM TUBE RIGHT, OUTER 1-BFM24 FORM TUBE LEFT, INNER 1-BFM35 MANDREL SLEEVE 1-7/8' 1-BDP21 STANDARD BAGEL CONV. w/ 9' WIDE BELT		
BFM3A	MINI SET-UP FROM STANDARD TO MINI SET-UP & FROM BULL TO MINI SET-UP INCLUDES: 1-MS2 2" MEASURING CUP 1-BDP23 MINI BAGEL w/ 6' WIDE CONV. BELT 1-BFM40 MINI FORMING TUBE 1-BFM42 MANDREL & SUPPORT BAR 1-1/8" 1-BFM15 VERT. PLATE MANDREL SUPPORT ADJUSTING ASSB. 1-BFM2 BAR-MANDREL MOUNT 1-BFM11 HEX NUT 1-BFM12 VERT. ADJUSTING SCREW w/ BFM13 HEX NUT 2-BFM14 VERT. SLIDE PIN		
BFM4A	BULL SET-UP ASSEMBLY INCLUDES: BFM41 FORMING TUBES BDP22 BULL BAGEL CONV. BELT 10' WIDE BFM37 MANDREL SLEEVE 2' DIA.		

M. MFG. CO.  
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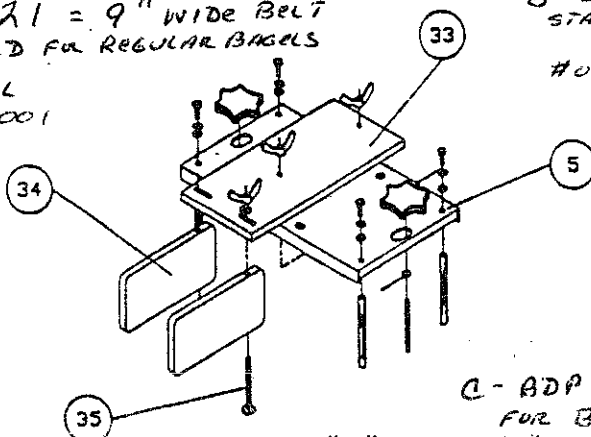
ACTUAL DESIGN MAY VARY,  
FROM THIS PICTURE.

ITEM	PART No.	DESCRIPTION	No. REQ'D.
1	1001R	IDLER	1
2	1011R	IDLER SHAFT	1
3	1021R	SHAFT COLLAR W/SCREW	2
4	1031R	ROLLER GUARD BAR	2
5	1041R	MOUNTING BRIDGE	1
6	F0416SD	1/4-20 THREADED ROD	2
7	F0400FW	FLAT WASHER	2
8	F0400WN	1/4-20 WING NUT	1
9	1051R	SUPPORT COLUMN	2
10	BCP5	STAR KNOB	4
11	F0404HH	1/4-20 BOLT	2
12	F0400FW	FLAT WASHER	8
13	F0400LW	LOCK WASHER	8
14	SF0011	FARING STRIP	8
15	SFPP13	PRESSURE PLATE	2
16	SFPP12	PRESUURE PLATE FACING	1
17	SFPP24	1/4-20 STUD	1
18	F0400NC	1/4-20 NUT	4
19	F0400FW	FLAT WASHER	12
20	152RC	PLASTIC STRIP	2
21	132RC	BLADE	1
22	133RC	SUPPORT BRACKET	1
23	F9700LW	LOCK WASHER	1
24	F9700FW	FLAT WASHER	4
25	F9700NC	#8 HEX NUT	4
26	F9703HH	#8 PAN HEAD BOLT	4
27	1061IR	ANGLE SUPPORT BRACKET	4
28	F0800NC	1/2-13 HEX NUT	2
29	1071R	1/2-13 THREADED ROD	2
30	1081R	PIN	2
31	SFPP17	SPRING	4
32	A + B + C *BDP21*	STD. BAGELFORMER 100 BELT	1
* 33	SFPP15	DOUGH GUIDE BRACKET	1
* 34	SFPP16	ADJUSTABLE DOUGH GUIDE	2
* 35	F0415RH	1/4-20 x 3-3/4' TRUSS HD BOLT	2
** 36	SFPP18	90° DOUGH GUIDE	1
** 37	F0404TH	1/4-20 TRUSS HEAD BOLT	2

(\*) OPTION 'A' FOR USE WITH MODEL (SAB 801) DIVIDER / FORMER ONLY...

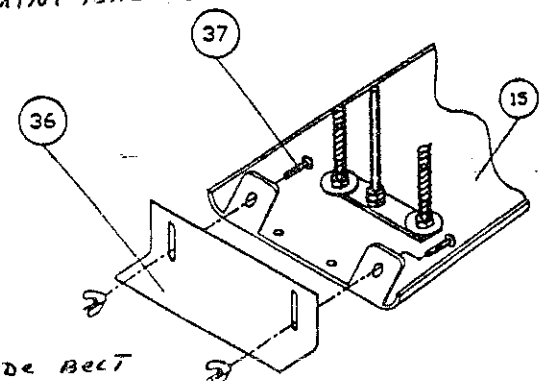
(\*\*) OPTION 'B' FOR USE WITH MODEL (RK2100) DIVIDER / FORMER ONLY...

A - BDP 21 = 9" WIDE BELT  
STANDARD FOR REGULAR BAGELS  
9" W X 15' L  
#0069210001



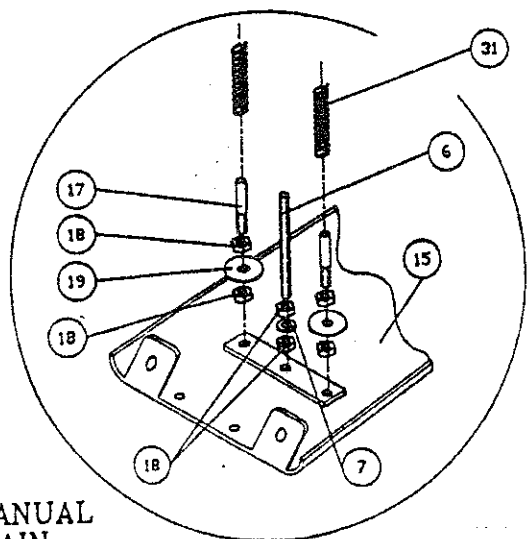
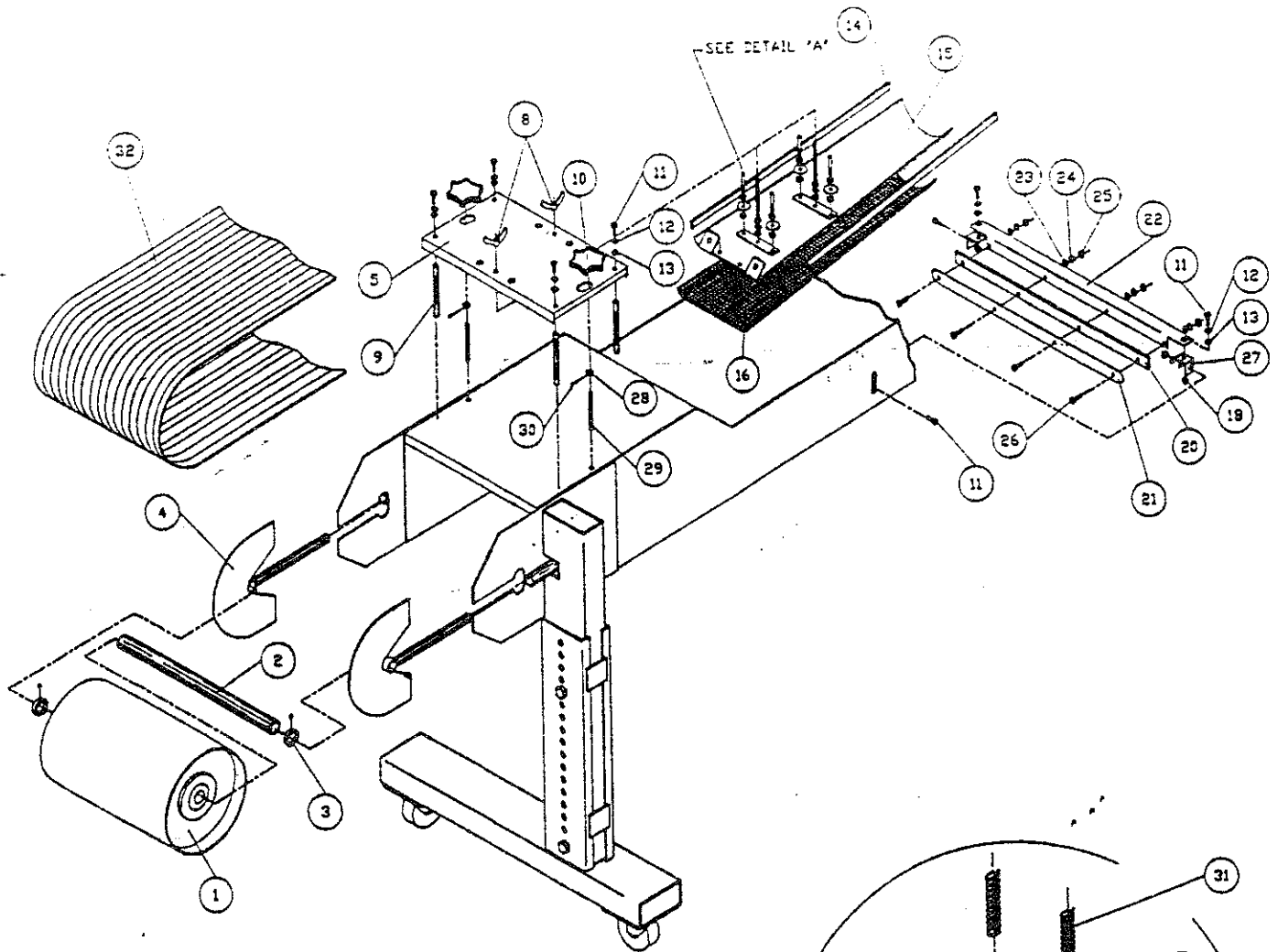
OPTION "A"

B - BDP 23 = 6" WIDE BELT  
STANDARD FOR MINI BAGELS  
6" W X 15' L  
#0069210002



OPTION "B"

C - BDP 22 = 10" WIDE BELT  
FOR BULK BAGELS  
10" W X 15' L  
#00692100



DETAIL "A"

# ⚠ IMPORTANT

KNOW YOUR UNIT. COMPARE DIAGRAMS IN THIS MANUAL  
WITH THE UNIT BEFORE STARTING SERVICE TO OBTAIN  
MAXIMUM SAFETY AND PERFORMANCE.

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