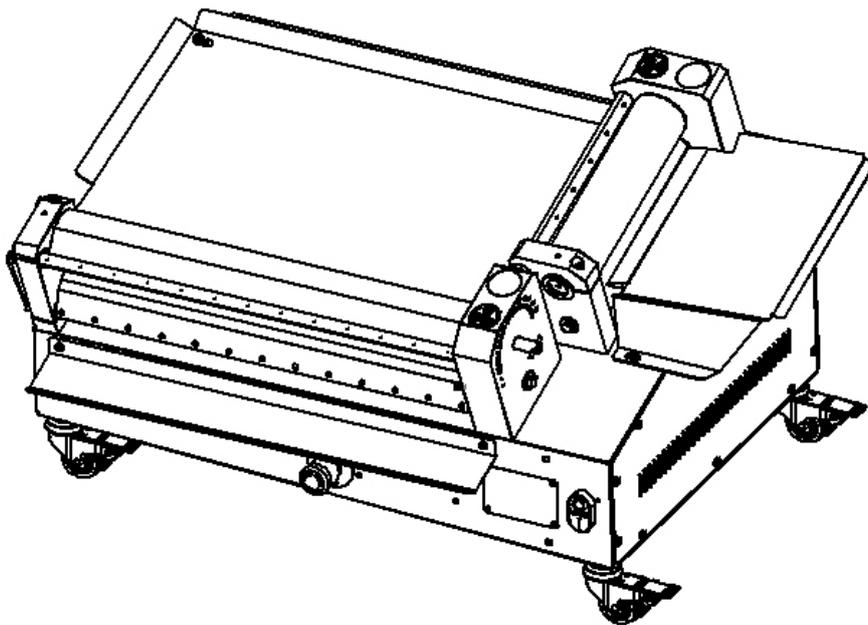




MODEL
TTA-55YH, TTA-60YH
DOUGH ROLLING MACHINE (HORIZONTAL SPEED CONTROL)



USER & MAINTENANCE MANUAL

GMG GmbH | Wendenweg 7 | 44149 Dortmund

Tel: +49(231) 1678 0152 Fax: +49(231) 1678 0153 Email: germany@gmgoven.com

WARRANTY CERTIFICATE



SERIAL NUMBER:

SALE DATE:

Sold at the above date **TTA-55YH MODEL DOUGHS ROLL OUT MACHINE** is guaranteed against production failures for **1 Year** by **GMG ENDÜSTRİYEL MUTFAK EKİPMANLARI SAN. TİC. LTD. ŞTİ.**

Warranty Terms;

- Warranty terms start after the product delivery for 1 year.
- Recommended daily working time is 10 hours. The scope of warranty is assessed by year or by working hours.
- The product is under warranty except plastic rollers (included plastic rollers if it is a manufacturing defect).
- Documents are invalid, if haven't sale date and confirm signature of company. You have to show the warranty certificate to benefit from the warranty.
- Device is guaranteed against defects if mount and use as described in the use and maintenance manual.
- Detection the location of defects, and elimination of the problems are responsibilities of the **GMG ENDÜSTRİYEL MUTFAK EKİPMANLARI SAN. TİC. LTD. ŞTİ.**
- Warranty terms include only one device. You can't claim any rights or compensation for another device.
- If Changes are made at the type, model and serial numbers, the warranty eliminates.
- If material, worker or assembly defects appear, repaired free by **GMG ENDÜSTRİYEL MUTFAK EKİPMANLARI SAN. TİC. LTD. ŞTİ.** at the product warranty period (Transportation cost is not included).
- Failures are only repaired by **GMG ENDÜSTRİYEL MUTFAK EKİPMANLARI SAN. TİC. LTD. ŞTİ.** personal. The intervention of unauthorized person, cancel the appliance of warranty.
- Installation have to be done by **GMG ENDÜSTRİYEL MUTFAK EKİPMANLARI SAN. TİC. LTD. ŞTİ.** personal. If usage place changes, customer must give information to **GMG ENDÜSTRİYEL MUTFAK EKİPMANLARI SAN. TİC. LTD. ŞTİ.**
- In the event of failure service must be informed.
- The failures and damages given by external factors are out of the warranty terms.
- Any failure of the product warranty period is added to the product warranty time. The repair time is until 20 working days.

AUTHORIZED PERSON

STAMP –SIGNATURE

PRESENTATION

- Please read the manual carefully before installing the machine.
- The machine will be out of warranty when you operate the machine without reading.
- Please read carefully the manual that gives you information on the installation is prepared in accordance with the legal regulations before arriving at the machine installation.
- For information you cannot understand, ask your nearest authorized service.
- Please note that if the technical service personnel is kept waiting you will be billed for each hour.

CONTENTS

WARRANTY CERTIFICATE

PRESENTATION

SECTION 1: INTRODUCTION

- 1.1 General Introduction of Dough Rolling Machine Model: TTA-55YH, TTA-60YH
- 1.2 Technical Specifications Table
- 1.3 Safety Warnings Labels

SECTION 2: INTRODUCTION OF MACHINE BODY COMPONENTS

SECTION 3: INSTRUCTIONS FOR USE

- 3.1 Usage Recommendations
- 3.2 Safety Warnings
- 3.3 Operating and Starting Instructions

SECTION 4: MAINTENANCE INSTRUCTIONS

- 4.1 Exterior Body Maintenance
- 4.2 Scraping Knife Maintenance

BÖLÜM 5: TTA-55YH, TTA-60YH SPARE YUFKA OPENING MACHINE SPEED CONTROL INSTRUCTION MANUAL

SECTION 6: SPARE PARTS MANUAL

- 6.1 TTA-55YH Spare Parts
- 6.2 TTA-60YH Spare Parts

SECTION 7: ELECTRICAL DIAGRAM

- 7.1 TTA-55YH / TTA-60YH Electrical Diagram

SECTION 1: INTRODUCTION

1.1 General Introduction of Dough Rolling Machine Model: TTA-55YH, TTA-60YH:

Uses at lahmacun, pizza and other dough rolling processes. Dough thickness and diameter get easy with roller gap adjustment system. Dough rolling process perform in min. 6, max. 8 seconds with fast and easy using feature.

1.2 Technical Specifications Table:

Technical Specifications Table	TTA-55YH	TTA-60YH
Length (cm)	59	63
Width (cm)	93	99
Height (cm)	52	55
Machine Weight (Kg)	64	68,2
Engine Power (kW)	0,55	0,55
Electrical Specifications (V-HZ)	230V 50/60HZ	230V 50/60HZ
Maximum Dough Weight (gr)	450	450
Dough Diameter (cm)	26-55	26-60
Roller Range (mm)	0-2	0-2
Hourly Production Quantity	450-600	450-600

1.3 Safety Warnings Labels:



CAUTION!
CLEANING INSTRUCTIONS

- Do not put foreign materials between working machine rollers.
- Do not wash the machine with wet cloth and clean water, when electrical line is connected.
- Do not clean the machine, when it is working.
- Always check the cooling fan is running on the machine.
- Two monthly, open the back cover of the machine after removing the plug and clean inside of the machine by a pain brush or vacuum cleaner.
- At the end of business, remove the roller scraper blades and clean by wet cloth or sponge. Do not hit hard objects and protect against bending.

ATTENTION!

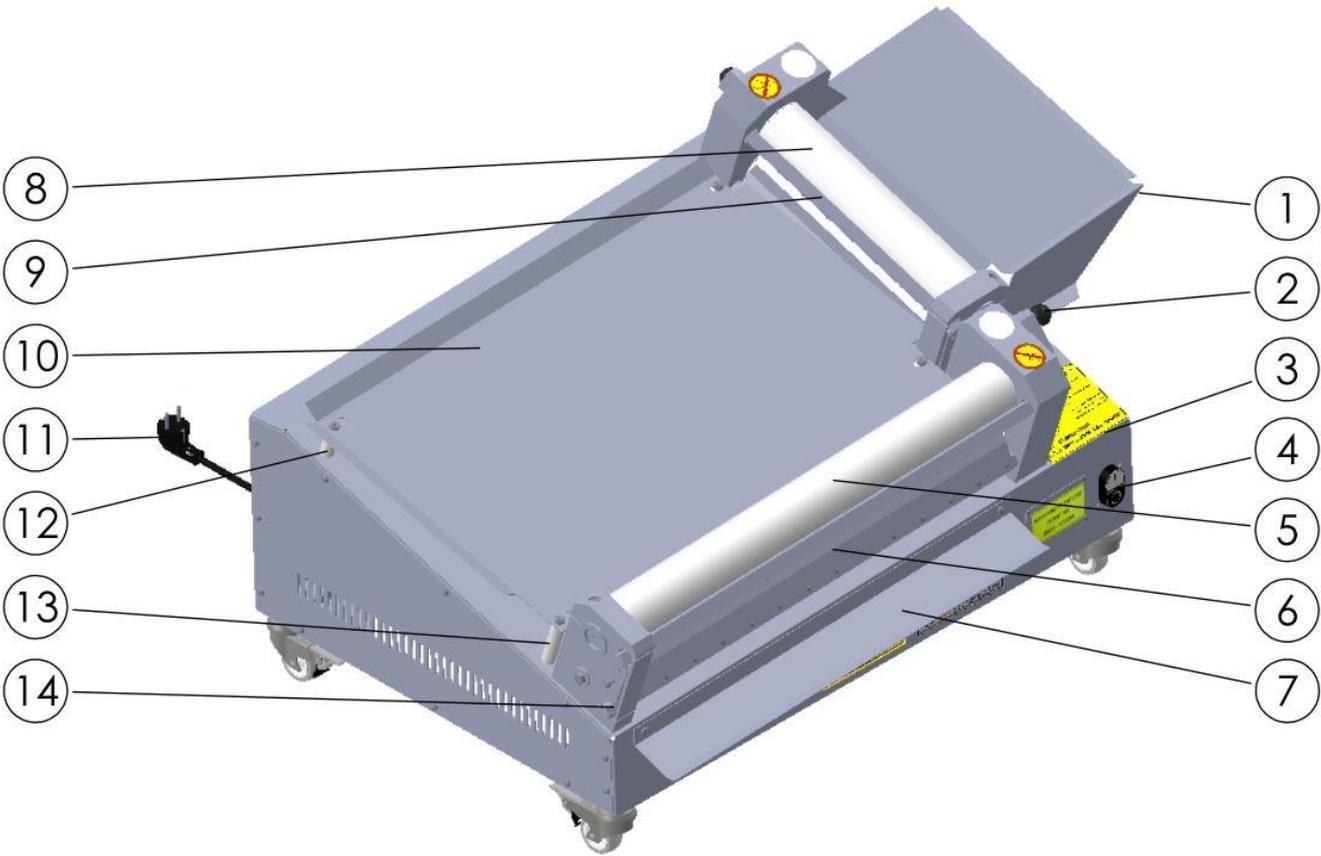
- CUT ELECTRIC CURRENT BEFORE OPENING PROTECTION SYSTEM
- DO NOT CLEAR WHEN MACHINE IS WORKING

KULLANIM TAVSİYELERİ

- 1- Hamur yuvarlağı giriş merdane genişliğinde yakın bir yükseklikte basılmalıdır.
- 2- Basılan hamur giriş merdanesinden şekildeki gibi geçirilir.
- 3- Çıkan uzun geniş elips şeklindeki hamur, orta yolluk sacında şekildeki oklar yönünde çıkış merdanesinden geçirilerek açma işlemi tamamlanır.

ÖNEMLİ UYARI
MAKİNA ÇALIŞIRKEN TEMİZLİK YAPMAYINIZ.

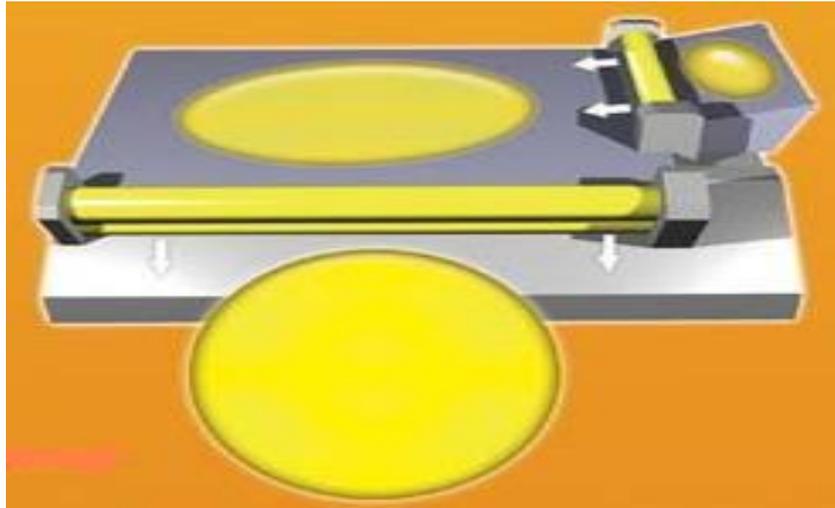
SECTION 2: INTRODUCTION OF MACHINE BODY COMPONENTS



PART DESCRIPTION			
1	ENTRANCE PLATE	8	TOP ROLLER
2	ADJUST LEVER	9	TOP ROLLER SCRAPER
3	BODY	10	CENTRAL PLATE
4	START/STOP SWITCH	11	POWER CABLE
5	BOTTOM ROLER	12	CENTRAL PLATE PIN (SHORT)
6	BOTTOM ROLER SCRAPER	13	CENTRAL PLATE PIN (LONG)
7	OUT PLATE	14	SCRAPER WIRE

SECTION 3: INSTRUCTIONS FOR USE

3.1 Usage Recommendations:



- 1- Compress the dough and make it circular.
- 2- Pass through the dough to the entrance roller gap shown in figure.
- 3- Pass through the dough to the exit roller gap from midway tray shown in figure.

3.2 Safety Warnings:

- 1- Secure voltage is between 230 V and 240 V.
- 2- Set up on a straight floor.
- 3- Single phase on operating.
- 4- Don't wipe the machine with a wet cloth when connect to plug.
- 5- Cut electric current before opening protection system.
- 6- Check the air intake of the cooling fan daily.

3.3 Operating and Starting Instructions:



1. Connect to mono phase electrical supply.
2. Push the "1" button.
3. Adjust the roller gap shown in picture. (This procedure adjust the dough thickness and diameter)

Adjust the dough thickness from "0" to "20" shown in figure.

- Pull back the bakelite knob and rotate the knob to "+" or "-" direction.
- Rotate the knob to "+" direction for enlarge the dough thickness. Rotate the knob to "-" direction for reduce the dough thickness.
- Push the bakelite knob when the intended roller gap adjusted.

NOTE: Entrance roller gap advice to be bigger than the exit roller gap.

NOTE: Scrapers must be stretched.

SECTION 4: MAINTENANCE INSTRUCTIONS

4.1 Exterior Body Maintenance:



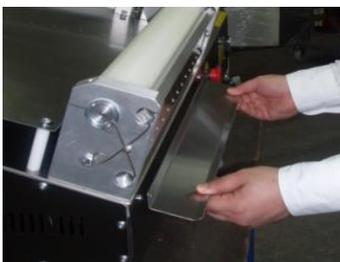
Pull up the entrance and central plates shown in picture then clean the flour and crumbs. Stop the machine and unplug the electrical supply then clean with wet cloth. Don't plug the electrical supply before the machine dry.

4.2 Scrapers Maintenance:



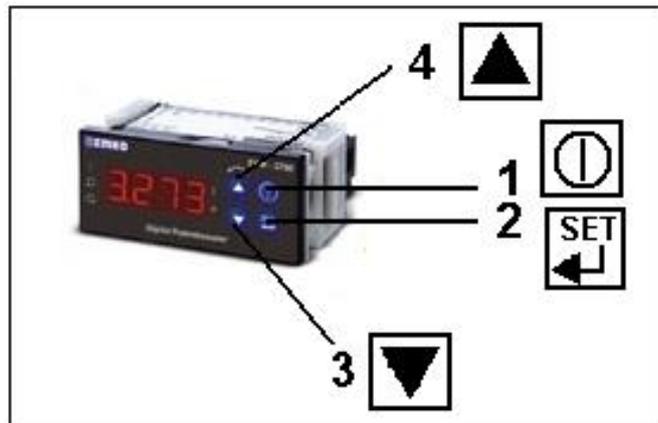
- Push up scrapers wire as shown in the figure
- Remove the scrapers from the hole as shown in the figure and clean the scrapers daily.

4.3 Out Plate Maintenance:



- Take down the bolts. Clean the out PLATE and assemble it back.

SECTION 5: TTA-55YH /TTA-60YH DOUGH ROLLING SPEED CONTROL INSTRUCTIONS FOR USE

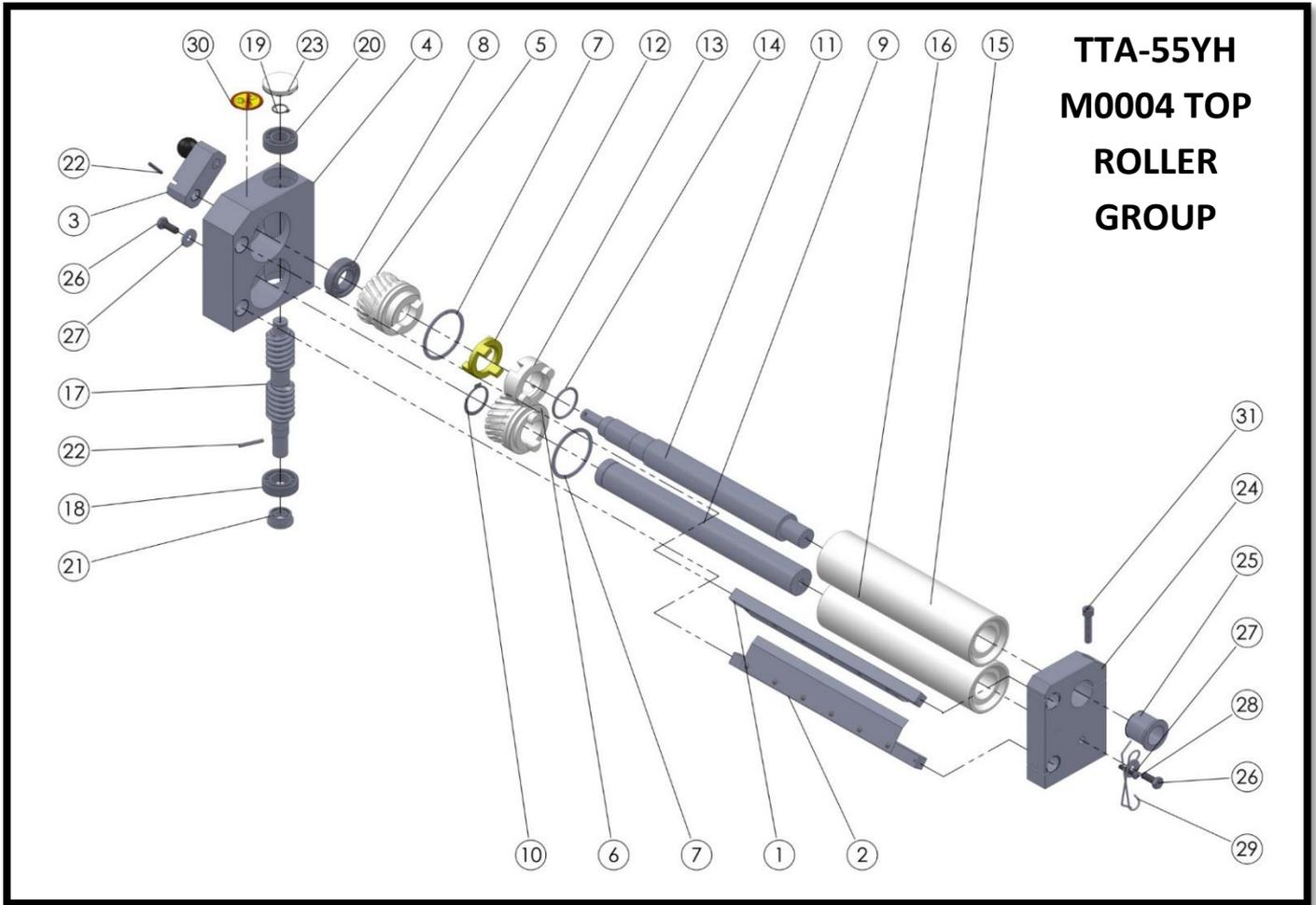


THE PACCO SWITCH IS OPENED AND ENERGY IS GIVEN TO THE MACHINE;

1. Press the power button to start speed control.
2. Press (SET) button to change roller speed with speed control. The speed value will start flashing on the screen, cycle change should be done at this time. Change the speed value with the down (**3**), up (**4**) direction buttons. Save the changed speed value by pressing (SET). (If the speed value flashes four times after pressing the SET button, the recording is done.)
3. Press up (**4**) to turn the rollers in reverse direction. When we repeat the same process, the direction of movement will return to the direction of work.

SECTION 6: SPARE PARTS

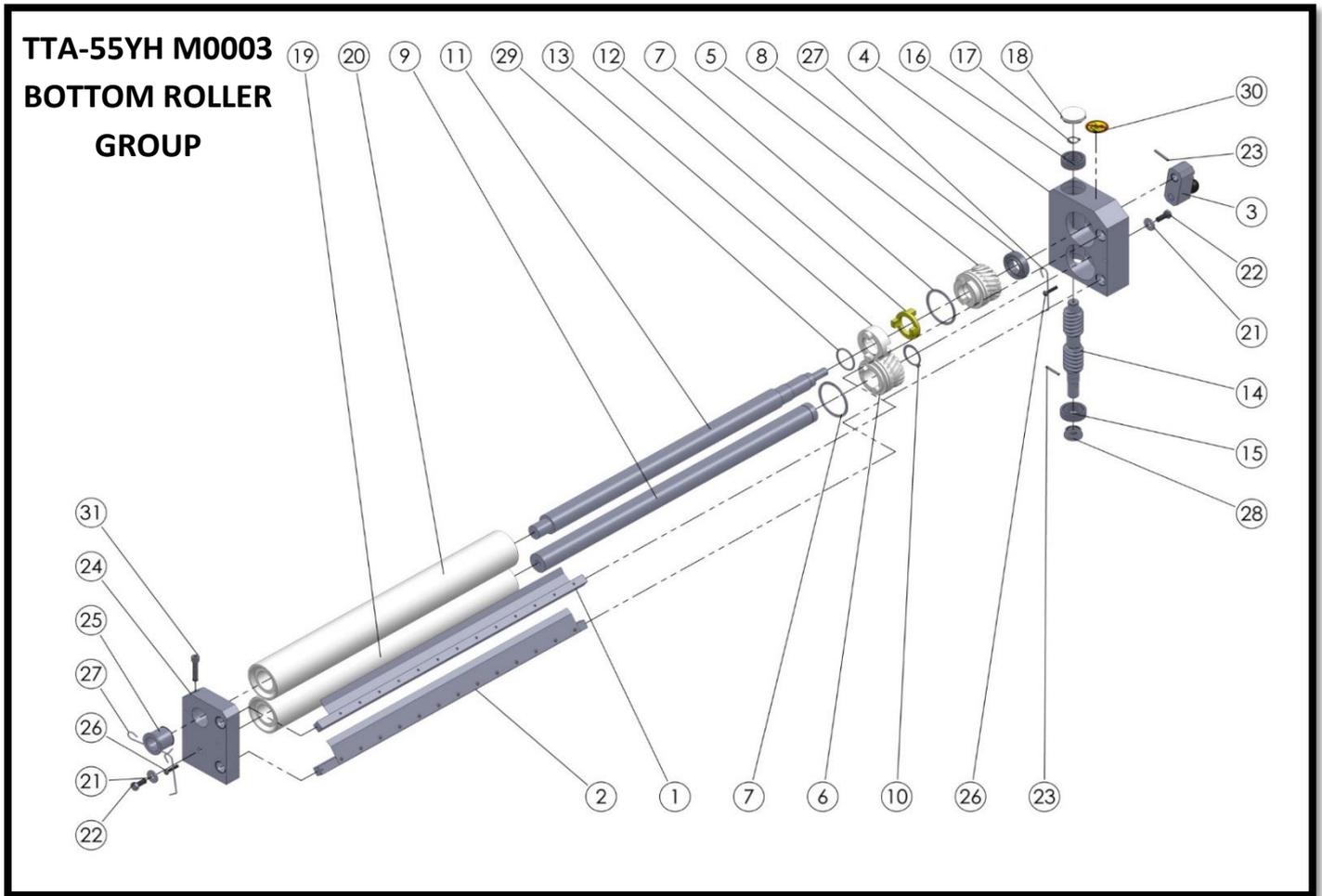
6.1 TTA-55YH Spare Parts Manual:



TTA-55YH M0004 (TOP ROLLER GROUP) SPARE PARTS LIST

ITEM NO	SPARE PART NUMBER	SPARE PART DESCRIPTION	UNIT
1	00346M	ROLLER SCRAPER (TOP)	1
2	00347M	ROLLER SCRAPER (BOTTOM)	1
3	00348M	ADJUST LEVER	1
4	00203	GEAR BOX	1
5	00204	GEAR (FEMALE)	1
6	00205	GEAR (MALE)	1
7	00228	GEAR RING	2
8	00208	BEARING	1
9	00244	SHAFT (BOTTOM)	1
10	00249	RING	1
11	00239	SHAFT (TOP)	1
12	00218	CLUTCH	1
13	00227	ROLLER CLUTCH	1
14	00226	O-RING	1
15	00260	ROLLER (TOP)	1
16	00255	ROLLER (BOTTOM)	1

ITEM NO	SPARE PART NUMBER	SPARE PART DESCRIPTION	UNIT
17	00206	WORM	1
18	00207	BEARING	1
19	00211	RING	1
20	00209	BEARING	1
21	00210	THIMBLE	1
22	00096	PIN	2
23	00219	COVER	1
24	00202	ROLLER BEARING	1
25	00222	THIMBLE	1
26	00043	BOLT	2
27	00044	WASHER	2
28	00266	BOLT	1
29	00267	SCRAPER SPRING	2
30	00037	LABEL	1
31	00349	BOLT	1

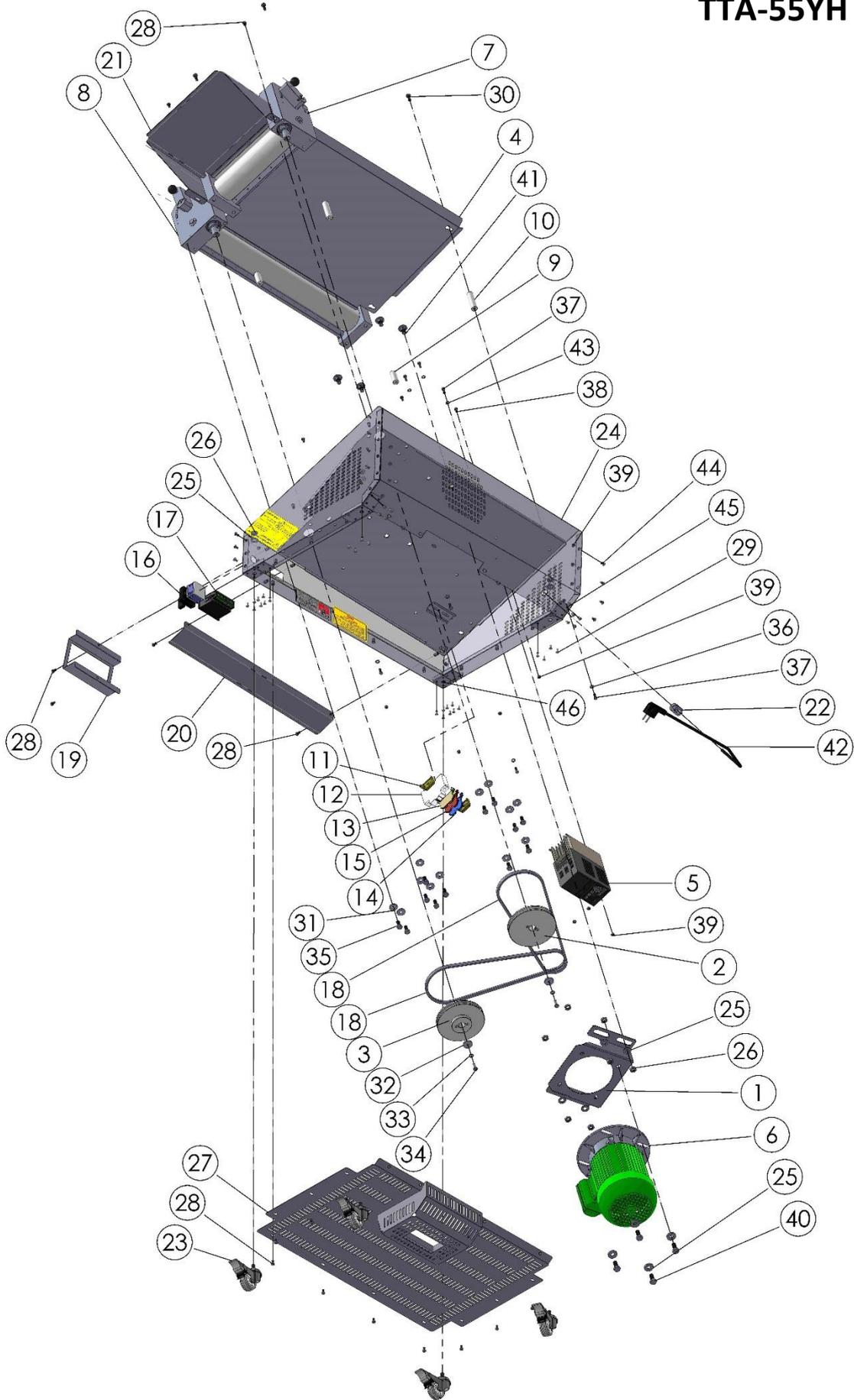


TTA-55YH M0003 (BOTTOM ROLLER GROUP) SPARE PART LIST

ITEM	SPARE PART NUMBER	SPARE PART DESCRIPTION	UNIT
1	00344M	ROLLER SCRAPER (TOP)	1
2	00345M	ROLLER SCRAPER (BOTTOM)	1
3	00348M	ADJUST LEVER	1
4	00201	GEARBOX	1
5	00204	GEAR (FEMALE)	1
6	00205	GEAR (MALE)	1
7	00228	GEAR RING	2
8	00208	BEARING	1
9	00247	SHAFT (BOTTOM)	1
10	00249	RING	1
11	00242	SHAFT (TOP)	1
12	00218	CLUTCH	1
13	00227	ROLLER CLUTCH	1
14	00206	WORM	1
15	00207	BEARING	1
16	00209	BEARING	1

ITEM	SPARE PART NUMBER	SPARE PART DESCRIPTION	UNIT
17	00211	RING	1
18	00219	COVER	1
19	00258	ROLLER (BOTTOM)	1
20	00263	ROLLER (TOP)	1
21	00044	WASHER	2
22	00043	BOLT	2
23	00096	PIN	2
24	00200	ROLLER BEARING	1
25	00222	THIMBLE	1
26	00266	BOLT	2
27	00267	SCRAPER WIRE	3
28	00210	THIMBLE	1
29	00226	O-RING	1
30	00037	LABEL	1
31	00349	BOLT	1

TTA-55YH BODY

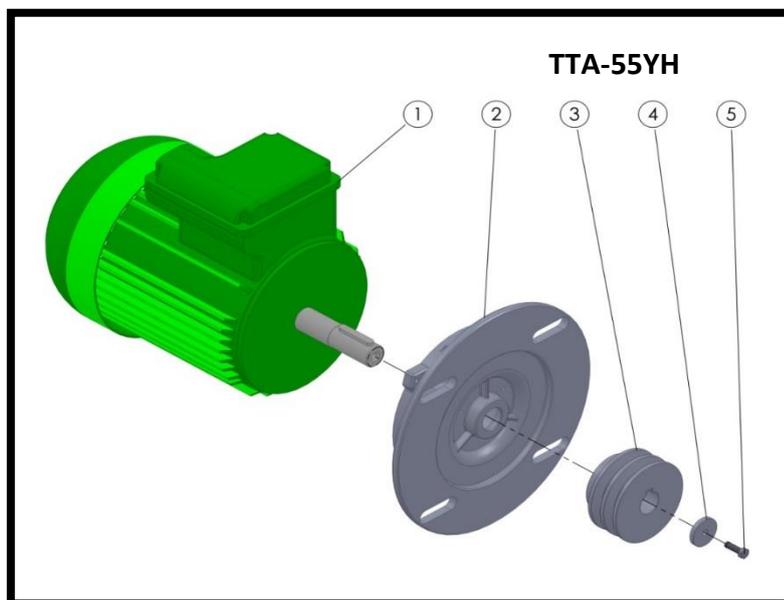


TTA-55YH BODY SPARE PARTS LIST

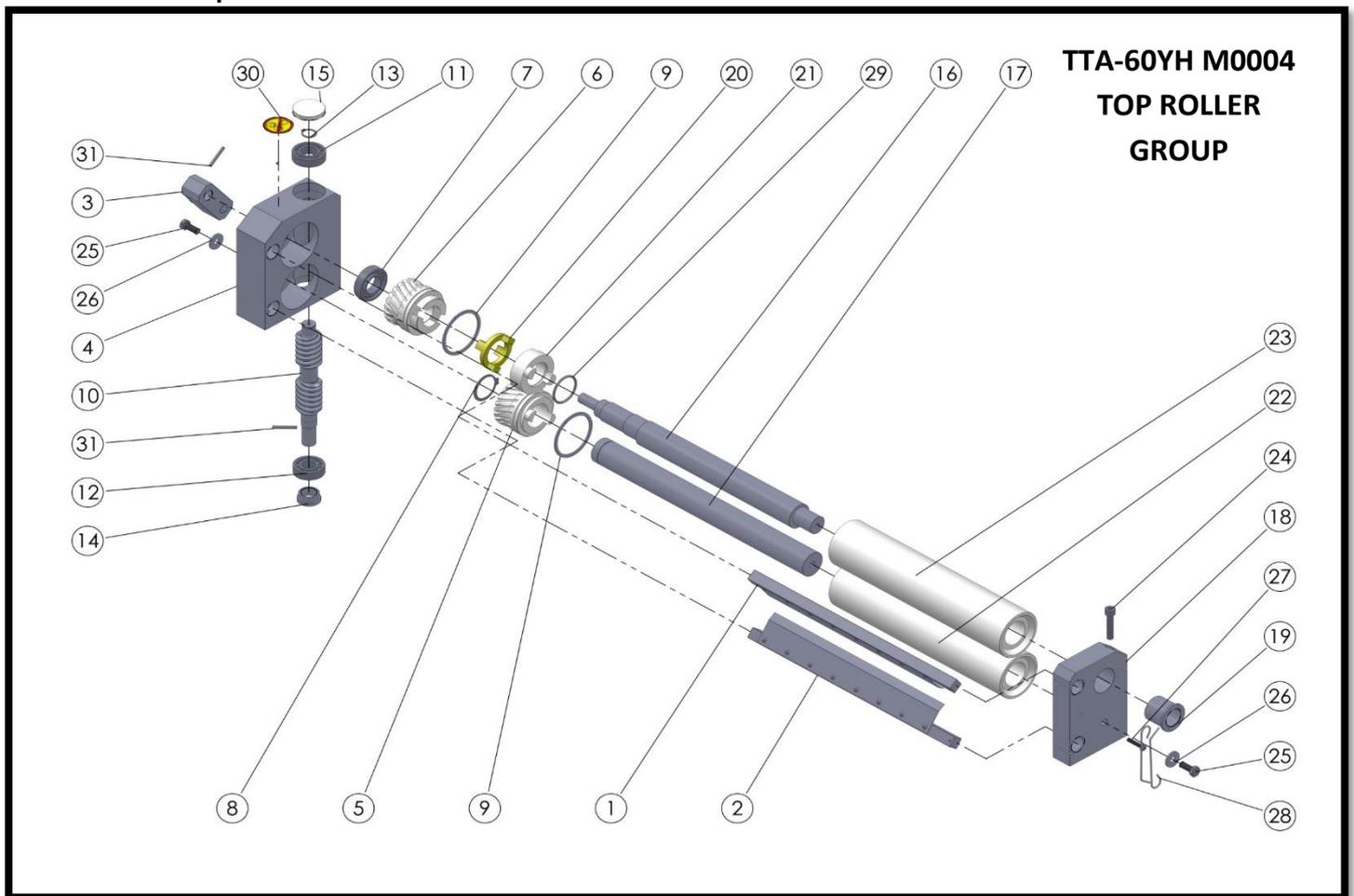
ITEM	SPARE PART NUMBER	SPARE PART DESCRIPTION	UNIT	ITEM	SPARE PART NUMBER	SPARE PART DESCRIPTION	UNIT
1	00480	ENGINE PLATE	1	24	00201M	BODY	1
2	00212	PULLEY	1	25	00277	WASHER	12
3	00213	V BELT PULLEY	1	26	00298	NUT	12
4	00285	MIDDLE FEEDER PLATE	1	27	00198M	BASE	1
5	00384	SPEED CONTROL	1	28	00278	BOLT	20
6	TTA-55YH M0001	ENGINE	1	29	01529	RIVET	32
7	TTA-55YH M0003	UPPER ROLLER GROUP (COMPLETE)	1	30	00291	BOLT	4
8	TTA-55YH M0007	BOTTOM ROLLER GROUP (COMPLETE)	1	31	00044	WASHER	12
9	00289	MIDDLE FEEDER PLATE PIN (SHORT)	2	32	00006	WASHER	2
10	00276	MIDDLE FEEDER PLATE PIN(LONG)	2	33	00042	PLAIN WASHER	2
11	00292	LIMITER	2	34	00041	BOLT	2
12	00301	FUSE	1	35	00043	BOLT	12
13	00293	CONNECTOR (GROUNDING)	1	36	00051	WASHER	4
14	00294	CONNECTOR (BLUE)	1	37	00049	BOLT	7
15	00295	CONNECTOR	1	38	00048	BOLT	4
16	00224	ON / OFF SWITCH	1	39	00052	NUT	21
17	00250	POTENTIOMETER	1	40	00279	BOLT	4
18	00299	BELT	2	41	00499	BOLT	4
19	00522	SWITCH PROTECTION VALVE	1	42	00403	ELECTRIC CABLE	1
20	00537	OUTPUT POLISH	1	43	02582	WASHER	3
21	00535	FEEDER PLATE	1	44	00157	BOLT	14
22	00097	COUPLING	1	45	00527	WHEEL PLATE	2
23	00297	WHEEL	4	46	00528	WHEEL PLATE	2

TTA-55YH M0001 SPARE PARTS LIST

ITEM	SPARE PART NUMBER	SPARE PART DESCRIPTION	UNIT
1	00254	ENGINE	1
2	00252	ENGINE FLANGE	1
3	00214	CASTING V BELT PULLEY	1
4	00098	WASHER	1
5	00049	WASHER	1



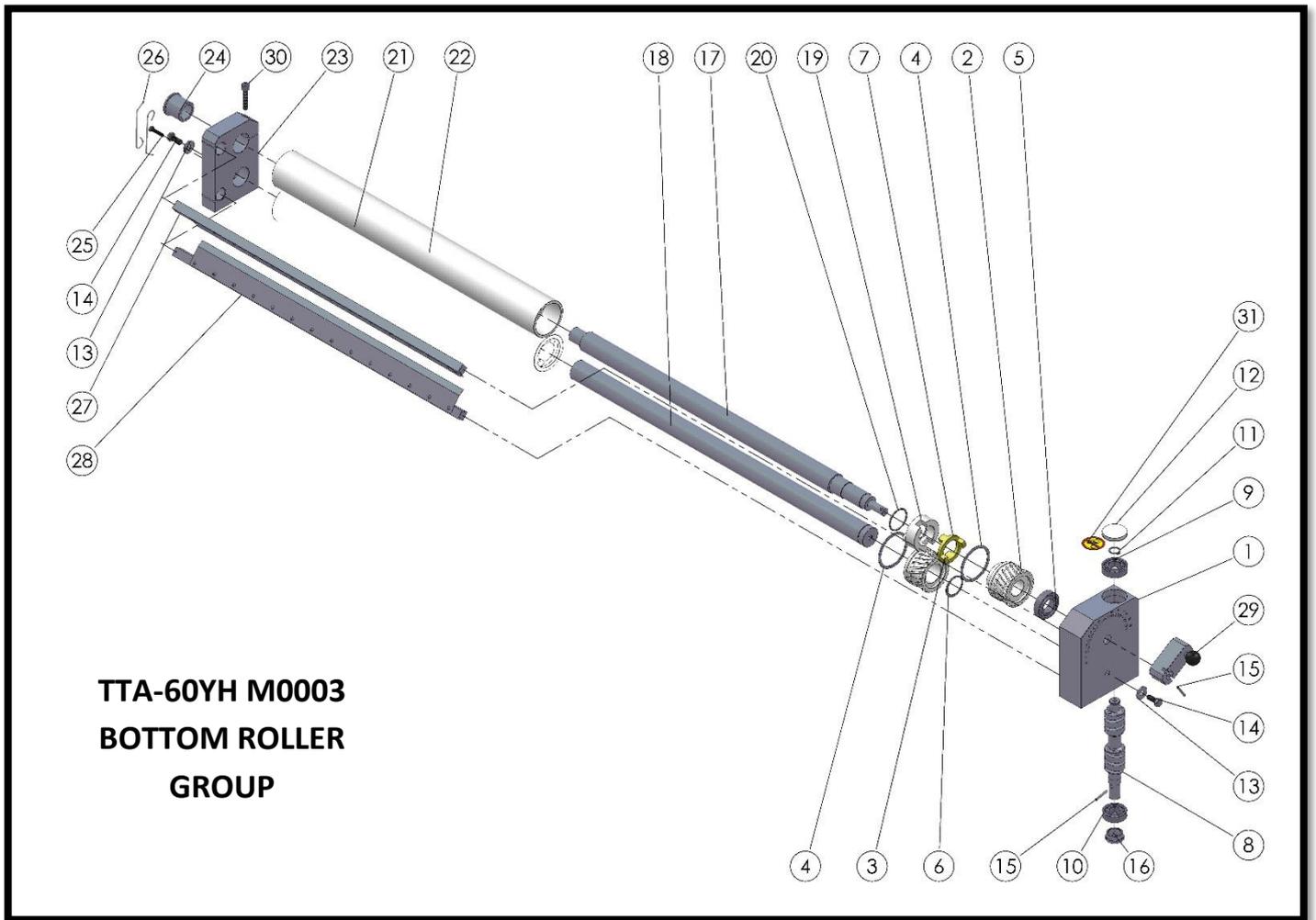
6.2 TTA-60YH Spare Parts Manual:



TTA-60YH M0004 (TOP ROLLER GROUP) SPARE PARTS LIST

ITEM	SPARE PART NUMBER	SPARE PART DESCRIPTION	UNIT
1	00351M	ROLLER SCRAPER (TOP)	1
2	00352M	ROLLER SCRAPER (ALT)	1
3	00348M	ADJUSTING HANDLE	1
4	00203	GEARBOX	1
5	00205	GEAR (MALE)	1
6	00204	GEAR (FEMALE)	1
7	00208	BEARING	1
8	00249	RING	1
9	00228	GEAR RING	2
10	00206	WORM	1
11	00207	GEARING	1
12	00209	GEARING	1
13	00211	RING	1
14	00210	THIMBLE	1
15	00219	COVER	1
16	00240	ROLLER SHAFT (TOP)	1

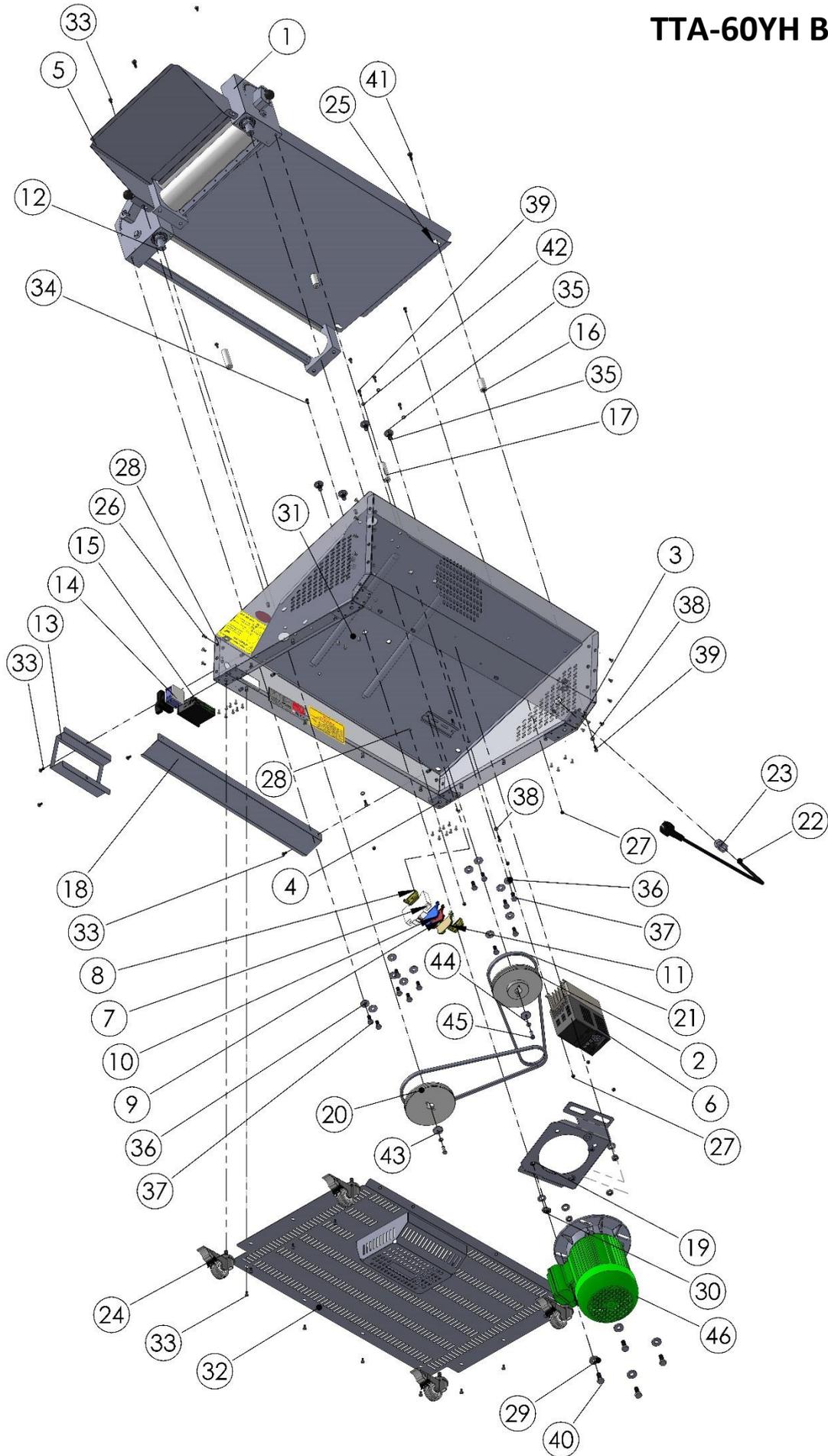
ITEM	SPARE PART NUMBER	SPARE PART DESCRIPTION	UNIT
17	00245	ROLLER SHAFT (BOTTOM)	1
18	00202	ROLLER BEARING	1
19	00222	THIMBLE	1
20	00218	CLUTCH	1
21	00227	ROLLER CLUTCH	1
22	00256	ROLLER (BOTTOM)	1
23	00261	ROLLER (TOP)	1
24	00349	BOLT	1
25	00043	BOLT	2
26	00044	WASHER	2
27	00266	BOLT	1
28	00267	SCRAPERS WIRE	2
29	00226	O-RING	1
30	00037	LABEL	1
31	00096	PIN	2



TTA-60YH M0003 (BOTTOM ROLLER GROUP) SPARE PARTS LIST

ITEM	SPARE PART NUMBER	SPARE PART DESCRIPTION	UNIT	ITEM	SPARE PART NUMBER	SPARE PART DESCRIPTION	UNIT
1	00201	GEAR BOX	1	17	00243	ROLLER SHAFT (TOP)	1
2	00204	GEAR (FEMALE)	1	18	00248	ROLLER SHAFT (BOTTOM)	1
3	00205	GEAR (MALE)	1	19	00227	ROLLER CLUTCH	1
4	00228	GEAR RING	2	20	00226	O-RING	1
5	00208	BEARING	1	21	00259	ROLLER (BOTTOM)	1
6	00249	RING	1	22	00264	ROLLER (TOP)	1
7	00218	CLUTCH	1	23	00200	ROLLER BEARING	1
8	00206	WORM	1	24	00222	THIMBLE	1
9	00207	BEARING	1	25	00266	BOLT	1
10	00209	BEARING	1	26	00267	SCRAPER WIRE	2
11	00211	RING	1	27	00353M	ROLLER SCRAPER (TOP)	1
12	00219	KAPAK	1	28	00354M	ROLLER SCRAPER (BOTTOM)	1
13	00044	WASHER	2	29	00348M	ADJUST LEVER	1
14	00043	BOLT	2	30	00349	BOLT	1
15	00096	PIN	2	31	00037	LABEL	1
16	00210	THIMBLE	1				

TTA-60YH BODY



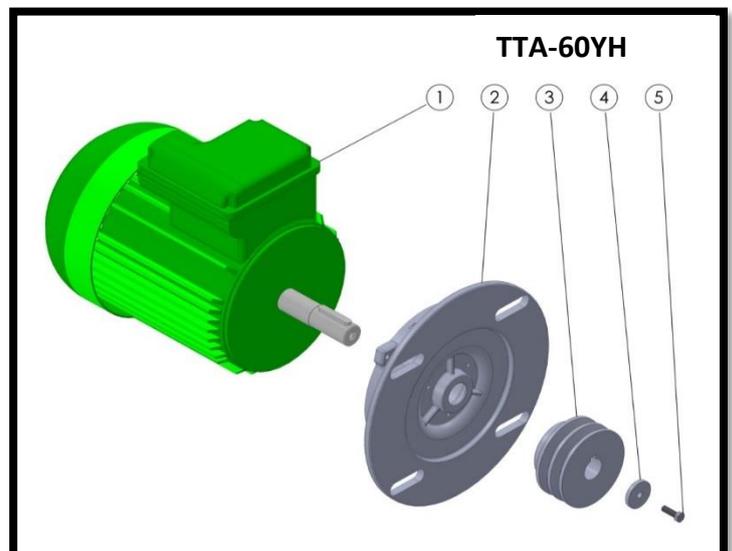
TTA-60YH BODY SPARE PARTS LIST

ITEM	SPARE PART NUMBER	SPARE PART DESCRIPTION	UNIT
1	TTA-60YH M0004	UPPER ROLLER GROUP (COMPLETE)	1
2	00213	V BELT PULLEY	1
3	00527	WHEE PLATE	2
4	00528	WHEEL PLATE	2
5	00523	FEEDER PLATE	1
6	00384	SPEED CONTROL	1
7	00057	FUSE	1
8	00292	LIMITER	2
9	00295	CONNECTOR	1
10	00294	CONNECTOR (BLUE)	1
11	00293	CONNECTOR (GROUNDING)	1
12	TTA-60YH M0007	ROLLER (COMPLETE)	1
13	00522	SWITCH PROTECTION VALVE	1
14	00224	ON / OFF SWITCH	1
15	00250	POTENTIOMETER	1
16	00289	MIDDLE FEEDER PLATE PIN (SHORT)	2
17	00276	MIDDLE FEEDER PLATE PIN	2
18	00275	OUTPUT PLATE	1
19	00480	ENGINE PLATE	1
20	00212	PULLEY	1
21	00299	BELT	2
22	00058	ELECTRIC CABLE	1
23	00097	COUPLING	1

ITEM	SPARE PART NUMBER	SPARE PART DESCRIPTION	UNIT
24	00297	WHEEL	4
25	00271	MIDDLE FEEDER PLATE	1
26	00157	BOLT	14
27	00052	NUT	21
28	00202M	BODY	1
29	00277	WASHER	12
30	00298	NUT	12
31	01529	RIVET	32
32	00199M	BASE PLATE	1
33	00278	BOLT	20
34	00048	BOLT	4
35	00499	BOLT	4
36	00044	WASHER	12
37	00043	BOLT	12
38	00051	WASHER	4
39	00049	BOLT	7
40	00279	BOLT	4
41	00291	BOLT	4
42	02582	WASHER	3
43	00006	WASHER	2
44	00042	PLAIN WASHER M6	2
45	00041	BOLT	2
46	TTA-60YH M0001	ENGINE (WITH FLANGE)	1

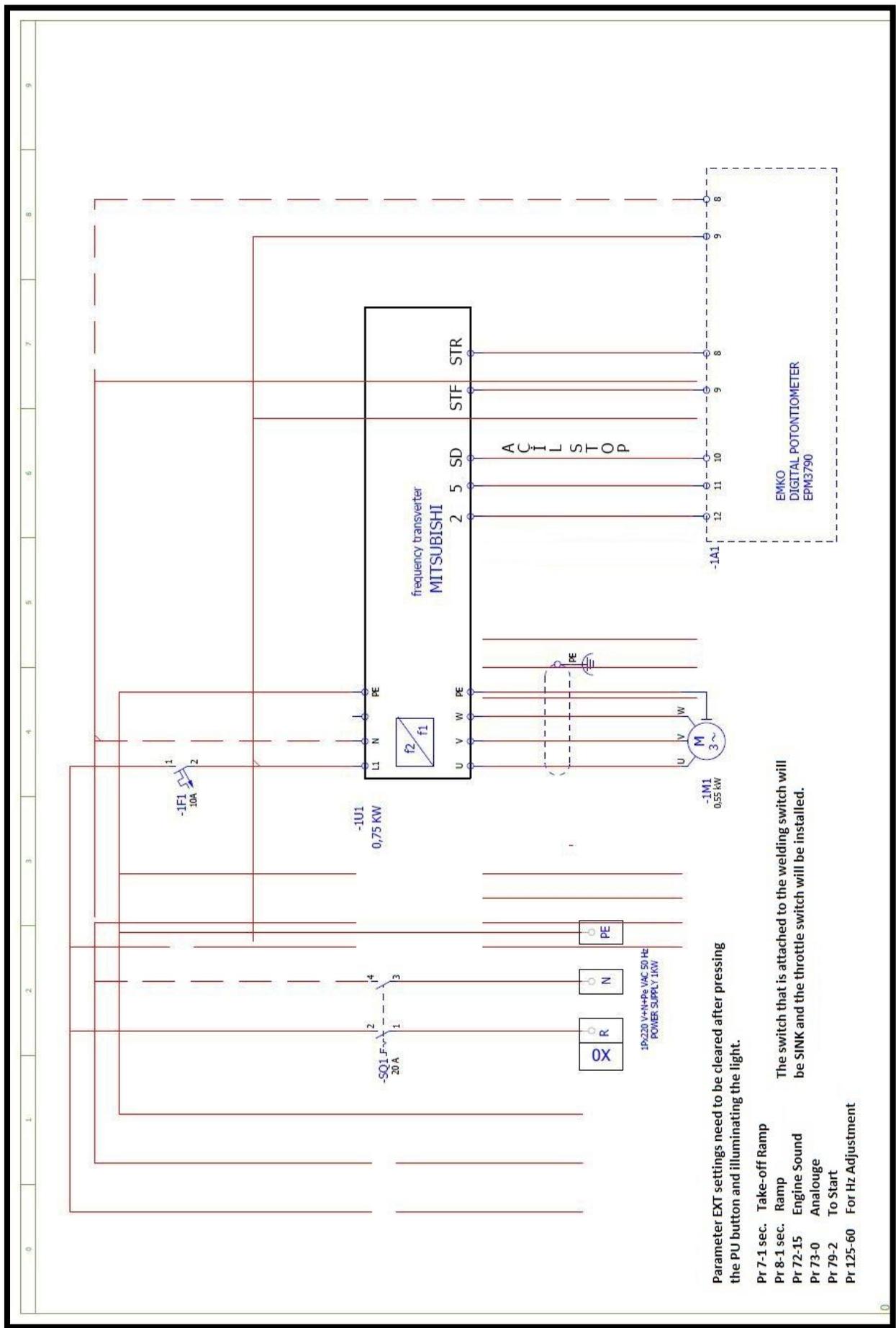
TTA-60YH M0001 SPARE PARTS LIST

ITEM	SPARE PART NUMBER	SPARE PART DESCRIPTION	UNIT
1	00254	ENGINE	1
2	00252	ENGINE FLANGE	1
3	00214	CASTING V BELT PULLEY	1
4	00098	WASHER	1
5	00049	BOLT	1



SECTION 7: ELECTRICAL DIAGRAM

7.1 TTA-55YH / TTA-60YH Electrical Diagram:



Parameter EXT settings need to be cleared after pressing the PU button and illuminating the light.

Pr 7-1 sec. Take-off Ramp
 Pr 8-1 sec. Ramp
 Pr 72-15 Engine Sound
 Pr 73-0 Analogue
 Pr 79-2 To Start
 Pr 125-60 For Hz Adjustment

The switch that is attached to the welding switch will be SINK and the throttle switch will be installed.



GMG GmbH | Wendenweg 7 | 44149 Dortmund

Tel: +49(231) 1678 0152 Fax: +49(231) 1678 0153 Email: germany@gmgoven.com