



Walker, Michigan, U.S.A. 49534

USER'S OPERATING AND INSTRUCTION MANUAL

MODEL 619-MDP

DOUGH PRESS



619-MDP DOUGH PRESS INDEX

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619-MDP DOUGH PRESS

SAFETY INSTRUCTIONS

Every effort has been made by Oliver Products Company to provide you with a safe machine. It is essential, however, that machine operators and maintenance personnel observe the following safety precautions.

1. Before attempting to operate your dough press read this manual. Never allow an untrained person to operate this machine.
2. Make sure that the machine is only connected to a properly grounded electrical supply source of sufficient capacity for the load the divider will put on it. Always unplug the machine when it is not in use.
3. Always make sure the machine has been disconnected and locked-out from the power supply before cleaning or servicing.
4. All guards must be in place before starting the machine.
5. Keep your hands away from the moving parts of the machine.
6. Use only proper replacement parts.
7. Do not wear loose fitting clothing. Shirt tails should be tucked in.
8. In addition to these general safety instructions, also follow the more specific safety instructions given for the different areas of the machine in the operating instructions.

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619-MDP DOUGH PRESS

DESCRIPTION/SPECIFICATION

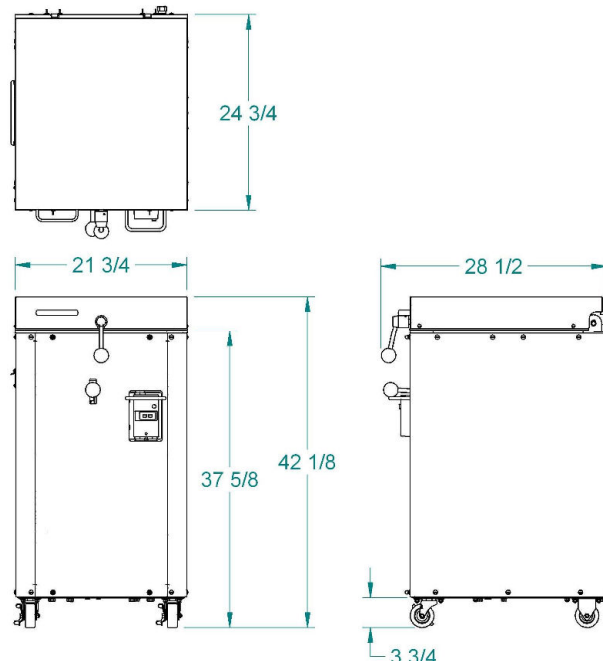
Description

The Oliver dough press consists of a hopper which can be loaded with dough from an approximate minimum of ten and one half pounds up to forty pounds, (depending on the density of the dough). The lid and sides of the hopper are made of hard anodized and Teflon impregnated cast aluminum. The pressing plate located at the bottom of the hopper is manufactured of a food grade plastic and is raised by hydraulic pressure to compress the dough. This makes the machine ideal for puff and fine pastries and products requiring dough lamination.

The hydraulic pump is powered by a two horsepower, totally enclosed motor. The system has a built-in four and one half gallon hydraulic oil tank making the machine totally self-contained and is provided with casters to allow for easy movement about the work area.

Physical specifications

OVERALL MACHINE DIMENSIONS





Physical specifications (continued)

Net Weight:
Approximately 455 pounds.

Shipping Weight:
Approximately 500 pounds.

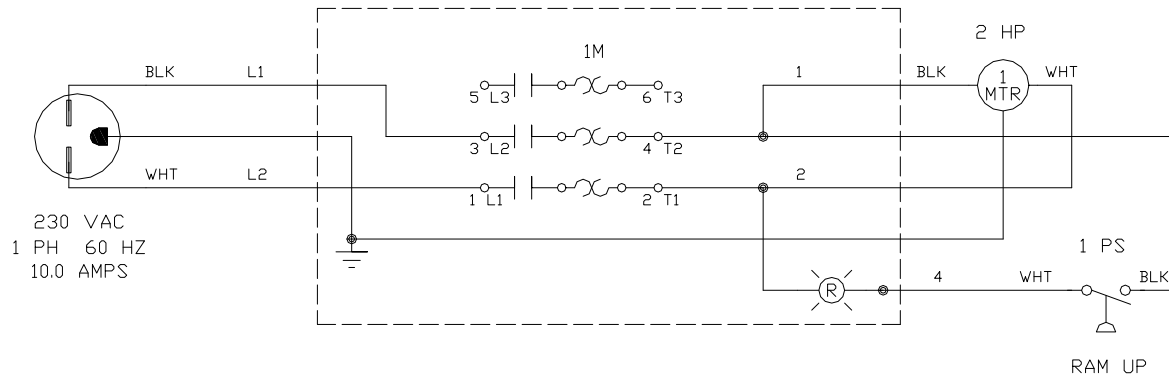
Product Capacities:
Fill Capacity (approximate) = 10-1/2 to 40 pounds

Electrical Specifications

- 2 Horse Power, 1 phase, 60 hertz, 230 Volts AC, 10 Amps.
- 2 Horse Power, 3 phase, 60 hertz, 208 Volts AC, 6.5 Amps.
- 2 Horse Power, 3 phase, 60 hertz, 230 Volts AC, 6.2 Amps.
- 2 Horse Power, 3 phase, 60 hertz, 460 Volts AC, 3.1 Amps.
- Others consult factory

Electrical Wiring Diagrams

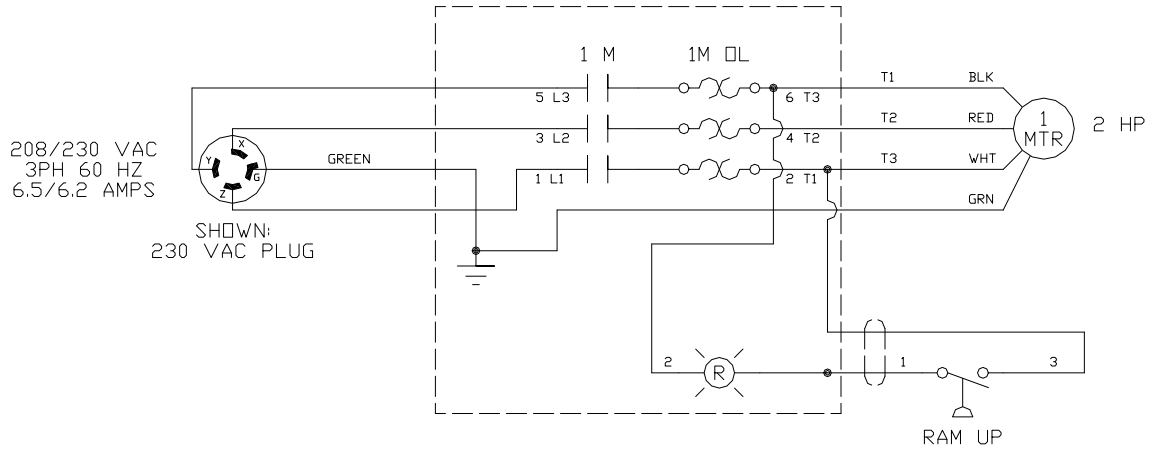
1 ph, 60 hz, 230 VAC



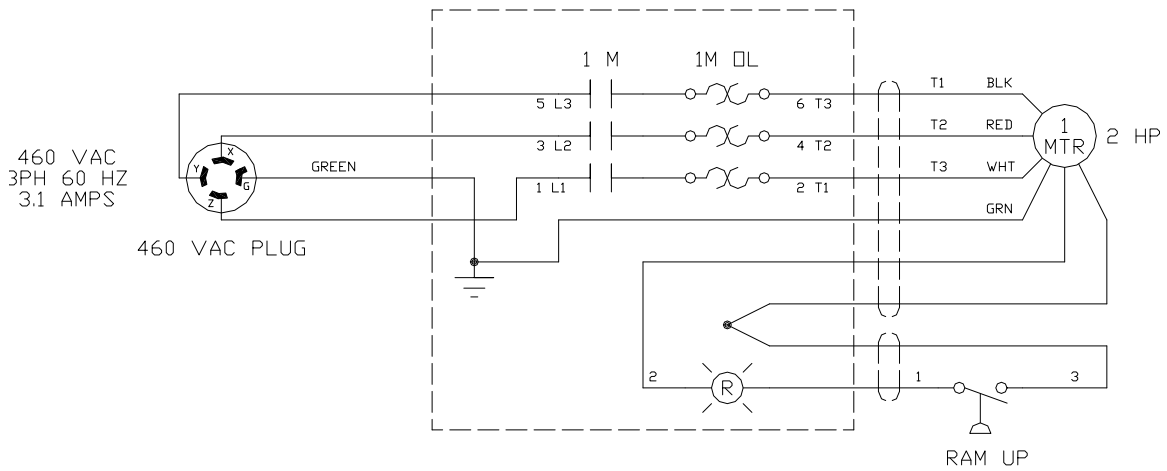


Electrical Wiring Diagrams (Continued)

3 ph, 60 hz, 208/230 VAC



3 ph, 60 hz, 460 VAC





619-MDP DOUGH PRESS

OPERATING INSTRUCTIONS

Before You Start

CAUTION

THE DOUGH PRESS SHOULD **ONLY** BE PLUGGED INTO AN OUTLET WITH THE SAME VOLTAGE AS STATED ON THE NAMEPLATE

Before starting a new dough press with **THREE PHASE** electrical power for the first time you should check to see if the motor is running in the correct direction. Remove the front cover by removing the four thumbscrews which secure it; you will also have to remove the handle from the directional control lever before removing the front cover. Once the cover has been removed you should be able to see the fan end of the motor on your dough press, this fan **MUST** rotate in a clockwise direction.

CAUTION

EXTENDED RUNNING OF A DOUGH PRESS WITH THE MOTOR ROTATING IN THE INCORRECT DIRECTION WILL SEVERELY DAMAGE THE HYDRAULIC PUMP OF YOUR MACHINE.

If the motor is rotating in the incorrect direction turn the machine off, disconnect it from the power supply and have a qualified electrician reverse two of the three power wires in the plug at the end of the power cord. **DO NOT** move the ground, (green), wire.

WARNING

ALWAYS HAVE ELECTRICAL WORK DONE BY QUALIFIED ELECTRICIANS ONLY.

Recheck the dough press making sure that it is now running in the correct direction, (clockwise looking at the fan end of the motor). Each time the machine is moved to a different power supply or has electrical work done which could alter the motor rotation, the motor must be rechecked for proper rotation.

Basic Operation

- Make sure the floor of the hopper has been lowered before attempting to open the lid of the divider.
- Open the lid and load the dough into the hopper. Spread the dough over the floor of the hopper making it approximately the same height, this is done to eliminate large air pockets.



Basic Operation (Continued)

- Close the lid and turn the handle in a clockwise direction making sure it is secure.
- With the machine running grasp the control valve handle and lift it to start the floor of the hopper up. Hold it in this position until the light on the starter switch box comes on, the light indicates that the preset pressing pressure has been achieved. Let loose of the valve handle when you see that the light is on.
- Press the control valve handle down slightly to release the pressure on the lid so it can be opened. Open the lid.
- The dough can now be removed and the above process repeated.

WARNING

NEVER LEAVE DOUGH IN A MACHINE WITHOUT OPENING THE LID;
RISING DOUGH MAY CAUSE EXPLOSIVE PRESSURES TO DEVELOP.

WARNING

NEVER FORCE THE LID HANDLE OPEN

- If dough has been left in the machine and the lid handle is difficult to turn, recompress the dough by lifting the control valve handle until the light come on. This will raise the floor of the hopper, after doing so lower the hopper floor by pressing down on the control valve handle. This may have to be done more than once if dough has been left in the machine for quite awhile. With the hopper floor all the way down try to open the lid again. The handle should turn easily, if it does not, recompress the dough and try again.
- The dough press is designed so that if dough is left in the hopper it will eventually force the hopper



619-MDP DOUGH PRESS MAINTENANCE

WARNING

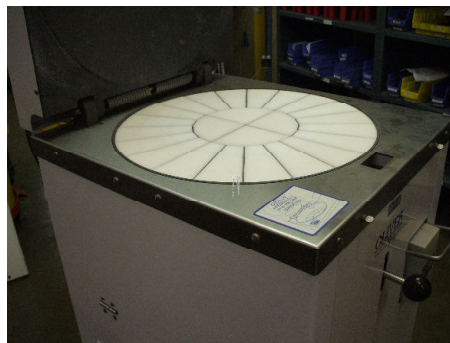
ALWAYS MAKE SURE THE MACHINE HAS BEEN DISCONNECTED FROM THE POWER SUPPLY BEFORE CLEANING OR SERVICING

Cleaning

Remove- all scraps from lower pan. Open side doors and brushing out all scraps. **Wash** all interior surfaces; Knives, pusher plates, hopper, lid surface with a damp rag and mild soap solution. The exterior and contact surfaces should be cleaned daily using common cleaners. The **knives** should be extended for easier cleaning. This can be done by placing the cleaning separator, furnished with the machine, **IN THE CENTER OF THE HOPPER** straddling the knives. Close the lid and bring the floor of the hopper up until the light on the manual starter is on, lower the floor slightly. **Open the lid and disconnect the divider from the power supply.** Clean the knives and plastic compartment floors of all dough build-up. **Rinse** all interior surfaces with a damp rag and clean water. **Sanitize** all interior surfaces with a damp rag and sanitizing solution. **Air Dry**, leave divider lid open and allow interior to air dry before using.

Occasionally, or as required, remove the front and rear covers to allow access to the drive chamber. There you should remove any build up of flour and dough particles in the base of the machine and from around the motor. When finished replace the covers.

CLEANING INSTRUCTIONS FOR THE 619



RUN PRESS ALL THE WAY UP



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*******WARNING*******

UNPLUG MACHINE



**USING THE ACCESS DOORS ON BOTH SIDES OF THE
UNIT
PULL DOOR UP, USE ONE HAND TO HOLD DOOR UP
WIPE DOWN MACHINE WITH OTHER, USING A RAG
OR A BRUSH**



Lubrication

The machine requires no lubrication but the oil level in the hydraulic system should be checked periodically. To check the oil level remove the rear cover by removing the four knobs which secure it to the divider, then remove the tank breather/cap and determine where the top of the oil is in relation to the top surface of the tank. Fill with oil to within approximately one inch of the top surface. If necessary add **HYDRAULIC OIL** to return it to the proper level, **DO NOT OVERFILL**. In addition to the above we advise replacing the hydraulic oil in the system approximately every three years.

Hydraulic Oil Specification

The hydraulic oil used in your divider should be made of good quality base stocks compounded with the following additives: anti-wear, anti-oxidation, antifoaming, and antirust. In addition it should be an



Replacing The Locking Hook Or Cam:

- Remove the lid cover by removing the four screws which secure it in position.
- Detach the spring from the hook.
- Open the lid.
- Turn the handle until the pin securing the cam to the shaft is in line with the notch in the locking hook. Using a small drift punch force the pin upwards removing it from the handle shaft.
- Pull the shaft and cam assembly forward out of the lid.
- The hook or locking cam can now be replaced.
- Reassemble by reversing the above steps.

Replacing A Pressing Plate

- Open the lid and raise the bottom of the hopper.
- Turn the machine off and disconnect it from the power supply.
- Remove the front and rear panels to gain access to the pusher components.
- Remove the sixteen screws securing the pressing plate to the backing plate.
- Using a narrow block of wood or other soft material, force the pressing plate upwards until it is free from the backing plate and then lift the pressing plate out of the cavity.
- Reassemble by reversing the above steps.

Removing the Backing Plate

- Remove the Pressing Plate as described above.
- Remove the bolt securing the backing plate to the cylinder rod. The backing plate can now be lifted from the machine.
- When the machine is re-assembled the bolt securing the backing plate to the cylinder rod should be installed using



Replacing The Hydraulic Cylinder

- Turn the machine on and raise the pressing plate to the top of the hopper and then turn the dough press off and disconnect it from the power supply.
- To remove the hydraulic cylinder the front, rear, and side panels must be removed from the machine.
- Remove the Pressing Plate and Backing Plate as described above.
- Remove the bolts securing the starter switch bracket from the hex support rods, and unplug the pressure switch wires. **DO NOT** disconnect the wires from the starter.
- Remove one of the snap-rings securing the yoke and safety lock pivot pin. Remove the pin so that the linkage can be unhooked from the top of the machine.
- Remove the eight screws securing the cylinder to the cylinder mounting channel.
- Remove the four bolts securing the cylinder mounting channel to the lower hex support rods.
- The upper portion of the divider can now be removed and set to one side.
- Disconnect both high pressure hoses at the cylinder allowing removal of the cylinder for repair or replacement.
- When the machine is reassembled the bolt securing the backing plate to the cylinder rod should be installed using



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Changing The Pump Or Coupling

- Disconnect the machine from the power supply.
- Remove the rear cover and the



619-MDP DOUGH PRESS TROUBLE SHOOTING GUIDE

The "Ram Up Light" does not come on.

Possible Causes

- There may be a disconnected wire.
- The pilot light may have burnt out.
- The pressure switch is not operating and needs replacement.

The motor "Hums" but will not start.

Possible Causes

- The motor is a dual voltage motor and may be wired for high voltage, but, an attempt is being made to run it on low voltage.
- The electric supply to the motor is single phase instead of three phase.
- One of the leads of the three phase system has opened.

The motor runs but "Stalls" at either end of the cylinder's travel.

Possible Causes

- The incorrect overload relay was installed or the setting of that overload relay is incorrect.
- The setting of the hydraulic relief valve is too high.
- The motor is running backwards and needs its rotation corrected. See



The motor runs “Slowly” but stalls easily before completion of its stroke.

Possible Causes

- The motor is wired for high voltage but is connected to a low voltage supply.

Trouble Shooting (Continued)

The motor has “Stalled” and can not be restarted.

Possible Causes

- The overload relay has tripped. Allow the relay about five minutes to cool and attempt to restart the divider.

The overload relay continually trips.

Possible Causes

- An incorrect overload relay was installed or the setting of the overload relay is incorrect.
- There is an electrical problem in the machine have it checked by a qualified electrician.

The dough press is not pressing properly.

Possible Causes

- Check the oil level in the tank, refill if necessary see



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619-MDP DOUGH PRESS

RECOMMENDED SPARE PARTS

<u>PART NUMBER</u>	<u>PART DESCRIPTION</u>	<u>NO. RE 'D.</u>
7024-6101	Extension Spring	1
7030-0024	LH Lid Spring	1
7030-0023	RH Lid Spring	1
5835-7636	Coiled Pin	1
5114-9556	Hydraulic Filter	1
5757-8518	Pressure Switch	1
5709-9924	Starter Enclosure	1
5709-0191	Pilot Light	1
5709-3040	Motor Starter (3-60-460V)	1
5709-3041	Motor Starter (3-60-230V)	1
5709-3042	Motor Starter (3-60-208V)	1
5709-3043	Motor Starter (1-60-230V)	1

OPTIONAL SPARE PARTS

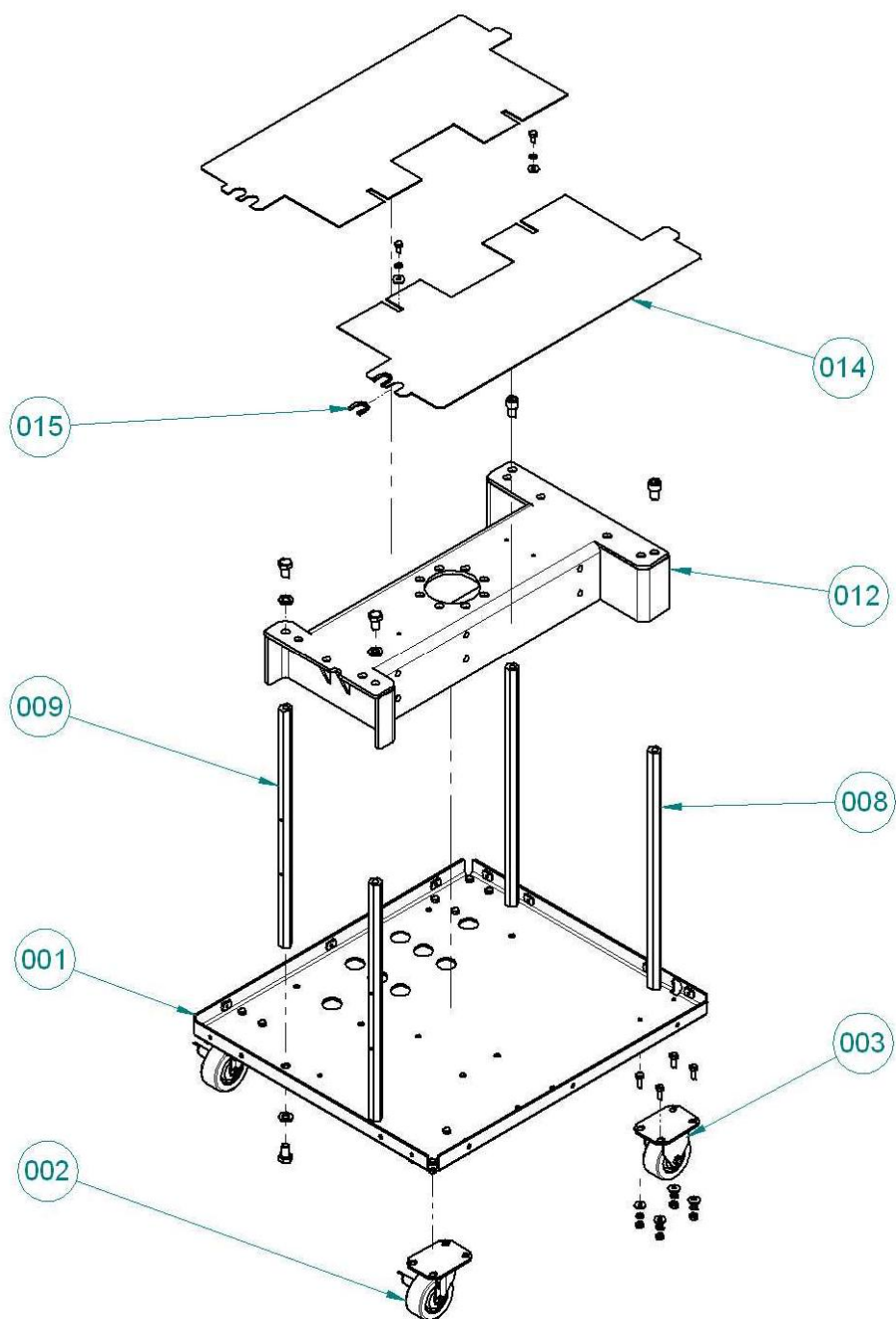
0620-0036	Handle Shaft	1
0620-0037-1	Latch Cam	1
0620-0017-3	Hook	1
0620-0067-1	Catch	1
0619-0018-002	Handle Rod	1
0619-0019-002	Hub	1
5911-7003	Handle Knob	1
5148-5624	Valve (Hydraulic)	1
5137-7004	Hydraulic Pump	1
5604-6958	Coupling	1
6303-6613	Motor 3 ph, 60 HZ, 208/230/460 VAC	1
6303-6725	Motor 1 ph, 60 HZ, 230VAC	1

Note: For Other electrics consult factory.



619-MDP DOUGH PRESS

MAIN FRAME





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MAIN FRAME PARTS LIST

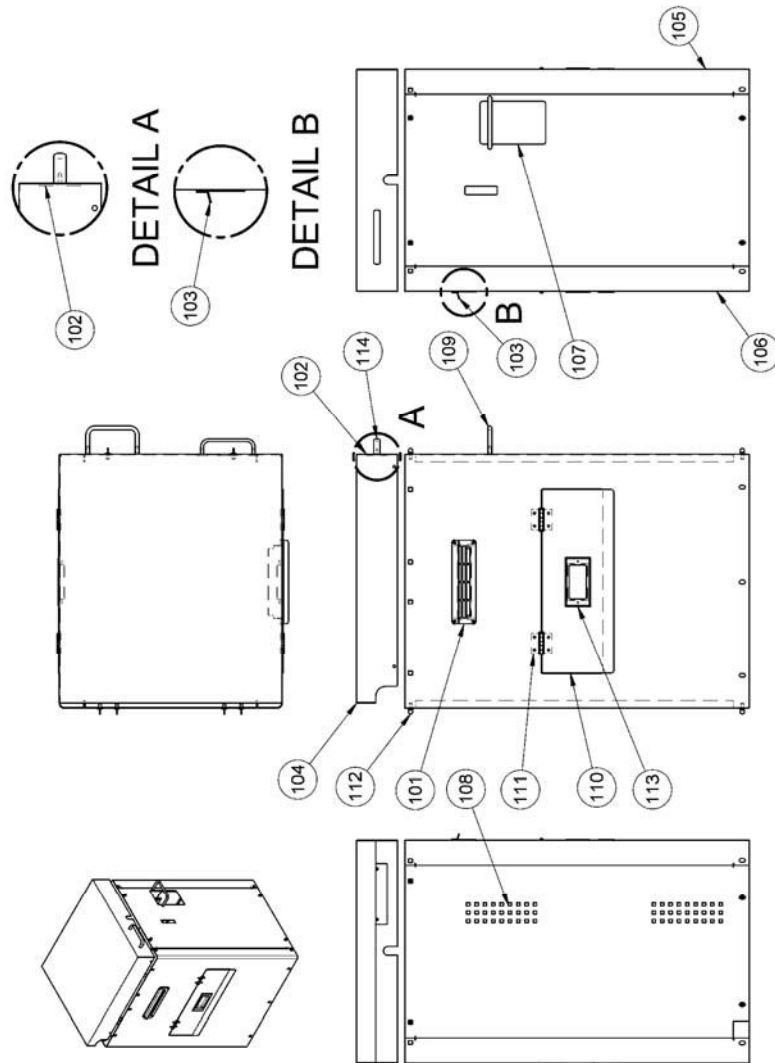
<u>ITEM NO</u>	<u>PART DESCRIPTION</u>	<u>PART NUMBER</u>
001	Base	0620-0008
002	Caster-Swivel	5902-2377
003	Caster-Rigid	5902-2378
008	Brace-Lower	0620-0006-001
009	Brace-Front Lower	0620-0006-002
012	Plate-Cylinder Support	0620-0007-001
014	Panel-Separation	0620-0032
015	Grommet-Edging Nylon	5767-1240

FOR SERVICE PARTS CALL OLIVER PRODUCTS @ 800-253-3893



619-MDP DOUGH PRESS

COVER ASSEMBLY





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COVER ASSEMBLY PARTS LIST

Stainless Steel Covers

<u>ITEM NO</u>	<u>PART DESCRIPTION</u>	<u>PART NUMBER</u>
101	Chute Dough	0619-0027-008
102	Plate Handle Backing	0619-0028
103	Deflector	0619-0043
104	Cover Top	0620-0001-001
105	Cover-Side W/Cleaning Door	0620-0029-008
106	Cover-Side W/Chute % W/Cleaning door	0620-0029-009
107	Cover-Front	0620-0030-003
108	Cover Rear	0620-0031-001
109	Guard-Switch	0620-0106
110	Door Access Cleaning	0620-0121-001
111	Hinge Door Access	0620-0122
112	Screw Thumb	5843-0536
113	Handle Recessed	5908-5046
114	Handle Pull	0620-0123



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Painted Covers

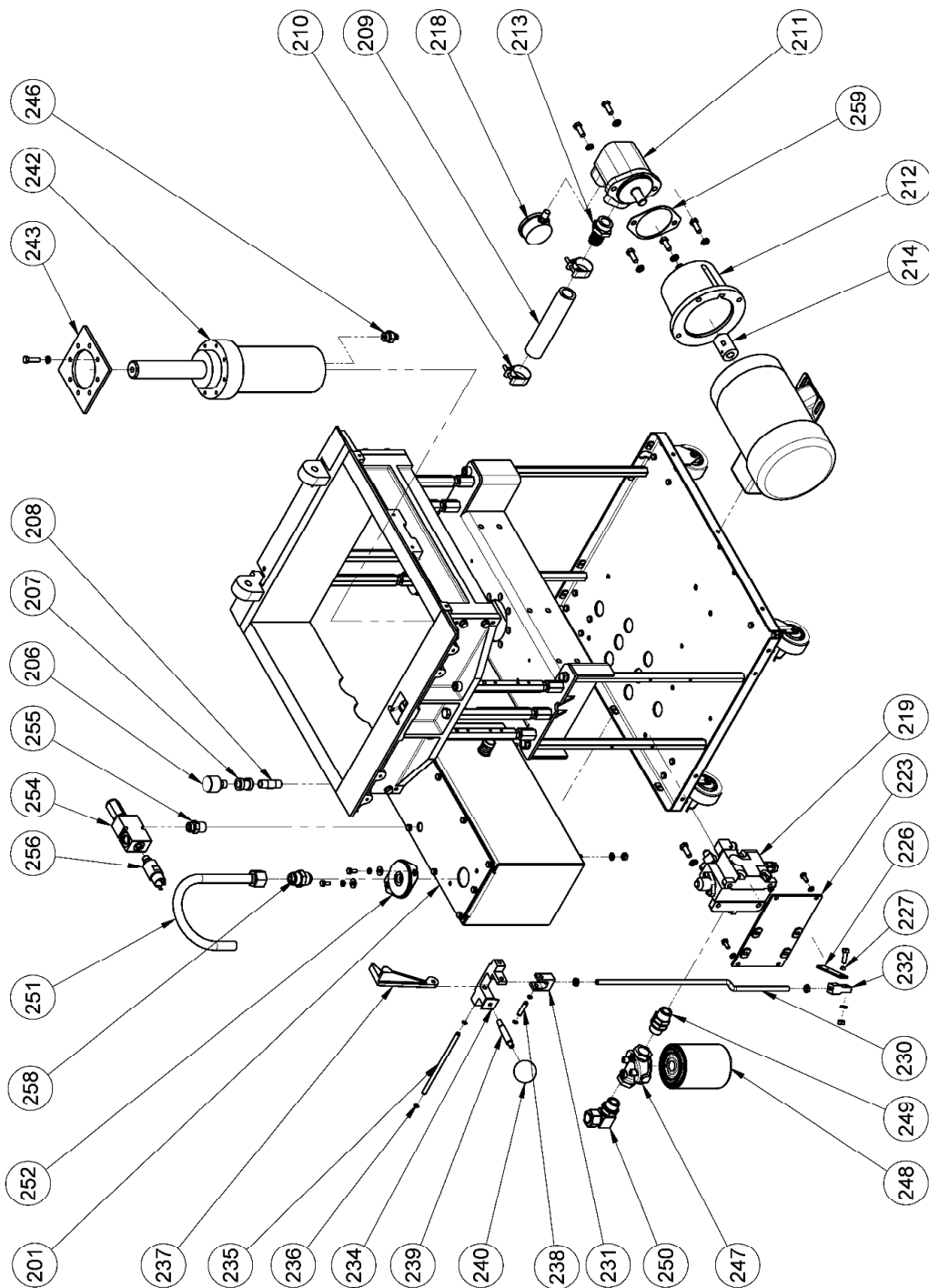
101	Chute-Dough	0619-0027-008
102	Plate Handle Backing	0619-0028
103	Deflector	0619-0043
104	Guard-Top Cover	0620-0001
105	Cover-Side W/Cleaning Door	0620-0029-006
106	Cover-side W/Chute & W/C Door	0620-0029-007
107	Cover-Front	0620-0030
108	Cover Rear	0620-0031
109	Guard-Switch	0620-0106
110	Door Access Cleaning	0620-0121
111	Hinge Door Access	0620-0122
112	Screw-Thumb	5843-0536
113	Handle Recessed	5908-5046
114	Handle Pull	0620-0123

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HYDRAULIC ASSEMBLY



Rev. 10/25/05



HYDRAULIC ASSEMBLY PARTS LIST

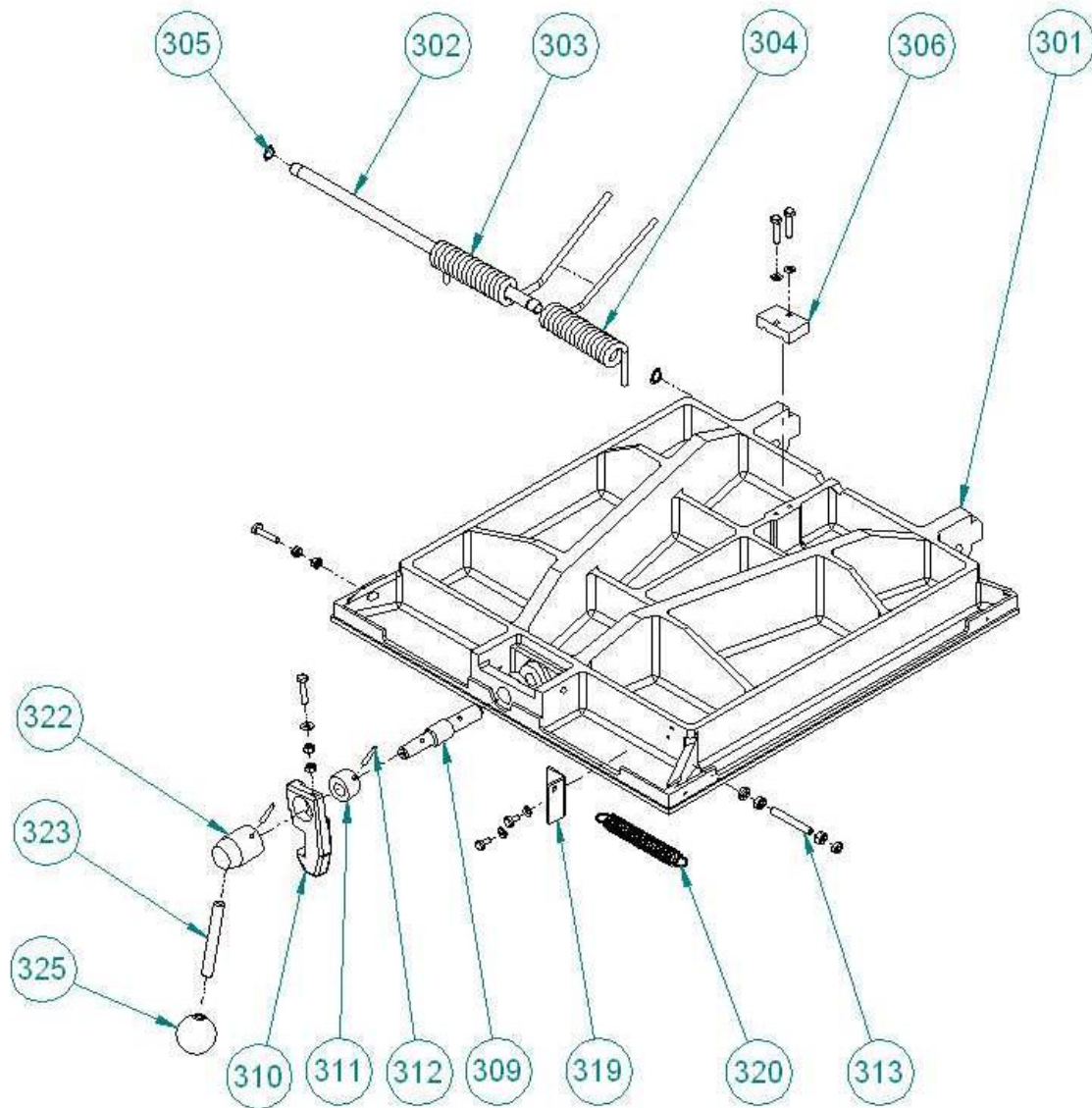
ITEM NO	PART DESCRIPTION	PART NUMBER
201	Tank-Oil Powdercoat	0620-0069-003
206	Breather-Tank	5149-0204
207	Coupling-Black Pipe	5115-0332
208	Nipple-Black Pipe	6203-0407
209	Hose-Suction	0619-0016
210	Clamp-Heavy Duty Hose	5106-8087
211	Pump-Vane 2GPM	5137-7004
212	Flange-Pump Mounting	5137-7375
213	Fitting-Hose	5115-2079
214	Coupling-Pump	5604-6958
218	Gauge-Liquid Filled	5118-0506
219	Valve-4Way	5148-5624
223	Plate-Valve Mounting	0620-0027-001
226	Lever-Valve Actuating	0620-0026-001
227	Spacer	0620-0086
230	Rod-Valve Actuating	0620-0019-002
231	Clevis-Rod	0620-0020
232	Eye-Rod	0620-0021
234	Stirrup	0620-0015
235	Pin-Stirrup Pivot	0620-0025
236	Ring-Retaining	5840-1110
237	Lock-Safety	0620-0016
238	Pin	0620-0022
239	Rod-Handle	0620-0024-002
240	Knob	5911-7001
242	Cylinder-Hydraulic	5108-7665
243	Plate-Cylinder Alignment	0620-0120
246	Fitting-Adapter	5115-2093
247	Head-Filter	5114-9554
248	Filter-Spin-On	5114-9556
249	Fitting-Adapter	5115-4031
250	Fitting-Elbow	5115-4032
251	Tube-Return w/Flare	5147-0130
252	Flange-Tank	5115-0388
254	Valve-Pressure Relief	5148-6306
255	Fitting-Adapter	5115-2095
256	Switch-Pressure	5757-8518
258	Valve-Check	5148-5217
259	Spacer-Pump/Flange	0619-0044
<u>Items Not Shown on Drawing</u>		
217	Hose-Pump High Pressure	5121-8235
241	Hose-Upper Cylinder	5121-8174
245	Hose-Valve to Lower Cylinder	5121-8187
257	Hose-Valve to Relief	5121-8196

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LID ASSEMBLY





LID ASSEMBLY PARTS LIST

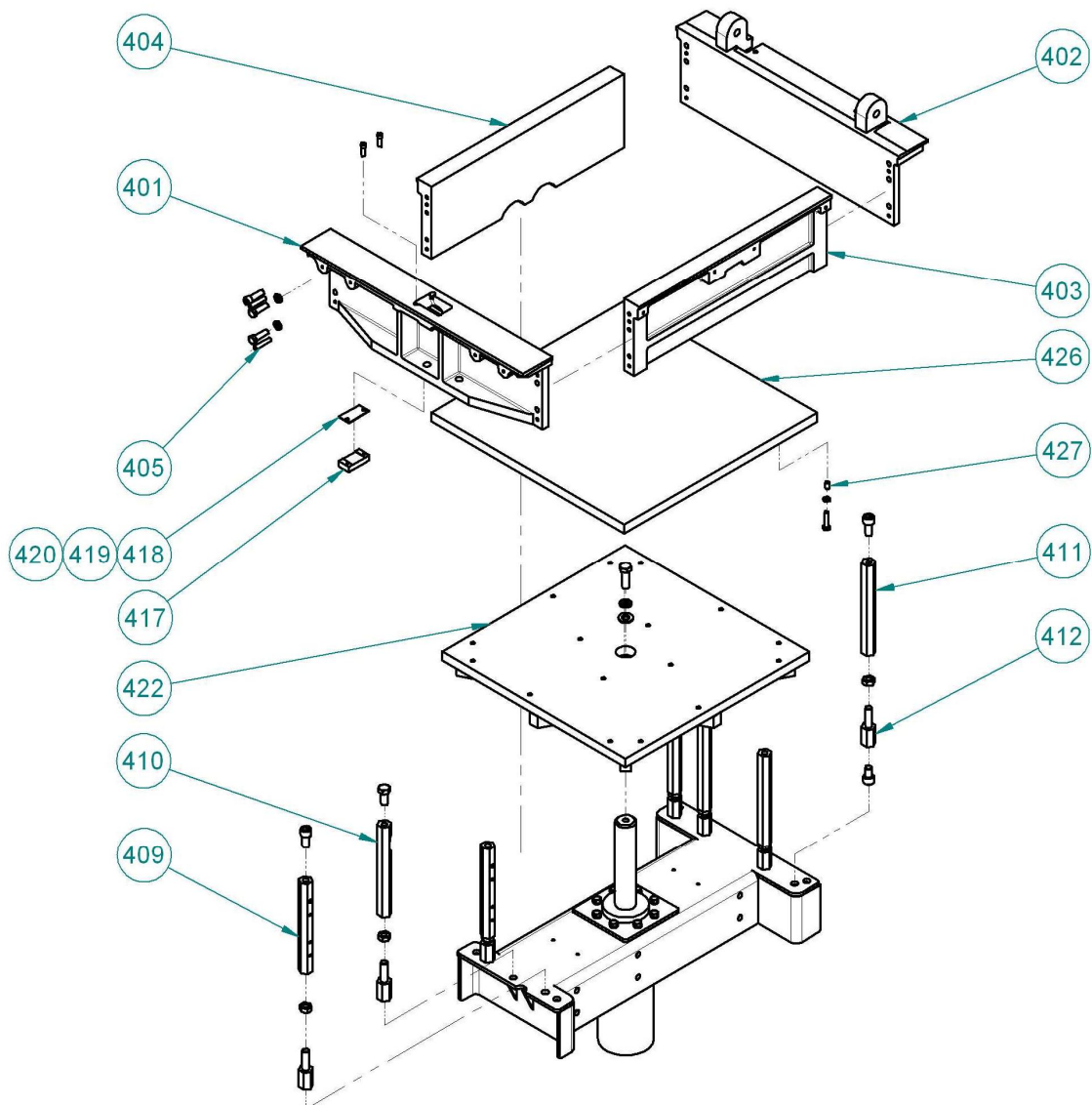
ITEM NO	PART DESCRIPTION	PART NUMBER
301	Lid-Square Hopper	0620-0018-001
302	Pin-Hinge	0620-0033
303	Spring-RH Torsion	7030-0023
304	Spring-LH Torsion	7030-0024
305	Ring-Retaining	5840-1127
306	Clamp-Spring	0620-0034
309	Shaft-Handle	0620-0036
310	Hook-Locking	0620-0017-3
311	Cam-Latch	0620-0037-1
312	Pin-Coiled	5835-7636
313	Screw-Socket Set (Oval Point)	5842-6479
319	Bracket-Spring	0620-0035
320	Spring-Extension	7024-6101
322	Hub	0619-0019-002
323	Rod-Handle	0619-0018-002
325	Knob	5911-7003

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PUSHER ASSEMBLY





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PUSHER ASSEMBLY PARTS LIST

<u>ITEM NO</u>	<u>PART DESCRIPTION</u>	<u>PART NUMBER</u>
401	Plate-Hopper Front	0620-0059
402	Plate-Hopper Rear	0620-0060
403	Plate-Hopper Side	0620-0061
404	Plate-Hopper Side W/Relief	0620-0061-001
405	Pin-Dowel	5835-6266
409	Brace-Front Upper Adj. W/Holes	0620-0002-005
410	Brace-Front Upper Center Adj.	0620-0003-003
411	Brace-Upper Adj.	0620-0063-002
412	Hex Adjustable	0619-0026-001
417	Catch	0620-0067-1
418	Shim-(.030)	0619-0029-001
419	Shim-(.048)	0619-0029-002
420	Shim-(.060)	0619-0029-003
422	Plate-Backing	0620-0076
426	Plate Pressing	0620-0077
427	Insert-Threaded	5822-2030

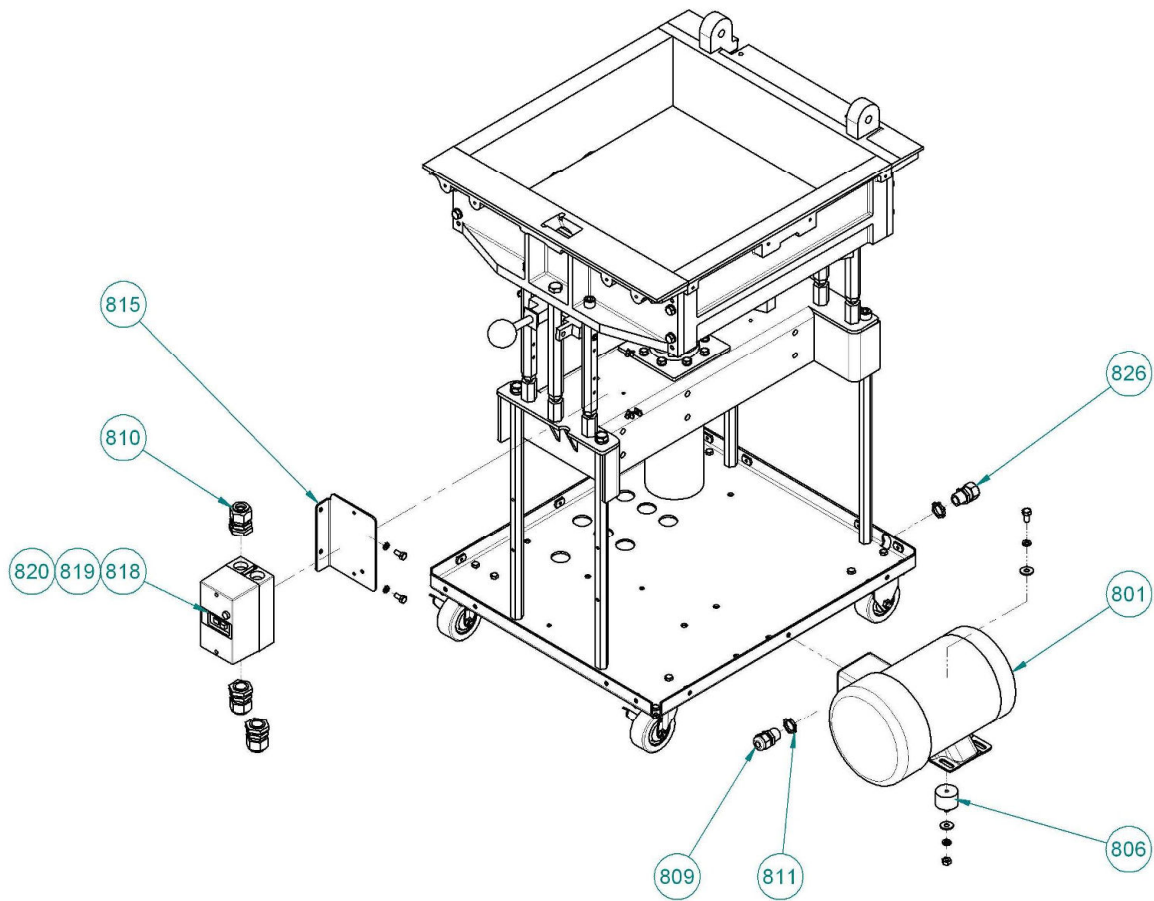
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619-MDP DOUGH PRESS ELECTRICAL ASSEMBLY





ELECTRICAL ASSEMBLY PARTS LIST

ITEM NO	PART DESCRIPTION	PART NUMBER
801	Motor-2 HP (3-60-208/230/460)	6303-6613
801	Motor-2 HP (1-60-230)	6303-6725
806	Shockmount	5918-6636
809	Strain Relief-Motor	5765-1082
810	Strain Relief-Starter	5765-1124
811	Nut-Lock	5766-7750
815	Bracket-Starter	0620-0042-1
818	Light-Pilot	5709-0191
819	Starter Manual 3-60-230	5709-3041
819	Starter Manual 3-60-208	5709-3042
819	Starter Manual 3-60-460	5709-3040
819	Starter Manual 1-60-230	5709-3043
820	Enclosure-Starter	5709-9924
826	Strain Relief-Power Cord	5770-4818

Items Not Shown on Drawing

808	Cord-Motor (3-60-208/230)	0620-0073
808	Cord-Motor (3-60-460)	0620-0071-001
808	Cord-Motor (1-60-230)	0620-0038
825	Cord-Power (3-60-208/230)	0643-0033-001
825	Cord-Power (3-60-460)	0620-0105
825	Cord-Power (1-60-230)	0620-0039
827	Cord-Pressure Switch	0619-0042
828	Cap-Plug (1-60-230)	5765-2030

* For other Electrics consult factory

FOR SERVICE PARTS CALL OLIVER PRODUCTS @ 800-253-3893

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WARRANTY

PARTS

Oliver Packaging & Equipment Company warrants that if any part of the equipment (other than a part not manufactured by Oliver Packaging & Equipment) proves to be defective (as defined below) within one year after shipment, and if Buyer returns the defective part to Oliver Packaging & Equipment within one year, Freight Prepaid to Oliver Packaging & Equipment plant in Grand Rapids, MI, then Oliver Packaging & Equipment , shall, at Oliver Packaging & Equipment option, either repair or replace the defective part, at Oliver Packaging & Equipment expense.

LABOR

Oliver further warrants that equipment properly installed in accordance with our special instructions, which proves to be defective in material or workmanship under normal use within one (1) year from installation or one (1) year and three (3) months from actual shipment date, whichever date comes first, will be repaired by Oliver Packaging & Equipment or an Oliver Packaging & Equipment Authorized Service Dealer, in accordance with Oliver Packaging & Equipment published Service Schedule.

For purposes of this warranty, a defective part or defective equipment is a part or equipment which is found by Oliver Packaging & Equipment to have been defective in materials workmanship, if the defect materially impairs the value of the equipment to Buyer. Oliver Packaging & Equipment has no obligation as to parts or components not manufactured by Oliver Packaging & Equipment, but Oliver Packaging & Equipment assigns to Buyer any warranties made to Oliver Packaging & Equipment by the manufacturer thereof.

This warranty **does not** apply to:

1. Damage caused by shipping or accident.
2. Damage resulting from improper installation or alteration.
3. Equipment misused, abused, altered, not maintained on a regular basis, operated carelessly, or used in abnormal conditions.
4. Equipment used in conjunction with products of other manufacturers unless such use is approved by Oliver Packaging & Equipment Company in writing.
5. Periodic maintenance of equipment, including but not limited to lubrication, replacement of wear items, and other adjustments required due to installation, set up, or normal wear.
6. Losses or damage resulting from malfunction.

The foregoing warranty is in lieu of all other warranties expressed or implied AND OLIVER PACKAGING & EQUIPMENT COMPANY MAKES NO WARRANTY OF MERCHANTABILITY OR FITNESS FOR PURPOSE REGARDING THE EQUIPMENT COVERED BY THIS WARRANTY. Oliver Packaging & Equipment Company neither assumes nor authorizes any person to assume for it any other obligations or liability in connection with said equipment. OLIVER PACKAGING & EQUIPMENT COMPANY SHALL NOT BE LIABLE FOR LOSS OF TIME, INCONVENIENCE, COMMERCIAL LOSS, INCIDENTAL OR CONSEQUENTIAL DAMAGES.

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Oliver Packaging and Equipment Company
3236 Wilson DR NW Walker, MI 49534

(800) 253-3893
www.oliverquality.com

WARRANTY PROCEDURE

1. If a problem should occur, either the dealer or the end user must contact the Parts and Service Department and explain the problem.
2. The Parts and Service Manager will determine if the warranty will apply to this particular problem.
3. If the Parts and Service Manager approves, a Work Authorization Number will be generated, and the appropriate service agency will perform the service.
4. The service dealer will then complete an invoice and send it to the Parts and Service Department at Oliver Packaging & Equipment Company.
5. The Parts and Service Manager of Oliver Packaging and Equipment Company will review the invoice and returned parts, if applicable, and approve for payment.

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RETURNED PARTS POLICY

This policy applies to all parts returned to the factory whether for warranted credit, replacement, repair or re-stocking.

Oliver Packaging and Equipment Company requires that the customer obtain a Return Material Authorization (RMA) number before returning any part. This number should appear on the shipping label and inside the shipping carton as well. All parts are to be returned prepaid. Following this procedure will insure prompt handling of all returned parts.

To obtain an RMA number contact the Repair Parts Department toll free at (800) 253-3893.

Parts returned for re-stocking are subject to a **RE-STOCKING CHARGE**.

Thank you for your cooperation,

Repair Parts Manager
Oliver Packaging and Equipment Company