

1200 model boba making machine

OPERATING INSTRUCTION

Before the use asks you in detail to read the instruction booklet



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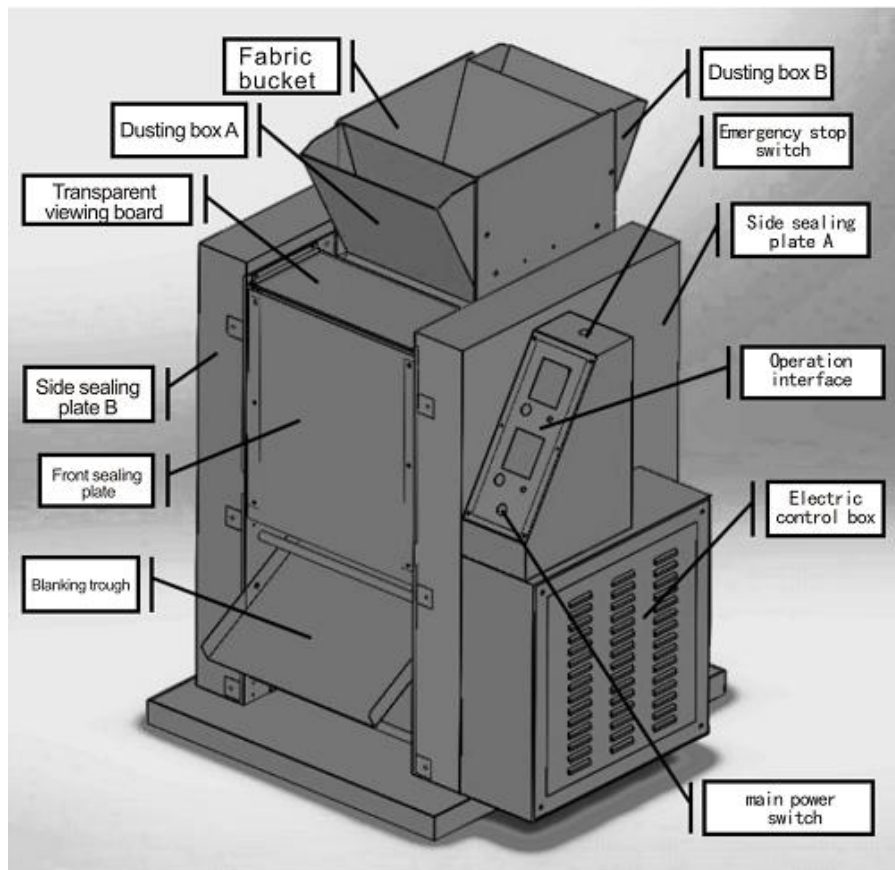
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一. Technical Parameters

Name	Boba making machine
Model	TZ 1200
Power	0.55Kw
Voltage	220V/380V/110v
Diameter	Φ 6- Φ 20mm
Capacity	50Kg/h-100Kg/h
Remarks	No filling. can be customized according to the diameter of the spherical product

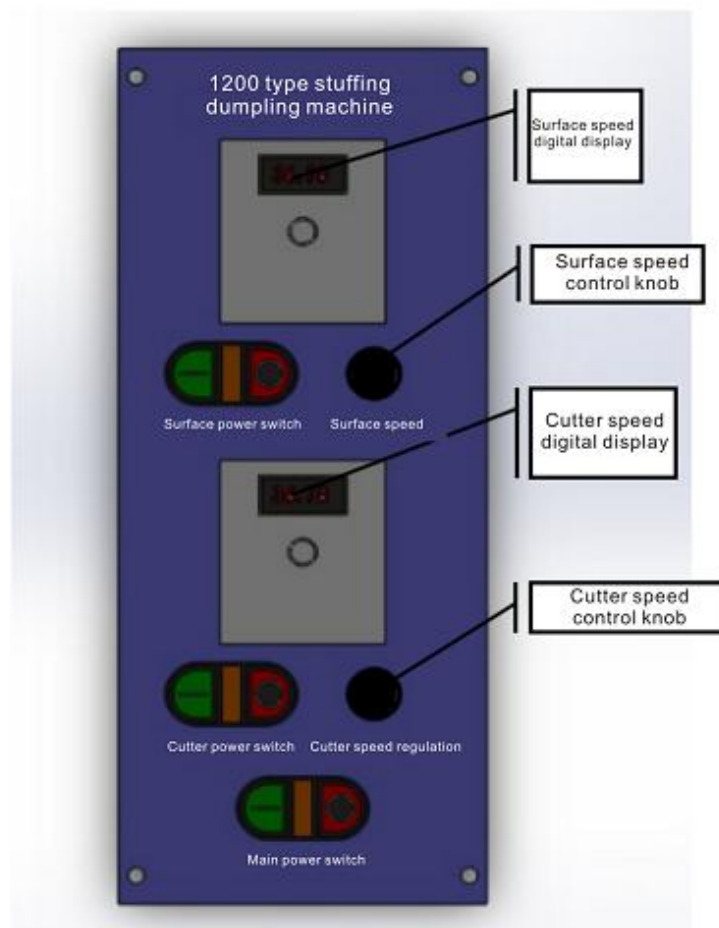
二. Machine Introduce



三、Operate processing

A, the operation interface

In order to use the machine, the manual operation panel for starting, stopping, speeding, and digital display of the machine is as follows:



B, machine operation process:

a, first use:

First right-hand pull up <emergency stop switch>, press <total power switch> green button, then press <face power switch>, <cutting knife power switch> green button, and finally <face speed control knob>, <Cutter speed control knob> Right turn to two digital display screen display 50, empty machine running for 10 minutes, and observe whether there is any fault and noise, stop after no abnormality.

b, production process steps:

1. After the empty machine is running, put the good fabric into the fabric bucket, and in <dust box A>, <dust box

B> 2 of 2 Dry powder, turn the <face speed knob>, <cutting speed knob> to the left;

2. Pull the <Emergency Stop Switch> to the right, turn on the <Total Power Switch>, <Side Power Switch>, and turn the <Face Control Knob> to the <Face Speed Digital Display> to display 30. Observe Whether the pressure roller is eating material;

3. After pressing the surface roller, observe whether the dough is smoothly sent from the pressure roller and the guide wheel in the <Transparent Observation Panel>, and open the <Cutter Power Switch>, <Cutter Speed Control Knob> to the right The two-digit display number is displayed as 50.

4.<Cutter speed control knob>Leftly adjust slowly. After the dough is dropped into the forming wheel, the molding is observed. When the material is smaller than the diameter of the forming groove, the cutting speed can be slowed down or the speed of the dough can be accelerated; when the material is larger than the diameter of the forming groove, the cutting speed can be slowly increased or the speed of the dough can be slowed down.

5. When the material diameter is consistent with the diameter of the forming groove, stop the surface speed regulation or cutter speed regulation.

C, machine notes:

1. Fabrics must be able to adapt to the requirements of machine production, such as not too soft, have certain toughness and gluten.

2. According to different customer materials, the moisture and fabric

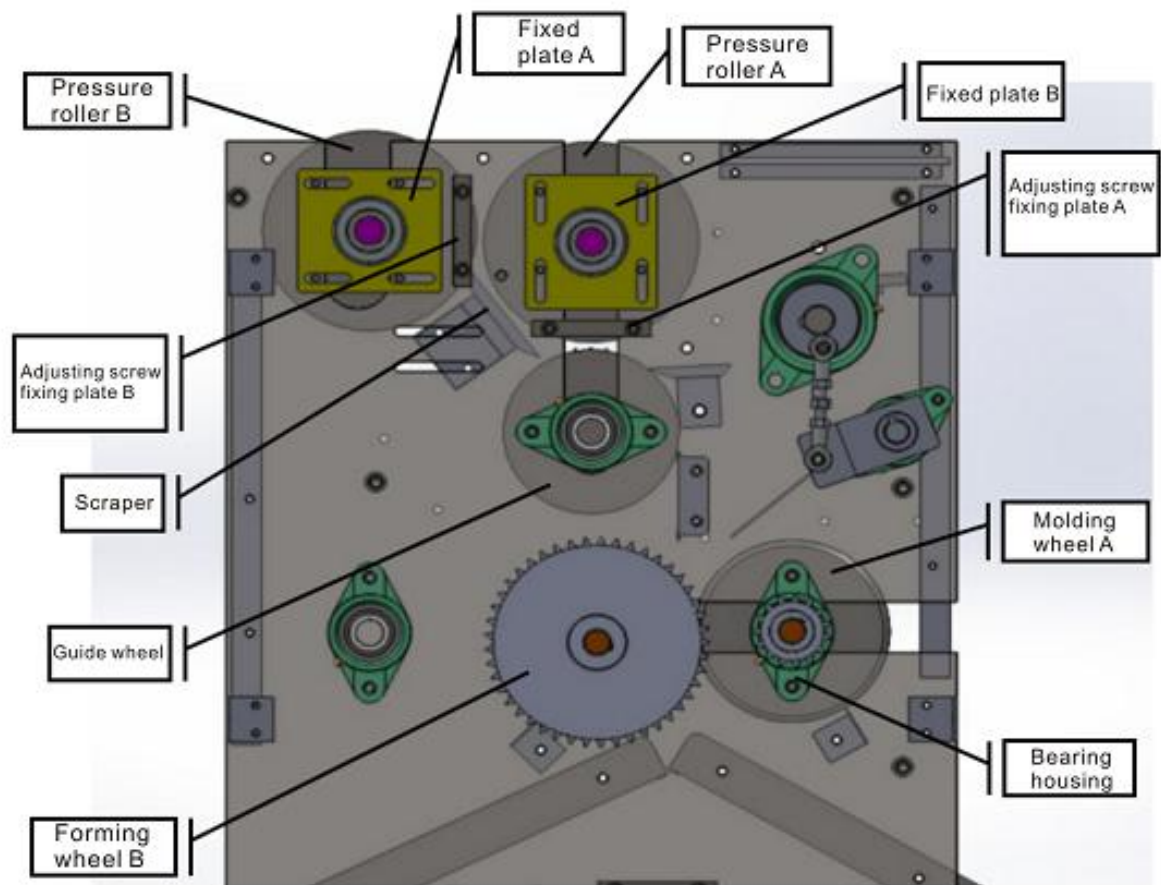
properties are different, and the thickness of the pressing surface is different.

The machine will sample when it leaves the factory. If it needs to be adjusted, it will only be fine-tuned.

※ When the thickness of the pressing surface is too thin, follow the steps below: (1) First adjust the pressure roller A, loosen the bolts on the upper plate of the <fixing plate B> (both sides of the left and right side plates are loose, the same below, to be able to move, do not remove all) and the scraper fixing bolts.

(2) Loosen the nut attached to the bolt of <Adjustment screw fixing plate A> (wrench to the right), rotate it to the right by 2 mm, and then use the wrench to adjust the bolt of the fixing plate to the right (the bolt rotates once) Extend or shorten the distance to 1.5 mm) to extend the required distance.

(3) After adjusting, first tighten the bolts on the fixing plate, then tighten the adjusting bolts to the fixing plate, and then lock the nuts on the bolts (the wrench to the left) to the top tightening <adjustment screw fixing plate>. **The principle of pressure regulating face wheel A: It is better to use a slightly pressed surface skin, and the whole pressing pressure is too easy to cause the blocking surface. According to the nature of the material, the adjusted skin thickness is determined by experiment.**



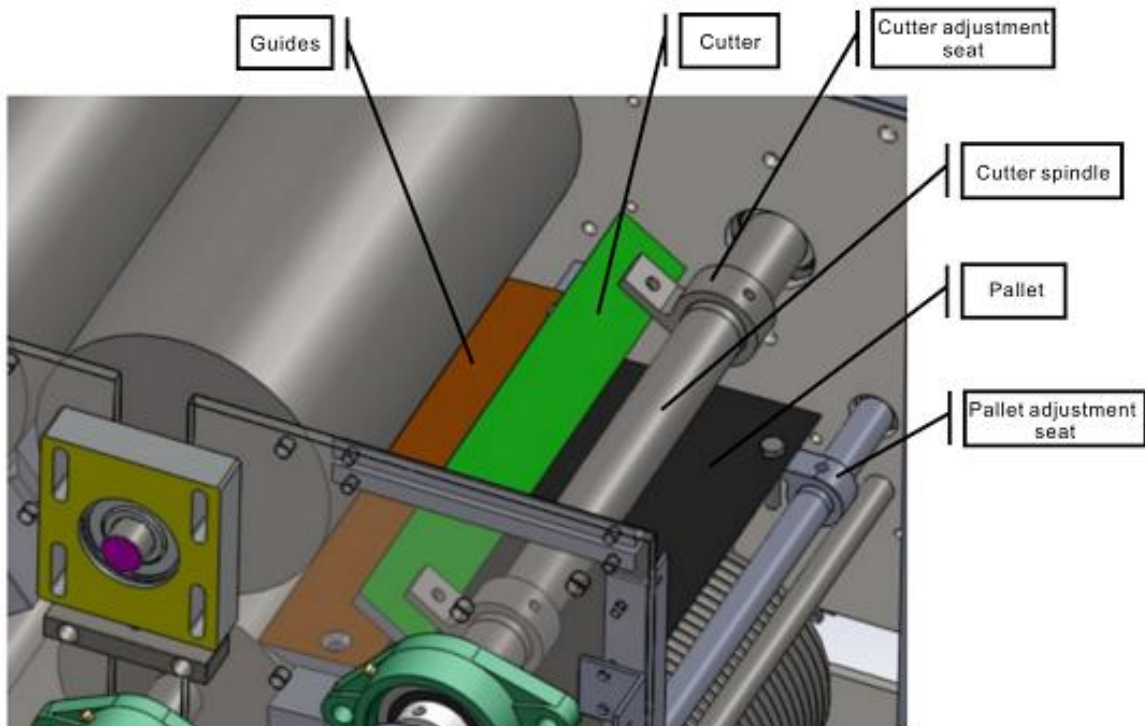
(4) Adjusting the pressing face wheel B, the adjusting method is the same as that of the pressure regulating face wheel A. The gap between the pressing face wheel B and the pressing face wheel A cannot be much larger than the gap between the pressing face wheel A and the guide face wheel, otherwise the fabric deposit pressure The middle of the wheel A and the scraper causes the dough to be laminated, which affects the production (depending on the nature of the specific material). Finally, the gap between the squeegee and the pressure roller B is adjusted. The principle is that the material can smoothly slide from the squeegee and there is no scratching sound.

※ When the thickness of the pressing surface is too thick, the operation steps are opposite to the above adjustment methods.

※ When adjusting the two pressure roller, the gap between the two wheels is even. If the gap is not uniform, the thin side of the dough will be faster and the thickness of the dough will be slower, resulting in different sizes of the dumplings.

※ If the spherical sides are made in the shape of a needle tail, loosen the bolts that fix the <bearing seat> (to be able to move, do not remove them all), and use a plastic rod or rubber hammer to slightly tap the left <housing >, press the face wheel A by hand, and twist and turn, there is no metal scraping sound.

3. Cut the knife continuously or touch the knife.



※ When there is a dough and it is continuous, turn the <Cutter Spindle> by hand so that the <Cutter> edge is facing the edge of the <guide plate>, and loosen the bolt of the fixed cutter on the <Cutter Adjuster> (to The movement shall prevail, do not remove all), and slightly move the cutter in the direction of the guide plate to move the gap. Rotate the cutter spindle again to observe whether the cutter edge and the guide edge are in collision.

※ The relative position principle of the pallet and the cutter: When the cutter rotates and cuts the dough, the pallet also descends (if the pallet is cut, there will be material thrown or collided with the cutter), and the cutter cannot rotate. To the bolts of the pallet and the fixed pallet, the pallet swings downward and cannot touch the forming wheel

A. The position of the cutter and the pallet is not correct. The pallet and the pallet adjustment seat are fixed first. Loosen the bolt on the cutter holder and rotate the cutter spindle by hand to observe that the pallet is swung to the lowest point without touching. To the forming wheel A;. The position of the cutting knife is adjusted according to the relative position of the upper plate and the cutting knife.

四. Maintenance and safety

◎Safety:

1. Prohibit uninterruptible power supply for maintenance;
2. When the machine is running, it is forbidden to remove the side sealing plate A, the side sealing plate B, the front sealing plate and the rear sealing plate;
3. When the machine is running, it is forbidden to press the face wheel A and the pressure wheel B by hand;
4. When the machine is running, it is forbidden to adjust the cutter and the pallet by hand;

maintenance:

1. Power off the machine during maintenance;
2. Check the chain, fixing bolts, etc. loosely every 6 months, and butter the chain sprocket once;
3. Check the chain and sprocket wear every 1 year;

五. Basic recipe for making milk tea boba

1. Use 10 kilograms of glutinous rice flour, add 4.5 kilograms of boiled boiling water, mix it evenly into the dough mixer, press the dough into a flat square by hand, and put the thickness of 25MM-35MM into the feeding hopper.

2, processing water mill powder, should be water-dried powder to dry, take one-third of rice flour steamed 8 ~ 9 mature, into the dough machine, pour one-third of the wet rice flour, add another three-point The dry rice flour is stirred evenly at the same time, and the dough is pressed into a flat square by hand, and the thickness is 25MM-35MM. It is processed into the feeding hopper, and it takes 10 to 20 minutes to be dried after forming, and can be packaged.

Add 10 kilograms of rice flour and water to form a dough, cook in a pot and then dry it. Mix two-thirds of the dry rice powder and mix it evenly in the dough mixer. It can be placed in the feed hopper for processing.

3. If you do not need boiling water and noodles, you can add appropriate amount of dumpling powder improver according to the powder quality [thickening, anti-freeze cracking, increase the roundness of the soup]. Use cold water and noodles. Stirring until the mass production will not disperse, will not stick the face wheel, the forming wheel can be.

Prepare the cube material of 35X200X300MM later.

4, surface speed and cutter speed ratio is about 1:1, depending on the specific conditions of the fabric, look at the molding effect, the appropriate amount to speed up or slow down the pressing surface speed until the dumplings into a round shape.