

## BIG T HANDBOOK MANUAL

REF/GES/16

The Big T is a single action rotary pie machine with optional Die Set.

### **OPERATOR CONTROL PANEL**

The machine is controlled from the operator control panel at the lidding end of the machine.

The machine is a two speed machine selection by the two speed switch (do not change speed with machine in motion).

### **HAND/AUTO SWITCH**

This selector either hand mode which releases the brake and allows machine to be hand wound or auto mode which if all the guards are in the correct position will allow machine to run in auto mode.

### **STOP-START SWITCH**

To stop and start machine in auto mode.

### **SIMMERSTAT**

1 For blocking die to control temperature of the dies.

1 For lidding die to control temperature of the dies.

### **GUARDS**

All access guards are switched to stop the machine being run with guards open or to stop machine if moved in or out.

Dies are made in sets consisting of a blocking die base, platform, and optional lidder and plastic support table.

### **DIES**

To fit dies - stop machine at top of stroke.

Together with a plastic support table it is essential that only items for one die set are fitted & are used, damage to the machine and dies will occur if mixed sets are used).

The top die is secured in place by passing the two producing studs through the top die disk and securing with two special countersunk nuts (on non round and/or twin die set, correct orientation is essential.

Lidding die as per top die.

### **BASE PLATFORM**

The base platform sits on the bolster plate and are secured to base bolster with either 2 offset bolts or a central countersunk bolt (on non round and/or twin die set, correct orientation is essential.

### **PLASTIC TABLE**

Fits over the central boss normal onto 3 location pins and is secured by a top plate and nut (on non round check for being correct side upwards) (usually fitted with fowling pin to avoid wrong fitment.

Prior to use select hand mode and wind the machine with the handwheel located on the top of the machine 1 complete cycle of the table to check for correct fitment of the dies failure to do this may result in damage to machine or dies or both

### **HEATING**

Insert cartridge element or plug flying lead onto die.

### **COMPRESSED AIR CONNECTION**

Connect either 1 or 2 air lines per block and lidding die.

### ELECTRICAL

Control box located in main cabinet

The control circuit is protected by a MCB located in control box, the heating circuit is controlled by a separate MCB also located in control box.

The machines motor is protected by two thermal cut-outs (low speed-high speed)

### ELECTRICAL INTERLOCKS

All movable guards are electrically inter-locked

### PNEUMATIC

Adjust timing and flow control in main cabinet.

### AIR SUPPLY

2 Bar

80 P.S.I. (50 C.F.M.)

### ELECTRICAL SUPPLY

Normal 380-440v 50-60 cycle 3 phase + N+E other specifications available as an option.

The machine must be connected by a suitable qualified electrician in the locality

of to conform to any local jurisdictions

### ROUTINE SAFETY CHECKS

The machine must not be used without the plastic table being correctly installed (the operator or person responsible for use of the machine must ensure this is in place before use.)

### CLEANING

All exposed surface should be cleaned down after each production cycle.

### SPARE PARTS

Only genuine Bruton spare parts should be fitted by a suitable qualified personnel.

Parts are available to order from the Bruton online web shop.

Please register your machine online by going to [www.brutonsltd.co.uk/shop](http://www.brutonsltd.co.uk/shop)

[SERVICE TEAM - PORTAL](#)

### DO'S AND DONT'S

1. **DO** always check the operation of the safety switches before commencing work.
2. **DO** ensure that the dies are correctly fitted.
3. **DO** always stop the machine by means of the stop button operators panel on the starter
4. **DO** always check that the correct safety frame is fitted for the dies used.
5. **DO** always check that the guard doors are correctly adjusted to leave 6mm gap inbetween the frame and the trip flap.
6. **DO** ensure that the operator is familiar with the controls and knows how to stop the machine in an **emergency**.
7. **DO** always stop the machine before changing speeds.
8. **DO** always stop the machine to clean down.
9. **DO** always leave the guards open when cleaning.
10. **DO** always remember that machines are replaceable - **HANDS ARE NOT**.

1. **DON'T** run the machine if any of the safety switches are not functioning.
2. **DON'T** stop the machine by use of the safety switches except in an emergency.
3. **DON'T** change speeds on the machine whilst the machine is in motion.
4. **DON'T** clean the machine whilst in motion.
5. **DON'T** rely on others as to the safety status of the machine operators should satisfy themselves that the machine is safe to commence work.
6. **DON'T** try to put your hands underneath the guards.
7. **DON'T** start the machine until other operators are aware of the start up.
8. **DON'T** leave anything on the rotating table that could be caught in the machine mechanism.
9. **DON'T** remove **HOT DIES** without hand protection.

### **MAINTENANCE ELECTRICAL**

- \* Check oil levels
- \* Check oil for contamination
- \* Check indexing and alignment
- \* Check for 'wear' in crank and test heights
- \* Check air cylinder trip
- \* Check air cylinder blow off rubber is delivering enough air
- \* Check motor brake and adjust if necessary
- \* Check handbrake release
- \* Check safety switches functioning
- \* Check safety interlock set and adjusted
- \* Check gates are free
- \* Check all covers
- \* Check die location holes for wear
- \* Check die heater socket
- \* Check wiring for damage & loose connections
- \* 1-2 speed selection and retaining pin
- \* Machines not fitted with cross tie cover requires one fitting
- \* Safety frame is required
- \* Advise: If safety gates are not to current standard
- \* Advise: If safety switches are not upto current standard
- \* Advise: If no operator/maintenance manual that they requires
- \* Brake is required to be fitted
- \* Advise: If missing/damaged or extra safety guards are required
- \* Check and adjust motor drive belt
- \* Check electrical connections
- \* Check overload setting
- \* Test motor current
- \* Check pneumatic circuits for leaks
- \* Non functional equipment
- \* Check safety switches for correct adjustment and operation and any damage
- \* Check earth
- \* Check supply voltage

### **MECHANICAL**

- \* Check indexing mechanism
- \* Check upper and lower right angled gearbox (oil level top up if needed)
- \* Check cranks
- \* Check die shaft
- \* Check bolster shaft, spring, guide plate.

### **PNEUMATIC**

- \* Check for leaks
- \* Check operation of main air control valve cut-off

### **DIMENSIONS**

**Height:** 175cm

**Width:** 125cm (including Table Ring)

**Length:** 200cm

**Weight:** 950kgs (approximately)