



**MOD R32/XP**

**Production code : 1D010290**

**09/2025**

# ROLLING MILL





BEFORE USING THE EQUIPMENT, IT IS MANDATORY TO INSTALL THE PROVIDED ROLLER SAFETY PROTECTIONS AS PER THE ATTACHED INSTRUCTIONS.  
THE PLASTIC SAFETY PROTECTIONS ARE DESIGNED TO PROTECT THE OPERATOR AGAINST CRUSHING AND THE MANUFACTURER DECLINES EVERY RESPONSIBILITY ARISING FROM THE NON-INSTALLATION OF SAFETY PROTECTIONS.

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# ENGLISH

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## SERIAL NO.

### RATING PLATE

The identification label consists in a grey screen-printed label attached to the back of the rolling machine. The following data is clearly and indelibly marked on the plate:

- |                            |   |
|----------------------------|---|
| - Name of manufacturer;    | - Serial no. ;                                |
| - Electrical power (kW/A); | - Voltage and electrical frequency (Volt/Hz); |
| - Model;                   | - Year of manufacture                         |
| - Wording "Made in Italy"; | - Weight of rolling machine                   |

## GENERAL INFORMATION

### IMPORTANCE OF MANUAL

Before using the rolling machine in question, it is mandatory to read and understand this manual in all its parts.

This manual must always be available to "authorised operators" and be kept near the rolling machine in a safe and protected location.

The manufacturer declines all responsibility for any damage to persons, animals and property caused by non-observance of the rules described in this manual.

This manual is an integral part of the rolling machine and must be stored until the final disposal of the machine itself.

"Authorised operators" must only perform operations on the rolling machine that fall under their specific responsibility.

### WARRANTY

The warranty is valid for one year with effect from the date of the tax invoice issued at the time of purchase.

Within this period, parts that have been inspected and unequivocally confirmed to have manufacturing defects, except for electrical and wear components, shall be replaced or repaired free of charge and only **ex-works at our facilities**.

Shipping and labour costs are not covered by the warranty.

The warranty shall expire in cases where it is confirmed that the damage was caused by: transport, poor or insufficient maintenance, operator incompetency, tampering, repairs made by unauthorised personnel, failure to observe the instructions of the manual.

Recourse against the manufacturer shall be excluded for direct or indirect damage in the event machine downtime causes:

failure, waiting for repairs or in any case is attributable to the non-physical presence of the equipment.



**TAMPERING WITH AND/OR THE REPLACEMENT OF PARTS WITH NON-ORIGINAL SPARES SHALL INVALIDATE THE WARRANTY AND RELEASE THE MANUFACTURER OF ALL LIABILITY.**

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## INFORMATION REGARDING NOISE

The **A**-weighted sound pressure level measured on an identical sample machine was constant and less than 70 dB (A).

## SAFETY PRECAUTIONS

The machine, albeit compliant with safety requirements laid down by electrical, mechanical and hygienic standards of reference, may constitute a hazard if:

- Used for scopes and in conditions other than those intended by the manufacturer.
- **The roller protections are tampered with.**
- Instructions are not followed regarding: Installation - Start-up - Use - Maintenance.

**BEFORE USING THE EQUIPMENT, IT IS MANDATORY TO INSTALL THE PROVIDED ROLLER SAFETY PROTECTIONS AS PER THE ATTACHED INSTRUCTIONS.**

**THE PLASTIC SAFETY PROTECTIONS ARE DESIGNED TO PROTECT THE OPERATOR AGAINST CRUSHING AND THE MANUFACTURER DECLINES EVERY RESPONSIBILITY ARISING FROM THE NON-INSTALLATION OF SAFETY PROTECTIONS.**

## ATTENTION

**In order to prevent hazardous conditions and/or possible injury caused by: electrical currents, mechanical parts, fire or causes of a hygienic nature, the following safety precautions must be followed.**

A - OPERATOR WORKSTATIONS MUST BE KEPT CLEAN AND TIDY.

Disorder generates the risk of accidents.

B - EVALUATE ENVIRONMENTAL CONDITIONS.

Do not use the machine in humid, wet conditions or in the case of insufficient lighting, near flammable liquids or gases.

C - KEEP CHILDREN AND UNAUTHORISED PERSONS AWAY.

Do not allow them to approach the machine or the workstation.

D - USE THE MACHINE ONLY WITH THE RATED POWER AND ONLY FOR ITS INTENDED USE.

The machine will work better and more safely if it is not overloaded. E - WEAR APPROPRIATE CLOTHING.

Do not wear loose clothing or hanging accessories that may get caught in moving parts. Use non-slip shoes. For hygienic and safety reasons, use a hair net and hand gloves.

F - PROTECT THE POWER CORD. Do not pull on the cord to detach the plug from its socket; do not expose the cord to high temperatures, avoid contact with sharp corners, water or solvents.

G - AVOID UNSAFE POSITIONS. Try and find the most suitable position that guarantees constant balance.

H - ALWAYS PAY MAXIMUM ATTENTION.

Observe your work. Never use the machine when distracted. I - DETACH THE PLUG FROM THE SOCKET.

After each use, before performing cleaning or maintenance operations or moving the machine.

L - UNSECURED EXTENSION CORDS. These must not be used.

M - CHECK THAT THE MACHINE IS NOT DAMAGED.

Before using the machine, carefully check the efficiency of the safety devices.

Check that moving parts are not blocked, that there are no damaged parts, that all parts have been properly assembled and that all conditions that may influence the regular operation of the machine are optimal.

N - HAVE THE MACHINE REPAIRED BY QUALIFIED PERSONNEL.

Repairs must be carried out only by qualified personnel using original spare parts. Failure to follow these precautions may constitute a hazard to the user.

O - LABELS ARE SAFETY DEVICES, and therefore must always be perfectly legible. Should they become damaged and illegible, they must be replaced.

## MACHINE FEATURES

The Rolling Machine has been designed and developed exclusively for food-grade use for the cold rolling of dough for bread-making and desserts, for the purpose of facilitating the formation of discs for the preparation of: pizzas, bread, focaccia, cakes, etc., without altering the fundamental properties of the dough.

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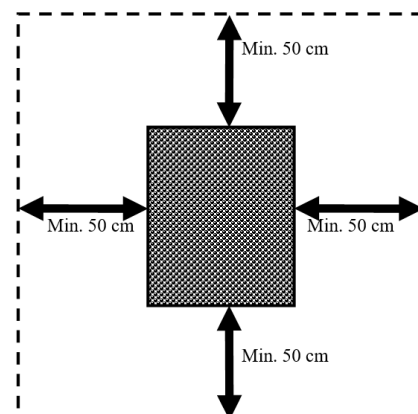
# INSTALLATION

## USER PRECAUTIONS

The environmental conditions of the location where the machine is installed must have the following characteristics:

- be dry
- water-based sources of heat located at a suitable distance
- suitable ventilation and lighting compliant with occupational health and safety standards.

The supporting surface must be horizontal and there must be no obstacles of any nature in the immediate vicinity of the machine that may affect its normal ventilation.



### **IMPORTANT**

**In accordance with current regulations, the electrical system must be equipped with an automatic differential switch having characteristics suited to those of the machine, in which the contact opening clearance is at least 3 mm; an efficient grounding system is also indispensable.**

Check that the mains voltage and frequency of the system are compatible with the values in both the technical features and the rating plate on the back of the machine.

## INSTALLATION METHOD

### **IMPORTANT**

**All installation and maintenance operations must be carried out by the manufacturer's qualified and authorised personnel, which denies all responsibility resulting from incorrect installation or tampering.**

The machine is supplied in closed packaging.

After removing the packaging from the machine, proceed as follows:

- Place the machine in its intended location.
- Remove the protective film without using tools that may damage the surfaces.

### **NOTE**

**All parts of the packaging must be disposed of in accordance with regulations in force.**

## ELECTRICAL CONNECTION

The machine must be connected to the electrical mains by way of a power cord fitted with a plug.

The mains socket must be easy to access and must not need to be moved.

The distance between the machine and the socket must be such as to avoid any tensioning of the power cord; moreover the cord must never be stuck under the feet of the machine.

### **IMPORTANT**

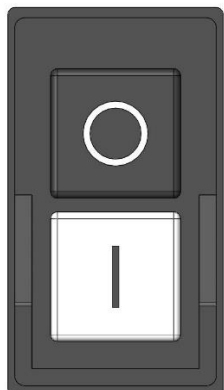
**It is mandatory for the system to have a grounding system and differential switch in accordance with legislation in force.**

# START-UP

## CONTROL DEVICES

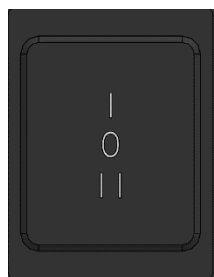
The machine is equipped with the following control devices:

### STANDARD



#### MAGNETIC SWITCH

Position 1 – MACHINE ready  
Position 0 – MACHINE OFF



#### SWITCH 1-0-2

Position 1 – MACHINE  
STARTED  
Position 0 – MACHINE OFF  
Position 2 – PEDAL  
OPERATION



#### OPTIONAL PEDAL

PRESS – Start rollers  
RELEASE – Stop rollers

After inserting the power cord into the mains socket, the machine is ready for operational testing.

#### Operational test standard machines:

**TO START:** Press the magnetic switch on the side into position 1, then press position 1 on the 1-0-2 switch, the machine will start.

**TO STOP:** Press the switch into position 0, the machine will stop.

#### Operational test for touch and go machines:

**TO START:** Press the switch on the side into position 1

Press the black "SET TIME" button on the control unit to set the operating time from 10 to 35 seconds; the machine is ready for the operating stage.

**THE ROLLERS WILL START AUTOMATICALLY WHEN THE DOUGH COMES INTO CONTACT WITH THE UPPER CHUTE.**

**TO STOP:** The rollers stop automatically when the previously set time expires, or when the "STOP" key is pressed.

Move the switch into position "0" to completely turn the machine off.



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Operational test OPTIONAL PEDAL (standard in RP):

**PEDAL START:** When the switch is pressed into position 2, the machine will not start but will go into standby. When the pedal control is lightly pressed, the rollers will start to turn and the machine is ready for use.

**PEDAL STOP:** When the operator lifts their foot off the pedal, the machine stops. Move the switch into position "0" to completely turn the machine off.

Finally, **RUN THE MACHINE ON EMPTY FOR ONE MINUTE, CHECK THAT IT OPERATES REGULARLY.**

## USE AND OPERATION

**IMPORTANT: ALL ADJUSTMENTS MUST BE MADE WITH THE MACHINE AT A STANDSTILL.**

The recommended adjustments are of a purely indicative nature given that adjustments must be defined by way of trial and error in consideration of the following variables: characteristics of dough, weight, thickness, size and form of the disc.

The machine is supplied with general adjustments suitable for medium-weight pizzas.

### REGULATION OF THICKNESS

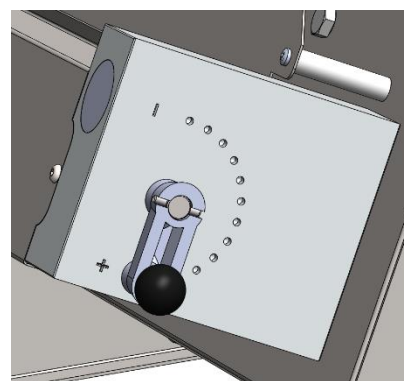
To satisfy individual needs, the machine allows different dough thicknesses by turning the knob, which is released by pulling on the black pommel. The thickness is adjusted depending on the direction of rotation of the pommel:

-**MINIMUM THICKNESS:** turn in an anti-clockwise direction.

-**MAXIMUM THICKNESS:** turn in a clockwise direction.

For best results it is recommended to differentiate the adjustments:

E.g.: upper roller opening 3.5 mm,  
lower roller opening 2 mm



**NOTE:** TO AVOID ANY INDENTATION OF THE DOUGH, PASS IT THROUGH THE ROLLERS ONCE ONLY.

### FORM REGULATION FOR ROLLING MACHINES 320/420 AND TOUCH&GO

For best disc form the sensitivity of the balance must be adjusted to suit variations in the weight of the dough so that its position can be changed from vertical to perfectly horizontal before entering the lower rollers.

**NOTE:** MAKE SURE THE SMALL BALANCE, WHEN NOT BEING USED, IS ALWAYS IN THE HIGH POSITION.

### SMALL BALANCE REGULATION

This adjustment allows the dough rotation speed to be varied. By turning the lock screw it is possible to change the position of the counterweight and consequently the sensitivity depending on its positioning in one of the holes in the small balance.

#### **MAXIMUM SENSITIVITY:**

- position the counterweight inside the hole;
- recommended for low weights.

#### **MEDIUM SENSITIVITY:**

- position the counterweight at the centre of the hole;
- recommended for medium weights.

#### **MINIMUM SENSITIVITY:**

- position the counterweight outside the hole;
- recommended for high weights.

At the end of regulation, block the counterweight by retightening the screw.

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## MACHINE USE

Before starting each operating cycle, check that the machine is perfectly clean, in particular the surfaces that come into contact with the dough. If cleaning is necessary, proceed in accordance with the methods described in the "MAINTENANCE" paragraph.



**ATTENTION: During the operating stage it is strictly prohibited to remove the safety protections due to the presence of moving parts that may cause hands to be crushed.**

### Standard Models:

**TO START:** Press the switch into position 1, the machine will place the two pairs of rollers in movement and is ready for the operating stage.

Before introducing the lightly floured and previously proofed (at least 6-8 hours) ball of dough into the opening of the protection, slightly squash part of the edge of the ball to facilitate its entry into the pair of upper rollers.

When the dough exits the rollers, its thickness will be slightly reduced and it will have an oval shape. Then as it slides onto the balance, it will be rotated in a diagonal direction by about 90°, ready for the next passage through the lower rollers, from which it will exit in a rough disc shape, which will then need to be perfected by hand.

**TO STOP:** Press the switch into position 0.

**FUNCTIONS AND USE OF PEDAL CONTROL.** The pedal control performs supplemental functions to the front controls in addition to allowing operation of the rollers in jog mode and only for the time strictly necessary for its use.

This control is connected to the machine by inserting the plug at the end of the pedal power cord into the socket on the side of the machine itself.

### Touch and go models:

**TO START** Press the switch on the side into position 1

Press the black "SET TIME" button on the control unit to set the operating time from 10 to 35 seconds; the machine is ready for the operating stage.

Before introducing the lightly floured and previously proofed (at least 6-8 hours) ball of dough into the opening of the protection, slightly squash part of the edge of the ball to facilitate its entry into the pair of upper rollers.

**THE ROLLERS WILL START AUTOMATICALLY WHEN THE DOUGH COMES INTO CONTACT WITH THE UPPER CHUTE.**

When the dough exits the rollers, its thickness will be slightly reduced and it will have an oval shape. Then as it slides onto the balance, it will be rotated in a diagonal direction by about 90°, ready for the next passage through the lower rollers, from which it will exit in a rough disc shape, which will then need to be perfected by hand. **The rollers will automatically stop turning at the end of the previously set time, or when the "STOP" key is pressed.**

**TO STOP** Press the switch on the side into position 0.

### **CONTINUOUS MODE:**

For continuous mode on touch-and-go machines: hold down the left button, then press the right button. To stop the machine, press the right button.

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## USE FOR DISC FORMATION

After manually turning the machine on by pressing the switch into position 1, or with the pedal control in position 2, the operating stage can begin.

Before introducing the lightly floured and previously proofed (at least 6-8 hours) ball of dough into the opening of the protection, slightly squash part of the edge of the ball to facilitate its entry into the pair of upper rollers, in which the dough thickness will be slightly reduced, assuming an oval shape. When this step is about to conclude, guide the dough's descent using your hand, moving it forward step by step until it is completely out, after which the rollers will stop. Turn the dough in a diagonal direction by about 90°, preparing it for the next passage through the pair of lower rollers, from which it will exit in a rough disc shape, which will then need to be perfected by hand.

## USE FOR RECTANGLE FORMATION

Place a clean, suitably sized tray under the machine, compatible with the width of the supporting feet.

Turn the machine on, start the rollers, then introduce the lightly floured and previously proofed (at least 6-8 hours) dough into the opening of the protection, slightly squashing part of the edge of the ball to facilitate its entry into the pair of rollers, in which the dough thickness will be slightly reduced. After its exit, for medium and high weights, it is essential to proceed in jog mode, manually widening the dough in preparation for its subsequent passage through the rollers from which the formed dough will be laid in the tray.

**IMPORTANT:** TURN THE MACHINE OFF AT THE END OF THE OPERATING STAGE.

## MAINTENANCE

**ATTENTION: Before performing any type of maintenance works, including cleaning, adopt the following precautions:**

- make sure the equipment is disconnected from the electrical mains (detach the plug from the power socket), making sure the power supply cannot be accidentally reactivated;
- Make sure the equipment has completely cooled;
- Use the personal protective equipment required by regulations in force;
- Always operate using appropriate tools;
- At the end of maintenance / repair / cleaning operations, before placing the equipment back into operation, reinstall all protections and safety devices;

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## CLEANING

**ATTENTION: Under no circumstances may non-food-grade abrasive or corrosive chemical products be used. It is strictly prohibited to use jets of water, various tools, rough or abrasive means, such as steel scourers, sponges, etc., which may damage the surfaces and in particular compromise the hygienic safety.**

Cleaning must be carried out after every use **in compliance with hygienic regulations in force and in such a way as to protect the functions of the machine**, proceeding as follows:

- Using a suitable brush, first remove any flour and dough residue;
- Remove the small balance and chutes from their housings;
- Release the springs and slide out the dough scrapers;
- Turn the adjustment levers so that the rollers are in their maximum open position;
- Thoroughly clean the machine and all its parts, including the dismantled components, using a sponge or cloth dampened with water and a neutral food-grade detergent;
- Rinse as needed to remove all traces of the detergent;
- Dry with food-grade paper towel, then wipe down first the surfaces in contact with the dough, then the entire machine with a soft and clean cloth dampened with a specific disinfectant for food-grade machines.

## SHAFT AND ROLLER LUBRICATION

The shafts and rollers must be lubricated on an annual basis.

After removing the protections, chutes, springs and dough scrapers;

- remove the screws and dismantle first the back panel and then the supports;
- finally, remove the rollers and joints;
- thoroughly clean all parts with a sponge, warm water and food-grade detergent, rinse as needed and dry with paper towel;
- lubricate both the shafts and the holes of the rollers using a sufficient quantity of paraffin oil;
- reassemble and secure all parts, carrying out the steps in the reverse order with respect to their disassembly.

**ATTENTION: At the end of maintenance / repair / cleaning operations, before placing the equipment back into service, check that all parts and relative protections have been properly positioned and secured;**

## TROUBLESHOOTING

PROBLEM	CAUSE	SOLUTION
The machine won't start	1_No mains electrical power 2_The pedal control is connected to the machine.	1_Check: the general contactor, socket, plug and power cord. 2_Press the pedal controls

## DEMOLITION AND DISPOSAL

**ATTENTION: The demolition and disposal of the machine is the exclusive onus and responsibility of the owner, who must act in accordance with regulations in force in their own country in regards to safety, respect and protection of the environment.**

When demolishing the machine, the provisions of regulations in force must necessarily be complied with. To facilitate recycling operations, sort the different parts composing the machine into the different types of construction materials (plastic, copper, iron, etc.).