

STRING KING MODEL "S"



- Stringline for the Production of 3,400 of 19 oz. (539 g) Strings of Dough Up to 26" (660 mm) Long
- Advanced Electrical System
- Compact Design
- Easy to Maintain
- Fresh, Frozen and Par-Bake

FEATURES & BENEFITS

- Electronic infeed synchronizing system to eliminate doubles
- Heavy duty flour dusting of empty and/or full proofer trays
- Adjustable dwell of infeed gates
- Pressure board/moulding section (with flour duster)
- Proofer section (with flour duster and two exhaust fans)
- Self-tilting proofer trays to prevent sticking
- High velocity exhaust fans to prevent sticking
- Controlled fall free discharge
- Discharge degassing (optional depending on dough)
- Other machines available up to 4,000 strings of dough up to 36" (914 mm) long
- Servo centering system
- Three stage moulding section (C/W two dough extenders)
- Stressless extending system
- Unique indexing flap system to transfer long strings and keep them broom stick straight
- Loaf splitter for two, three or four loaves
- Lifiable club roll cutting section
- Roll cutting system that cuts strings into rolls and recycles cut-offs up to 10 cuts (depending on dough and length)
- Transfer conveyor
- Multiple discharge options:
 - Peel and panning
 - Direct final proofer and freezer infeed

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MECHANICAL FEATURES

Indexing Conveyor

- Photo eye controlled for proper timing of the dough balls into the moulder
- Double eliminator logic
- Constructed of formed stainless steel with UHMW side wedges
- Powered by a hollow shaft gear and brake motor

Moulder Section

- Stainless steel frame
- Air operated lifting device permits rapid changeover of dough guides and easier access for sanitation and maintenance
- Flour sifter
- Pneumatic pressure board

Common Drive

- Proofer drive is protected by an electronic over torque meter against catastrophic damage

Proofer

- 4.5 minutes of proofing time at 3,375 pieces per hour
- Stainless steel tubular construction
- Stainless steel paneling
- Upper horizontal section with sliding plexi-glass panels
- Teflon coated and pneumatically controlled dropping gates with separate timing valves
- Adjustable flour duster located above the double dropping gates
- Proofer trays are made of rolled aluminum, plastic end brackets, and sandblasted to a coarse finish
- Proofer chain is 1 1/2" (40 mm) extended pitch oversized rollers
- Oversized hub sprockets
- Horizontal sections of the proofer have angle iron chain guides and rails that tilt to one side helping to reduce sticking in the trays
- Strings are transferred from the trays to the discharge conveyor without dropping
- Discharge conveyor is stainless steel construction and is driven by the proofer chain

Centering Device

- Brings string of dough back to center of moulding conveyor
- Stainless steel frame with aluminum based plate
- Conveyor section is built from stainless steel side plates with an adjustable UHMW bed for proper tensioning of the stainless steel balanced weave mesh conveyor belt
- Driven by a flange mount gear motor using a belt drive system
- Centering is accomplished by a multi-element infra red light beam source and receiver, processor, servo controller, and linear actuator

Three Stage Moulder Section

- Consists of a moulding conveyor with two powered extender pressure boards made up of two conveyors at 90 degrees to the moulding conveyor
- Extender pressure boards have rough top conveyor belt and travel to the outside of the moulding conveyor very slowly causing the dough string to extend with very little stress. In addition, there is a standard pressure board with universal side guides.
- Moulding conveyor is constructed of stainless steel with an adjustable speed gear motor
- Adjustable infeed roller for tracking
- Two pressure boards supplied with the Stringline. One pressure board is for final moulding of strings to full length. The second pressure board has a slot in the middle, where a stationary knife is located to split long strings into two rounded end loaves

Roll Cutting Section

- Cuts blunt end rolls and transports the elongated strings to the next step in the process
- Constructed of stainless steel and a flat top Intralox conveyor belt
- Driven by a fixed speed gear motor
- Stainless steel side panels
- Rotary timing flaps at the infeed end to keep the string straight and evenly spaced from each other
- Flaps are driven from a gear motor and controlled from a signal from the common drive
- Slip clutch on the flaps to prevent injury
- Machine comes with one set of cutting devices with four knives
- Cutting device is constructed of stainless steel

Transfer Conveyor

- Transfers loaves or rolls from club roll cutter
- Inverter controlled
- Pneumatic Teflon coated infeed flaps
- Powered transfer roller eases transfer of loaf between two conveyors



Indexing Conveyor



Centering Device



Moulding Conveyor



Roll Cutting Section



ELECTRICAL FEATURES

- **NEMA 12 painted steel electrical enclosure including**
 - Alarm reset, MCR, emergency stop
 - Main disconnect switch
 - Allen Bradley 5/03 PLC
 - Allen Bradley PanelView 1000 monochrome keypad
 - Allen Bradley AC inverters
 - Allen Bradley Ultra 3000 servo amplifier
 - Convenience plug to allow programming without having to open panel door
- **Allen Bradley PanelView 1000 keypad operator interface which displays:**
 - Status messages
 - Alarm messages
 - System start/stop buttons
 - Flour sifters start/stop buttons
 - Fans start/stop buttons
 - Fans speed control

MECHANICAL OPTIONS

- Degassing roller can be supplied with separate drives and two Teflon lined rollers, 4" (102 mm) in diameter
- Spare parts kit

ELECTRICAL OPTIONS

- NEMA 12 stainless steel electrical panel
- Allen Bradley PanelView 1000 color
- Spare parts kit

SPECIFICATIONS

Throughput Range:

3,400 of 19 oz. (539 g) strings of dough up to 26" (660 mm) long

Electrical Requirements:

Main Power: 25 KVA

PLC I/O Voltage: 24VDC in/120VAC out

Air Requirements: 18 SCFM @ 90 PSIG

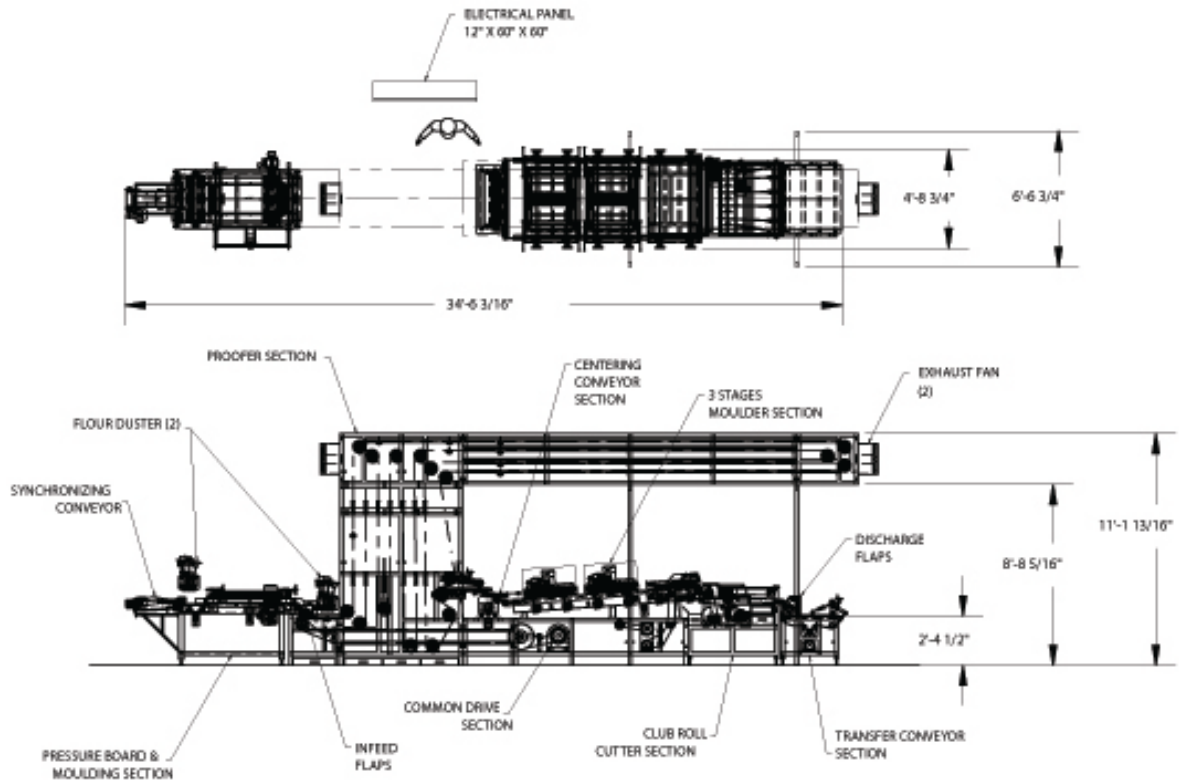
Approximate Shipping Dimensions:

34'6" L x 6'6" W x 11'2" H

(1051 cm x 1981 mm x 3404 mm)

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DIMENSIONAL DRAWING



Headquarters:
 2115 W. Laburnum Ave.
 Richmond, Virginia 23227
Tel: 1-800-225-3771
or 1-804-355-7961
Fax: 1-804-342-9724
sales@amfbakery.com

Europe Office:
 6 The Sidings
 Station Road, Guiseley
 Leeds LS20 8BX, England
Tel: 44-1943-875703
Fax: 44-1943-871806
sales-europe@amfbakery.com

Asia Office:
 Room 15-2, A-Building
 Thunis Dev. Building
 No.11 Hui Xin East St.
 Chaoyang District
 Beijing, China 100029
Tel: 86-10-64823613
Fax: 86-10-64934259
sales-asia@amfbakery.com

FOR MORE INFORMATION PLEASE CALL YOUR ACCOUNT MANAGER OR

1-800-BAKERS-1
www.amfbakery.com

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