

The Moline Starwheel Chunker



Designed to deliver uniform dough chunks to an extrusion system for consistent and controlled operation.

The Moline starwheel chunker is designed to deliver uniformly measured dough pieces, or chunks, to an extruder installed below the hopper. This synchronized and consistent dough delivery system provides continuous dough extrusion to the production line.

From a mixer, dough is delivered to the chunker hopper where chunks are formed by "starwheel" paddles rotating 120° per cycle. The chunks are released to the extruder below at the desired interval. Electronic dough sensors,

mounted on the sides of the chunker frame, sense the dough level in the extruder hopper and signal when the next dough chunk should be released. The starwheels are driven by a drive motor and gear reducer. A pneumatic torque limiter prevents damage if an overload occurs.

The starwheel chunker, electronically synchronized with a Moline extruder, maintains a constant level of dough for consistent extrusion onto the sheeting line, greatly improving product uniformity and weight control.

- **Electronically synchronized to the extruder for uniform and consistent dough delivery.**
- **Large capacity chunkers can easily match dough extruder output.**
- **Simple design provides efficient sanitation.**



**Star Wheel
Paddles Inside
Hopper**



**Chunker and
Extruder**

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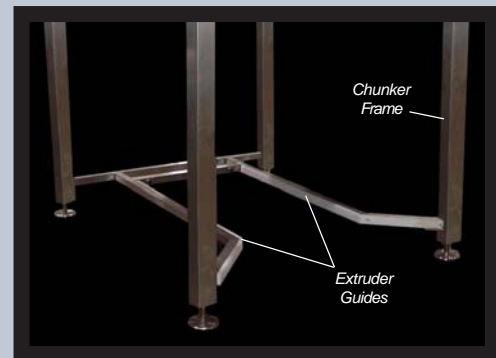
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Features

- **Construction:**
Heavy-gauge stainless steel with precision-machined components. Chunker hopper interior is specially coated for optimum dough release.
- **Control Functions:**
Activation and speeds are easily accessed through the production system's operator interface. Electronic dough sensors mounted on the chunker frame (see photo at right) sense dough levels in the extruder hopper and signal dough chunk release.
- **Drive System:**
Standard: direct drive, gear reducer, pneumatic torque limiter and drive gears.
- **Pneumatic System:**
Contains a filter/regulator and control valve necessary to operate the pneumatic torque limiter on the drive. Standard Pneumatic Requirements: 10 cfm @ 80 psi (5 liters/second @ 5 bar).
- **Electrical System:**
Standard Electrical Requirements: 480 Volt / 60 Hertz / 3 Phase (other options are available).



Dough Sensors on Chunker Frame



Optional Extruder Guides on Chunker Frame



Starwheel Chunker with Rotor Extruder

Using a Chunker and Extruder

The chunker is typically used with a Moline extruder. The two units provide synchronized delivery of portioned dough chunks to maintain a constant level in the extruder hopper. This system provides a continuous and consistent dough sheet which greatly improves weight control of the final product.

The portable extruder is easily moved into position beneath the chunker. Optional guide brackets can be installed (see photo above) to make the process simple even in confined or low-visibility areas.

The chunker and extruder are electronically interlocked to ensure synchronized operation.