



Grand Rapids, Michigan, U.S.A. 49504-5298

**USER'S OPERATING AND INSTRUCTION MANUAL**

**MODEL 625-DR & 625-S**

DOUGH DIVIDER / ROUNDERS

0625S20000-CVR



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**MODEL 625 DOUGH DIVIDER - ROUNDERS  
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## GENERAL

### DEFINITIONS

The use of the words WARNING, CAUTION, and NOTE in this manual should be guided by the following.

#### **WARNING**

AN OPERATING PROCEDURE, TECHNIQUE, ETC., WHICH MAY RESULT IN PERSONAL INJURY IF NOT CAREFULLY FOLLOWED.

#### **CAUTION**

AN OPERATING PROCEDURE, TECHNIQUE, ETC., WHICH MAY RESULT IN DAMAGE TO EQUIPMENT IF NOT CAREFULLY FOLLOWED.

#### **NOTE**

AN OPERATING PROCEDURE, TECHNIQUE, ETC., WHICH IS CONSIDERED ESSENTIAL TO EMPHASIZE.



## MODEL 625 DOUGH DIVIDER-ROUNDERS

### SAFETY INSTRUCTIONS

Every effort has been made by Oliver Products Company to provide you with a safe machine. It is essential, however, that machine operators and maintenance personnel observe the following safety precautions. Improper installation or operation of this equipment may cause personal injury or damage to the equipment.

1. Read this manual before attempting to operate your machine. Never allow an untrained person to operate or service this machine.
2. Connect the machine to a properly grounded electrical supply that matches the requirements shown on the electrical specification plate and follow specifications of local electrical codes.
3. Disconnect and lock-out the machine from the power supply before cleaning or servicing.
4. Check and secure all guards before starting the machine.
5. Observe all caution and warning labels affixed to the machine.
6. Use only proper replacement parts.
7. Do not wear loose fitting clothing or loose hair. Shirt tails should be tucked in.
8. Wear proper personal safety equipment.
9. Keep Hands away from the moving parts of this machine while it is in operation.
10. In addition to these general safety instructions, also follow the more specific safety instructions given for the different areas of the machine in the operating instructions.

### **WARNING**

DO NOT USE FOR OTHER THAN ORIGINALLY INTENDED PURPOSE.



### MODEL 625 DOUGH DIVIDER-ROUNDERS DESCRIPTION/SPECIFICATIONS

#### DESCRIPTION

The Model 625 Series of Dough Divider Rounders will divide a pre-weighed amount of dough into either 15 or 36 equal parts. The same machine will then shape each of the parts into a convenient ball shape for stamping or baking.

The Model 625 Series of dough Divider Rounders are built of heavy gauge steel and cast iron. All contact parts are either electroless nickel plated or plastic.

The standard Divider Rounder is driven by a 3/4 HP, TEFC, single phase, capacitor start motor.

#### SPECIFICATIONS

Weight (Approx.)----- 715 lbs.  
Shipping Weight ----- 800 lbs.

#### Electrics:

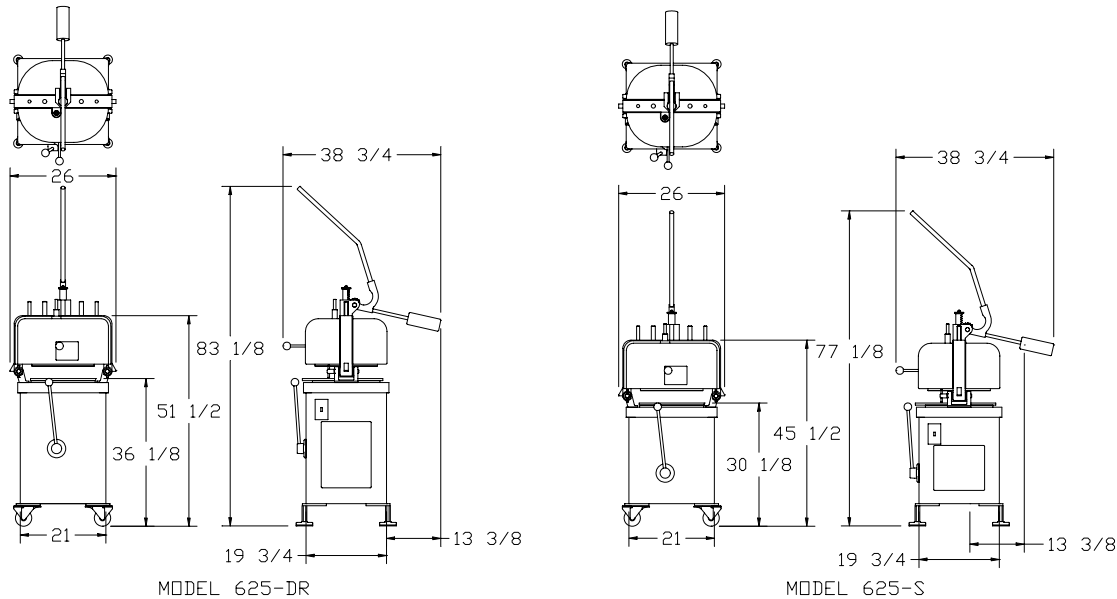
- Standard----- 3/4 hp, 1 ph, 60 hz, 115 volts, 11.4 amps.
- Optional----- 3/4 hp, 1 ph, 60 hz, 208 volts, 5.7 amps.
- Optional----- 3/4 hp, 1 ph, 60 hz, 230 volts, 5.7 amps.
- Optional----- 3/4 hp, 3 ph, 60 hz, 230 volts, 2.6 amps.
- Others----- Consult Factory

#### Product Weight Range (Approx.)

- 36-Part ----- 1 to 3-1/2 oz.
- 15-Part ----- 2-1/2 to 8-1/4 oz.

#### Physical Size of Machine (plus/minus

1/2") :



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## MODEL 625 DOUGH DIVIDER-ROUNDERS SETUP & OPERATION

### SETUP

Removing the Divider Rounder from the Skid

The first thing to do is to pick a location where the machine will be used. It should have a grounded power outlet of the same rating as that of the machine and be capable of carrying the load that the Divider Rounder will put on it. As the Divider Rounder weighs over 715 pounds we suggest that you next move the crate as near as possible to this area.

#### **WARNING**

THE MACHINE MUST BE CONNECTED TO A PROPERLY GROUNDED ELECTRICAL SOURCE OF THE SAME RATING AS THE MACHINE.

If you haven't already removed the upper crate do so now. You will find that the Divider Rounder is bolted to the skid and that the Pressure lever, counter weight, and the four leveling pads and other components have been shipped loose. Remove the four bolts from the feet of the machine freeing the Divider Rounder from the skid. Also set to one side those parts which have been shipped loose.

Carefully raise the machine and remove the skid, or gently slide the machine from the skid, using care not to tip it over. Locate the machine as near as possible to its permanent location. Install the legs between the feet of the machine and the cast pads.

Following the installation of the legs and pads, attach the pressure lever and the counter weight and connect the machine to the power source. After reading the instruction manual you will be ready to start your machine.

#### **CAUTION**

BEFORE ATTEMPTING TO OPERATE THE MACHINE MAKE SURE THAT ALL OPERATORS HAVE READ THIS MANUAL.



## OPERATING INSTRUCTIONS

### Adjusting the Main Plate Stop

The only adjustment on the Divider Rounder is the adjustment of the stop for the Main Plate.

When rounding the divided dough the Main plate is elevated above the Molding Plate to create a rolling space for the dough. This is done by releasing the Main Plate from the Gear Shaft using the Releasing Lever. Spring Tension will move the Main Plate above the Molding Plate to a position set by a stop located on top of the machine. This distance or stop setting, is determined by the volume of the individual pieces of dough. More space is required to round a large piece of dough than is required to round a small piece. Once these settings have been determined we suggest that they be recorded for future use.

The actual adjustment is made by loosening the large knurled hand locking nut at the top of the machine and then turning the index screw counter clockwise to raise the plate, (larger pieces of dough), or clockwise to stop the plate lower for smaller pieces of dough. After each adjustment, before running the machine, make sure that the index screw has been secured by tightening the knurled locking nut.

Improper or incomplete rounding can occur either because not enough space has been allowed or that too much space has been provided. When improper rounding occurs check this adjustment.

### Operation

1. The first step is to weigh a piece of dough which when divided will provide you with pieces of the desired size. The large piece of dough should weigh either 36 or 15 times, (depending on the option you have chosen), as much as you wish the divided piece to weigh.

Example: 2-1/4 pounds of dough = 36 one ounce pieces.  
4-1/2 pounds of dough = 36 two ounce pieces.  
6-3/4 pounds of dough = 36 three ounce pieces.  
2.4 pounds of dough = 15 two and a half ounce pieces.  
7-3/4 pounds of dough = 15 eight and a quarter ounce pieces.

Place one of the plastic molding plates on a work surface with the circular pockets facing upward. Place the large piece of weighed dough in the center of the molding plate and spread it over the plate by hand. The dough should not be spread so that it lies outside of the large containment ring of the Divider Rounder.



### Operation (Cont'd.)

2. Take the Molding Plate with the dough and place it on the Working Plate of the machine against the stops in the back and over the alignment pin in the front.
3. Using the Pressure Lever compress the dough firmly to fill the containment ring and to remove all air.
4. Reduce pressure on the Lever and release the spring loaded Main Plate by actuating the releasing lever with one hand while maintaining slight pressure on the Pressure Lever with the other hand.
5. Increase the pressure on the large Pressure Lever and bring it down firmly to the limit of its travel. This movement will now cut the single large flattened piece of dough into equal pieces.
6. Again reduce the pressure on the handle but keep it at the bottom of its travel. Turn the power switch to the "ON" position. Start the rounding action by grasping the Molding Lever and moving it in a counter clockwise direction as far as it will go. Hold it in this position for 3 to 5 seconds.
7. Allow the Pressure Lever to return to its normal position. Turn the machine off and remove the Molding Plate with the rounded pieces of dough. If the pieces are not rounded properly see the adjustment section of this manual.



## 625 DOUGH DIVIDER-ROUNDERS

### MODEL 625 DOUGH DIVIDER-ROUNDERS MAINTENANCE

#### **WARNING**

**NEVER ATTEMPT TO CLEAN OR SERVICE THIS MACHINE UNTIL IT HAS BEEN DISCONNECTED FROM THE POWER SUPPLY.**

#### **CLEANING**

**Remove-** all scraps from lower pan. **Wash** all interior surfaces; Knives, pusher plates, hopper, lid surface with a damp rag and **mild soap solution**. The exterior and contact surfaces should be cleaned daily using common cleaners. The **knives** should be extended for easier cleaning. This can be done by placing the cleaning separator, furnished with the machine, Clean the knives and plastic compartment floors of all dough build-up. **Rinse** all interior surfaces with a damp rag and clean water. **Sanitize** all interior surfaces with a damp rag and sanitizing solution. **Air Dry**, leave all areas open and allow interior to air dry before using.

**Remember normal maintenance will increase the life of the machine. It is a good time to inspect the machine for damaged or worn components, which may later cause problems or interrupt production.**

#### **CAUTION**

**FREQUENT CLEANING OF THE MAIN PLATE, LARGE CONTAINMENT RING AND KNIFE ARE REQUIRED TO PREVENT DAMAGE TO THE KNIFE.**

At the end of the day remove one of the T-pins so that the Arch assembly can be tipped to one side for easier cleaning. It is best to have two people tip the arch assembly, one lifting and one catching. After the arch is opened for cleaning actuate the pressure handle to lower the main plate and knife assembly.

Begin cleaning by dislodging particles of hardened dough with compressed air, a stiff bristle brush, or a plastic scraper.

#### **CAUTION**

**NEVER USE WIRE BRUSHES AS DAMAGE TO THE SURFACE PLATING OF THE CONTACT SURFACES MAY RESULT.**



## 625 DOUGH DIVIDER-ROUNDERS

### **CLEANING (cont'd.)**

Those particles which can not be removed using the above procedure should be softened using a spray bottle containing water, or by applying small amounts of vegetable or mineral oil. Once softened remove these particles with a cloth, stiff bristle brush or plastic scraper. Clean all cracks, crevices and surfaces of the Main Plate, Working Plate, and Large Containment Ring. Rinse with a light spray of clean water or a damp cloth and dry.

**Using the releasing lever, release the main plate from the gear shaft so that the knife will be exposed. Clean the knife using the same cleaning methods as described above.**

Monthly

Once a month, more often in heavy use, the Work Plate should be lifted from the machine and the area beneath it cleaned of all dough debris, a vacuum works best. Make sure that when lifting the Work Plate to use care to lift the plate "Straight" up.

#### **NOTE**

While the Work Plate is removed it is a good time to complete periodic lubrication in this area as well. See the lubrication section for details.

Care should be used when replacing the Work Plate. It must be lowered straight down, making sure that the bearing surface of the rotary carriage's slider enters into the roller bearing in the Work Plate while at the same time the the guide plate slides between the four cam followers on the opposite side of the Plate. Make sure that the plate is lowered completely and is contacting the top surface of the Base Plate.

3 to 6 Months

Remove the Front and Rear covers and blow or brush the area to clean it of flour, dough and other materials which may have accumulated there.

### **LUBRICATION**

#### **WARNING**

**NEVER ATTEMPT TO CLEAN OR SERVICE THIS MACHINE UNTIL IT HAS BEEN DISCONNECTED FROM THE POWER SUPPLY.**

#### **NOTE**

Always use food approved lubricants when greasing or oiling this machine.



## 625 DOUGH DIVIDER-ROUNDERS

### LUBRICATION (Cont'd.)

Monthly

Most lubrication should be done monthly and should be completed with the normal cleaning. Following is a list of things which should be greased or oiled.

1. Monthly, (weekly for machines experiencing heavy usage), grease the fittings on the left hand side of the machine.
2. Grease the four guide rods on the top of the machine which guide the Large Containment Ring and Main Plate.
3. Grease the gear on the end of the Pressure Lever and the rack gear if meshes with.
4. After cleaning beneath the Work Plate, (See cleaning section on the previous page), grease the guide rods for the slider on the Rotatory Carriage.
5. Add a few drops of food approved oil to each of the oilers located around the pivot for the Pressure Lever on the top of the machine.

### TIGHTENING OR REPLACEMENT OF V-BELTS

#### **WARNING**

NEVER ATTEMPT TO CLEAN OR SERVICE THIS MACHINE UNTIL IT HAS BEEN DISCONNECTED FROM THE POWER SUPPLY.

#### TIGHTENING

To begin, remove the access panel from the right hand side of the machine, (determined by facing the machine in a normal operating position).

The motor is suspended on a plate mounted to a large shaft suspended from the main casting above. There are four set collars securing the motor plate on the shaft. The outer two secure the motors vertical position and should never be loosened unless the motor is to be removed.

#### **WARNING**

LOOSENING THE LOWER SET COLLAR COULD ALLOW THE MOTOR TO FALL CAUSING PERSONAL INJURY OR DAMAGE TO THE MACHINE.

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## 625 DOUGH DIVIDER-ROUNDERS

### TIGHTENING (Cont'd.)

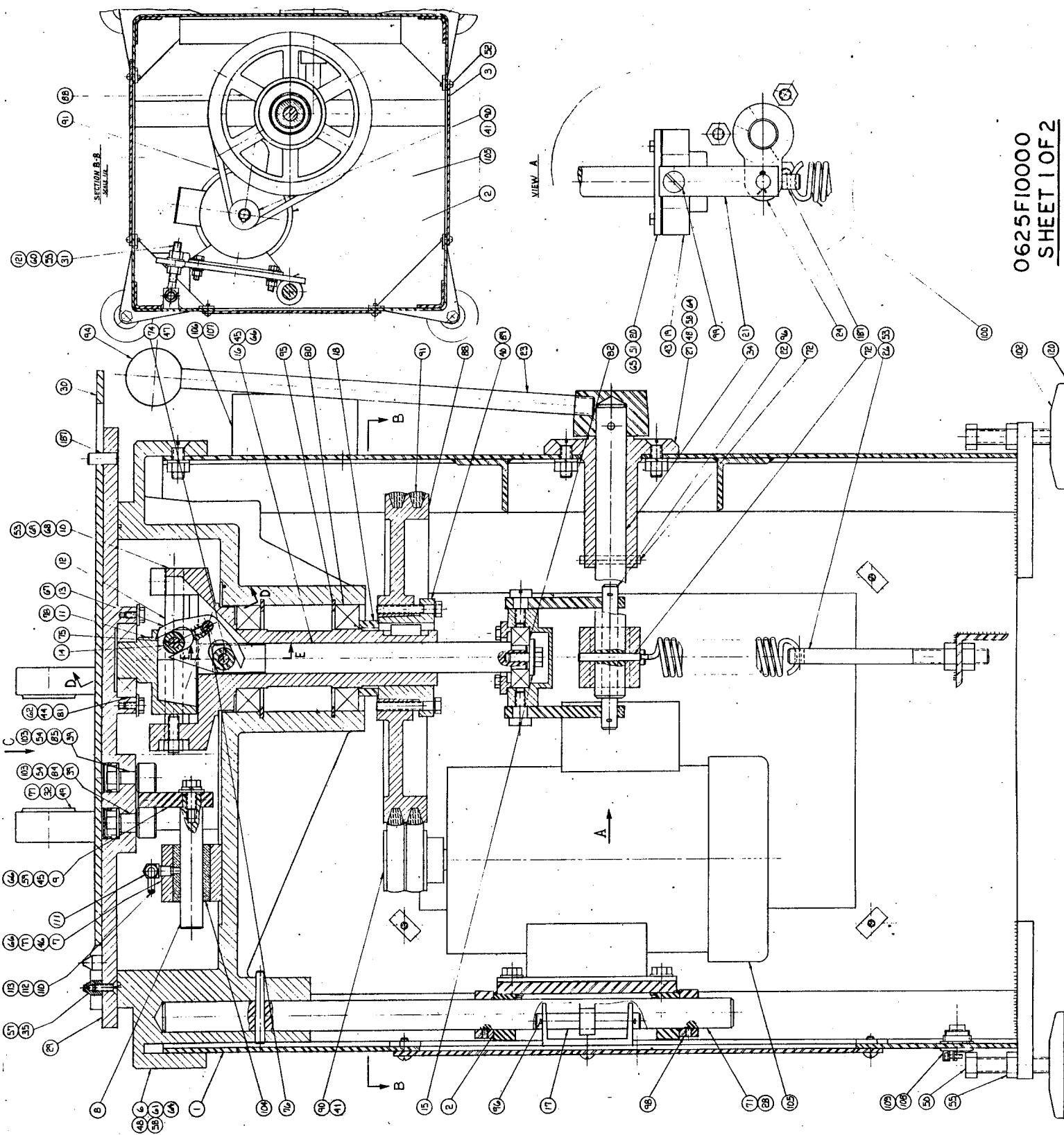
Loosen the set screws in the two center set collars, (the ones welded to the motor mounting plate).

Loosen the nut closest to the pivot point on the eyebolt, which passes through the center of the motor mounting plate. By turning the remaining nut, (which is on the other side of the mounting plate), clockwise you can increase the tension on the belt. Once desired tension is achieved secure the motor plate by retightening the nut closest to the pivot of the eyebolt and the screws in the set collars.

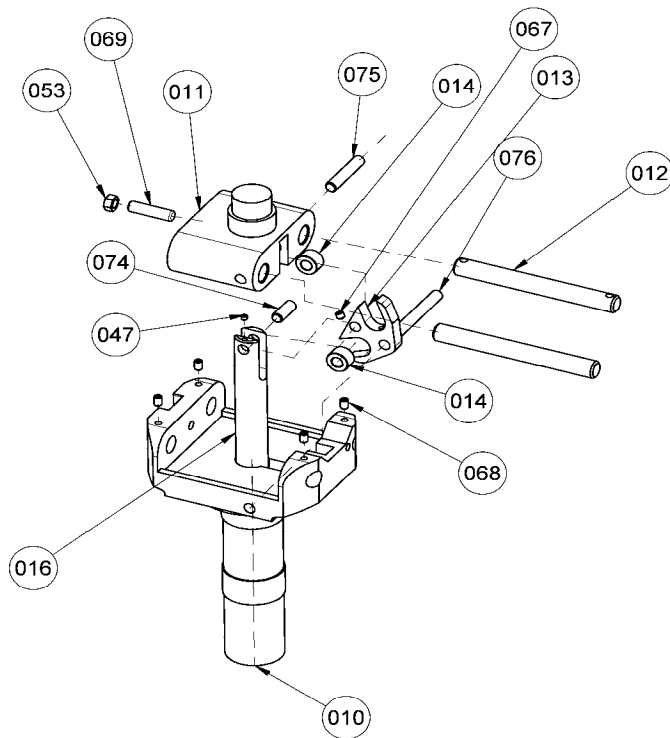
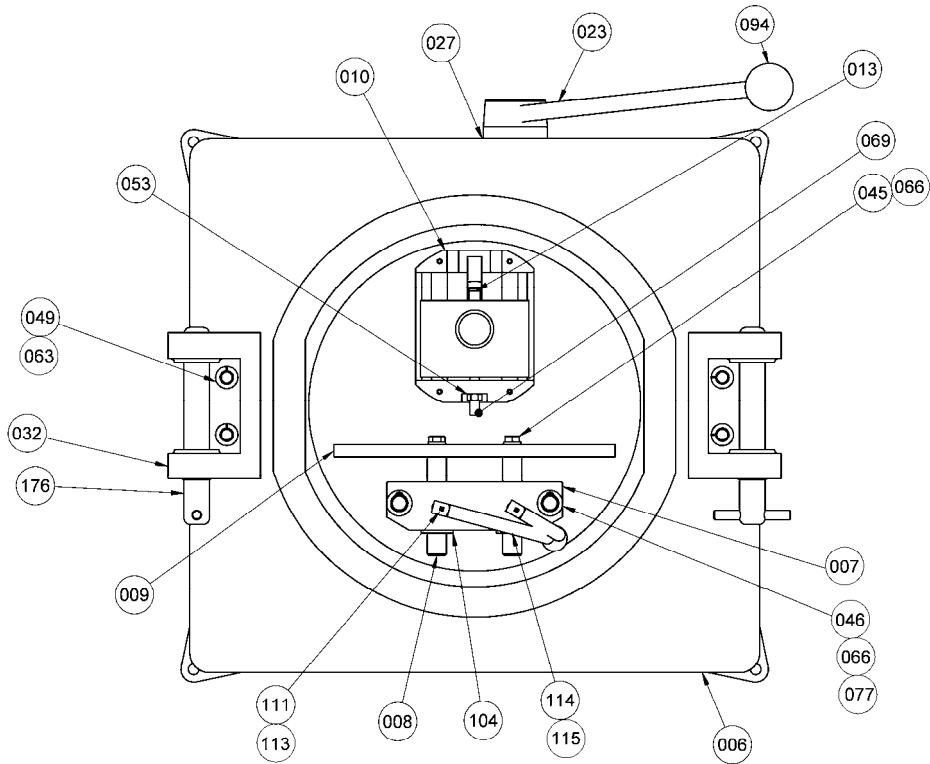
### REPLACEMENT

To remove a belt follow the steps above except turn the remaining nut on the eyebolt counter-clockwise until all tension has been removed from the belt. Swing the eyebolt to one side and move the motor as close as possible to the driven pulley, thus allowing removal of the belt.

To replace the belt simply reverse the above procedure and tighten the belt to required tension as instructed above.



0625F10000  
SHEET 1 OF 2





### BASE REPLACEMENT PARTS LIST

<u>ITEM NO.</u>	<u>PART DESCRIPTION</u>	<u>PART NUMBER</u>	<u>QTY.</u>
001	Frame (Model 625-DR)	0625-0006-1	1
001	Frame (Model 625-S)	0625-0006-101	1
002	Plate-Motor	0625-0013	1
003	Panel-Access (Model 625-DR)	0625-0015-002	3
003	Panel-Access (Model 625-S)	0625-0015-001	3
006	Plate-Base	0625-0007-001	1
007	Bracket-Double	0625-0025	1
008	Axis-Bracket	0625-0039	2
009	Plate-Guide	0625-0040	1
010	Rotary Carriage	0625-0024	1
011	Slider	0625-0023	1
012	Guide-Cylindrical	0625-0037	2
013	Pusher	0625-0033	1
014	Roller	0625-0034	2
015	Washer-Special	0625-0032	1
016	Pusher-Long	0625-0031	1
017	Axis-Motor Mounting	0625-0008	1
018	Piece-Distance	0625-0036	1
019	Bushing	0625-0004	1
020	Cover	0625-0020	1
021	Flat-Plain	0625-0029	2
022	Finger	0625-0030	1
023	Lever-Molding (5/8-11 THRD)	0625-0027	1
024	Lever-Clutch	0625-0021	1
026	Bolt-Eye (Model 625-DR)	5804-1000	1
026	Holder-Spring (Model 625-S)	0625-0028-001	1
027	Bushing-Flange	0625-0011	1
028	Shaft-Motor Mounting	0625-0009	1
029	Plate-Work	0625-0019	1
030	Plate-Molding (36 Part)	5502-4310	3
030	Plate-Molding (15 Part)	5502-4311	3
031	Eye Bolt-Motor Mounting	0625-0014	1
032	Plate-Anchor	0625-0017	2
034	Shaft-Molder	0625-0018-001	1
035	Lug	0625-0041	4
039	Washer-Special	4655-0215-1401	4
040	Key-Rect 7/16 x 1/2 x 1"	0625-0035	1
043	Cap-Plated Tubing	5902-2112	1
045	SCREW-HEX HEAD 3/8-16 X 3/4	5842-1552	2
046	SCREW-HEX HEAD 3/8-16	5842-1555	2
047	SCREW-SOCSET CPT #10X3/16	5842-6120	1
049	SCREW-HEX HD 1/2-13	5843-1105	4
050	Leg	0625-0070	4
053	NUT-HEX FULL 3/8-16	5832-0027	1
063	WASHER-STST SPRNG LOCK	5851-9361	4
066	WASHER-3/8"HELICAL SPRNG	5851-9010	4
067	PUSHER	0625-0033	1
068	SCREW-SOCSET CPT 1/4X3/8	5842-6133	2



**BASE REPLACEMENT PARTS LIST (Cont'd.)**

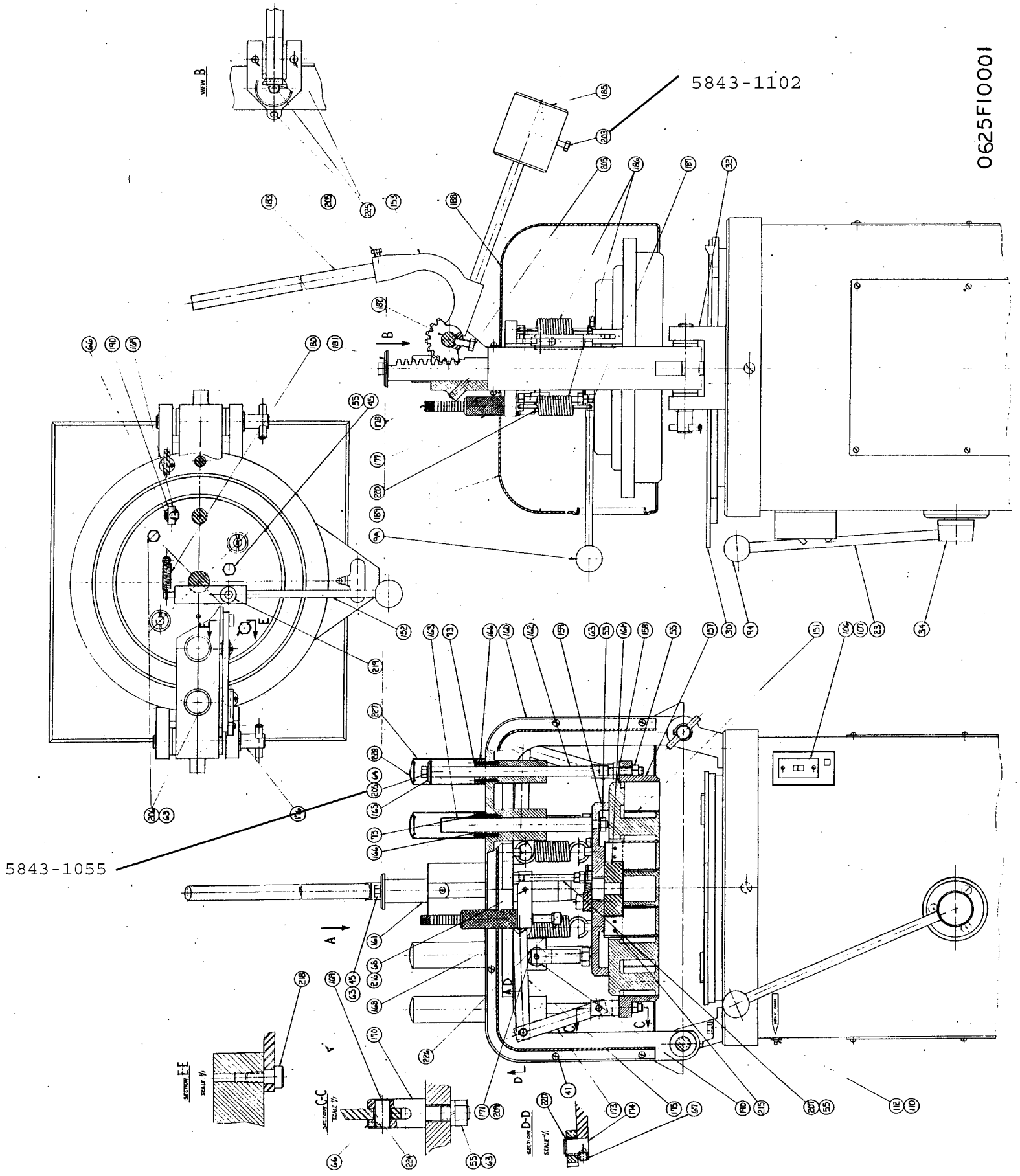
<u>ITEM NO.</u>	<u>PART DESCRIPTION</u>	<u>PART NUMBER</u>	<u>QTY.</u>
069	SCREW-SOCSET CUPPT 3/8	5842-6166	2
071	Pin-Spring 5/16 Dia x 2-1/4"	5835-6683	1
072	Pin-Spring 1/4 Dia x 2"	5835-6655	1
073	Pin-Spring 3/16 Dia x 1-1/2	5835-6613	8
074	Pin-Dowel 3/8 Dia x 1"	5835-6284	1
075	Pin-Dowel 3/8 Dia x 2"	5835-6288	1
076	Pin-Dowel 3/8 Dia x 3"	5835-6291	1
077	Pin-Spring 1/4 Dia x 1"	5835-6647	2
078	Pin-Spring 3/8 Dia x 3/4"	5835-6692	1
080	Bearing	5221-0040	2
081	Bearing	5250-4610	1
082	Bearing (for Plate)	5230-4600	1
084	Cam Follower (Eccentric)	5251-0073	2
085	Cam Follower	5251-0023	2
088	Sheave-2 Groove 10.6PD	5615-3564	1
089	Bushing-QD	5602-0848	1
*090	Sheave-2 Groove 1.9PD (60 Hz)	5615-3545	1
091	Belt-V A36	5601-1316	2
094	Knob	5911-7104	1
095	Ring-Retaining	5840-1006	2
096	Pin-Cotter 3/32 x 3/4	5835-6021	2
098	Collar-Set 1"	5806-7016	2
099	Screw-Shoulder 3/8 Dia x 1/2	5842-2951	2
100	Spring-Extension	7025-5204	1
102	Mount-Shock	0625-0061	4
103	Plug	5765-8302	1
104	Bearing-Bronze W/Grooves	0625-0038	2
110	Coupling-Brass Pipe	5115-1050	2
111	Fitting-Brass Street Elbow	5115-1002	2
112	Fitting-Straight Grease	5115-7000	3
113	Hose-Grease	5121-9004	2.187"
114	Fitting-Brass Hose Barb	5115-2000	4
115	Clamp-Hose	5106-8060	4
120	Pad-Vibra Mount	5504-0701	4
121	Grommet-Rubber	5767-1207	2
187	Holder-Spring	0625-0028	4

**NOTE:**

- Numbered drawing items not shown on this list are considered standard hardware items which can be purchased locally.

\*For electrics other than (60 hz) consult factory.

0625F10001





### ARCH REPLACEMENT PARTS LIST

<u>ITEM NO.</u>	<u>PART DESCRIPTION</u>	<u>PART NUMBER</u>	<u>QTY.</u>
151	Knife-36 Part	0625-0001	1
151	Knife-15 Part	0625-0001-001	1
151	Knife-36 Part (Low Stick)	0625-0001-002	1
152	Lever-Releasing	0625-0003	1
153	Handle-Gear	0625-0010-1	1
157	Ring-Big	0625-0026	1
157	Ring-Big (Low Stick)	0625-0026-001	1
158	Plate-Main 36 Part	0625-0002	1
158	Plate-Main 15 Part	0625-0002-001	1
158	Plate-Main 36 Part (Low Stick)	0625-0002-002	
159	Plate-Cover	0625-0052	1
160	Arch	0625-0016-001	1
161	Assy-Gear Shaft & Crest (36 Part)	0625-0005	1
161	Assy-Gear Shaft & Crest (15 Part)	0625-0005-001	1
162	Bolt-Guide	0625-0056-001	2
163	Rod-Guide	0625-0051-001	2
168	Support-Stop	0625-0044	1
169	Axis	0625-0049	2
170	Holder	0625-0060	2
171	Pusher	0625-0047	2
173	Connector-Short	0625-0058	2
174	Axis	0625-0059	2
175	Connector-Long	0625-0057	2
176	Pin-Removable	0625-0042	2
177	Nut-Lock	0625-0046	1
178	Screw-Index	0625-0045	1
185	Weight	0625-0055	1

**NOTE:**

- Numbered drawing items not shown on this list are considered standard hardware items which can be purchased locally.

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**ARCH REPLACEMENT PARTS LIST (Cont'd.)**

<u>ITEM NO.</u>	<u>PART DESCRIPTION</u>	<u>PART NUMBER</u>	<u>QTY.</u>
186	Spring-Big	7026-5301	2
187	Holder-Spring	0625-0028	4
188	Cover-Front	5500-5149	1
180	Spring-Small	7023-4100	1
181	Washer-Special	0625-0043-001	1
182	Axis	0625-0054	1
183	Lever-Pressure Formed	0625-0012-001	1
189	Cover-Back	5500-5148	1
190	Roller	0625-0048	2
203	Bolt	5843-1102	2
205	Bolt	5843-1052	2
215	Pin-Spring 1/4 Dia x 3/4" (36 Part)	5835-6842	6
215	Pin-Spring 1/4 Dia x 7/8" (15 Part)	5835-6843	8
216	Pin-Dowel	5835-6250	1
218	Screw-Shoulder 1/2 Dia x 3/8	5842-8990	2
219	Screw-Shoulder 3/4 Dia x 5/8	0625-0065	1
224	Bearing-Bronze	5254-0151	4
225	Valve-Oil	5133-6030	2

Parts Not Shown On Drawing

---	Bracket-Stop	0625-0069	2
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NOTE:

- Numbered drawing items not shown on this list are considered standard hardware items which can be purchased locally.

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### ELECTRICAL REPLACEMENT PARTS LIST

<u>ITEM NO.</u>	<u>PART DESCRIPTION</u>	<u>PART NUMBER</u>
* 105	Motor-3/4 HP, 1-60-115/208/230	6301-5602
* 106	Starter-Manual, 1 Phase	5709-1125
* 107	Heater-Overload SQD # A16.2 (1-60-115)	5708-2438
108	Bushing-Strain Relief	5765-1082
* 109	Cord-Power 1-60-115	5765-8302

\*For electrics other than (1-60-115vac) consult factory.

#### NOTES:

- See both assembly drawings numbered 0625F10000 and 0625F10001 for location of the above parts.
- Numbered drawing items not shown on this list are considered standard hardware items which can be purchased locally.



## RECOMMENDED SPARE PARTS

### EMERGENCY SPARE PARTS

<u>PART DESCRIPTION</u>	<u>PART NUMBER</u>	<u>NO. REQ'D.</u>
Bearing-Ball	5221-0040	2
Bearing-Roller	5250-4610	1
Bearing-Ball	5230-4600	1
Cam Follower (Eccentric)	5251-0073	2
Cam Follower	5251-0023	2
Belt-V A36	5601-1316	2
* Starter-Manual, 1 Phase	5709-1125	1
* Element-Heater, 1-60-115	5708-2438	1

### OPTIONAL SPARE PARTS

* Motor 3/4 HP, 1-60-115/208/230	6301-5602	1
* Cord-Power 1-60-115	5765-8302	1
Spring-Small	7023-4100	1
Spring-Big	7026-5301	2

\* For other electrics consult factory.

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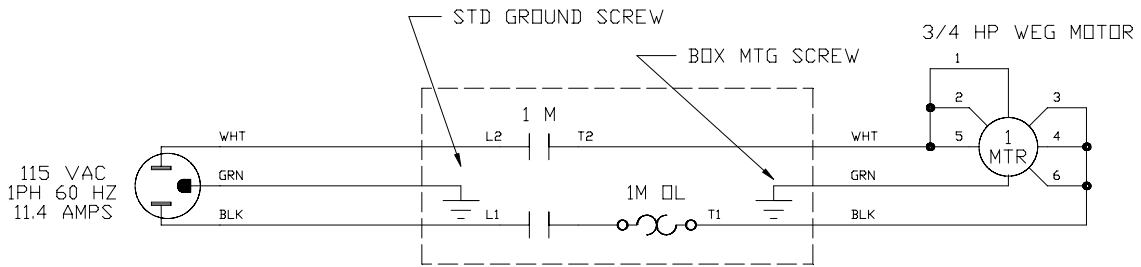


### MODEL 625 DOUGH DIVIDER-ROUNDERS WIRING DIAGRAMS

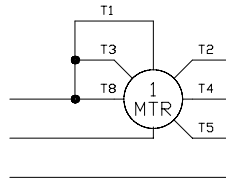
#### NOTE

Select the Wiring Diagram to be used for your machine based on its electrical ratings. See the nameplate on the machine for this rating. For electricians which are not shown please consult the factory.

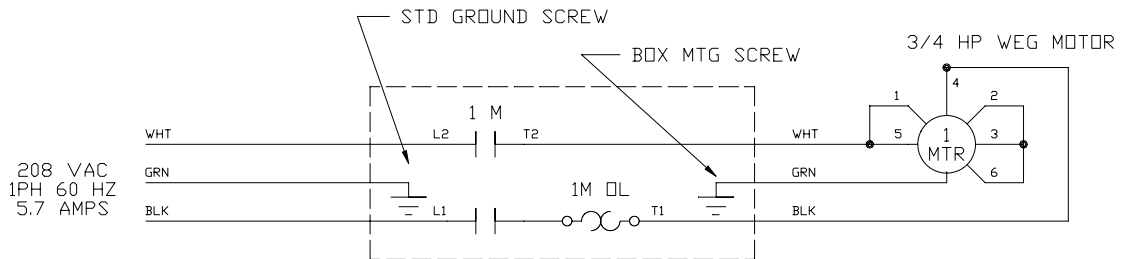
Machines rated  $\frac{3}{4}$  HP, 1-60-115 VAC:



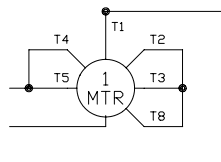
3/4 HP 115VAC LEESON MOTOR



Machines rated  $\frac{3}{4}$  HP, 1-60-208 VAC:



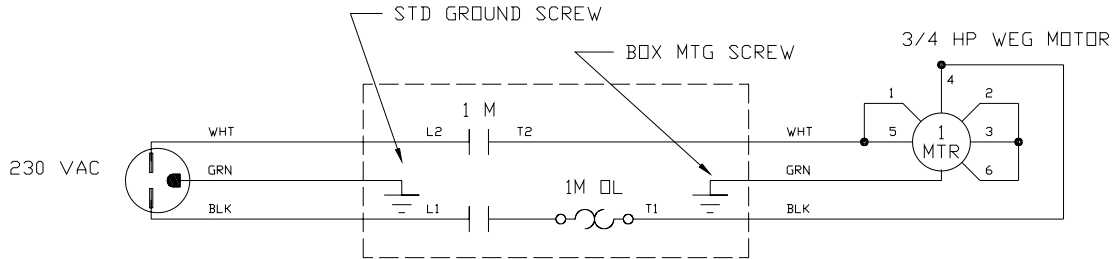
3/4 HP 208VAC LEESON MOTOR



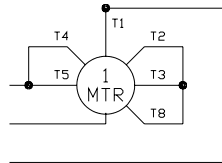
Rev. 3-29-02



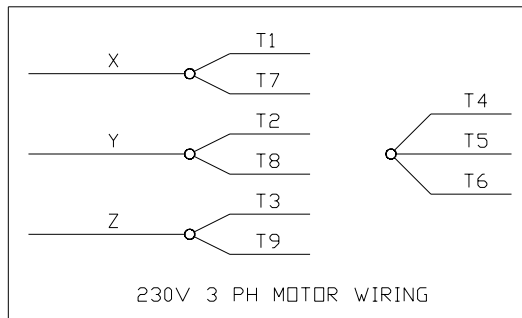
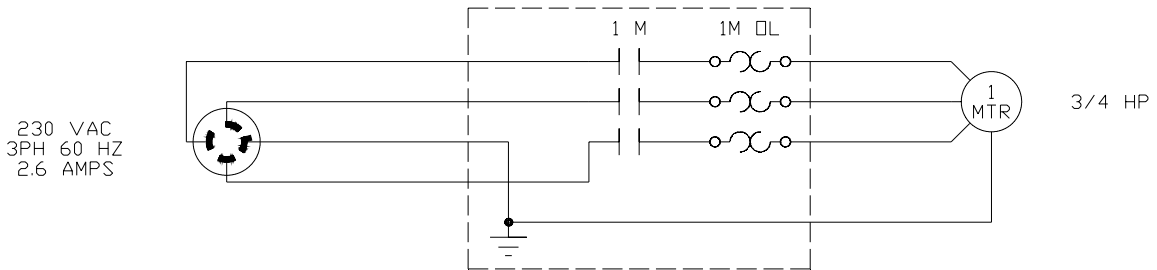
**Machines rated 3/4 HP, 1-60-230 VAC:**



3/4 HP 230VAC LEESON MOTOR



**Machines rated 3/4 HP, 3-60-230 VAC:**



Rev. 3-29-02