

YRW-300 I 型肉丸成型机使用说明

1 概述

1.1 用途：我厂生产的 YRW-300 I 型肉丸成型机，适用于生产以肉、鱼、虾、菜等为主要原料的肉丸制品，是宾馆、餐厅、酒楼、个体加工户理想的肉丸加工设备。

1.2 特点：制品需经水煮定型。定型后的制品呈球状，并富有弹性，且大小均匀、皮光肉滑。该机操作简单、维修方便，效率高。

2 主要结构与工作原理

2.1 主要结构

主要有机架、切刀组合、成型齿轮组合、料斗、

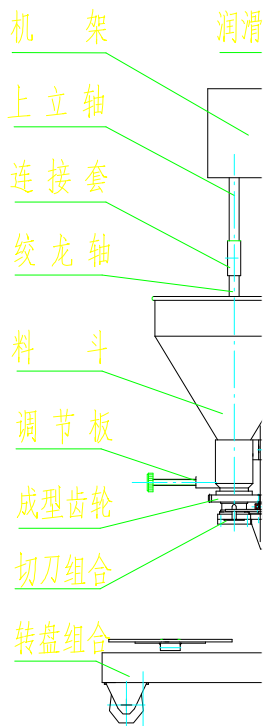


图1 结构示意图

2.2 该机接触食品的零部件均采用不锈钢和有色金属合金材料制成，符合食品卫生要求，便于清理。外部护板均采用不锈钢材料，外型美观，耐腐蚀。

YRW-300 I Meatball molding Machinery

1 Introduction

1.1 Application

YRW-300 I Meatball molding Machinery we manufactured is used for producing balls of meat ,fish and shrimps , vegetable ect . It fits for grogshop and self-employed in balls .

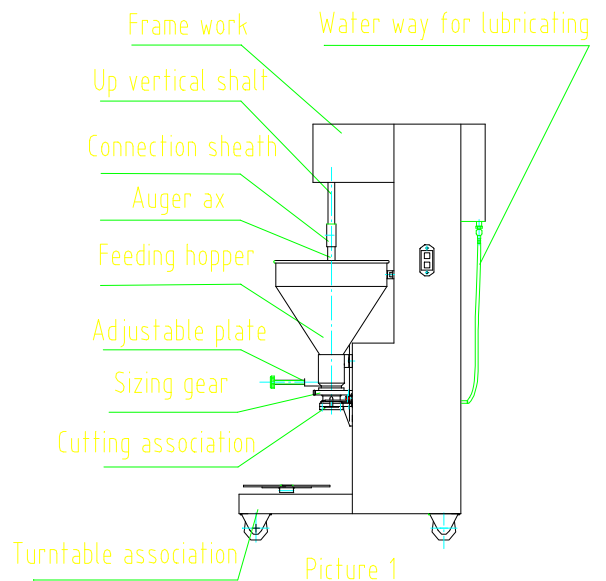
1.2 Characteristic

This machinery need to boil and size after boiling ,it's globosity、elastic and equality. The strong point of this machine is easy and reliable to operate and maintain and high efficiency.

2 Structure Features and Working Principle

2.1 Main structure

This machine mainly consists of frame work, connection, water way (see picture 1)



2.2 The main part touching the meat are all made of stainless steel and coloured copper alloy, under hygiene test and easy to clean. the wearing plate are all made of stainless steel material, beauty and corrosion proof.

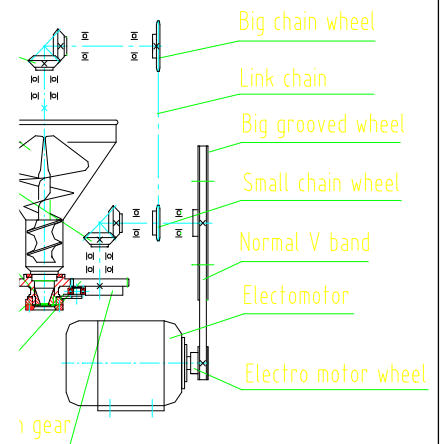
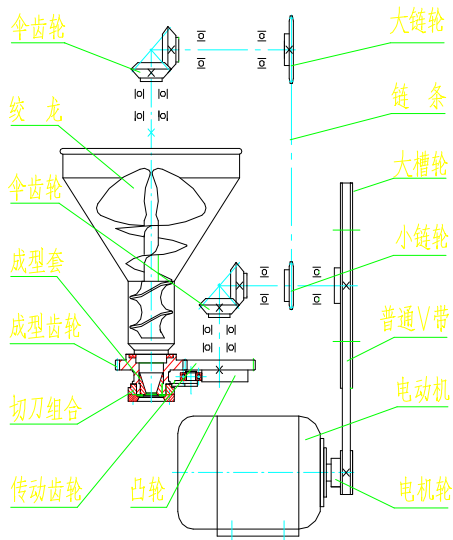


图2 传动原理图

Picture 2

2.4 工作原理 机器工作时, 绞龙旋转下压, 使料斗内肉丸原料经过成型齿轮、成型套, 在拨叉带动下的断刀做往复运动, 将旋转的丸子馅料切断, 完成丸子的制作。(参见图3)

2.4 Working principle

As the machine working ,the auger revolving downward ,pressure the meat material down to the sizing gear ,sizing sheath ,and the cuttings drive by the poking fork .reciprocate ,cut off the meat material , in this the balls are made.(see picture 3)

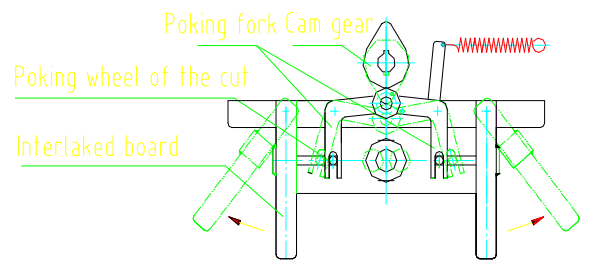
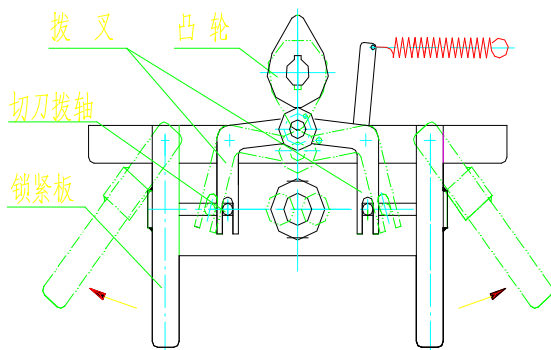


图3 工作原理图

Picture 3

3 技术参数

3 Technical Parameter

- a. 电机功率: 1.1kw ~ 220V
- b. 额定频率: 50Hz
- c. 防水等级: IPX1
- d. 生产能力: 295 个/分钟

- a. The power of motor: 1.1kW ~ 220 V
- b. Rated frequency: 50Hz
- c. Waterproof grade: IPX1
- d. Throughput: 295 piece/min

e. 肉丸规格：5-20 克/个（用户根据肉丸原料情况调整）

4 尺寸、重量

- a. 外型尺寸：800×405×1240 mm
- b. 机器重量：95 kg

5 安装、调试

5.1 将机器放置在水平的工作场地，确保机器工作平稳可靠。若肉丸成型后直接入锅油炸，可将机架中间的活动支脚调整好，卸去紧固螺栓，把转盘架拆去（参见图 4），并将机器出料口与油锅保持高度固定好。

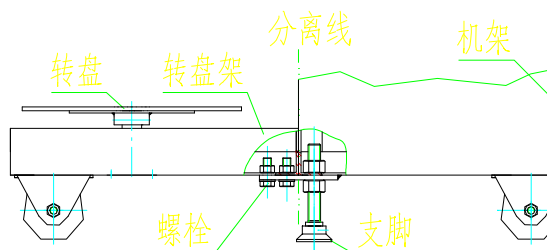


图4 分离转盘架简图

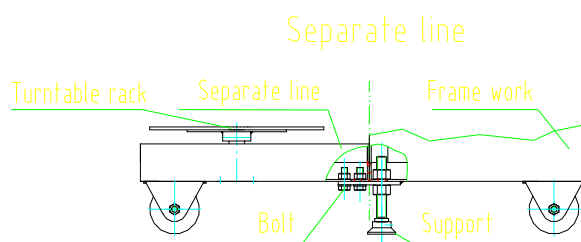
e. Boiling specs: five-twenty g/piece

4 Size and Weight

- a. Dimension: 800 × 405 × 1240 mm
- b. Weight: 95 kg

5 Installation and Debugging

5.1 Put the machine in dry, well ventilated place on a level surface, confirm it works stably and reliably. If it need deep-fry balls ,turning up the support structure ,removed the fasted bolt ,discharge the turntable,(see picture 4) , and adjust the oil-bath pan's high , made it propitious to the export door, then fix them.



Picture 4

5.2 使用前对各部位进行检查，紧固件是否在运输途中松动，开关及电源线是否因运输而破损，切刀拨轴是否在拨叉槽内。

5.3 检查料斗内是否有异物，如有异物清理干净，以免外来硬性杂质引起的机器零件损坏。

5.4 将电源软线伸长，把带有接地符号的线芯可靠接地，把其余两条线芯（三相电机时为三条）分别接到开启式负荷开关（闸刀开关）断开时的引出线接线端子上。

5.5 将水箱安装在机器后上方，用随机带的塑料软管连接水箱和润滑管路。

5.6 闭合开启式负荷开关，按开启按钮，从料斗上方观察绞龙转向，逆时针方向旋转为正确，机器运转平

5.2 Check the machine before using. Check out whether fastening pieces is loosened, power wires damaged or not during transit, and make corrections in time.

5.3 Check the feeding hopper, if there are foreign matter , please clear it up to avoid damage the machine's parts

5.4 Elongate the soft power cord and ground olive wire with power port, connect the rest three cores (two cores when equipping single phase machine) to the eduction line terminals of breaker (airbreak switch) , respectively.

5.5 Installing the water tank on the above and behind of the machine .connect the water tank and the lubrication system with the soft pipe .

5.6 Close the on-off switch ,put the “on” button ,through the feeding hopper watch the auger's revolving way . if

稳，并无异常声音时方可试机。

5.7 将调制好的肉丸原料倒入料斗中，左手拿一洁净的小盘接在出口下面，启动机器，观察落入容器中的肉丸大小和形状是否符合自己的理想，根据需要用手旋转调节螺丝改变调整板的位置，调整肉丸的大小（肉丸一般要调长一点，加温时会变短一点而成为圆形）。如不能满足要求时，可根据需要更换切刀或成型套。换好后，再调整调节板的位置，使丸子的大小和形状符合要求。调节好后，将小盘中试切制品倒回馅斗中，即可正常使用。

5.8 本机的切刀、成型套分别为三套，机器上安装一套，其余各两套为随机配件。孔径大小不同的成型套、切刀各分为大、中、小三种规格，用户可以根据需要组合成六种形式进行使用。A 大号切刀与大、中号成型套配合。B. 中号切刀与中、小号成型套配合。C. 小号切刀与中、小号成型套合。

6 使用、操作

6.1 正常使用时，产出的肉丸必须经过热水定型，水的温度一般在 50-70℃ 为最佳。油炸时自行掌握油的温度。

6.2 肉丸成型后水煮定型时，将水箱内加上干净的冷水；肉丸成型后直接入锅油炸的，当馅料含油脂多，自润滑较好的情况下可不润滑；当添加的面粉较多、馅料较粘时，在水箱内加入食用油润滑。

6.3 打开水箱上放水的旋塞冲水（油炸时为食用油）润滑切刀，启动开关开始工作。将盛有温水的容器放置在出口下面的转盘上，工作时慢慢转动容器，使里面的肉丸不叠压而变形（直接入锅油炸无转盘）。

6.4 水箱内的润滑水或食用油要及时地添加和补充，以免缺少润滑水或油，致使机器零件磨损、过早的损坏或机器无法使用，使机器的使用寿命减少。

7 故障分析与排除

故障现象	产生原因	排除方法
正常生产过程中，肉丸制品不呈圆球状或大小不均	调整手柄松动，使送馅量不均匀。	停车重新调整出馅量，并旋紧手柄

it's clockwise ,that's ok .wait until the machine smooth running ,you can try to use it.

5.7 Put the prepared meat material into the feed hopper , hold an plate under the out put door , turn on the machine , see the ball's size falling on the plate , according to your demand , adjust the adjusting screw to your content size . If it's unsatisfactory , PLS change the cut or sizing sheath . After that , you can product the balls .

5.8 Fittings 3 sets : cut and sizing sheath , one set on machine ,the other two sets are service parts .you can assemble them into six series for use . A . big cut and big ,middle sizing sheath B . middle cut and middle , small size sheath C . small cut and middle , small size sheath .employ and operate

6 Operation and Usage

6.1 During normal using , the meat ball must be sized in hot water . the temperature between 50 °C -70 °C is ok . Deep-fry should adjust the oil's temperature as to your need .

6.2 Put cool water into the water tank , as you need water-sizing balls; if you need deep-fry balls , set the fryer in right way ; when there are more flour in the meat material , put a little of edible oil in the water tank .

6.3 Open the lubricating cut with faucet on the water tank , make the switch "on" . Then put an warm water plate on the turntable under the output door , when the machine working , revolving the plate , avoid the ball overly and distort .

6.4 The cool water and edible oil in the water tank should supply in time to avoid parts fray .

7 Fault Analysis and Resolution

Failure symptom	Analysis of cause	Solution method
During normal production, the ball's size is anomaly and non-uniform	Adjusting handle loose , cause to the input meat material is non-uniform	Stop the machine , adjust the input meat material's quantity ,and fasten the handle

机器转动而绞龙不转	绞龙轴上的销子没有安装或断裂	销子对准转子槽安好
正确生产过程中, 拨叉与切刀行程不到位	拨叉弹簧疲劳	打开后护板更换拨叉弹簧

8 安全注意事项

- 8.1 机器运转中, 切勿将手触摸切刀, 以免造成人身伤害。
- 8.2 机器运转中, 切勿将手及硬物放入馅斗中, 以免造成伤害和损坏机器。
- 8.3 机器维修中, 切勿启动开关, 以免发生危险。
- 8.4 机器运转中, 不要进行任何形式的维护和保养, 以免造成人身伤害。

9 保养、维修

所有的维护和保养工作都必须在切断电源的情况下进行。

- 9.1 每次使用后, 应对机器认真清洗, 尤其对接触肉丸馅的绞龙、料斗、绞龙壳、成型齿轮、成型套、切刀、切刀固定架等零件拆下进行清洗干净。严禁用喷水管直接冲洗。
- 9.2 切刀组合的拆卸方法: 更换时, 把锁紧板分别向两边打开, 用手托住切刀固定架向下移动, 使成型齿轮与绞龙壳脱开。将成型齿轮从切刀固定架中取出, 成型套在成型齿轮内, 从下面往上推就可取出。切刀在切刀固定架内, 拿住切刀拨轴向两端移动就可以分别将两切刀取出。
- 9.3 绞龙及料斗的拆卸方法: 用手将绞龙轴上的连接套向上提起 50mm, 将绞龙轴与上立轴脱开, 把料斗顺时针旋转 90° 后向上提升, 直到料斗从绞龙壳中提出。
- 9.4 轴承内每半年更换一次润滑脂, 机箱内齿轮每个月添加一次润滑脂, 选用钙基润滑脂。
- 9.5 在工作过程中, 如果机器声音不正常, 必须立即停机检查, 待故障排除后方能继续工作。

The machine is running , but the auger is stand still	Auger ax's dowel is offset or breakage	Made the dowel reposition
During normal production , the cut and poking fork's travel is not in the right place	Poking fork became degradation	Open the behind guard , change poking fork spring

8 Safety Device and Notice

- 8.1 When the machine working , don't touch the cut or draw near the shield.
- 8.2 When the machine working , don't put hand in the feeding hopper ,avoid the harm to machine and person .
- 8.3 During repairing ,don't open the switch ,avoid danger .
- 8.4 When the machine working , don't repair and maintain the machine .

9 Maintenance

Always unplug before repairing or maintenance.

- 9.1 Clean the machine after each time use. Do not use sharp appliances to clean the machine, especially the parts that touching the meat material ,such as auger , feeding hopper ,auger shell , sizing gear ,sizing sheath ,cut ,cutting fixed structure and so on . Don't flush directly with spray pipe.
- 9.2 Cutting associate's discharge way: put the lock board beside , hold the cutting fixed structure and moved it downward , disunite the sizing gear and auger shell , then push it from down to upward ,you can pick it up .the cut is inside the cut fixed structure , hold the poking wheel of the cut and move it to two sides ,then you can take two cuts out .
- 9.3 Auger and feeding hopper's discharge way : pick the Connection sheath on the auger ax up 50mm , disunite the auger ax vertical shaft , turn the feeding hopper 90° in clockwise , then pick it up until take the feeding hopper out of the auger shell .
- 9.4 Change the lubricating grease half a year ,add lubricating grease to the gear inside the machine ,choose calcium-based grease .
- 9.5 When the machine working , if there are some noise ,must immediately stop the machine and check it .

10 运输、贮存

10.1 产品在运输过程中，严禁磕碰、歪倒、倒置。以免损坏机器，影响使用。

10.2 产品在长时间不用的情况下，要贮存在干燥、无腐蚀性气体的环境中，不要与腐蚀物接触，以免产品受损。

装 箱 单

序号	名称	数量	备注
1	肉丸成型机	1台	
2	说明书	1份	
3	合格证	1份	贴在机器上
4	切 刀	2套	大中小三种. 一种装在机器上
5	成型套	2个	大中小三种. 一种装在机器上
6	密封圈	1个	备 用
7	拨叉拉簧	2根	备 用
8	水 箱	1个	
9	尼龙软管	1根	

after excluding the malfunction , you can continue the production .

10 Transportation and Storage

10.1 Do not bump, lean or invert during transportation to avoid damage and affecting the machine use.

10.2 The machine should be put in dry, free from corrosion gas condition, and avoid contacting with erosive objects when it is not used for a long time.

装 箱 单

No.	Name	Quantity	Remark
1	Meat-balling machine	1 set	
2	Instruction book	1 pc	
3	certificate of competency	1 pc	Stick on the machine
4	Cuts	2 sets	Big ,middle , small 3 model .one set on the machine
5	Sizing sheath	2 pc	big ,middle , small 3 model .one set on the machine
6	Gasket ring	1 pc	Reserve
7	Poking fork spring	2 pc	Reserve
8	Water tank	1pc	
9	Soft nylon pipe	1 roll	

TABLE OF CONTENTS

1 Introduction.....	1
2 Structure Features And Working Principle.....	1
3 Technical Parameter	3
4 Size And Weight	3
5 Installation And Debugging	3
6 Operation And Usage	4
7 Fault Analysis And Resolution	4
8 Safety Device And Notice	5
9 Maintenance	5
10 Transportation And Storage	6