



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

USER'S OPERATING AND INSTRUCTION MANUAL

MODEL 641

DOUGH ROLLER



641 DOUGH ROLLER INDEX

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641 DOUGH ROLLER

SAFETY INSTRUCTIONS

WARNING

VARIOUS SAFETY DEVICES AND METHODS OF GUARDING HAVE BEEN PROVIDED ON THIS MACHINE. IT IS ESSENTIAL HOWEVER THAT THE MACHINE OPERATORS AND MAINTENANCE PERSONNEL OBSERVE THE FOLLOWING SAFETY PRECAUTIONS. IMPROPER INSTALLATION, MAINTENANCE, OR OPERATION OF THIS EQUIPMENT COULD CAUSE SERIOUS INJURY OR DEATH.

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 all 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 when working near this machine. Shirt tails should be tucked in.
8. Wear proper, personal, protective, 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, please follow the more specific safety instructions in the rest of this operating instruction manual.

WARNING

DO NOT USE FOR OTHER THAN ORIGINALLY INTENDED PURPOSE.



641 DOUGH ROLLER DESCRIPTION/SPECIFICATIONS

Description

The Oliver Model 641 Dough Roller is engineered to exacting standards. It's designed to provide maximum performance in minimal space. The machine is easy to operate, crusts of uniform thickness are made quickly and easily.

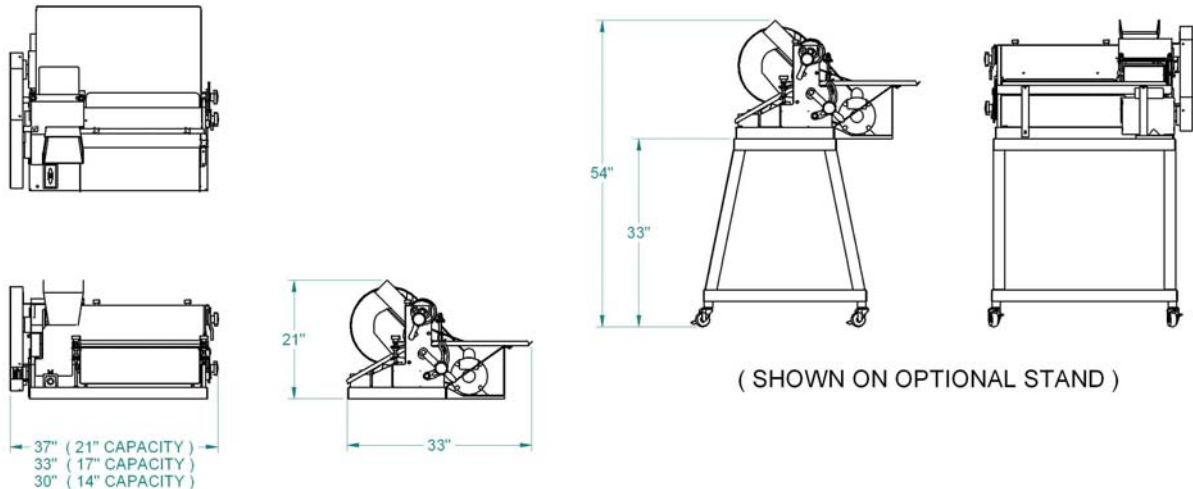
Parts to be cleaned are quickly removed without the use of tools.

Available in 14", 17" and 21" capacities.

Specifications

Space Requirements:

Model 641 (All Dimensions are Approximate)



Continued



DESCRIPTION/SPECIFICATIONS (Continued)

NOTE

Standard Electrical Options: (Others consult factory).

- ½ HP, 1 phase, 60 hz, 115VAC, 7 Amps.
- ½ HP, 1 phase, 60 hz, 230VAC, 3.5 Amps.
- ½ HP, 1 phase, 50 hz, 220VAC, 3.5 Amps.

Standard Product Width Capacity

14", 17", & 21"

Shipping Weight

- 14": 212 lbs. (95 kg) (approximate)
- 17": 227 lbs. (102 kg) (approximate)
- 21": 257 lbs. (116 kg) (approximate)

Height

- Bench Top: 21" (533 mm), (all widths) (approximate)
- On Optional Stand: 54" (1372 mm), (all widths) (approximate)

Bench Space (All Dimensions are Approximate)

- 14": 30" (762 mm) X 33" (838 mm)
- 17": 33" (838 mm) X 33" (838 mm)
- 21": 37" (940 mm) X 33" (838 mm)

Options

33" High Metal Stand with 3" Casters.

Above specifications subject to change without notice.



641 DOUGH ROLLER INSTALLATION INSTRUCTIONS

Dough Roller Installation:

Before starting the Installation process make sure you observe the following three caution notes.

CAUTION

**THE DOUGH ROLLER IS HEAVY, USE PROPER TECHNIQUE WHEN LIFTING.
KEEP BACK STRAIGHT, KNEES BENT, AND LIFT WITH LEGS.
USE GLOVES TO PROTECT HANDS.**

CAUTION

NEVER LIFT THE DOUGH ROLLER BY ITS COVERS OR GUARDS.

CAUTION

**BEFORE PLACING THE DOUGH ROLLER ON THE TABLE OR COUNTER MAKE
SURE THAT IT CAN SUPPORT THE DOUGH ROLLER'S WEIGHT WHICH IS
APPROX. 260 POUNDS (21").**

Bench Mounted

Select a location for your dough roller which has a substantial mounting surface, (see the caution note above), and which has electrical service compatible with the load the machine will place on it as indicated on the electrical data plate of the machine.

Position the machine while it is still in its packaging as close as possible to the desired end location. Expose the machine by removing the outer packaging. Remove any straps or fasteners securing machine to crate. Using at least two people, (one in the front and one at the back of the machine), lift the dough roller from the resting surface of the packaging and set the machine onto the counter or table as close as possible to the desired end location. The machine must be sealed to the counter using the included neoprene rubber under machine edges. Plastic Hole plugs are included to close any unused holes in machine base.

Continued



INSTALLATION INSTRUCTIONS (Continued)

Optional Stand Mounted

Note: One bottom guard bolt will have to be removed to mount machine to stand.

Select a location for your dough roller which has a level surface, and which has electrical service compatible with the load the machine will place on it as indicated on the electrical data plate of the machine.

Position the machine while it is still in its packaging as close as possible to the desired end location. Expose the machine and stand by removing the outer packaging. Remove any straps or fasteners securing machine and stand to crate. Machine will only go on the stand one way. Using at least two people, (one in the front and one at the back of the machine), lift the dough roller from the resting surface of the packaging and set the machine onto the stand. Secure to stand using the provided fasteners. (see page 14-1)

For all Machines

1. Be sure machine is clean and dry.
2. Make sure power switch is in "Off" position.
3. Check machine nameplate for correct voltage and frequency.
4. Connect machine to a power source that matches nameplate requirements.
5. Switch power "On" and check for proper operation of the machine.



641 DOUGH ROLLER OPERATING INSTRUCTIONS

WARNING

**ALWAYS USE CARE WHENEVER WORKING NEAR THE ROLLERS.
KEEP HANDS CLEAR OF DOUGH CHUTE.**

Machine Preparation

1. Make sure the dough chute and trays are dry.
2. Dust the transfer tray (Item 200, page 10-1) with flour, Leave a little extra flour in the tray to dust the bottom side of the dough before it is sent through the second set of rollers.
3. Make your initial setting of the roller adjustment levers. Loosen knob, move handle, then tighten knob. Dial numbers are for reference only.

Dough Preparation

1. Size and shape of the dough ball affects size and shape of the finished crust. For round pies make a dough piece a fat sausage shape and flatten slightly.
2. Dust the dough pieces with flour before putting them in the machine.

Making a Crust

1. Place the dough piece in the top hopper chute (Item 206, page 10-1) end first.
2. When the dough piece comes out in the transfer tray it should be a little longer than the diameter of the pie.
3. Dust the top of the dough with flour. There should be sufficient flour in the transfer tray to dust the bottom of the dough.
4. Turn the dough piece a quarter of a turn in the transfer tray and slide it sideways into the second pass rollers.

WARNING

NEVER PUSH THE DOUGH WITH THE TIPS OF YOUR FINGERS.

5. The second pass rollers should produce a crust of the proper thickness and about round in shape. If the crust is too thin, open the lower rollers. If the crust is too thick, close the lower rollers. If the thickness is right but the crust is too short, make the initial dough piece bigger and open the upper rollers. If it is too long, make the initial dough piece smaller and close the upper rollers. When you get the results you want, it is a good idea to write down the setting numbers if the adjustment levers for future reference.



641 DOUGH ROLLER TROUBLESHOOTING

WARNING

ALWAYS DISCONNECT THE DOUGH ROLLER FROM THE POWER SUPPLY BEFORE ATTEMPTING ANY TYPE OF MAINTENANCE TASK, INCLUDING TROUBLESHOOTING.

The Dough Roller Will Not Start (Motor Is Not Humming)

- The machine is not plugged in.
- There is no power at the outlet. (Check by plugging in a small working appliance, like a lamp. Check to see if a circuit breaker has tripped. If the circuit breaker has not tripped and the circuit is still not working have a qualified electrician check the circuit.)
- The thermal overload on dough roller power switch has tripped – turn machine off, allow to cool then push switch further “Off” to reset.
- The problem is somewhere else in the electrical system of the machine. (Have a qualified electrician find and repair the problem.)

The Dough Roller Will Not Start (Motor Is Humming)

CAUTION

**DO NOT ALLOW THE MOTOR TO HUM WITHOUT STARTING.
OVERHEATING CAN PERMANENTLY DAMAGE THE MOTOR.**

NOTE

A SPECIAL NON-VENTILATED MOTOR MUST BE USED WITH THIS DOUGH ROLLER.

- The drive system is binding. (Have a qualified service agent check for defective bearings or other restrictions to free movement.)
- There is mechanical interference between other parts of the Dough Roller. (Have a qualified service agent evaluate the machine for adjustment or replacement of defective parts.)

Continued



TROUBLESHOOTING (Continued)

- Broken belt or chain. (Have a qualified service agent evaluate the machine for adjustment or replacement of defective parts.)
- The motor has failed. (Have it checked by a qualified electrician.)

Lines or Marks in Finished Crust

- The rollers need to be cleaned. (see Maintenance section of this manual)

The Dough is Not Feeding

- Too much flour on dough surface. Dust dough with less flour.
- Dough piece is too thin for current roller setting.

The Dough is Sticking to Rollers

- Dough needs more flour on surface. Dust dough with more flour.
- The rollers need to be cleaned. (see Maintenance section of this manual)
- Missing or improperly installed scrapers. (see Maintenance section of this manual)



641 DOUGH ROLLER MAINTENANCE

WARNING

**ALWAYS UNPLUG THE DOUGH ROLLER BEFORE PERFORMING
ANY TYPE OF MAINTENANCE TASK.**

Cleaning

The machine should be cleaned daily, more often during heavy use. Use a damp, soft cloth on the fixed parts of the machine. Trays and scrapers may be taken to sink for cleaning.

Removing Scrapers

Remove the scrapers and slides as follows. Reverse the procedures to install them.

1. Long top scraper and tip.
 - a. Grasp the scraper with both hands.
 - b. Press down to compress springs and release the retainer.
 - c. Shift sideways toward the belt guard.
 - d. Swing the end opposite the guard away from machine.
 - e. Slide the scraper sideways away from the guard to free the second end. When reinstalling the scraper make sure the long slot is toward the belt guard.

2. Long bottom scraper slide and tip.
(first remove the long top scraper as described above)
 - a. Look under the slide before you attempt to remove it. Note the angles on the bottom of the slide that hold it in place.
 - b. To remove the slide grasp it with both hands, one on either side, and lift sharply to both compress the springs and lift the angles clear of the pins that support and retain the tray.
 - c. Pull the tray toward you to remove it from the machine.

3. Short top scraper and tip.
 - a. Grasp the scraper with both hands.
 - b. Press down to compress springs and release the retainer.
 - c. Shift the scraper toward the center of the machine.
 - d. Swing the end closest to belt guard of the scraper away from the machine.
 - e. Slide the scraper sideways away from the center of the machine to remove it. When reinstalling the scraper make sure the long slot is toward the center of the machine.

Continued



MAINTENANCE (Continued)

Removing Scrapers (Continued)

4. Short bottom scraper slide and tip.
(first remove the long top scraper as described above)
 - a. Grasp the scraper with both hands.
 - b. Lift up sharply to compress the springs and release the retainer.
At the same time, raise the end of the slide so it will clear the lip of the transfer tray.
 - c. Swing the inboard end of the scraper which is furthest from the belt guard toward the roller.
 - d. Slide the scraper sideways toward the belt guard until the end furthest from the belt guard clears the stud assembly.
 - e. Swing the end furthest from the belt guard away from the roller until the scraper is in front of the stud assembly.
 - f. Slide the scraper toward the center of the machine to remove it.
 - g. When reinstalling the scraper you must lift the retainer plate on the stud assembly furthest from the belt guard so that the hooked end of the scraper can slide under the plate and around the stud.

General Notes on Disassembly

1. **DO NOT LOOSEN THE ACORN NUTS OR THE STUD ASSEMBLIES!** They are factory set to assure proper contact of the scraper tip on the roller.
2. The white nylon scraper tips are easily removed from the scraper bar from cleaning by sliding them off with your fingers.
3. **WHEN REINSTALLING THE WHITE SCRAPER TIP, MAKE SURE THE SMOOTH SIDE OF THE TIP (NOT THE STEPPED SIDE) WILL BE TOWARD THE DOUGH DURING OPERATION!**

Lubrication

1. All bearings are permanently lubricated and do not require further lubrication.
2. Add a drop or two of medium weight food safe oil to the oil cup on the chain idler arm every 200 hours. The cup is located above the shaft of the main drive pulley and slightly under the dough hopper casting.

Service

If you properly care for your Oliver Products Company Dough Roller, it will give you long, trouble free service. If replacement parts are required, order them from the factory. Refer to the Replacement Parts section of this manual for the item's specific part number.



**641 DOUGH ROLLER
RECOMMENDED SPARE PARTS**

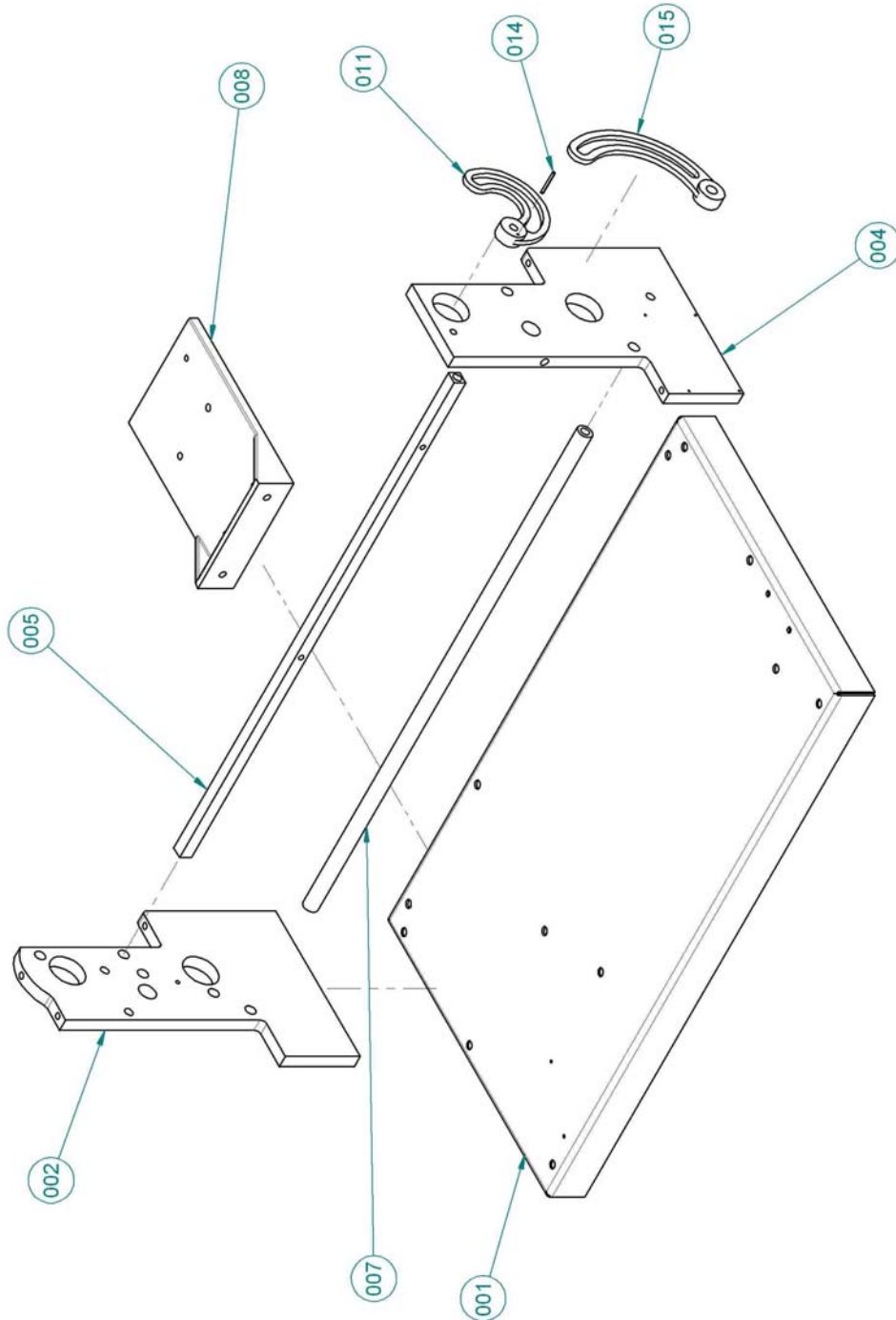
<u>PART NUMBER</u>	<u>PART DESCRIPTION</u>	<u>NO. REQ'D</u>
0641-1201-001	Tip-Scraper 7" roller	2
0641-1201-002	Tip-Scraper (14" machine)	2
0641-1201-003	Tip-Scraper (17" machine)	2
0641-1201-004	Tip-Scraper (21" machine)	2
5601-1238	Belt-V (5L580)	1
6301-3609*	Motor-1/2 HP, 1-60-115/230	1
5709-1137	Starter-Manual (Power Switch and Enclosure)	1
5708-2430	Heater-Overload (115 VAC)	1
5708-2423	Heater-Overload (220/230 VAC)	1
4560-2508-1109	Knob with stud (1/4-20)	2
5911-7033	Knob (3/8-16)	2
5911-7046	Knob (1/2-13)	2
0641-1017	Main Drive Sprocket	1
0641-0188	Chain assembly	1

***For Other Electrics Contact the Factory**

For Service Parts Call Oliver Products @ 800-253-3893



MAIN FRAME





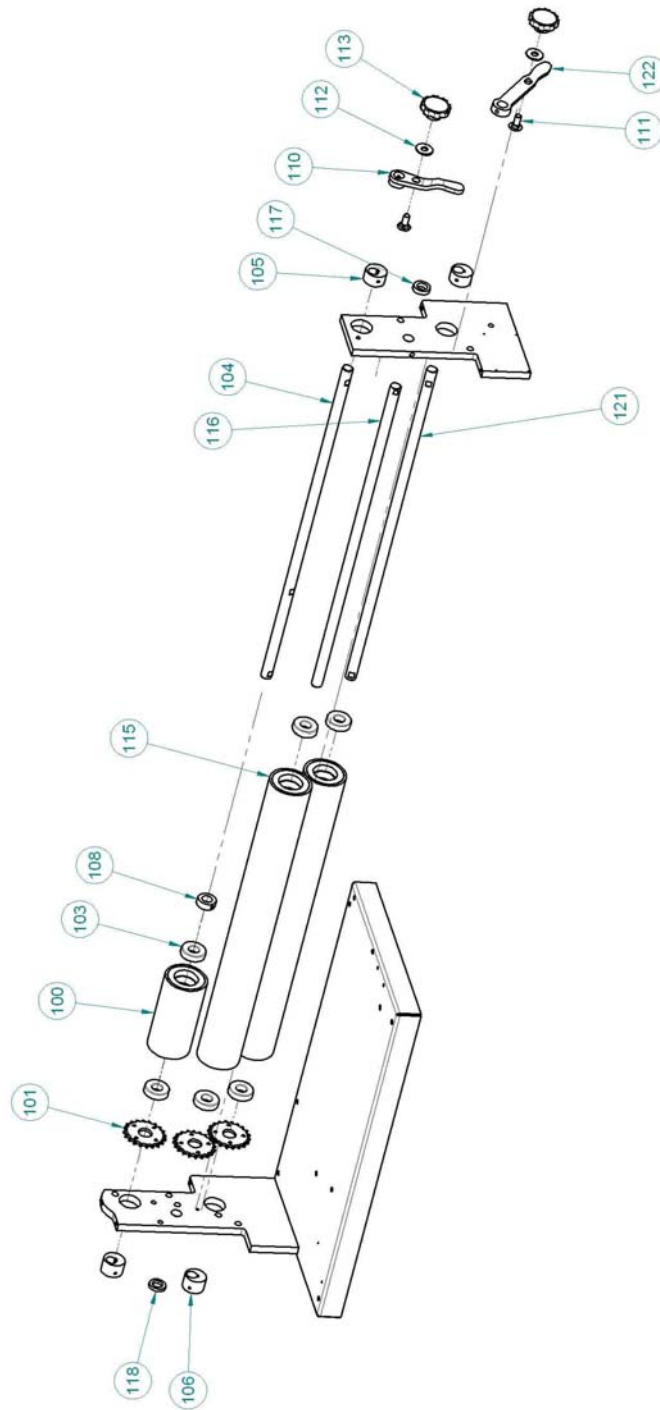
MAIN FRAME PARTS LIST

<u>ITEM NO</u>	<u>PART DESCRIPTION</u>	<u>PART NUMBER</u>
001	Base RH (14" machine)	0641-1004-0011
001	Base RH (17" machine)	0641-1275-0011
001	Base RH (21" machine)	0641-1048-0011
002	Plate-Side Drive	0641-1209
004	Plate-Side Adjustment	0641-1210
005	Tie Bar (square) (14" machine)	0641-1011-001
005	Tie Bar (square) (17" machine)	0641-1011-002
005	Tie Bar (square) (21" machine)	0641-1011-003
007	Tie Bar (round) (14" machine)	0641-1012-001
007	Tie Bar (round) (17" machine)	0641-1012-002
007	Tie Bar (round) (21" machine)	0641-1012-003
008	Motor Mounting Plate (14" machine)	0641-1203-001
008	Motor Mounting Plate (17" & 21" machines)	0641-1203-002
011	Dial-Top	0641-1100
014	Pin-Spring	5835-6789
015	Dial-Bottom	0641-1101

FOR SERVICE PARTS CALL OLIVER PRODUCTS @ 800-253-3893



ROLLERS





ROLLERS PARTS LIST

ITEM NO	PART DESCRIPTION	PART NUMBER
100	Roller 7"	0641-1240-101
101	Sprocket-Drive Roller	4615-4120-3631
103	Bearing	5250-0207
104	Shaft-Top Roll (14" machine)	0641-1016-001
104	Shaft-Top Roll (17" machine)	0641-1016-002
104	Shaft-Top Roll (21" machine)	0641-1016-003
105	Eccentric-Drive Side	0641-1051
106	Eccentric-Adjustment Side	0641-1052
108	Set Collar	5806-7058
110	Handle-Adjustment	0641-1105
111	Screw-Adjustment	0641-0012-008
112	Flat Washer ½ STST	5851-9308
113	Knob (1/2-13)	5911-7046
115	Roller (14" machine)	0641-1240-102
115	Roller (17" machine)	0641-1240-103
115	Roller (21" machine)	0641-1240-104
116	Shaft-Center Roller (14" machine)	0641-1013-001
116	Shaft-Center Roller (17" machine)	0641-1013-002
116	Shaft-Center Roller (21" machine)	0641-1013-003

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FOR SERVICE PARTS CALL OLIVER PRODUCTS @ 800-253-3893



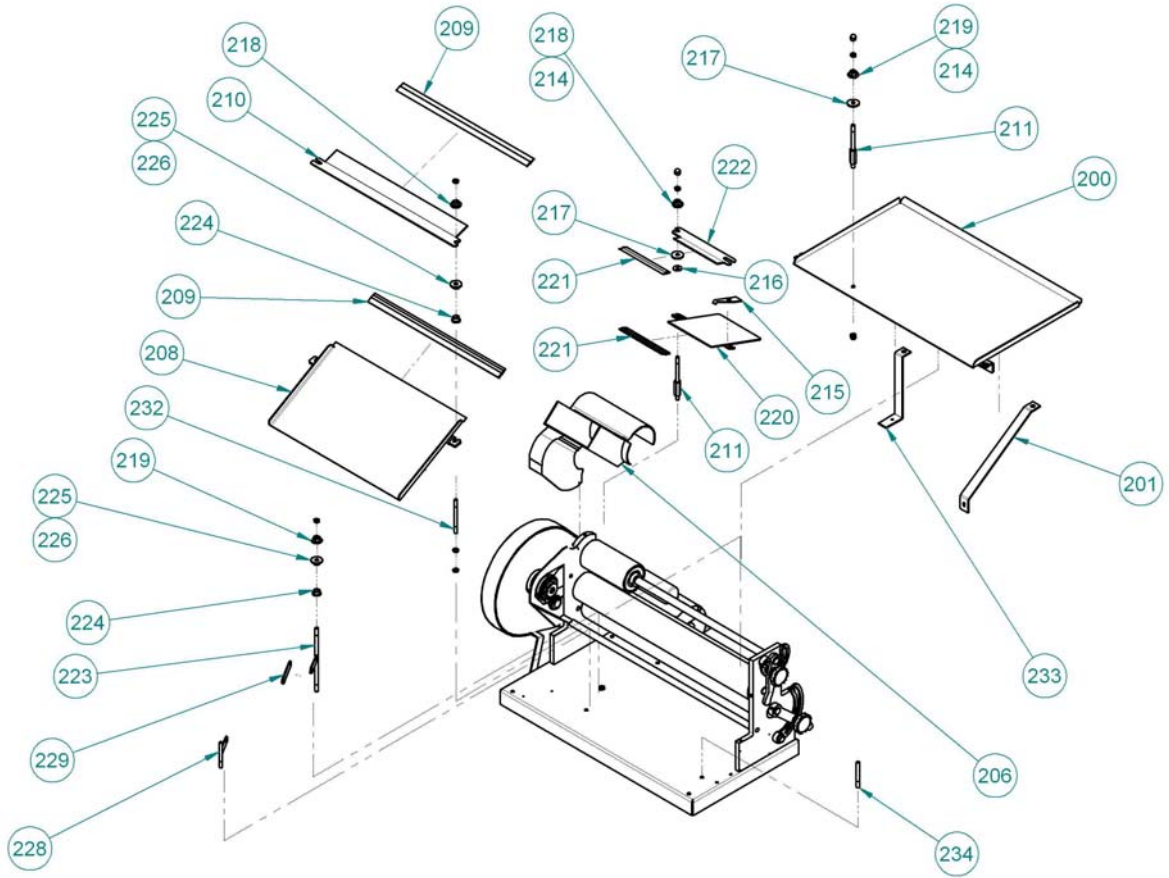
ROLLERS PARTS LIST (Continued)

ITEM NO	PART DESCRIPTION	PART NUMBER
117	Spacer-Adjustment Side	0641-1074
118	Spacer-Drive Side	0641-1075
121	Shaft-Finish Roller (14" machine)	0641-1014-001
121	Shaft-Finish Roller (17" machine)	0641-1014-002
121	Shaft-Finish Roller (21" machine)	0641-1014-003
122	Handle-Adjustment Lower	0641-0012

FOR SERVICE PARTS CALL OLIVER PRODUCTS @ 800-253-3893



TABLES





TABLES PARTS LIST

ITEM NO	PART DESCRIPTION	PART NUMBER
200	Tray Assembly (14" machine)	0641-1302
200	Tray Assembly (17" machine)	0641-1104-001
200	Tray Assembly (21" machine)	0641-1104-002
201	Bracket-Support (14" machine)	0641-1084
201	Bracket-Support (17" & 21" machine)	0641-1106
206	Hopper-Dough Chute	0641-1091
208	Scraper Slide Assembly (14" machine)	0641-1143-001
208	Scraper Slide Assembly (17" machine)	0641-1143-002
208	Scraper Slide Assembly (21" machine)	0641-1143-003
209	Scraper Tip (14" machine)	0641-1201-002
209	Scraper Tip (17" machine)	0641-1201-003
209	Scraper Tip (21" machine)	0641-1201-004
210	Scraper Body RH (14" machine)	0641-1141-001
210	Scraper Body RH (17" machine)	0641-1141-002
210	Scraper Body RH (21" machine)	0641-1141-003
211	Post-Scraper	0641-1312
214	Spring-RH	4605-1000-0016
215	Lifter-Spring RH	0641-1053-0001
216	Washer-U	5851-8137

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FOR SERVICE PARTS CALL OLIVER PRODUCTS @ 800-253-3893
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TABLES PARTS LIST (Continued)

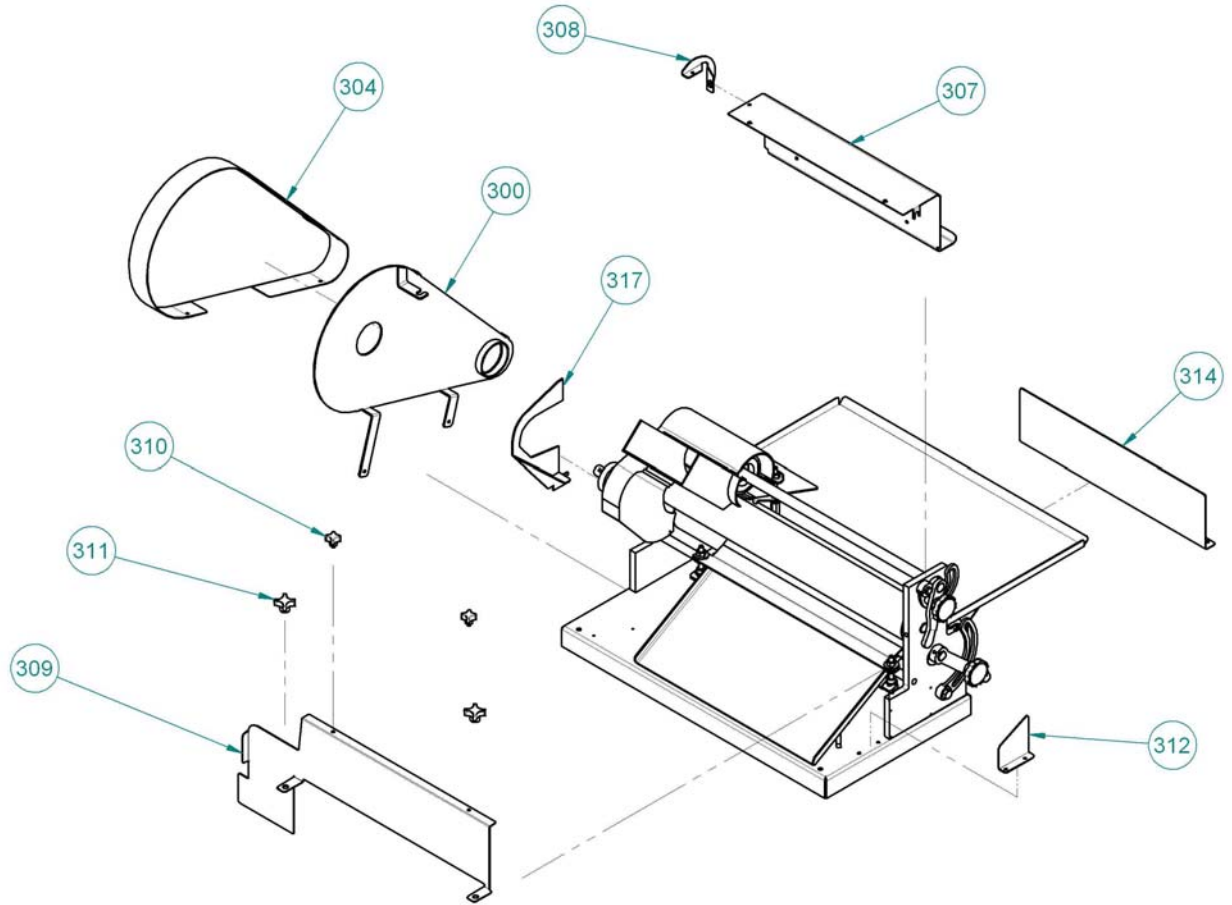
ITEM NO	PART DESCRIPTION	PART NUMBER
217	Washer 1-3/8 O.D.	4655-0314-1001
218	Locknut & Washer Assembly	0641-1061
219	Retainer-Scraper	0641-1062
220	Scraper Slide Assembly 7"	0641-1147
221	Scraper Tip 7"	0641-1201-001
222	Scraper Assembly RH	0641-1144-0001
223	Support Scraper Slide	0641-1058
224	Retainer-Spring	0641-1034
225	Retainer-Spring Upper	0641-1034-001
226	Spring 15/16 x 2-1/16	4605-1000-0017
228	Support Scraper Slide	0641-1056
229	Link-Strap	0641-1059
232	Support Tray and Slide	0641-1055

FOR SERVICE PARTS CALL OLIVER PRODUCTS @ 800-253-3893

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COVERS



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COVERS PARTS LIST

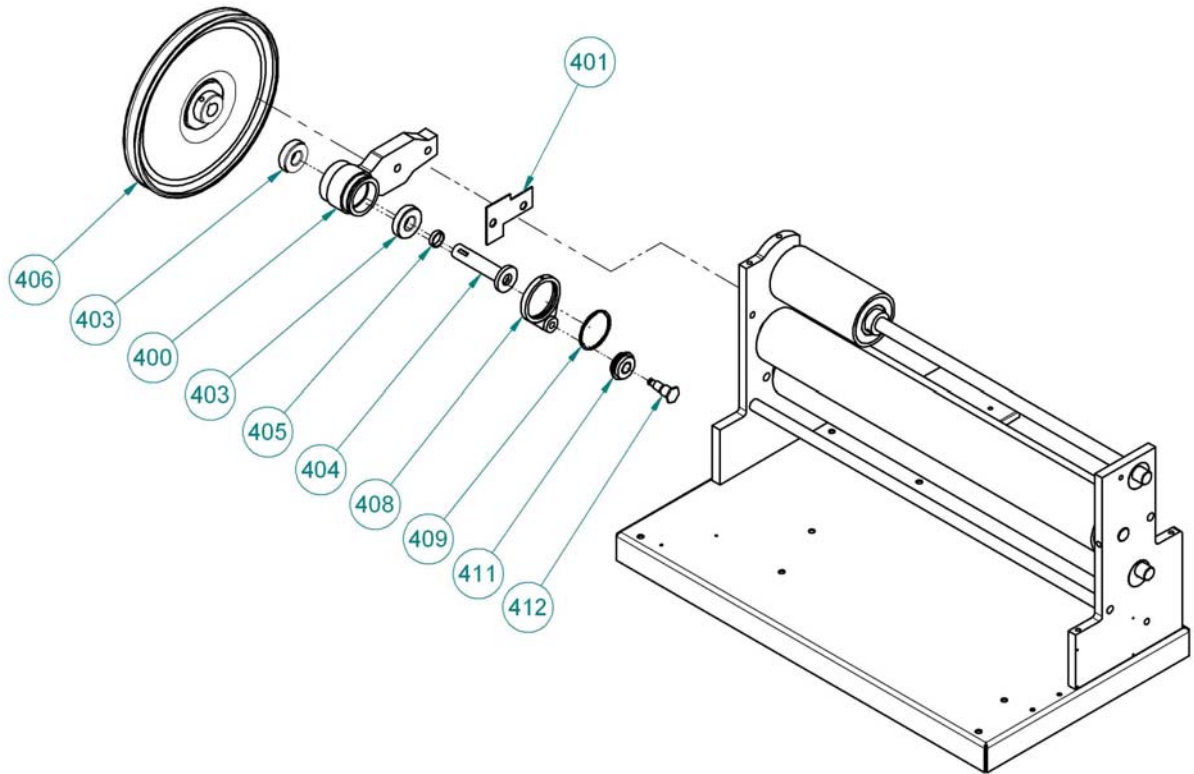
ITEM NO	PART DESCRIPTION	PART NUMBER
300	Guard Backing Plate	0641-0022-0001
304	Belt Guard	0641-0023-0011
307	Center Roller Guard (14" machine)	0641-0024-0011
307	Center Roller Guard (17" machine)	0641-0024-0001
307	Center Roller Guard (21" machine)	0641-0024-0021
308	Guard- Roller End	0641-0033-0001
309	Rear Guard (14" machine)	0641-0032-0011
309	Rear Guard (17" machine)	0641-0032-0001
309	Rear Guard (21" machine)	0641-0032-0021
310	Knob with Stud (1/4-20)	4560-2508-1109
311	Knob (3/8-16)	5911-7033
312	Outfeed Guard	0641-0028-0001
314	Bottom Guard (14" machine)	0641-0027-001
314	Bottom Guard (17" machine)	0641-0027
314	Bottom Guard (21" machine)	0641-0027-002
317	Chain Guard	0641-0026-0001

REV. 11/10/05

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DRIVE





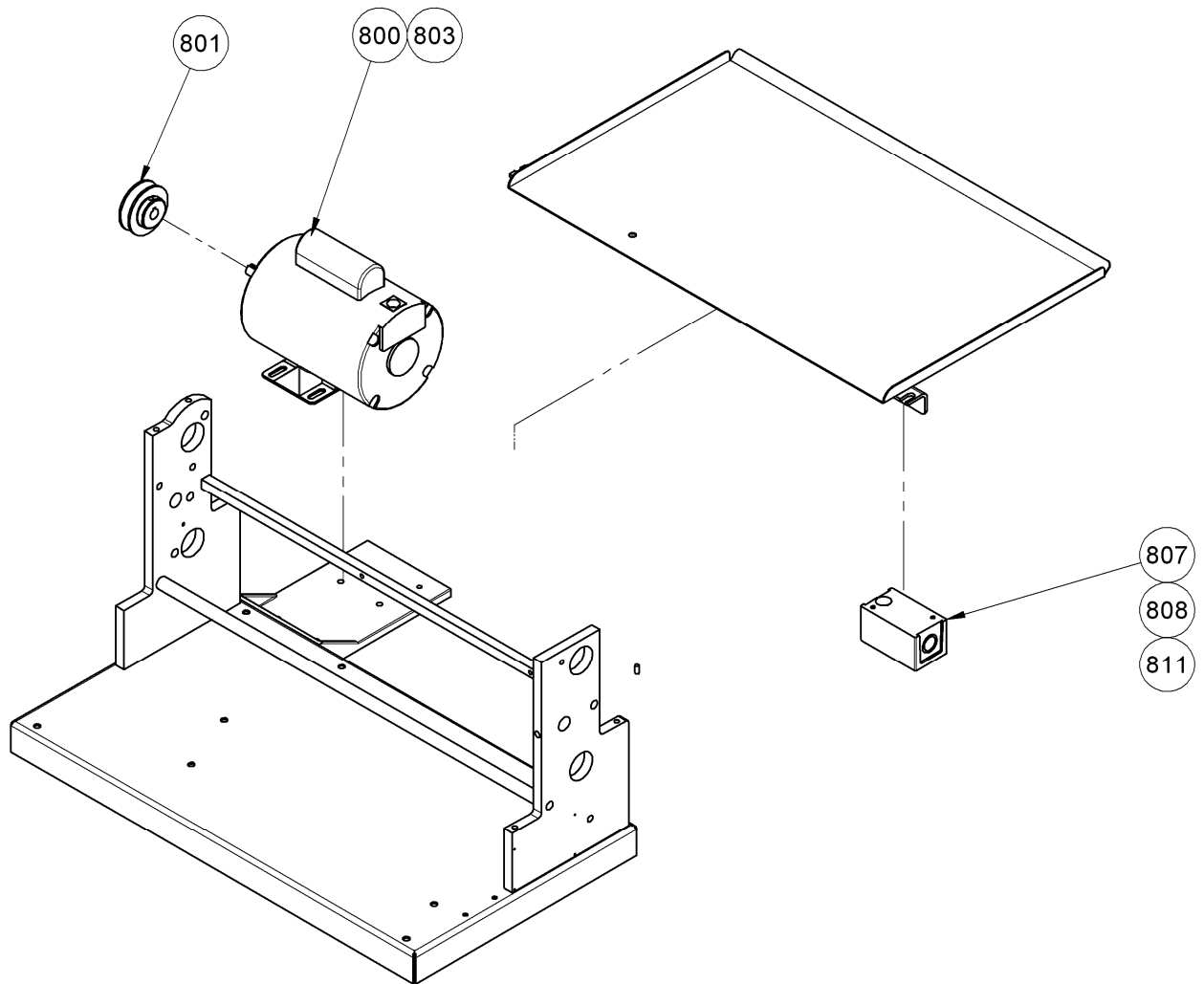
DRIVE PARTS LIST

ITEM NO	PART DESCRIPTION	PART NUMBER
400	Bracket-Drive Sprocket	0641-1025
401	Shim-Bracket	0641-1353
403	Bearing	5250-0207
404	Main Drive Sprocket	0641-1017
405	Spacer-Main Drive Sprocket	0641-1079
406	Sheave 5L	5615-1629
408	Arm-Chain Takeup RH	0641-1028-0001
409	Retaining Ring	5840-1357
411	Idler Roller	0641-1029
412	Stud-Shaft Idler	0641-1031

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ELECTRICAL PARTS



Rev. 8/27/05



ELECTRICAL PARTS LIST

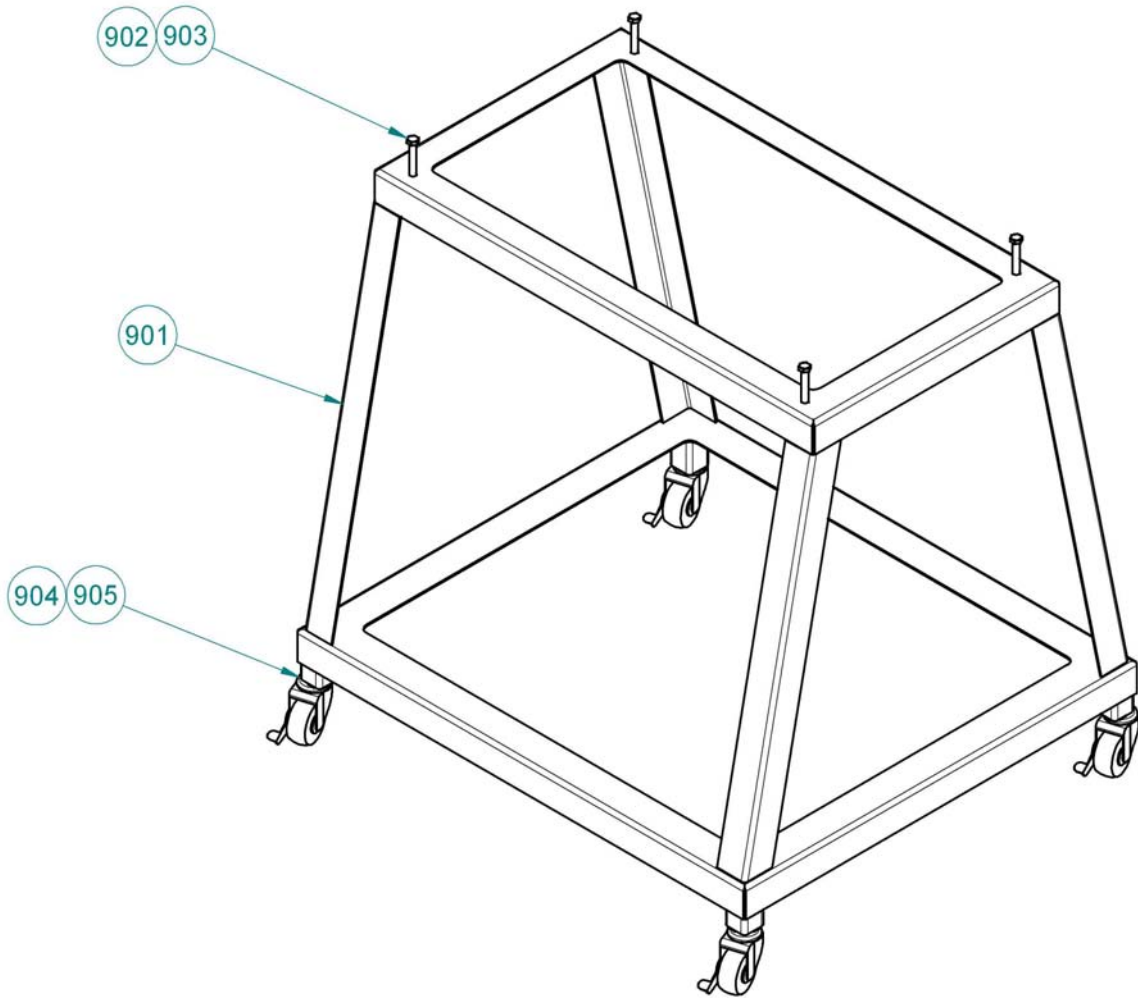
ITEM NO	PART DESCRIPTION	PART NUMBER
800*	Motor-1/2 HP, 1-60-115/230	6301-3609
801	Sheave	5615-1500
802	Belt-V (5L580) (Not shown)	5601-1238
803	Strain relief 90 deg.	5770-4806
807	Starter-Manual	5709-1137
808*	Heater-Overload (115 VAC)	5708-2434
808*	Heater-Overload (230 VAC)	5708-2427
811	Strain Relief	5765-1082

***For Other Electrics Contact the Factory**

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OPTIONAL STAND





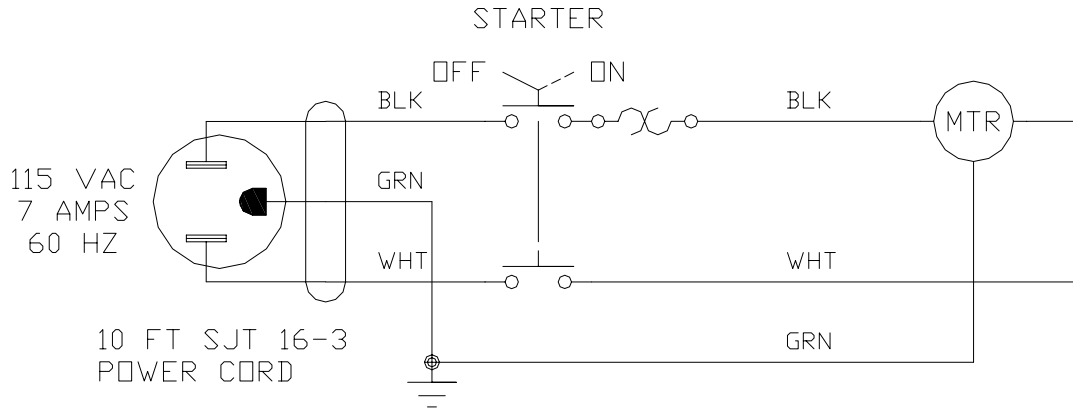
OPTIONAL STAND PARTS LIST

ITEM NO	PART DESCRIPTION	PART NUMBER
901	Stand (14" machine)	0641-1044-101
901	Stand (17" machine)	0641-1044-102
901	Stand (21" machine)	0641-1044-103
902	Bolt 3/8 x 2-1/2	5843-1060
903	Nut 3/8	5832-0522
904	Socket-Caster	5902-2601
905	Caster 2-1/2"	5902-2348

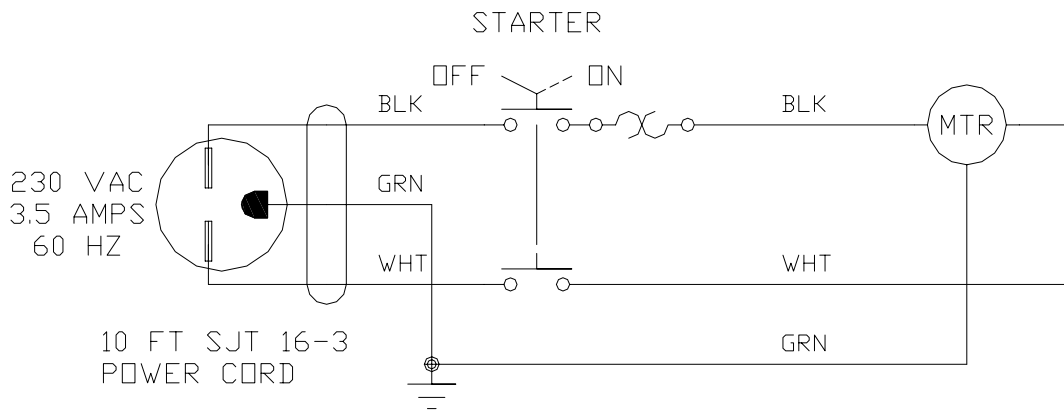
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WIRING DIAGRAM 1-60-115



WIRING DIAGRAM 1-60-230



***For Other Electrics Contact the Factory**

FOR SERVICE PARTS CALL OLIVER PRODUCTS @ 800-253-3893



WARRANTY

PARTS

Oliver Packaging & Equipment Company (Oliver) warrants that if any part of the equipment (other than a part not manufactured by Oliver) proves to be defective (as defined below) within one year after shipment, and if Buyer returns the defective part to Oliver within one year, Freight Prepaid to Oliver's plant in Grand Rapids, MI, then Oliver, shall, at Oliver's option, either repair or replace the defective part, at Oliver's expense.

LABOR

Oliver further warrants that equipment properly installed in accordance with our special instructions, which proves to be defective in material or workmanship under normal use within one (1) year from installation or one (1) year and three (3) months from actual shipment date, whichever date comes first, will be repaired by Oliver or an Oliver Authorized Service Dealer, in accordance with Oliver's published Service Schedule.

For purposes of this warranty, a defective part or defective equipment is a part or equipment which is found by Oliver to have been defective in materials workmanship, if the defect materially impairs the value of the equipment to Buyer. Oliver has no obligation as to parts or components not manufactured by Oliver, but Oliver assigns to Buyer any warranties made to Oliver by the manufacturer thereof.

This warranty **does not** apply to:

1. Damage caused by shipping or accident.
2. Damage resulting from improper installation or alteration.
3. Equipment misused, abused, altered, not maintained on a regular basis, operated carelessly, or used in abnormal conditions.
4. Equipment used in conjunction with products of other manufacturers unless such use is approved by Oliver Products in writing.
5. Periodic maintenance of equipment, including but not limited to lubrication, replacement of wear items, and other adjustments required due to installation, set up, or normal wear.
6. Losses or damage resulting from malfunction.

The foregoing warranty is in lieu of all other warranties expressed or implied AND OLIVER MAKES NO WARRANTY OF MERCHANTABILITY OR FITNESS FOR PURPOSE REGARDING THE EQUIPMENT COVERED BY THIS WARRANTY. Oliver neither assumes nor authorizes any person to assume for it any other obligations or liability in connection with said equipment. OLIVER SHALL NOT BE LIABLE FOR LOSS OF TIME, INCONVENIENCE, COMMERCIAL LOSS, INCIDENTAL OR CONSEQUENTIAL DAMAGES.



Oliver Packaging & Equipment Company
511 Sixth Street NW • Grand Rapids, MI 49504

(800) 253-3893
www.oliverquality.com

WARRANTY PROCEDURE

1. If a problem should occur, either the dealer or the end user must contact the Parts and Service Department and explain the problem.
2. The Parts and Service Manager will determine if the warranty will apply to this particular problem.
3. If the Parts and Service Manager approves, a Work Authorization Number will be generated, and the appropriate service agency will perform the service.
4. The service dealer will then complete an invoice and send it to the Parts and Service Department at Oliver Products Company.
5. The Parts and Service Manager of Oliver Packaging and Equipment Company will review the invoice and returned parts, if applicable, and approve for payment.



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RETURNED PARTS POLICY

This policy applies to all parts returned to the factory whether for warranted credit, replacement, repair or re-stocking.

Oliver Packaging and Equipment Company requires that the customer obtain a Return Material Authorization (RMA) number before returning any part. This number should appear on the shipping label and inside the shipping carton as well. All parts are to be returned prepaid. Following this procedure will insure prompt handling of all returned parts.

To obtain an RMA number contact the Repair Parts Department toll free at (800) 253-3893.

Parts returned for re-stocking are subject to a **RE-STOCKING CHARGE**.

Thank you for your cooperation,

Repair Parts Manager
Oliver Packaging and Equipment Company