



Walker, Michigan, U.S.A. 49534-7564

MODEL 644

RONDO ECONOMAT
DOUGH SHEETER

Index


1 Safety Information	B0100093
1.1 Explanation of Symbols	010 - 1
1.2 Explanation of Warning Signs	010 - 1
1.3 Safety Elements	010 - 1
1.3.1 Safety Guards	010 - 1
1.4 Safety Instructions and Information which Must be Followed	010 - 2
 2 Transporting, Setting up, Connecting, Dismounting, Storing the Machine	 B0200093
2.1 Machine Delivery	020 - 1
2.2 Transportation	020 - 1
2.3 Unpacking the Machine	020 - 1
2.4 Setting Up the Machine	020 - 2
2.4.1 Installing the Machine Tables	020 - 2
2.4.2 Tensioning the Conveyor Belts	020 - 3
2.5 Requirements for Putting the Machine into Operation	020 - 4
2.6 Moving Direction Test	020 - 4
 3 General Data about the Machine	 B0300096
3.1 General Information	030 - 1
3.1.1 The Machine's Applications	030 - 1
3.1.2 Noise Values	030 - 1
3.1.3 Temperatures	030 - 1
3.1.4 Ambient Humidity	030 - 1
3.1.5 Machine Weight	030 - 1
3.1.6 Working Area for the Operating Personnel	030 - 1
3.2 Machine Models	030 - 2
3.2.1 SWT 513	030 - 2
3.3 Prerequisites	030 - 2
3.4 General View of the Machine	030 - 3
3.5 Operating Elements	030 - 4
3.5.1 Safety Guards	030 - 4
3.5.2 Roller Gap Adjusting Mechanism	030 - 4
3.5.3 Roller Gap Limit stop	030 - 4
3.5.4 Start push-button	030 - 4
3.5.5 Stop push-button	030 - 4
 4 Putting the Machine into Operation	 B0400093
4.1 Preparing for Operational Readiness	040 - 1
4.2 Starting/Stopping the Machine	040 - 1

5 Operation	B0500096
5.1 Operating Instructions	050 - 1
5.1.1 Sheeting	050 - 1
5.2 Sources of Errors in the Sheeting Process	050 - 2
6 Cleaning	B0600093
6.1 Cleaning	060 - 1
6.1.1 General Information	060 - 1
6.1.2 Care	060 - 3
7 Maintenance	B0700093
7.1 General Information on Maintenance of the Machine	070 - 1
7.1.1 Greasing	070 - 1
7.2 Replacement Parts List	070 - 1
8 Trouble shooting	B0800093
9 Technical Data	B0900096

Hint for operating manual: The numbers of the illustrations (Ex. — 1) are numbered chapterwise.

1 Safety Information

1.1 Explanation of Symbols

All the sections in this Operating Manual containing safety instructions which absolutely must be observed are marked with this symbol  and with a number.



1.2 Explanation of Warning Signs

Sign indicating Prohibited Activity

Reaching under the closed safety guard is prohibited!



Instruction and Information Signs

Make sure to disconnect the plug before opening!



Danger Warning Sign

Danger Warning



High-Voltage Warning Sign

Warning against electrical shock
Disconnect mains plug before opening.



1.3 Safety Elements

1.3.1 Safety Guards

Operation

1. The safety guards protect the operator against inadvertent contact with the rollers.
2. The machine is stopped by lifting up the safety guard. Raising the safety guard even just slightly will cause the machine to discontinue operation.



1.4 Safety Instructions and Information which Must be Followed

- The dough sheeters are built for the food industry exclusively for the sheeting, booking and final sheeting of dough pieces and marzipan.
- Any other use of these units is not in accordance with the purpose for which they are built. Therefore, the manufacturer will not be liable for any accidents or damage arising as a result of unauthorized use; the risk in any such instance will be borne solely by the user.
- Authorized use also means that the user must follow all instructions prescribed by the manufacturer in respect of operation, maintenance and service.
- Any work on the electrical components of the machine, in particular the correct professional mounting of the mains plug, may only be carried out by qualified personnel who are familiar with the prescribed safety instructions.
- Protective covers over the electrical controls and the mechanical moving parts may only be removed by professionally qualified personnel and must be remounted before the machine is put back into operation.
- Any unauthorized changes made to the machine, and in particular, to the safety devices on the machine will automatically exclude any liability on the part of the manufacturer for accidents or damage sustained as a result of such changes.
- The machine may only be connected to electricity using the mains plug! No permanent electrical installation may be carried out using, for example, terminal screws.
- The machine may only be connected to the mains using the plug once the machine has been fully assembled.
- Before beginning any repairs, service or cleaning work on the machine, the electricity supply to the machine must be interrupted (pull out mains plug).
- Safety devices on the machine may not be adjusted, shorted-out or expanded.
- Operation of the machine when any of the safety devices is out of order is prohibited.
- Defective safety devices must be replaced immediately with new original parts.
- Machine parts located in the area in which the dough is being processed, and whose surface coating becomes worn (e.g. chrome plate worn off) must be replaced.



- The machine should be fastened and transported on a pallet. The safety guard should be fastened in the upper position.



- Reaching under the closed safety guard is prohibited!



- The machine may only be operated with the machine tables mounted!



- Ensure that conveyor belt tension is correctly adjusted!



- Do not deposit any loose objects such as knives, tools, articles of clothing, etc. in the area where the dough is located.



- The machine must be placed so as to rest properly over the whole work table!



- Check to ensure that there are no loose screws in the area where the dough is located.



- The machine may not be operated without the use of a scraper.

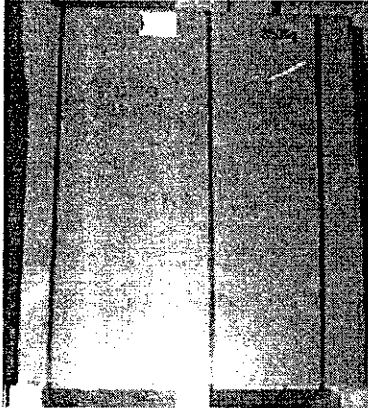


- Any disposal of the machine must be carried out in accordance with environmentally-accepted practices. The operators are fully responsible for ensuring that such practices are followed.



2 Transporting, Setting Up, Connecting, Dismounting, Storing the Machine

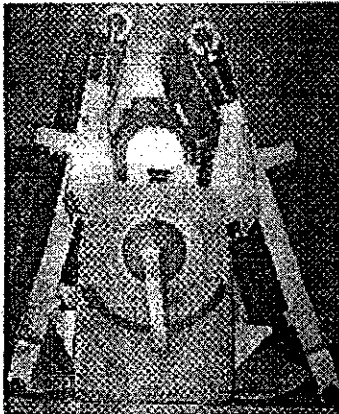
2.1 Machine Delivery



The machine is delivered in its original packaging.

- Report any claims for damage caused as a result of transportation directly to the freight handlers (See the packaging: The delivery documentation is found on the outside of the packaging)

2.2 Transportation



When being transported, the machine must be fastened onto a pallet. The tables must be dismounted and the safety guards fixed in the upper position.

The machine must not be tipped over.
(For machine weight, see Technical Data, Page 090-1)

2.3 Unpacking the Machine

- Remove cardboard packaging and plastic covering

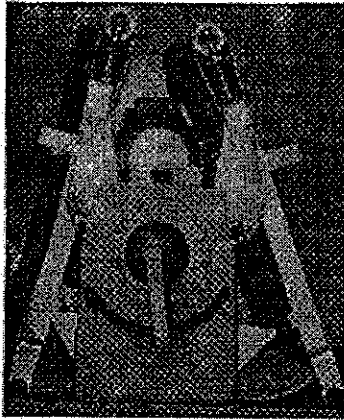
For further information regarding the ambient conditions required for the machine, see General Information, Page 030 - 1

- Unpack tables and attachments
- Check all items received against the delivery slip to ensure completeness

2.4 Setting Up the Machine

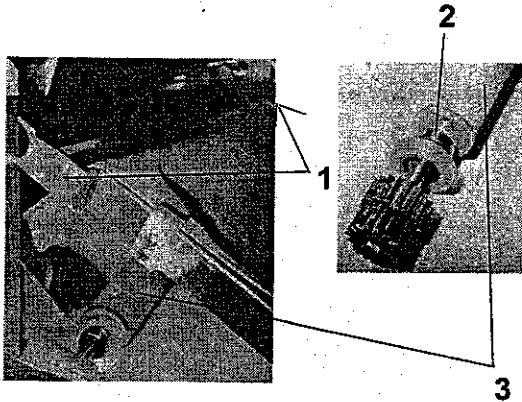


Two people are required to set up the machine

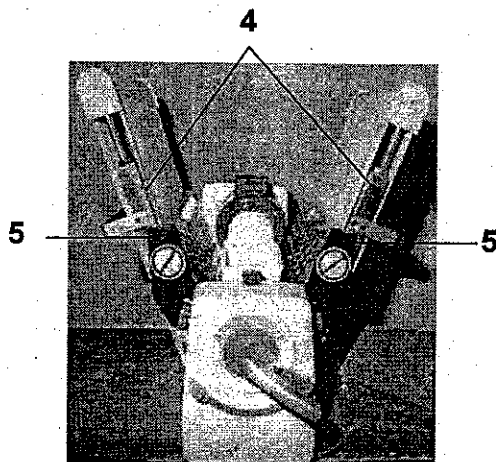


- Set the machine on a level work table
(Make sure that the working height for the operator is correctly set)

2.4.1 Installing the Machine Tables



- Place the forked supports 1 in the drive roller mounting 2
(Do not dismount drive rollers)
- Tension the conveyor belts slightly in order to secure the table
(See Tensioning the Conveyor Belts, Page 020 - 3)

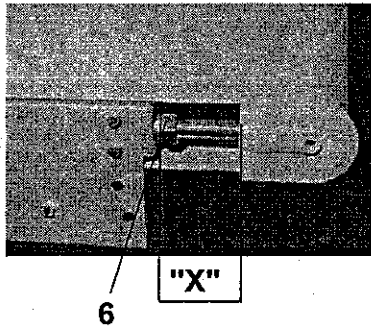


- Place machine tables 4 in upright position
- Secure machine tables 4 to the safety guards 5

2. Transporting, Setting up, Connecting, Dismounting, Storing the Machine

2.4.2 Tensioning the Conveyor Belts

Tension the conveyor belts only enough so that the heaviest pieces of dough (max. 4 kg) can still be moved along the belt without the conveyor belt dragging.



Proceed as follows:

- Retighten the left and right tension nuts 6 so that they are even and parallel
- Remeasure distance "X" on both sides using a millimeter measuring instrument
Distance "X" must be identical on both sides.
- Switch on the machine (See Putting the Machine into Operation, Page 040 - 1/Operating Elements, Starting button, Page 030 - 4)
- Observe both the left and right running movement of the conveyor belt

If the belt runs off toward one side, proceed as follows:

- Retighten the side where it runs off using a tension nut
or
- Loosen on the opposite side using a tension nut
- Monitor the belt, and if necessary, correct it until it runs exactly in the middle of the table

Repeat this procedure several times, if necessary. Routinely monitor the belt during the initial hours that the machine is operational, and if necessary, correct again.

Tensioning and adjusting the conveyor belts demands patience!

Prior to carrying out any further correction, allow the machine to run for at least 30 seconds.

Before putting the machine into operation, the conveyor belts must be rubbed lightly with flour in order to prevent the dough from sticking to the belt.

2. Transporting, Setting up, Connecting, Dismounting, Storing the Machine

2.5 Requirements for Putting the Machine into Operation



Power supply and frequency at the main circuit to which the machine is to be connected must be in accordance with the specifications contained on the plaque affixed to the machine (The plaque is located at the mains cable lead-through.)



Direct connection without a plug is prohibited! Ensure that the connection is made by professionally qualified personnel and that it is carried out in accordance with local regulations (An electrical schematic is delivered with every machine and it is to be found next to the electrical control in the rear machine housing).



- Connect the machine plug to the power supply

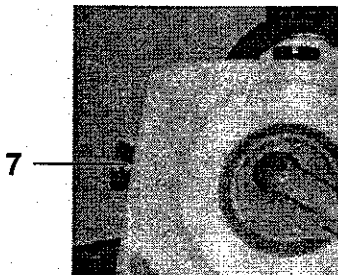


The machine may only be operated with tables mounted.

2.6 Moving Direction Test



Monitor to ensure that the belts are properly tensioned.



- Press the left Start push-button 7 (only impulse)
The conveyor belts must move from left to right.



If the belts are moving in the wrong direction:

- Exchange two phases in the plug

3 General Data about the Machine

3.1 General Information

3.1.1 The Machine's Applications



The machine is suitable for sheeting, booking and final sheeting of dough pieces and marzipan for the food industry.

Booking

Booking in fat. Through sheeting to a thickness of approx. 6 - 11 mm, and subsequent folding of the dough there is a resulting formation of layers of fat and dough. A repetition of this process yields many thin layers.

Final Sheeting

This entails sheeting the dough to the final thickness required for further processing.

3.1.2 Noise Values

Noise emission values at place of operation:
"70 dB(A)" according to DIN 45635

3.1.3 Temperatures

The ambient temperatures permissible for the machine:

+ 5° to + 40°C

Permissible temperatures for storage of the machine:
- 25° to + 55°, for brief periods of time up to + 70°C

3.1.4 Ambient Humidity

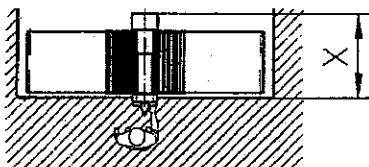
The ambient humidity permissible for the machine lies in the area of 30 % - 95 %, relative humidity, uncondensed (for the dusting flour in the flour duster, the relative humidity should not exceed 60 %).

3.1.5 Machine Weight

Total weight of SWT approx. 80 kg
(Compare Technical Data, Page 090-1)

3.1.6 Working Area for the Operating Personnel

The hatched area shows the work area designated for the operating personnel.



The machine must cover the whole width of "X" on the work table!

3.2 Machine Models

3.2.1 SWT 513

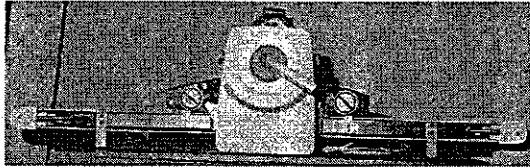


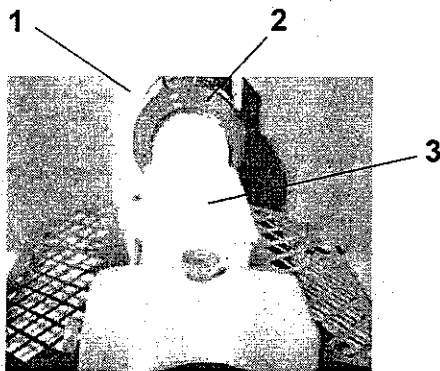
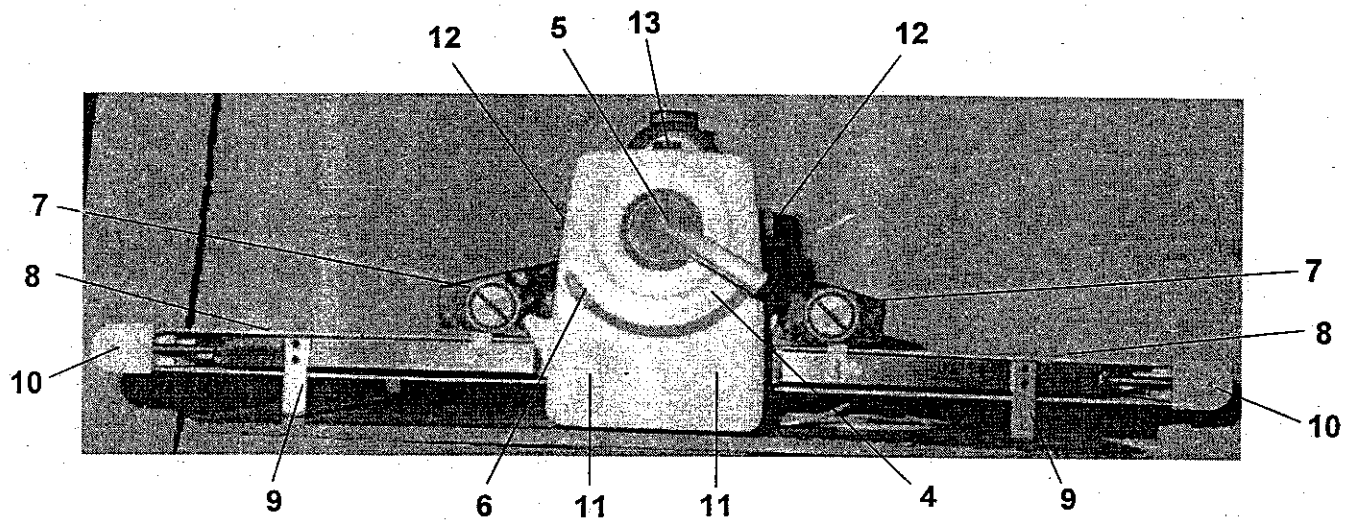
Table model
(See Technical Data, Page 090-1)

3.3 Prerequisites

In order for the dough and marzipan to be sheeted by the machine, the following prerequisites must be fulfilled:

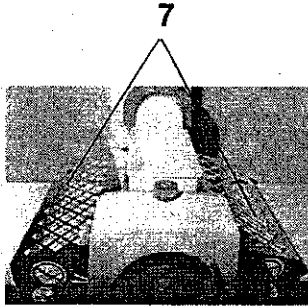
- Max. dough piece weight 4 kg
- Dough pieces must be well-floured
This will serve to prevent the dough from sticking to the rollers and scrapers.

3.4 Complete View of the Machine



- | | |
|----|--------------------------------|
| 1 | Rear housing |
| 2 | Motor |
| 3 | Flour container |
| 4 | Front housing |
| 5 | Roller gap Adjusting mechanism |
| 6 | Roller gap Limit stop |
| 7 | Safety guards |
| 8 | Conveyor belt |
| 9 | Forked support |
| 10 | Idle roller |
| 11 | Cover |
| 12 | Start push-button |
| 13 | Stop push-button |

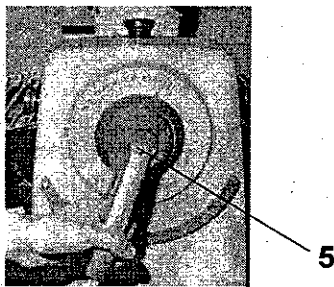
3.5 Operating Elements



3.5.1 Safety guards

The safety guards 7 protect the operator against inadvertent contact with the rollers.

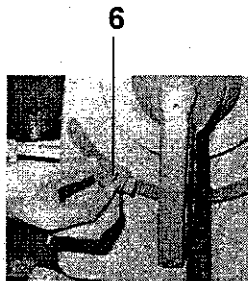
By raising the safety guards 7 the machine can also be stopped.



3.5.2 Roller gap Adjusting mechanism

The desired roller gap is set using the roller gap adjusting mechanism 5.

(See also Sheeting, Page 050 - 1)



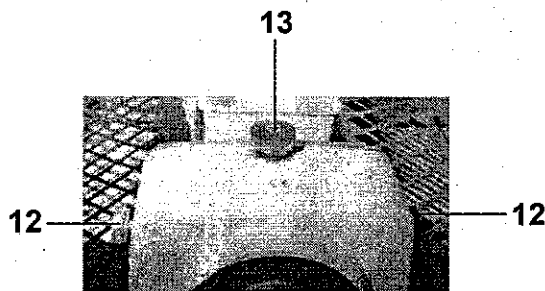
3.5.3 Roller gap Limit stop

The roller gap limit stop 6 serves for mechanical Adjusting of the roller gap (repeatedly sheeting)

(See also Sheeting, Page 050 - 1)

3.5.4 Start push-button

Both start push-buttons 12 (two push-buttons on the side of front housing) serve to start the machine. (See also Starting/Stopping the machine, Page 040 - 1)



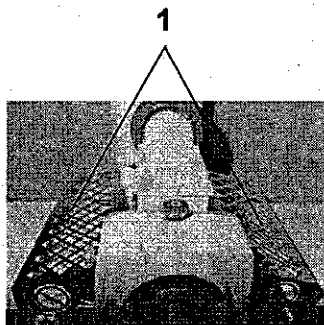
3.5.5 Stop push-button

The stop push-button 13 (push-button at the top of front housing) serve to stop the machine.

(See also Starting/Stopping the machine, Page 040 - 1)

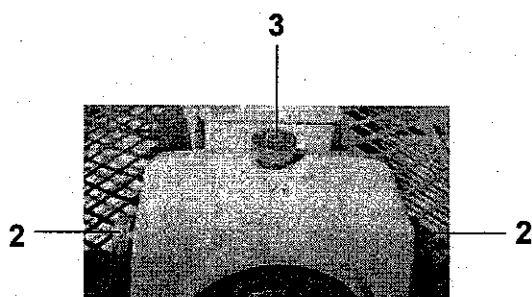
4 Putting the Machine into Operation

4.1 Preparing for Operational Readiness



- Close both safety guards 1
(See Safety Guards, Page 030 - 4)

4.2 Starting/Stopping the Machine



In order to start up the machine:

- Briefly press the left Start push-button 2
The conveyor belts begins to move from left to right.

or

- Briefly press the right Start push-button 2
The conveyor belts begins to move from the right to the left.

In order to stop the machine:

- Briefly press the Stop push-button 3

5 Operation

5.1 Operating Instructions



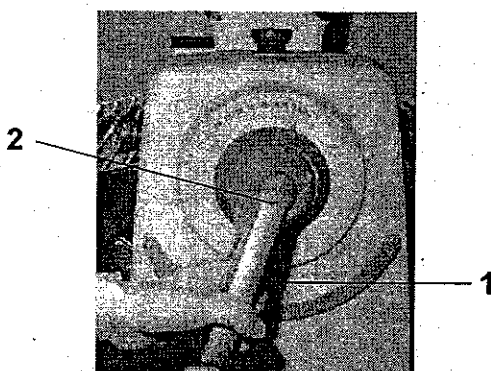
Reaching under the safety guard when it is closed is prohibited!

5.1.1 Sheeting

The machine is designed to accommodate dough pieces with a maximum weight of 4 kg!



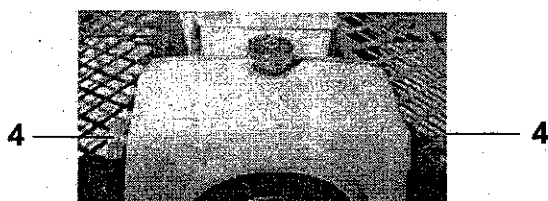
Never leave loose objects such as knives, tools, articles of clothing, etc. lying in the area where the dough is located.



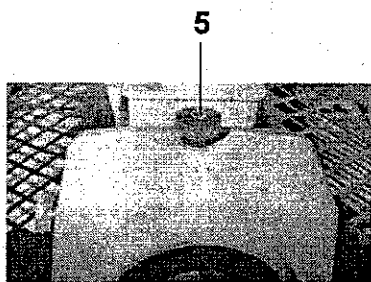
- Set desired roller gap (maximum 30 mm/ minimum 0.5 mm) as follows:
- Push lever 1 towards the roller gap adjusting mechanism 2, do not release
- By way of the roller gap adjusting mechanism 2, set the roller gap desired (Scale)
- Release lever 1
Lever 1 must lock into place.



- Compress Roller gap Limit stop 3 and push it against the lever 1 and release it

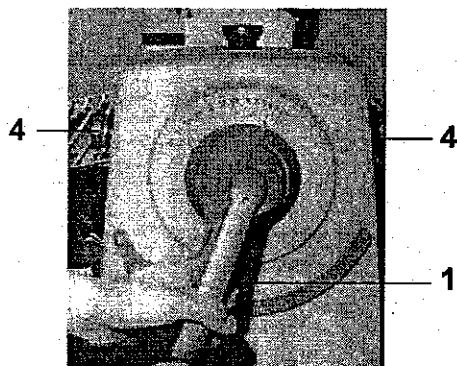


- Place the dough piece (max. 4 kg) on the machine table (do not "throw" it on the table!)
- Start up the machine as follows:
- On the dough's infeed side, briefly press the Start push-button 4
(See Starting/Stopping the Machine, Page 040 - 1)



Once the dough piece has fully cleared the rollers:

- Press the Stop push-button 5
The machine will stop.
- Manually set the next roller gap (depending on type of dough being processed) (See top of Page 050-1)



- Release lever 1
Lever 1 must lock into place.
- On the dough's infeed side, briefly push the Start push-button 4
(See Starting/Stopping the Machine, Page 040-1)

Once the dough piece has fully cleared the rollers:

- Press the Stop push-button 5
The machine will stop.
- Repeat this procedure until the desired final thickness of the dough has been obtained

5.2 Sources of Errors in the Sheeting Process

Fault finding	Cause / Defect	Remedy / to remove
1. Dough piece sticks, tears under neath.	Dough too moist. Dough piece rubs against scraper bar.	Flour dough piece well. Mount scraper properly (see Mounting the scraper unit, page 060 - 1).
2. Dough piece piles up (ripples).	Reduction steps too big.	Select smaller reduction steps: Let down the roller in smaller steps (see Sheeting, page 050 - 1).
3. Dough sheet tapers.	Reduction steps too small.	Select bigger reduction steps: Let down the roller in bigger steps (see Sheeting, page 050 - 1).

6 Cleaning

6.1 Cleaning



The machine must never be cleaned using spray water, high-pressure cleaners or a steam cleaning machine

6.1.1 General Information



Dismounting the Scraper

- Open rollers fully
- Lock the safety guard into the upper position
- Using the thumb, push the front and rear scraper blade 1 downwards



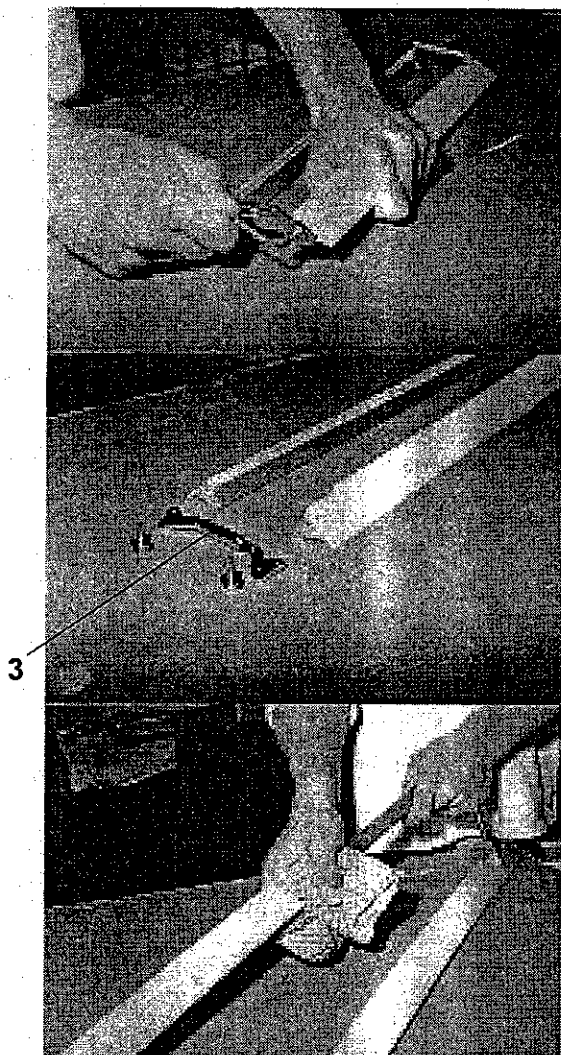
1



2

- Lift the scraper 2 out of the scraper mounting
- Pull out the scraper 2
- Clean the scraper (See Care, Page 060 - 4)

Exchange of Scraper blade



Required tool: Allen key No. 4

Exchange of scraper blades:

- Disassemble the spring clamp 3 on the left or right hand side
- Slide the scraper blade off

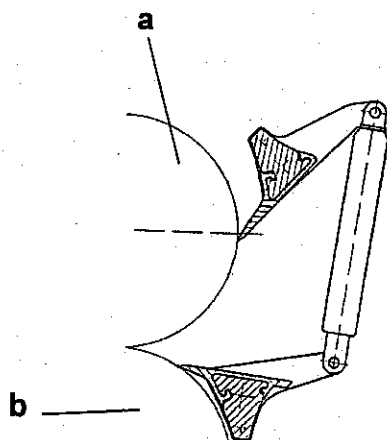
Note

Use a cloth; danger of injury!

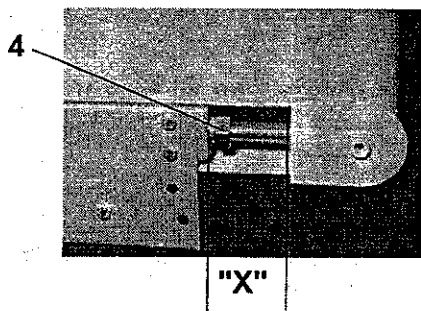
- Assemble the new scraper blades in reverse order
- Assemble the spring clamp in reverse order

Mounting the Scraper

- To remount the scraper, carry out the dismounting instructions in reverse order



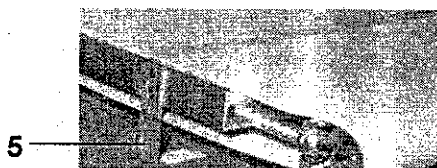
- a upper roller
- b lower roller



Dismounting Machine Tables/Conveyor Belts

In order to dismount the machine tables and conveyor belts, proceed as follows:

- Pull out the mains plug
- Lift up the safety guards
- Loosen the tension nuts 4 parallel, in order to loosen the conveyor belt



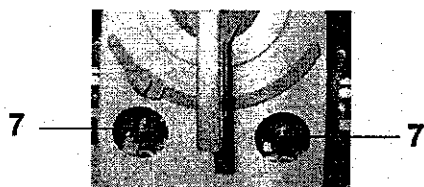
- Dismount forked supports 5

- Dismount tables (To dismount, follow machine table mounting instructions in reverse order, see Page 020 - 2)

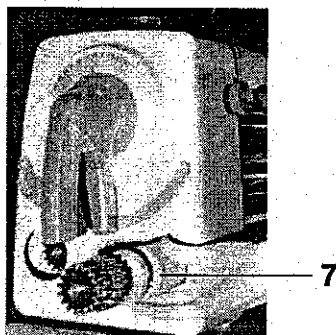
In order to dismount the conveyor belts, proceed as follows:



- Remove covers 6 with aid of a screw driver



- Remove the drive rollers 7 towards the front out of the machine head



- Remove the conveyor belt
- The conveyor belt can now be cleaned or replaced (see Care, Page 060-4/Replacement Parts List, Page 070-1)



Mounting the Machine Tables and Conveyor Belts



Make absolutely sure that you do not confuse the left and right drive rollers or the left and right machine tables!

- Remount machine tables and conveyor belts by proceeding in reverse order of the instructions for dismantling them

6.1.2 Care

Part	see	daily see legend	weekly see legend
Machine head and socle	Page 030 - 3		A
Scraper	Page 060 - 1	A	
Cotton belt	Page 060 - 3	B	(D)
Driving roller	Pages 020 - 2 / 060 - 3		C
Idle roller	Page 020 - 3		C



Alcohol, solvents or cleaning materials which exceed a pH value of 8 must not be used for cleaning purposes! Only those cleaning materials which are approved for use in the food industry may be used.

Legend

- A Wet clean using a cloth and soapy water
- B Dry clean using a brush
- C Using a brush and scraper, remove any remaining pieces of dough
- D Wash cotton belt monthly as follows:
 - Water temperature must not exceed 40° C
 - Once belt has been washed, hang it over a rod and weight it down with a weight of approx 10 kg

7 Maintenance

7.1 General Information on Maintenance of the Machine



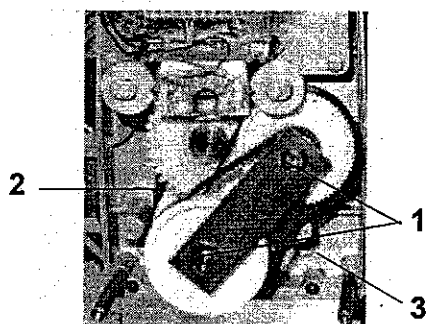
Any defects on the machine must be repaired by an authorized customer service representative!



7.1.1 Greasing



- Pull out the mains plug
- Remove rear cover
- Oil the marked parts as follows:
(Lubricant: Molykote PG 65)



1 Gear bedding: every 2 years

Legend:

- 2 V belts
- 3 Rear housing

7.2 Replacement Parts List

Item-no.	Description	Dimensions	Application
122773T02	Scraper	-	SWT 513
79302	Cotton belt	1490 x 475 mm	SWT 513

8 Trouble Shooting

Fault finding	Cause / Defect	Remedy / To remove
1. Machine stands still after assembly.	Main switch not/not correctly plugged in. Safety guard not closed. Right or left Start push-button not pressed. Machine tables not level.	Plug in the main switch. Close safety guard. Press the desired Start push-button. Put the machine tables in a even level position.
2. When pressing the right Start push-button the conveyor belts move to the right.	Sense of rotation reverse (mains).	Moving direction test (see page 020 - 4).
3. Machine runs intermittently, stops, rattles.	Safety guard limit switch incorrect. Support for safety guard incorrect. Loose cables, wires.	Readjusting by an expert. Adjust supporting eccentric. Adjust loose wires, cables.
4. Main drive motor runs, rollers and conveyor belts stand still.	Belt drive defective.	Call after-sales service! Remove rear cover of machine base and roller head, replace belts or toothed belts if necessary.
5. Conveyor belts loops up, motor and rollers run.	Belt tension too weak. Driving roller dirty.	Tension conveyor belt equally. (see Tensioning the conveyor belts, page 020 - 3). Clean driving roller (see Care, page 060 - 4).
6. Machine only runs to one side.	Defective motor contactor. Safety guard limit switch defective.	Call specialist (electrician). Replace motor contactor/limit switch.

Fault finding

Cause / Defect

Remedy / To remove

7. Discharge conveyor belt stands still or jerks.

Table drive defective.
Belt tension too weak.

Call after-sales service.
Tension the belt equally (see Tensioning the conveyor belts, page 020 - 3).

8. Dough piles up before the roller or passes under the roller between scraper and infeed conveyor belt.

Scrapers inserted incorrectly.
Scraper blades worn out.

Close the scraper levers properly (see Cleaning, Mounting the scraper unit, page 060 - 1)
Check and if necessary adjust scraper levers by means of eccentric (center of motion). If necessary replace scraper blades or the complete scraper.

9. Conveyor belts run to one side, tear at the edges.

Incorrect belt tension.
Drive roller dirty

Tension conveyor belt (see Tensioning the conveyor belts, page 020 - 3)
Clean drive roller (see Care, page 060 - 4).

10. Cotton conveyor belts too short after washing.

Washing temperature too high..

Washing temperature max. 40° C.
Hang washed conveyor belt over a rod and weigh it down below with approx. 10 kg.

11. All other faults/falling outs

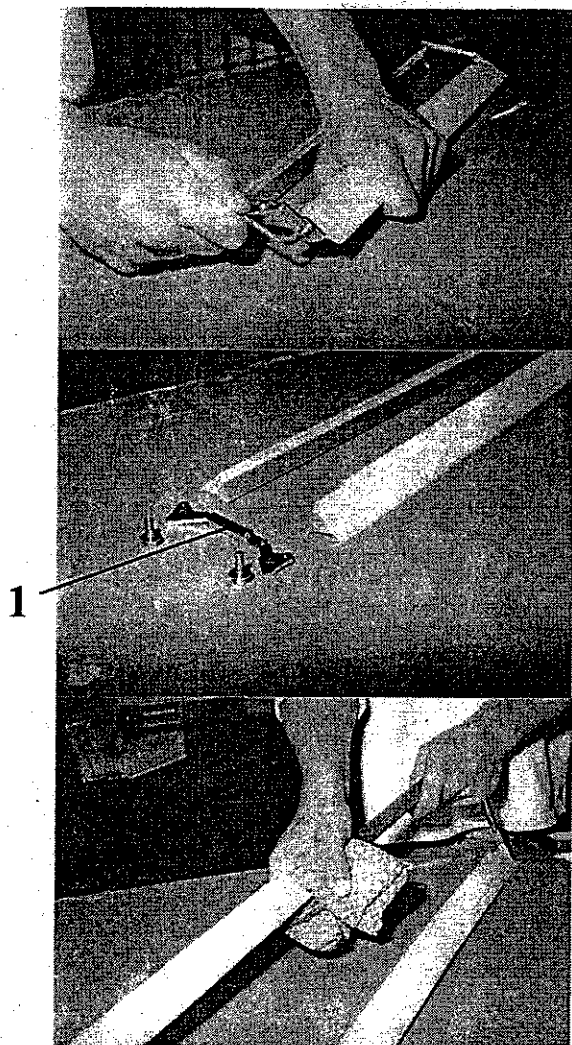
Contact the next after-sales service with giving them so much informations as possible.

9 Technical Data

Technical Data	SWT 513
Belt width	475 mm
Max. table width	935 mm
Total table length	1590 mm
Roller length	500 mm
Machine length: in working position	1590 mm
in resting position	700 mm
Roller gap	0,5 - 30 mm
Sheeting speed of discharge conveyor	50 cm/sec
Rated power	0,75 kVA
Supply voltage	3 x 200 - 420 V, 50 / 60 Hz 1 x 220 V, 50 Hz 1 x 110 V, 60 Hz
Machine weight	approx. 80 kg

Subject to technical changes without notice.

NEW SCRAPERS 2000 / EXCHANGE OF SCRAPER BLADE ON SHEETING MACHINES WITH A ROLLER OPENING OF 30 MM (AND PIZZOLO)



Required tool : Allen key No. 4

Exchange of scraper blades

- disassemble the spring clamp No. 1 on the left or right hand side

- slide the scraper blade off

Note

Use a cloth ; danger of injury!

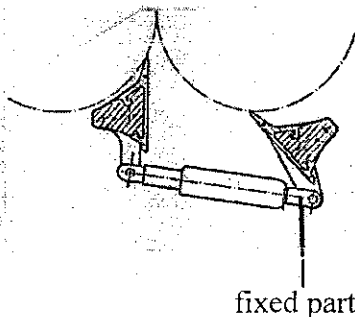
- Assemble the new scraper blades in reverse order

- Assemble the spring clamp in reverse order

Pizzolo

Note

the spring clamps for the Pizzolo are assembled reversed in comparison with the sheeting machines



fixed part



511 Sixth St. N.W. Grand Rapids, MI 49504
Ph: (800) 253-3893 www.oliverbakeryequip.com

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.



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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