



ARCOBALENO[®]
PASTA MACHINES

MODEL AEX20 OPERATING, INSTALLATION & MAINTENANCE MANUAL



IMPORTANT SAFETY NOTICE

This manual contains important safety instructions which must be strictly followed when using this equipment.

FOR SERVICE, CONTACT ARCOBALENO

If you have any questions or issues regarding your machine, please contact us at: **717.394.1402** or service@arcobalenollc.com. When contacting us, please have your serial number and model number available so we can assist you based on your machine's individual specifications.



A R C O B A L E N O[®]

Arcobaleno Machine Certification

The following machine(s) have been inspected and tested by Arcobaleno prior to shipment to customer:

Model number(s): _____

Serial Number(s): _____

And found to meet the following requirements as certified by the undersigned.

- All safety switches and E-stops function properly
- Machine power connections are installed correctly and function properly
- All covers and guards are present and undamaged
- The machine has been run and tested to meet the required standards
- An operating manual has been included in the packaging
- Appropriate tools have been included in the packaging
- The machine has been packaged properly and is free of physical defects

Authorized Arcobaleno Representative Signature: _____

Date: _____



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SAFETY NOTICE/WARRANTY

MODEL AEX20

IMPORTANT SAFETY NOTICE

To insure both safe and trouble-free performance, we stress that all personnel that will be involved with your new Arcobaleno Pasta Machine **must** read and understand these instructions **before** attempting to operate this unit.

LIMITED WARRANTY

Warranty Effective only when Certificate of Acceptance is received.

Please mail back with enclosed pre-paid envelope.

If not received within 14 days warranty is VOID.

Arcobaleno Pasta Machines, LLC. guarantees this device against defects in workmanship or material under use and service **for a period of twelve (12) months, which begins upon receipt of machine by the customer.** All obligations and liabilities under this guarantee are limited to repairing or replacing, at our option, F.O.B. our plant of such allegedly defective units as are returned and carrier charges prepaid. All repairs or replacements are made subject to factory inspection of returned parts at company plants. No liability is accepted for consequential damage which may include but is not limited to: damage or failure that has occurred due to misuse, acts of God, damage due to reinstallation labor or improper application. This warranty does not include electrical parts. Defects as defined in the above paragraph shall not include decomposition by chemical action (corrosion).

In the event that a defect in material or workmanship occurs during the first ninety (90) days of the warranty and if Arcobaleno determines that field service is required, Arcobaleno will provide the required service and parts free of charge. The buyer will be responsible for and invoiced for all out of pocket travel and living expenses incurred by such a service call. After the initial ninety (90) days of the warranty, Arcobaleno will service the equipment at the customer's facility at its prevailing labor rates plus expenses. A purchase order will be required for any parts or service ordered under this warranty.

Defects due to materials or manufacturing shall be examined at our expense but if the claim is unjustified, all repairs and replacement costs have to be borne by the customer. The guarantee does not cover accidental damage, negligence or inappropriate treatment, incorrect use or phenomena not depending on the regular functioning or use of this machine.

Guarantee on equipment and accessories furnished by outside manufacturers shall be limited to the guarantees of the respective equipment and/or accessory manufacturer for such units. This guarantee is null when the machine has been repaired by non-authorized personnel and/or when spare parts have been supplied that have not been approved by the manufacturer.

FOR WARRANTY SERVICE

Contact the Arcobaleno warranty service department at **(800) 875-7096** or **(717) 394-1402** to report warranty claims before arranging repair or attempting to return the unit to Arcobaleno Pasta Machines, LLC.



INTRODUCTION

MODEL AEX20

Please read this manual carefully before using the machine.

This manual contains the description of the operation and the instructions needed to properly perform the use, the routine and the periodic maintenance of the machine.

For an easier consultation, this manual is divided into sections (see Table of Contents on next page).

All information contained in this manual are intended for the user, who must have specific knowledge about the operation of the machine, and who must be authorized to use it and properly trained.

We recommend the use of original spare parts and accessories. Non-original parts will void the warranty and can be dangerous. Non-original parts could also damage the machine.

In case of transfer or selling of the machine, the manual must always be included with the machine.

If the manual should be lost or damaged, you should request a new copy from Arcobaleno. The manual is considered a part of the machine.

For additional copies contact:

Arcobaleno Pasta Machines, LLC.
160 Greenfield Road
Lancaster, PA 17601

Tel: 717.394.1402
Fax: 717.397.0258



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GENERAL INFORMATION

MODEL AEX20

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GENERAL INFORMATION

MODEL AEX20

1.1 GENERAL

This publication, hereinafter simply defined as the “manual”, includes any information regarding installation, use, and maintenance of the “AEX20” manufactured by Arcobaleno Pasta Machines, LLC.

The recipients of this publication, generally defined as “users”, include all individuals who, according to their relevant involvement, need and/or are required to provide instructions or to attend this machine operationally.

These individuals can be identified as follows:

- ✓ Directors
- ✓ Chief of Operations
- ✓ Heads of Department
- ✓ Machine operators who are directly involved in its transportation, storage, installation, use, and maintenance, starting from its market introduction until its dismantling
- ✓ Private direct users

This publication must be considered as being an integral part of the machine and, as such, it must be kept for future references until final dismantling and scrapping of the machine.

1.2 PURPOSE OF MANUAL

The purpose of this manual is to allow specific individuals to learn how to use this machine safely for a long period of time in order to perform all relevant tasks; provided that such individuals shall take any measure and arrange in advance any human resources and materials as necessary. This manual is written pursuant to Directives Machines 2006/42/CE. The machine’s intended use and configuration are the only ones approved by the manufacturer; users are advised to avoid usage of the machine in a way non-compliant with the instructions given. Every other use or configuration should be previously agreed with the manufacturer and, in such case, an Annex will be attached to this manual. The machine operator shall comply with any applicable labor law in force at the machine’s place of installation.

1.3 WHERE AND HOW TO KEEP THIS MANUAL

This manual should be kept in a safe and dry place where it is always available for consultation. It is advisable to make a copy which should be kept on file. In the event of exchanges of information taking place with the manufacturer, please refer to the rating plate and serial number. This manual should be kept for the entire life of the machine, and if needed, (for example damage that compromises its consultation, even if only partially, etc.), the user must purchase a new copy which should be requested to the manufacturer only.



1.4 MANUAL UPDATE

This manual forms an integral part of the machine and reflects its current status upon its market introduction. This publication complies with any law, directive, and regulations in force at that time; it shall not be deemed unsuitable if updated at a later time.

Any changes, adjustments, etc. made on machines marketed afterwards shall cause the manual to be reviewed, however, any manual always represents the current condition of the machine associated with it.

Any additions to this manual that the manufacturer considers appropriate to send to every user should be kept in conjunction with its relative manual.

1.5 COOPERATION WITH THE USER

The manufacturer is available for any additional information its clients may need and for taking into consideration any suggestion as to improve its products in order to make this manual more responsive to users' needs. In case of equipment transfer, the equipment should be accompanied by this manual. In this regard, the principal user should send the address of the new user to the manufacturer, so that the manufacturer will be able to provide him/her with any necessary information and/or updates.

Arcobaleno Pasta Machines, LLC. reserves title to this publication and warns against any reproduction, in whole or in part, without its prior written consent.

1.6 MANUFACTURER'S WARRANTY

In order to benefit from the manufacturer's warranty, users should strictly comply with any precautions set forth in this manual, in particular such as:

- ✓ To operate the machine within its usage limits
- ✓ To carry out regular and accurate maintenance
- ✓ To select qualified personnel having the necessary skills and capabilities and being appropriately trained to use this machine

The manufacturer accepts no responsibility, direct or indirect, arising from:

- ✓ Non-compliance with operating instructions and uses which differ from those provided in this manual
- ✓ Usage from personnel unaware of any instructions and details included in this manual
- ✓ Non-compliant usage with specific regulations in force in the installation country
- ✓ Changes made on the machine without prior authorization
- ✓ Unauthorized repairs
- ✓ Use of unoriginal parts
- ✓ Exceptional events



ARCOBALENO®

GENERAL INFORMATION

MODEL AEX20

Any transfer of the machine to a second user shall take place in conjunction with its related manual; the lack of it shall automatically cause decline of any responsibility on the part of the manufacturer for any incorrect use of the machine.

If the machine is transferred to a second user residing in a country whose language differs from the country of the first user, such first user shall be responsible for providing the second user with a reliable translation of this manual in the language of the country where the machine is transferred to.

1.7 AFTER-SALE SERVICE

For any after-sale service please refer directly to the manufacturer at the following address:

Arcobaleno Pasta Machines, LLC.

160 Greenfield Road

Lancaster, PA 17601

Tel: 717.394.1402

Fax: 717.397.0258

service@arcobalenollc.com

www.arcobalenollc.com

AFTER HOURS TECH SUPPORT contact Antonio at 610.656.0391



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PRELIMINARY INFORMATION
MODEL AEX20

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PRELIMINARY INFORMATION

MODEL AEX20

2.1 COMPLIANCE OF RATING PLATES - LABELING

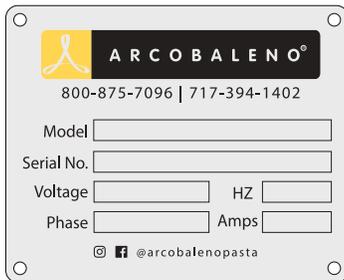
As shown in particular in A, the rating plate includes main data on the manufacturer and on the machine in addition to the EC labeling. The rating plate is secured with four rivets.

As shown in particular in B, C, D, and E other rating plates are added in order to display general warnings as to the correct use of the machine.

Readability and preservation of rating plates:

Rating plates should always be kept in readable form concerning all data included. For such purpose, they should be cleaned on a regular base. In case of degradation and/or illegibility of any one piece of Information included, users should request another plate from the manufacturer. Upon such request, they should mention the details included in the original plate and arrange for its substitution.

WARNING: The below rating plates should not be removed or covered with others.



A



B



C



D



E

2.2 PACKING - HANDLING

Machines are delivered completely assembled so that packaging and/or special protections are not included in the delivery. In case of different agreements between the manufacturer and the user regarding packing of parts or the entire machine as well as handling, see any specific instructions attached to this publication. Machines should be handled by a fork lift truck or the appropriate handling equipment and fabric slings (fabric/nylon) in conjunction with proper guards for sharp edges.



2.3 STORAGE UPON RECEIPT

Storage can take place soon after delivery of the machine and is allowed for a maximum period of two years in sheltered areas with the following features:

- The storage area should be a sheltered place with a temperature of no less than 41° F / 5° C and not over 104° F / 40° C, with a humidity ratio not exceeding a value equal to 80%.
- Should the above mentioned values change in the course of storage, it shall be required to perform some preliminary checks before setting the machine at work (please consult with the manufacturer).
- Should the temperature within the storage area exceed or drop below the above mentioned values and the relative humidity goes over 80%, it shall be necessary to take proper measures such as using a bag barrier and hygroscopic salt.

WARNING: For storage periods longer than two years or under different environmental conditions, please request the relevant preservation procedures from the manufacturer.

2.4 MACHINE AND SUPPLY KIT INSPECTION

The machine and its relative supply kit (as agreed with the manufacturer) should be in perfect conditions. Before shipping, each item is carefully checked and inspected, however, upon its receipt, it is always advisable to verify the completeness and working condition of the goods shipped.

In case of any defects and/or incompleteness, please inform the manufacturer immediately and comply with his instructions before proceeding with the installation of the machine.

Verify any possible damages to the frame, buckles, etc. cracks or tears of electrical conductors, etc... Take the machine's documentation and verify the absence or any discrepancy between what is stated in the shipping documents and the goods received.

Standard supply kit:

- ✓ Machine Certification
- ✓ Certificate of Acceptance - Please mail back with enclosed pre-paid envelope.
If not received with-in 14 days warranty is VOID.
- ✓ Operator's manual - installation, usage, and maintenance



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**TECHNICAL DESCRIPTION
& OPERATION**
MODEL AEX20

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TECHNICAL DESCRIPTION & OPERATION

MODEL AEX20

3.1 GENERAL FEATURES AND OPERATING TIPS

The Arcobaleno AEX20 model is a professional pasta machine for fresh pasta, an ideal machine for restaurants, food services, pasta shops and catering. AEX20 produces any shape of short and long fresh pasta. It is equipped with one electronic cutting knife.

The following are its main features:

- Kneading/extruding bowl in stainless steel
- Extruding auger and support pasta die ring in alimentary bronze
- Safety protection guard
- Safety micro-switch for automatic stopping of the machine
- Mixing/extruding/stop buttons via touch screen control
- Electronic cutting knife with adjustable speed
- Painted cover
- Die wrench
- Water cooling system extruding nozzle
- Electrical motor dual speed

FLOUR+WATER RECIPE FOR AEX20

(30% Hydration)

2,500g of flour
750g of cold water

Additional water (25-50g) may be required.

Recipe may vary based on flour type, eggs, relative humidity, & environment. Please adjust accordingly.

WHOLE EGG RECIPE FOR AEX20

(32% Hydration)

2,500g of flour
8 whole eggs (Approximately 50 grams per egg)*
400 grams of cold water

** Egg size may vary. Please adjust accordingly.*

Eggs + Water must be whisked together before adding to flour.

Note: *The recipe may vary due to relative humidity (RH%) of the flour and kitchen environment. Different flours have different RH%. Please adjust accordingly.*

If your mix is too wet, try holding back some of the liquid (25-50g) to see how the mix is affected.

DIRECTIONS FOR AEX20 RECIPES:

Weigh out flour and liquid required for the batch.
If applicable, mix cold water and eggs together with whisk.

Put flour in hopper and set mix time to 4-6 minutes.
Turn on mix mode. Slowly add liquid, moving the container back and forth along the opening. Mix for 4-6 minutes.

Stop machine and check consistency of contents, dough should start to clump and form a coarse crumbly flour texture like streusel. If you do not see a coarse crumbly flour texture, drizzle an additional 25-50g of water while in mix mode for 60 seconds.

The consistency of the egg pasta dough should look like small pebble sized dough balls.

Set desired extrusion time. If no time is set, the timer will begin counting up once extrusion is started.
Begin to extrude. Never extrude dry flour.

Questions? Please call Arcobaleno at 717-394-1402.

WARNING: If EXTRUDE is pressed instead of MIX, **STOP and remove the die IMMEDIATELY.** Dry flour will clog the die, cause damage, and void the warranty. See page 29 for more information.



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TECHNICAL DESCRIPTION & OPERATION

MODEL AEX20

3.2 TECHNICAL DATA

Model	AEX20 - Same size dies as AEX18!
Hourly Production*	Up to 20 lbs/hr *Production varies by pasta shape
Mixer Capacity (flour)	2,500 g (5.5 lbs)
Mixer Production (flour + liquid)	3,250 g/batch (7 lbs/batch)
Electrical Power	120V/1/60Hz 10 Amps
Machine Dimensions	14.5"W x 29.25"D x 20.5"H (with knife)
Shipping Dimensions	23.75"W x 31.5"D x 31.5"H
Machine Weight	88 lbs
Shipping Weight	110 lbs
Shipping Class	125

3.3 EXPECTED USE - INTENDED USE

This machine is intended for fresh pasta production. The dough is produced by the mixing arm in the mixing bowl. The shaping is obtained by the extrusion operation, the die mold and the cutting operation by the electronic cutting knife. The primary ingredients, the time of mixing operation, the extrusion velocity, the cutting velocity and the die mold determine the final product.

The use herein indicated is the only one recognized by the manufacturer. In the event that the manufacturer and the user agreed on specific operating conditions, these will be documented and enclosed as annexes to the machine manual, thus forming an integral part of it.

Instruction For Use

Refer to those specific paragraphs set forth in Sections 5 of this manual.

3.4 MACHINE CONFIGURATION

All machines are exclusively marketed under the configurations set forth in this depiction.

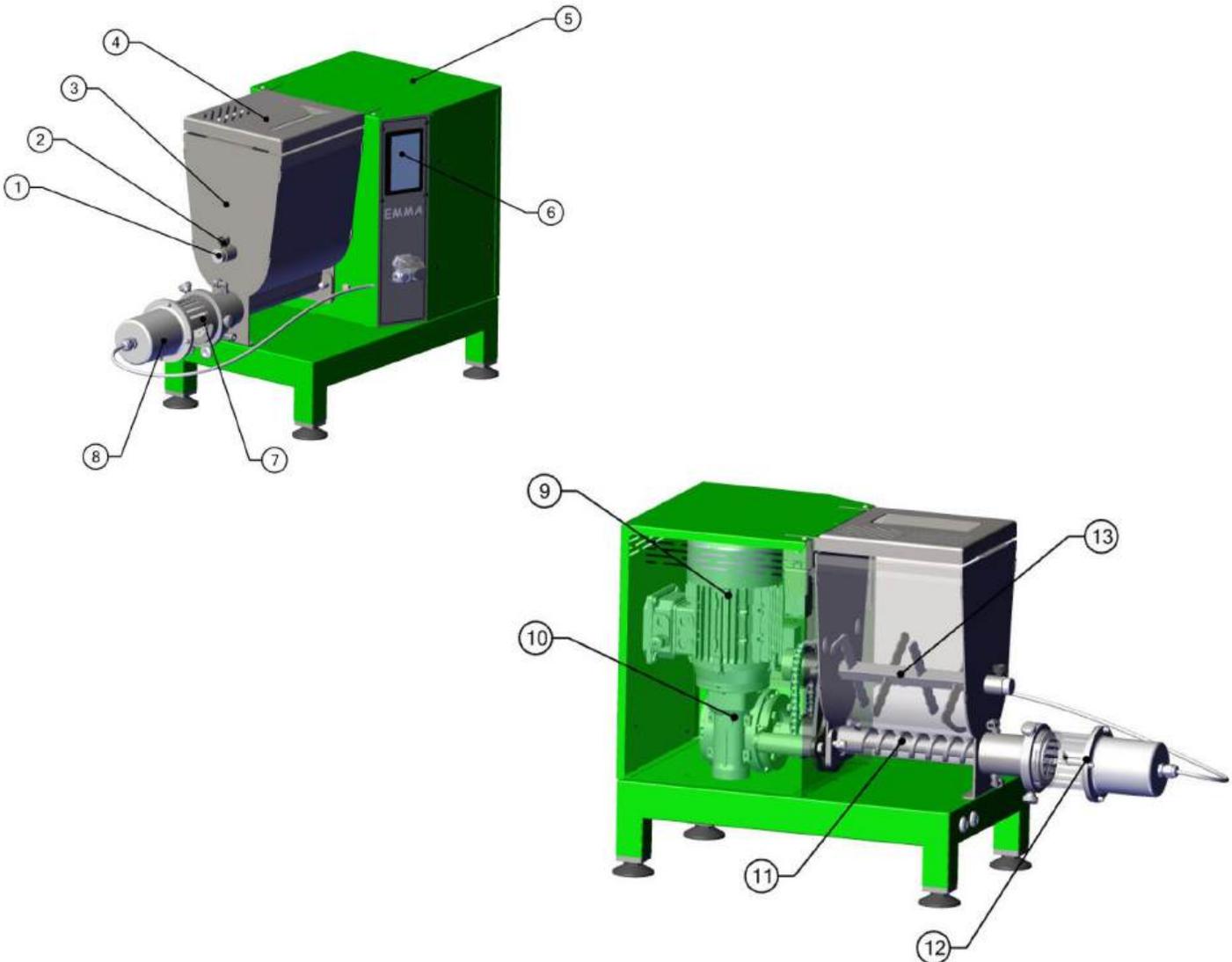


Figure 3-1

- | | |
|------------------------------|------------------------------|
| 1. Mixing arm bushing | 8. Knife motor |
| 2. Mixing arm knob | 9. Motor |
| 3. Tank | 10. Gearbox |
| 4. Extrusion tank safety lid | 11. Auger |
| 5. Cover | 12. Electronic cutting knife |
| 6. Touchscreen control panel | 13. Mixing arm |
| 7. Knife safety guard | |



TECHNICAL DESCRIPTION & OPERATION MODEL AEX20

3.5 OPERATING ENVIRONMENT

The expected operating environment must have the following features:

- Temperature:
 - Minimum: 41° F / 5° C
 - Maximum: 104° F / 40° C
- Maximum relative humidity/dampness: 80%

The machine cannot be operated in open places, or in fire or explosion risk environments, or in such places where usage of explosion-proof components is required.

3.6 USERS

In selecting the most appropriate person (operator) to operate the machine, who will necessarily be someone fit for work in compliance with the regulations in force, the individual in charge of company security shall take into consideration the physical aspect (no impairment), the psychological aspect (mental balance, sense of responsibility), as well as the educational level, training, experience and knowledge of rules, instructions, and measures designed for accident prevention.

Based on the dispositions and skills emphasized by the operator, the individual in charge of company security shall arrange for his/her training on the machine as to provide him/her with a complete knowledge of this machine.

In addition the operator will learn the content of this manual as well as its attachments.

WARNING: Don't allow anyone to approach the area when the machine is working and prohibit its usage by individuals unfamiliar with ongoing operations.



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INSTALLATION & START UP

MODEL AEX20

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**4.1 PRELIMINARY CHECKS**

- Verify the integrity and perfect condition (no signs of rust, humidity, dent, etc.) of both the machine and of any anticipated accessories within the consignment.
- Assess the integrity of the electric installation wiring (no signs of cracks, squashes, etc.)
- Verify that the expected way to get to the installation place (machine handling) is free from any possible obstacles (things or persons). Foresee contingent protection barriers and get to the selected installation place.

4.2 INSTALLATION

Proceed with the machine setting in the area specifically designed pursuant to instructions given in Section 2 of this manual.

Operator

This machine requires one operator for the installation.

During normal working order the operator must stay in its proximity, at “visual” distance in order to intervene in case of malfunction or loading/downloading operations, as the case may be.

Lighting system

This machine is not equipped with an off-the-shelf lighting system. The lighting level of the environment should always avoid shadow areas and ensure that any operation is within the maximum levels of security in relation to its usage type.

Should servicing be necessary in parts where there is not enough lighting, it is mandatory to be equipped with portable lighting systems in order to avoid shadows that prevent or reduce visibility on the place of intervention or in its surroundings.



INSTALLATION & START UP

MODEL AEX20

4.3 OPTIONAL WATER COOLING TANK ASSEMBLY SET UP

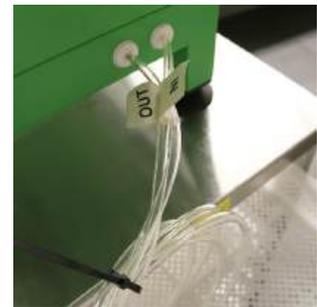
The optional water cooling tank helps to maintain a constant temperature within the extrusion chamber. By maintaining a consistent temperature, the operator gains increased control and consistency over their product.

The machine should not be connected directly to the water supply. It should be connected to the water cooling tank as follows.

Optional Water Cooling Tank Set Up:

The optional water cooling tank includes:

- water pump
- tank with lid
- 2 water cooling hoses (In and Out) (attached to back of machine)



1. Place the water pump into the tank. Pull the cord and plug of the power cord out of the tank and through the large hole in the center of the lid.



2. Insert the IN hose through the top small hole in the lid. Connect the IN hose to the barb on the water cooling pump.





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INSTALLATION & START UP

MODEL AEX20

3. Insert the OUT hose through the bottom small hole in the lid. Place the OUT hose into the tank. Ensure the end of the hose is towards the bottom of the tank to prevent water from squirting out.



4. Fill the water cooling tank with water. **Water must be added to the tank before using. The pump must be submerged.**



Water level is above pump

5. Secure lid to tank. The two hoses will be going into the lid/tank. The water pump cord and plug will be coming out of the lid/tank.



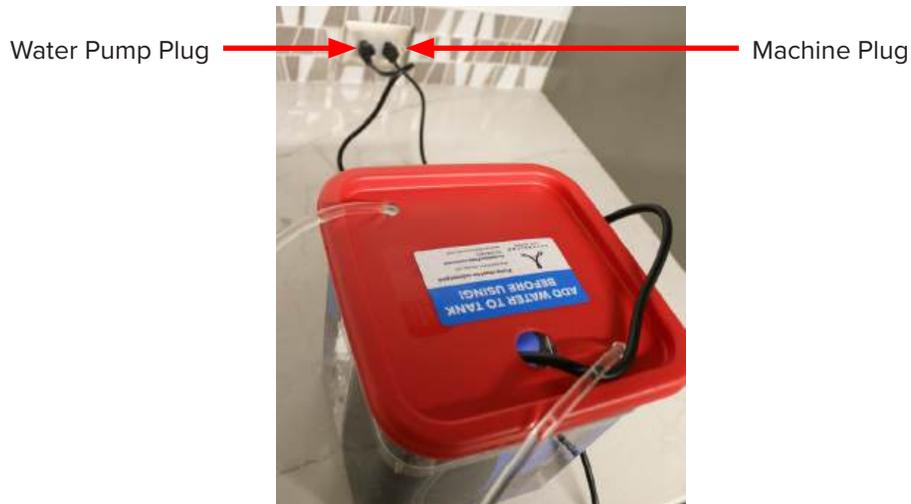


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INSTALLATION & START UP

MODEL AEX20

6. Connect the water pump power cable to an outlet (120V).
Two 120V outlets total will be needed: one for the water pump and one for the machine.



7. The water temperature in the cooling tank is the same temperature as water flow to cool the extrusion neck. If cooler water temperatures are desired, add ice cubes daily to keep water cool.
8. To deactivate the water cooling pump, unplug it from the outlet.
9. Refill or change out water as needed. The pump must be submerged before using.
10. If you have any questions please call the Arcobaleno Service Team at 717-394-1402



INSTALLATION & START UP

MODEL AEX20

4.4 CONTROLS AND CONTROL PANEL

HOME

Allows you to start the machine and view the current parameters:

MIXING: Displays current mixing time

- Press the  button to start or stop the mixing. (During the mixing, the extrusion cannot be started.)
- Press the  button to enter the mixing setting.

EXTRUSION: Displays current extrusion time

- Press the  button to start or stop the extrusion. (During the extrusion, the mixing cannot be started.)
- Press the  button to enter the extrusion setting.

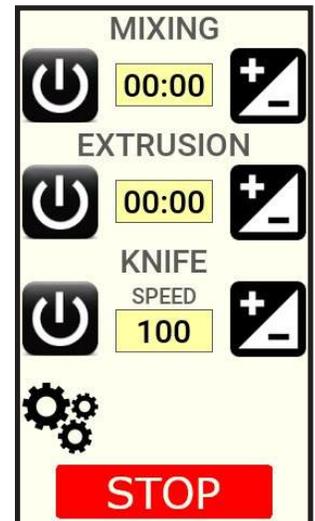
KNIFE: Displays current knife speed (if no cutting time set) or current knife cutting time (if cutting time set)

- Press the  button to start or stop the knife.
- Press the  button to enter the knife setting.

SETTINGS:

- Press  to enter the machine settings.

The  button stops all machine components.



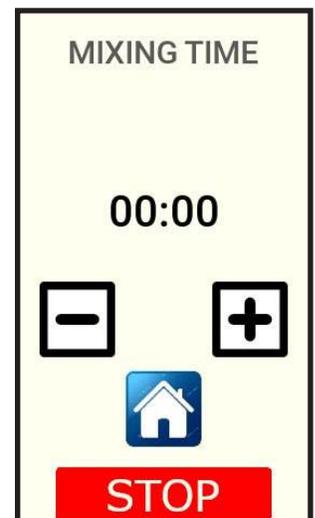
MIXING

TIME: Displayed in minutes and seconds (ex: 6 minutes : 00 seconds)

- To increase or decrease the mixing time utilize the “+” or “-” button.
- If the time is set at 00:00, the machine continues to mixing without stopping and the time goes up indicating how long the mixing is on.

The  button takes you back to the home menu.

- Press the mixing  button to start or stop the mixing. (During the mixing, the extrusion cannot be started.)
- When the selected time is reached, the machine stops mixing and the timer defaults to the set value.
- If the time is set at 00:00, the machine continues to mixing without stopping.





INSTALLATION & START UP

MODEL AEX20

- If mixing is stopped mid cycle, it will pause the timer. When mixing is resumed, the timer will resume from the time it was paused.

The **STOP** button stops all machine components.

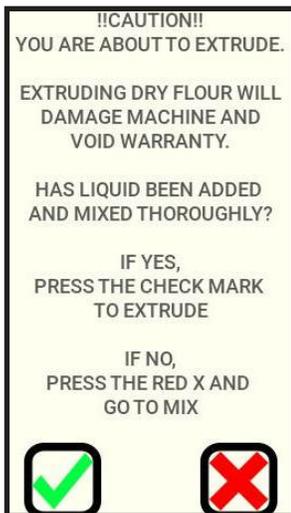
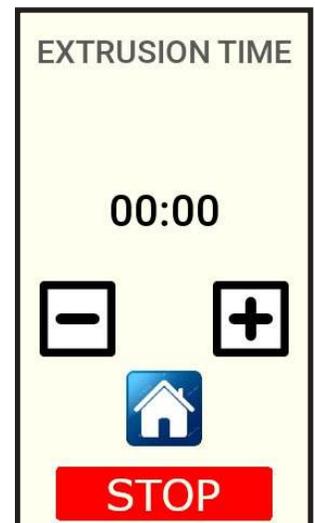
EXTRUSION

TIME: Displayed in minutes and seconds (ex: 6 minutes : 00 seconds)

- To increase or decrease the extrusion time utilize the “+” or “-” button.
- If the time is set at 00:00, the machine continues to extrude without stopping and the time goes up indicating how long the extrusion is on.

The  button takes you back to the home menu.

- Press the extrusion  button to start or stop the extrusion. (During the extrusion, the mixing cannot be started.)
- The Extrusion Confirmation page appears after the extruder  button is pressed to start extrusion.



The confirmation page asks the operator to confirm liquid has been added and thoroughly mixed. Extruding dry flour will damage the machine and void the warranty.

- Pressing the green  will activate extrusion.
- Pressing the red  will return to the home page.

- When the selected time is reached, the machine stops extruding and the timer defaults to the set value.
- If the time is set at 00:00, the machine continues to extrude without stopping.
- If extruding is stopped mid cycle, it will pause the timer. When extruding is resumed, the timer will resume from the time it was paused.

The **STOP** button stops all machine components.



INSTALLATION & START UP

MODEL AEX20

KNIFE

CONTINUOUS ROTATION

When the time value is set to 0.0, the cutter attachment blade will rotate continuously at the selected speed.

SPEED:

- To increase or decrease the knife speed utilize the “+” or “-” button.
- The knife speed can only be adjusted if the time is set to 0.0.
- Faster speed will result in shorter cuts. Slower speed will result in longer cuts.

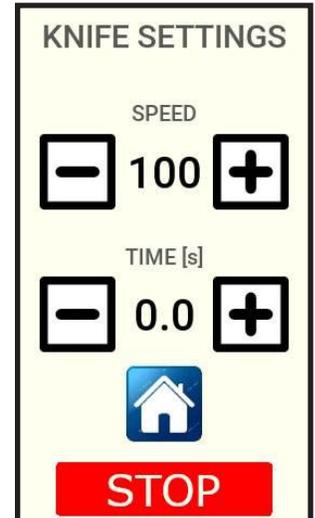
TIME:

- The timer must be set to “0” for continuous rotation.

The  button takes you back to the home menu.

- Press the knife  button to start or stop the knife.

The  button stops all machine components.



TIME (DELAYED) ROTATION

When the time value is set greater than 0.0, the cutter attachment will complete one rotation per timed cycle.

See 5.5 Time (Delayed) Rotation Operation Instructions on page 38.

SPEED:

- While the time mode is active, the knife speed is locked at 100%.

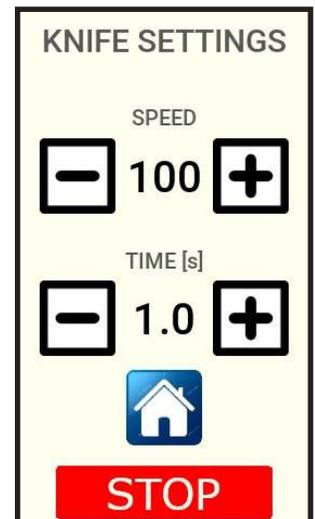
TIME:

- To increase or decrease the knife timed cycle utilize the “+” or “-” button.
- Shorter times will result in shorter cuts. Longer times will result in longer cuts.

The  button allows you to return to the home page.

- Press the knife  button to start or stop the knife.

The  button stops the machine completely.





INSTALLATION & START UP

MODEL AEX20

SETTINGS

BRIGHTNESS:

Press to access the menu to adjust the screen brightness.

SOUND:

Press to access the menu to activate or deactivate the sounds.

SYSTEM:

Press to access the system menu.

LANGUAGE:

Press to access the menu to change languages.

The  button allows you to return to the home page.

BRIGHTNESS

Moving the cursor left or right allows you to adjust the brightness of the screen. 100% is maximum brightness.

The  button confirms the set brightness.

The  button takes you back to the settings page.

The  button allows you to return to the home page.

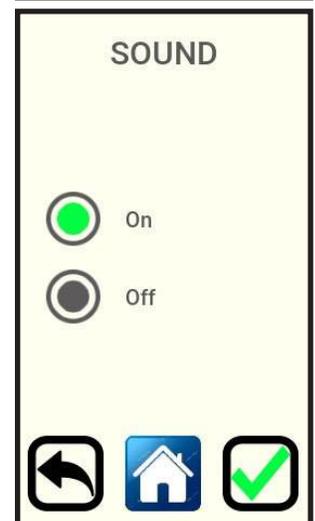
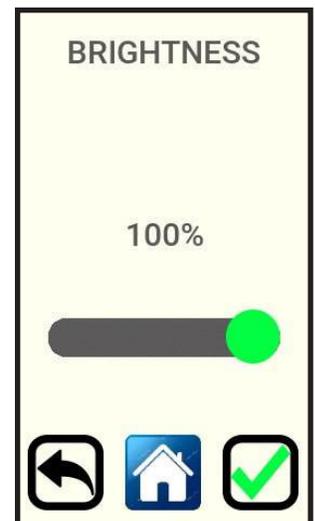
SOUND

By selecting On or Off you can activate and deactivate the sounds.

The  button confirms the set sound.

The  button takes you back to the settings page.

The  button allows you to return to the home page.





INSTALLATION & START UP

MODEL AEX20

LANGUAGE

By pressing on the different flags, the machine's language is changed.

The  button takes you back to the settings page.

The  button allows you to return to the home page.

SYSTEM

INFO:

Takes you to the machine's working hours screen and the current touch screen panel software version.

SENSOR:

Through this menu you can check if the touch screen panel detects whether the lid is open or closed (in case of faults it is possible to check if the sensor is not working and exclude the panel).

SERVICE:

This menu is a password protected. Contact Arcobaleno 717-394-1402.

The  button takes you back to the settings page.

The  button allows you to return to the home page.

INFO

SOFTWARE VERSION:

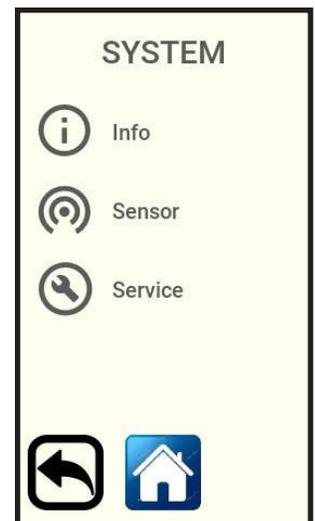
Shows software version.

HOURS OF USE:

The total working hours of the machine in mixing and extrusion.

The  button takes you back to the settings page.

The  button allows you to return to the home page.





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INSTALLATION & START UP

MODEL AEX20

SENSOR

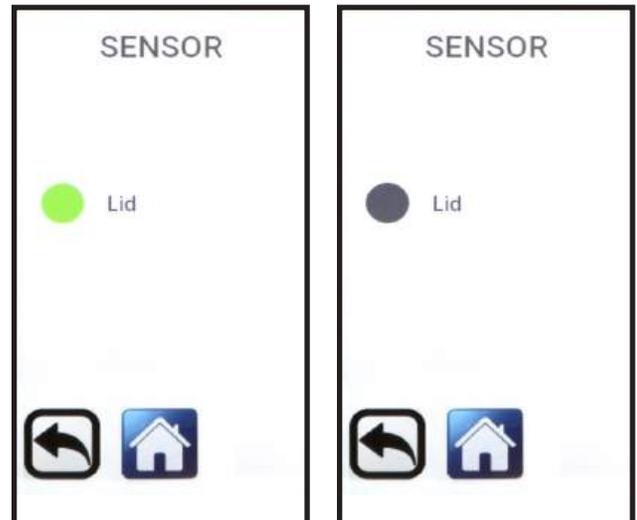
Shows if the touch screen panel detects the lid as being open or closed

Solid Green ● = Lid detected as closed by touchscreen

Solid Grey ● = Lid detected as open by touchscreen

The  button takes you back to the settings page.

The  button allows you to return to the home page.



ALARMS

When the alarm icon is flashing , a safety has been triggered and will prevent all machine functionality. See below table for alarms, causes, and solutions.

NOTE: If resolving the issue does not clear the alert, cycle power. When cycling power, leave machine disconnected for 1 minute. If this does not work contact manufacturer.

ALARMS	CAUSE	SOLUTION
LID OPEN	The safety lid is open. This will cause the machine to stop.*	Close the safety lid.
CODE 01	Alarm occurs when the machine cover is opened.	Close the door of the electric panel with the related key.
CODE 02	Alarm occurs when the machine's engine reaches a temperature that is too high and could cause a breakdown.	When the temperature returns to normal operating values, this alarm disappears.
CODE 03	See next page.	See next page.

***WARNING:** If the machine does not stop when the lid is opened, stop operation and contact the manufacturer IMMEDIATELY. Continued use of the machine can result in serious injury.

ATTENTION: If the alarm, the problems or the actions taken to correct them are not clear or sufficiently explained or in the event of any other problem, contact the manufacturer before restarting the machine, otherwise there can be serious damage to the machine itself or people.



ARCOBALENO®

INSTALLATION & START UP

MODEL AEX20

ALARMS	CAUSE	SOLUTION
CODE 03	Alarm occurs to prevent dry extrusion and prevent machine damage that is not covered under warranty.	<ul style="list-style-type: none"> • <u>Remove the die from the machine immediately</u> and soak in water. • Remove all ingredients from the machine. • Reassemble with a clean pasta die and start a new batch. • After cleaning and reassembling the machine, unplug the machine for 1 minute. • Plug machine in and verify the recipe. The base recipe for AEX20 is 2,500g Semolina flour and 750-825g water. (This recipe is 30-33% hydration.) Running less than 30% hydration will result in CODE 03. <p>If you have any questions, please contact Arcobaleno at 717-394-1402.</p>

Tools needed to remove pasta die:

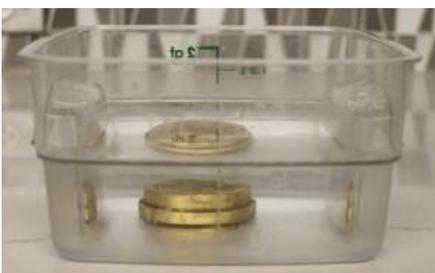
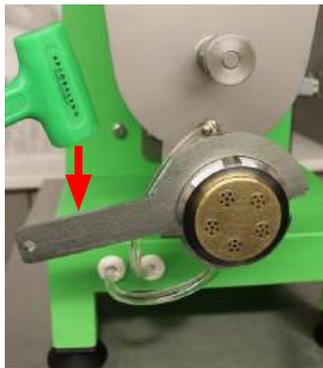


- spanner/die wrench



- hammer

While holding the die wrench firmly, tap the arm of the die wrench with the hammer as shown. Use care when using the hammer to avoid damage to the user or the machine.



Pasta die must be removed immediately and soaked in water!



4.5 CONNECTION TO THE ELECTRIC LINE

The operator is responsible for providing a suitable electric system. The operator should arrange for connection to a proper power source equipped with wires of suitable sizes. The supply source should be suited to the machine and comply with any relevant regulations.

Any electrical equipment of Arcobaleno Pasta Machines, LLC meets the standards CEI-EN 60204, therefore, supply should be within a $\pm 10\%$ range based on the current value and within a $\pm 1\%$ range continuously, as well as within a $\pm 2\%$ range for a brief period of time based on the frequency value.

The electric system should be equipped with an automatic release system, having a differential thermal-magnetic switch, as well as with a ground system able to ensure the minimal parameters requested by regulations. It should also respect specific provisions of the law in force in the machine's installation country.

Prior to performing any connection, verify that the features of the electric line corresponds to any technical information included in the electrical system's diagram and in the Arcobaleno name plate located on the machine.

Any equipment connection to the electric system (when the manufacturer didn't already prearrange for a cable with a EC plug), should be carried out only by qualified and trained staff, directly to the terminal or the master switch through the relevant fairlead.



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SECTION 5

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USE OF THE MACHINE

MODEL AEX20

5.1 CERTIFICATION

Before starting for the first time any operating activity, perform the checks provided for in Section 4

- Supply the electric box
- Activate any circuit by turning on the master switch

5.2 OPERATIVENESS

WARNING: A complete reading of this instruction manual and of any related attachments is necessary prior to starting any operating activity. The warranty according to the working order of the machine within safety conditions and absolute performance according to its expected use, is strictly dependent on the accurate application of this instruction manual and of any related attachments.

Operator

He/she should be a person fit for work and able to attend to any needs regarding the machine operation (see Section 3). He/she should not allow any other person to approach the area when the machine is working and should forbid its use by staff unfamiliar with such activities. He/she should follow any directions provided in this manual in order to achieve maximum performance, minimum wear and tear, and greater security for both himself/herself and others.

WARNING: If machine does not start, make sure the lid is closed. If machine is not functioning properly, don't perform any operations that might compromise the good working order of the whole unit. When in doubt, always request the help of the manufacturer.

✓ ANY VIOLATION OR DAMAGE TO THE EQUIPMENT ON THE PART OF THE USER RELIEVES THE MANUFACTURER FROM ANY LIABILITY AND MAKES THE USER EXCLUSIVELY LIABLE FOR ACCIDENT PREVENTION TO THE COMPETENT AUTHORITY

WARNING: DO NOT remove safety devices before or during machine operation! Doing so may damage machine and users. The manufacturer is NOT LIABLE for any tampering of the machine!

WARNING: It is advisable to read any specific paragraph several times and, if in doubt, to consult the manufacturer indicating the passage whose construction seems unclear.



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USE OF THE MACHINE MODEL AEX20

5.3 ASSEMBLING

PHASE 1 - Auger

Insert the auger into the hopper. Ensure it is fully seated on the driveshaft in the machine.



PHASE 2 - Die Ring and Die

Place the die and die ring face down so that the backs are facing you. Insert the die into the die ring.



Front Of Die Ring & Die

- die ring front is flat/smooth
- die front is flat/smooth



Back Of Die Ring & Die (Face Down)

- die ring back has threads
- die back is uneven/has pockets



Insert face down die into
face down die ring.



Die inserted into die ring.
(Back shown)

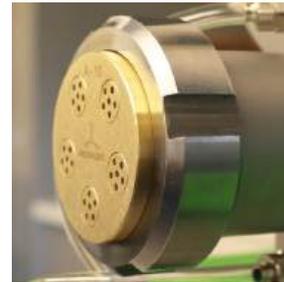
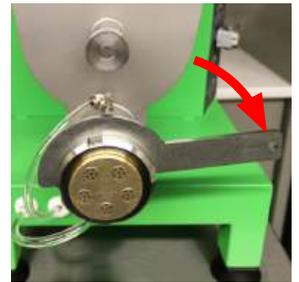
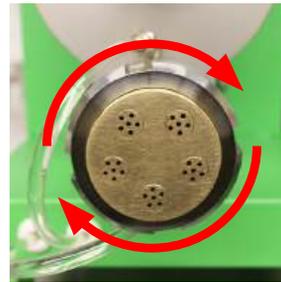
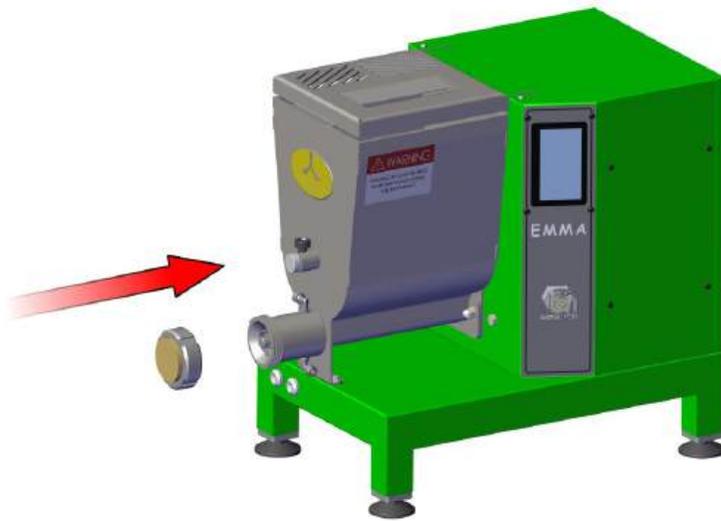


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USE OF THE MACHINE MODEL AEX20

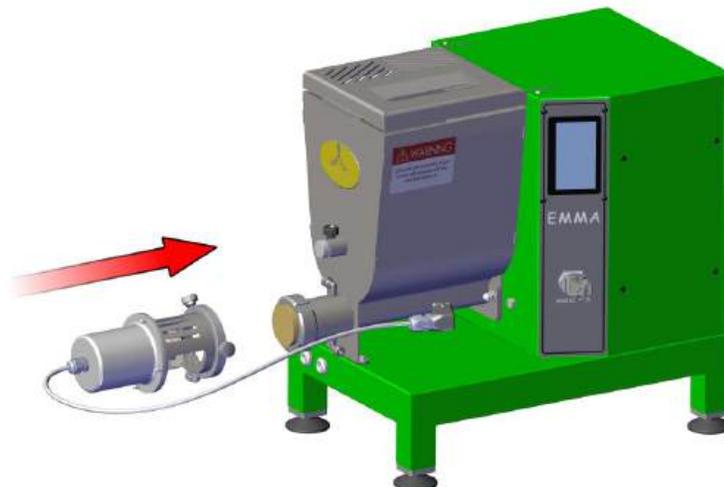
With die inserted in the die ring, thread the back of the die ring onto the extrusion head. The back of the die will not be visible once on the machine. The front of the die will be visible now.

Rotate clockwise to tighten the die ring. Lightly tighten the die ring until it is snug using the die ring wrench. When the die is installed, the front of the die will protrude from the front of the die ring.



PHASE 3 - Cutting Knife

Loosen the knobs and slide the knife onto the die ring. Use the adjustment knobs on the knife to secure it to the die ring. The knife must be plugged into the machine (below the touchscreen) to operate. If you need any help assembling the knife, please call the Arcobaleno Service Team at 717-394-1402





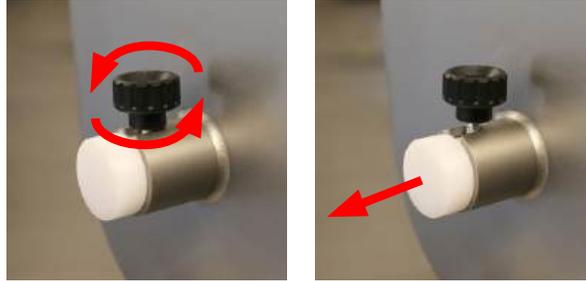
ARCOBALENO®

USE OF THE MACHINE

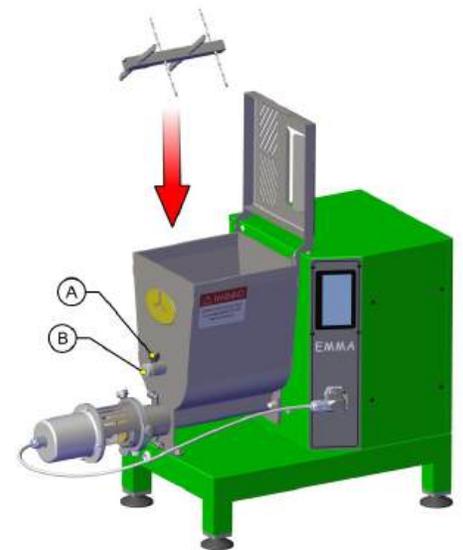
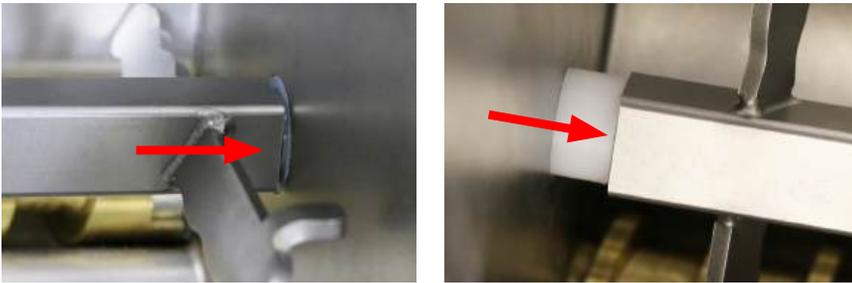
MODEL AEX20

PHASE 4 - Mixing Arm

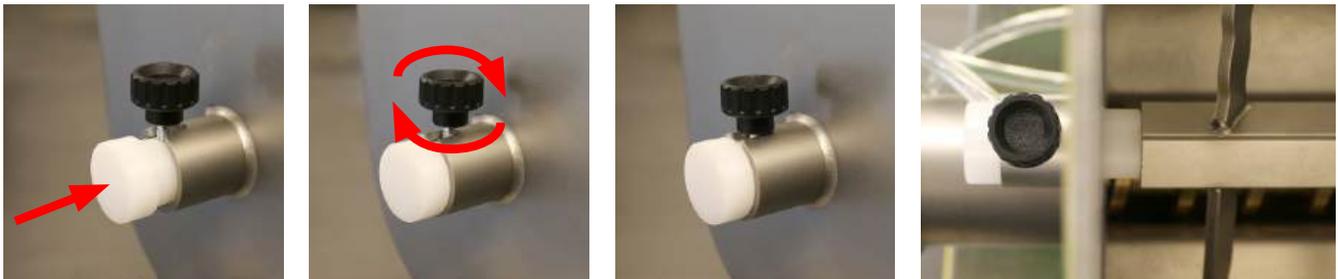
Loosen the knob (A) (rotate counter-clockwise) so that the mixing bushing (B) can be pulled forward.



Insert the mixing arm and ensure it is fully seated on the driveshaft in the machine. Insert the mixing bushing (B) into the front end of the mixing arm so that it supports the front of the mixing arm.



Fully insert the mixing bushing into the front of the machine. It must be fully inserted to properly support the mixing arm. Tighten the knob (A) (rotate clockwise) so that it locks into place.





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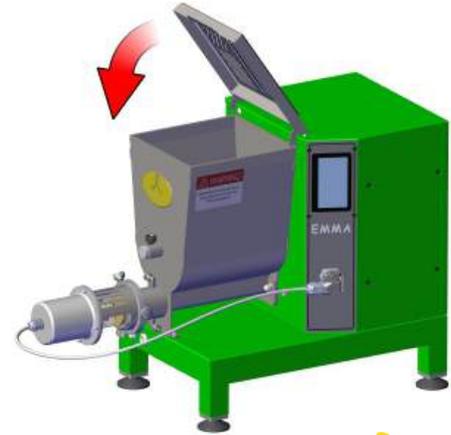
USE OF THE MACHINE MODEL AEX20

PHASE 5 - Lid

Close the lid. The lid must be closed for machine to operate.

Plug the machine in and the screen will turn on. A guide to the touch screen controls can be found in Section 4.4 - CONTROLS AND CONTROL PANEL on Page 23.

If you have any questions regarding assembly or operation please contact Arcobaleno.



RECIPE!

FLOUR+WATER RECIPE FOR AEX20 (30% Hydration)

2,500g of flour
750g of cold water

Additional water (25-50g) may be required.

Recipe may vary based on flour type, eggs, relative humidity, & environment. Please adjust accordingly.

WHOLE EGG RECIPE FOR AEX20 (32% Hydration)

2,500g of flour
8 whole eggs (Approximately 50 grams per egg)*
400 grams of cold water

** Egg size may vary. Please adjust accordingly.*

Eggs + Water must be whisked together before adding to flour.

Note: *The recipe may vary due to relative humidity (RH%) of the flour and kitchen environment. Different flours have different RH%. Please adjust accordingly.*

If your mix is too wet, try holding back some of the liquid (25-50g) to see how the mix is affected.

DIRECTIONS FOR AEX20 RECIPES:

Weigh out flour and liquid required for the batch. If applicable, mix cold water and eggs together with whisk.

Put flour in hopper and set mix time to 4-6 minutes. Turn on mix mode. Slowly add liquid, moving the container back and forth along the opening. Mix for 4-6 minutes.

Stop machine and check consistency of contents, dough should start to clump and form a coarse crumbly flour texture like streusel. If you do not see a coarse crumbly flour texture, drizzle an additional 25-50g of water while in mix mode for 60 seconds.

The consistency of the egg pasta dough should look like small pebble sized dough balls.

Set desired extrusion time. If no time is set, the timer will begin counting up once extrusion is started. Begin to extrude. Never extrude dry flour.

Questions? Please call Arcobaleno at 717-394-1402.

WARNING: If EXTRUDE is pressed instead of MIX, **STOP and remove the die IMMEDIATELY.**

Dry flour will clog the die, cause damage, and void the warranty. See page 29 for more information.



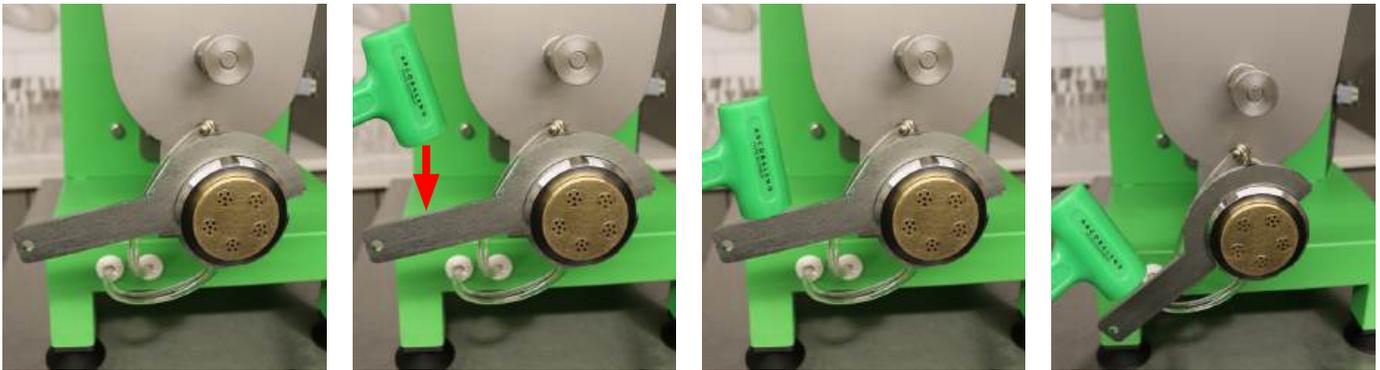
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USE OF THE MACHINE

MODEL AEX20

5.4 DIE CHANGING

- Stop the machine by pressing the proper button.
- Turn off and remove the cutting knife if in use.
- Use caution as the die and die ring may be hot.
- Unscrew the die ring with the provided die ring wrench, remove the die and replace with new die.
- **NOTE:** The supplied hammer can be used to aid in removal of the die ring with the die wrench. While holding the die wrench firmly, tap the arm of the die wrench with the hammer as shown. Use care when using the hammer to avoid damage to the user or the machine.



- **WARNING:** Do not press the mixing start button once die ring is off of machine. Doing so will cause the auger to become stuck.
- **NOTE:** If the die is difficult to remove, press the EXTRUSION start button to run the machine for a few seconds to release pressure from the extrusion neck. Make sure to catch the die so that it is not damaged.
- Secure the new die by screwing the die ring back onto the extrusion neck. The die ring should turn smoothly. If it does not, the die ring holder grooves may have dough that needs to be removed.
- **NOTE:** To remove dough from the die ring, use the stainless steel tool provided in the cleaning kit. If the dough is not removed, it can damage the threads of the extruding head.
- Immerse the used die in water until it is needed again. Failure to do so will cause the dough inside of the die to become like cement.

Lasagna Die:

The lasagna die should be placed into the die ring so that the cutting slot (small pin) is situated at the 12 o'clock or 6 o'clock position. This aids the opening of the pasta tube.



- To get a thin sheet tighten the central screw (clockwise) to desired thickness
- To get a thick sheet loosen the central screw (counter-clockwise) to desired thickness

NOTE: Open the die BEFORE removing from the extruder to allow water flow through the die when submerged after use. To open the die, loosen the central screw (counter-clockwise) and run the machine for a few seconds so that the die is pushed out.

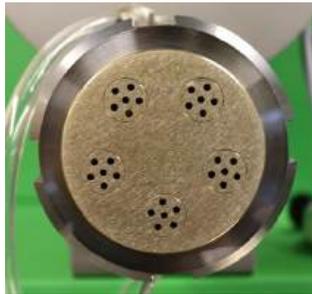


USE OF THE MACHINE MODEL AEX20

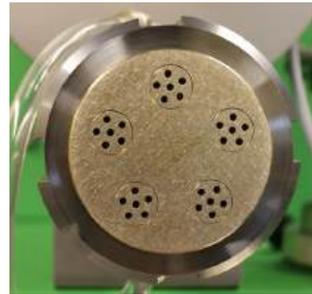
5.5 TIME (DELAYED) ROTATION OPERATION INSTRUCTIONS

Installing The Die

- Secure the selected die to the machine. Align the pasta inserts so that none are at the 12 o'clock position. If an insert is in the 12 o'clock position, the die must be repositioned.



No inserts at 12 o'clock



Insert at 12 o'clock

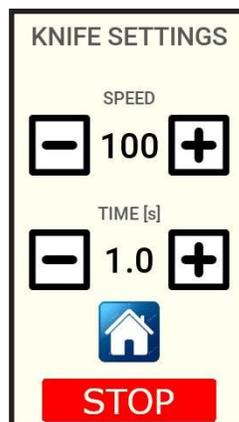


Reset Cutter Knife Home Position

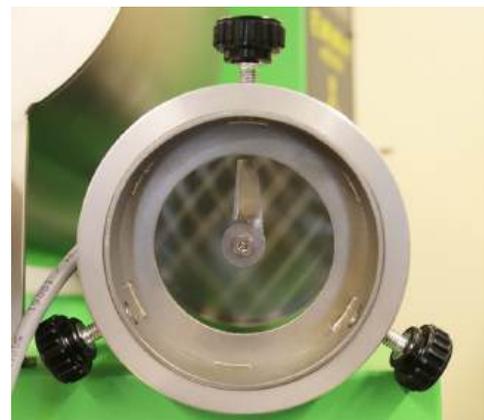
- Set the cutter attachment on the base of the machine.
- Plug in the cutter attachment.
- Navigate to the Knife page.
- Set the Timer value to greater than "0.0". (This will lock the knife speed at 100%.)
- Press the  button to return to the home page.
- Press the  button to activate the knife for one rotation.
- Press the  button to stop the knife.
- The blade is now in the home position (approximately 12 o'clock position).



Cutter attachment set on base of machine.



Timer value set greater than "0"



After one rotation, stop the knife. The blade is now in the home position (approximately 12 o'clock).



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USE OF THE MACHINE

MODEL AEX20

Securing The Cutter Attachment To The Machine

- Secure the cutter attachment to the machine via the three locking knobs.
- Ensure the blade is not obstructing/covering any of the openings in the pasta die.



- If the blade is obstructing any of the openings, loosen the three knobs and realign the cutter attachment.
 - For small misalignments, rotate the cutter attachment left or right to correct the alignment.
 - If the misalignment cannot be corrected by a small rotation of the cutter attachment, remove the cutter attachment. Then reposition the die.
- Once the cutter attachment is secure, press the  button to activate the knife. Observe the blade's rotation. The blade should complete one full rotation per timed cycle, stopping at approximately the 12 o'clock position.
 - If there is any misalignment/obstruction of the opening in the die, readjust accordingly.

If you have any questions, please contact Arcobaleno at 717-394-1402.

TIME (DELAYED) ROTATION

When the time value is set greater than 0.0, the cutter attachment will complete one rotation per timed cycle.

SPEED:

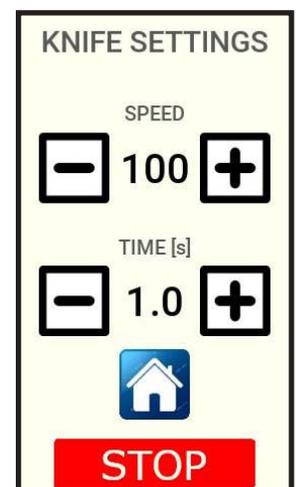
- While the time mode is active, the knife speed is locked at 100%.

TIME:

- To increase or decrease the knife timed cycle utilize the “+” or “-” button.
- Shorter times will result in shorter cuts. Longer times will result in longer cuts.

The  button allows you to return to the home page.

- Press the knife  button to start or stop the knife.



The  button stops the machine completely.

**5.6 DURING USAGE**

Expected use - precautionary standards and measures:

Correct use of the machine allows operators to fully benefit from its performance within complete safety conditions. Such potential is guaranteed only by compliance with the directions provided thereunder, therefore:

ALWAYS follow this manual's directions and instructions and, prior to start up production, verify the integrity of the machine parts.

ALWAYS observe any instructions and possible warnings marked on the machines; any warning sign displayed on the machine should always be readable.

ALWAYS assess the appropriateness of upkeep (cleaning, etc.) both of the machine and its main parts.

ALWAYS verify the suitability and working order of the electrical system; in particular check the connection and make sure there are no insecure or dangerous connections.

ALWAYS work under the best lighting conditions as to the whole installation and, in particular, in the application area.

Before leaving the work area, ALWAYS disconnect the machine's feeding line as necessary.

At any time during inspections, repairs, routine maintenance services of the machine, ALWAYS disconnect the machine and the electric box.

ALWAYS keep the floor clean and dry surrounding the machine.

At any time during operation, ALWAYS wear suitable work clothes (including individual safety devices) subject to work environment safety standards and warning signs displayed on the equipment designed to prevent possible accidents.

ALWAYS report any defect during running (suspected breakage, incorrect movements, excessive noise) to the department head and put the machine out of order by disconnecting the equipment.

Use proper signs to indicate that the machine or the whole production line is out of order.

ALWAYS use the machine in a sheltered area, within a suitable operating environment as specified in this manual.

ALWAYS use original replacement parts.



USE OF THE MACHINE

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In case of servicing of the machine's electric system ALWAYS contact qualified and trained personnel.

In case of doubt as to the real construction of any operating procedures described in this manual, ALWAYS contact the manufacturer; don't perform any actions if the operating procedures seem unclear to you.

ALWAYS disconnect the machine from the power supply before removing or connecting accessories.

5.7 UNAUTHORIZED USE - UNEXPECTED USE - USE NOT RECOMMENDED - EXPECTED AND UNEXPECTED IMPROPER USE

Any machine usage for unauthorized operations, its improper use and lack of service can endanger personnel safety in addition to compromising functionality and security.

The measures provided hereunder, which obviously cannot cover the whole spectrum of improper usage possibilities, represent those more "reasonably" expected and, therefore, should be considered absolutely forbidden:

NEVER use the machine under unexpected environmental conditions.

NEVER use the machine with "temporary" connections, such as temporary cables which are not insulated.

NEVER allow any unfit persons to use the machine.

NEVER use the machine without wearing suitable work clothes (including individual safety devices) subject to work environment safety standards and warning signs displayed on the equipment designed to prevent accidents.

NEVER change any safety devices, remove protection measures and/or damage the equipment.

DO NOT remove safety devices before or during machine operation! Doing so may damage machine and users. The manufacturer is NOT LIABLE for any tampering of the machine!

NEVER leave the machine unattended when already qualified for operating activities.

NEVER use the machine to perform tasks different from the ones for which it was intended.

NEVER change functional and performance features of the machine and/or of its components in order to increase production capacity.

NEVER allow personnel unfamiliar with ongoing operations to approach the area when the machine is working. **41**



USE OF THE MACHINE

MODEL AEX20

NEVER use or service the machine under inadequate or poor lighting/visibility.

NEVER use the machine if the content of this instruction manual was not fully understood.

NEVER carry out any routine maintenance activity, inspections or repairs without first deactivating the machine and the whole production line.

NEVER use any replacement parts not original or not recommended by the manufacturer.

NEVER have the machine serviced by inexperienced staff.

NEVER leave the machine unattended after any service without posting the appropriate warning sign and informing the department head.

5.8 ADJUSTMENTS

To obtain the desired length of the pasta, adjust the knife speed or time. (See Section 4.4)

5.9 STANDSTILL AND EMERGENCY OPERATIONS

To bring the machine to a temporary stop, press the proper button or the STOP button.

To stop the machine in case of emergency, unplug the machine.

If during the work cycle, you open the lid of the tank, the machine stops automatically.

WARNING: If the machine does not stop when the lid is opened, stop operation and contact the manufacturer IMMEDIATELY. Continued use of the machine can result in serious injury.

WARNING: If the machine does not start the first time or does not restart after stop, unplug the machine and wait a few minutes before turning it on again, then try again.

5.10 DEACTIVATION

To deactivate the machine at the end of the work shift, turn off the master switch and make sure that the light of the numbered switches on the control panel goes off.

Deactivate the department feeder line relative to the electric box. Proceed with routine maintenance procedures scheduled to take place daily after the end of production. (See specific paragraph in Section 6.)

WARNING: Whenever necessary, post a sign on the machine indicating any defects and/or adjustments which occurred during its use or usage of the equipment related to the entire production line. Before leaving the work place, please inform the department head about the above.



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MAINTENANCE
MODEL AEX20

SECTION 6

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6.1 GENERAL

The maintenance plan includes routine procedures, that is operations that should be performed daily and don't need any special instruments and/or equipment; and scheduled procedures, that is operations which may involve partial disassembly and removal of safety devices.

For scheduled maintenance procedures contact only competent and experienced department maintenance staff.

WARNING: Prior to carrying out any maintenance procedure make sure that the equipment is disconnected from the power outlet.

6.2 ROUTINE MAINTENANCE

Daily procedures before putting the machine into service:

Carry out a visual inspection by verifying the correct tightening/clamping of any component; perform a test on the idling machine in order to locate any faults/defects, creakings, abnormal noises, etc., and operate as deemed necessary.

WARNING: In case of abnormal conditions or failure of any equipment component first make sure that the instructions provided in the previous paragraphs have been followed correctly.

DON'T ever carry out rush or course repairs which might compromise the good working order of the machine and of any related equipment. Whenever in doubt, request servicing by specialized staff authorized by the manufacturer.

Daily procedures to be carried out once the work shift ends:

Open the lid and proceed with an accurate cleaning of the entire machine. Make sure to remove any product residual. Clean carefully by using the supplied dough scraper, brush, a shop vacuum, and/or cloths dampened with water and vinegar; don't use any type of detergent. NEVER pour water into the hopper. This can cause machine damage or failure. You must use a DAMP cloth or sponge.

6.3 SCHEDULED MAINTENANCE

Procedures carried out semi-annually:

Check the safe tightening/clamping of any element that makes up the equipment by requesting the assistance of skilled and experienced department maintenance personnel. Should any excessive wear and tear or breakage be found proceed with proper replacement.

Procedures carried out annually:

Check the conditions of any electric components and proceed with proper replacement as deemed necessary in case of fault or wear and tear; for any operation contact skilled and experienced maintenance personnel.



6.4 CLEANING

Clean the mixing hopper and the removable parts (auger, mixing arm, die ring) after use.

NEVER use corrosive or flammable cleaning products that contain substances harmful to human health. DO NOT clean the AEX20 Pasta Extruder with sodium hypochlorite based solutions or abrasive cleaners since this could damage the unit.

Cleaning the machine and individual parts:

1. Before cleaning the machine, turn the machine off and disconnect the power supply.
2. Open the lid.
3. Clean the hopper using the supplied dough scraper, brush, and/or a shop vacuum to remove flour and dough deposits. The hopper and lid can be cleaned using a damp cloth or sponge with water and disinfectant. The cloth or sponge being used must be wrung out before being used to clean the machine. **Never pour water into the hopper.**
4. Do not leave dough deposits attached to the side of the extrusion hopper. This could affect the next batch of dough.
5. Remove and clean the mixing arm, auger, and die ring. These can be washed in a sink with water and mild detergent that is “food safe”. Rinse and dry thoroughly.
6. Once cleaning is complete, reassemble the parts into the machine.
7. Accurately clean the work surface and all surrounding areas.
8. Clean external appliance surfaces with a damp cloth or sponge.

WARNING: DO NOT POUR WATER INTO THE HOPPER. Pouring water into the hopper can cause machine damage or failure. You must use a DAMP cloth or sponge. The cloth or sponge being used must be wrung out before being used to clean the machine.

To clean pasta dies, see instructions on next page.

CLEANING TOOLKIT INCLUDED

Toolkit bag, dough scraper, cleaning pick, brush, die wrench, and hammer (to aid in removal of die ring with die wrench)





Die Cleaning:

After extruding pasta, remove die and gently clean the back of the die with wooden skewer. Wash off any exterior dough. Remove as much external dough as possible.

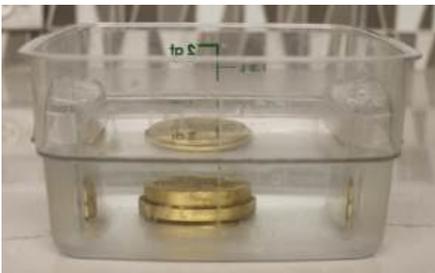
Never use metal tools with pointed ends- that will damage the dies. Picking and poking at brass dies with brushes and scrubbies is also a bad idea. It can etch and scratch the dies and this will adversely affect the extruded pasta.

After removing external dough, soak the die in water until the next use. Store extruding dies in individual labeled storage containers. Cover the die with approved food safe sanitizer and water to the proper dilution.

Soaking the used dies in water keeps the dough stuck in the nooks and crannies soft, so that the next time you use one the new dough pushes out the old. Discard the old dough and then keep going. This method won't affect the new batch of pasta or damage the die in any way.

When the die is being used again, rinse thoroughly with warm water. Place die into die ring and thread onto machine. Extrude pasta, discarding the first 6-12 inches of dough.

As you store the dies you certainly want to change the water as it turns cloudy and keep them in a relatively cool spot, but overall maintenance is simple – Just soak and go.



Dies can also be cleaned with a power washer/a strong jet of water. Dies can also be boiled in a pot of water. This will help to soften any dough trapped inside.

TO CLEAN LASAGNA DIE:

Open the die BEFORE removing from the extruder to allow water flow through the die when submerged after use. To open the die, loosen the central screw (counter-clockwise) with the supplied wrench and run the machine for a few seconds so that the die is pushed out.



The lasagna die can be submerged like other dies. Do not submerge the supplied wrench.



Lasagna Die with Wrench



ARCOBALENO®

**SCRAPPING & DISPOSAL,
SPARE PARTS DIAGRAM**
MODEL AEX20

SECTION 7

SCRAPPING AND DISPOSAL48
SPARE PARTS 49



ARCOBALENO®

SCRAPPING & DISPOSAL, SPARE PARTS DIAGRAM

MODEL AEX20

7.1 SCRAPPING AND DISPOSAL

Should the machine be scrapped, you need to arrange for disposal of its parts by taking into consideration their different nature. For the above purpose, it may be advisable to contact companies specialized in this field which, in any case, abide by the law in force in the machine installation country as to disposal of solid industrial wastes.

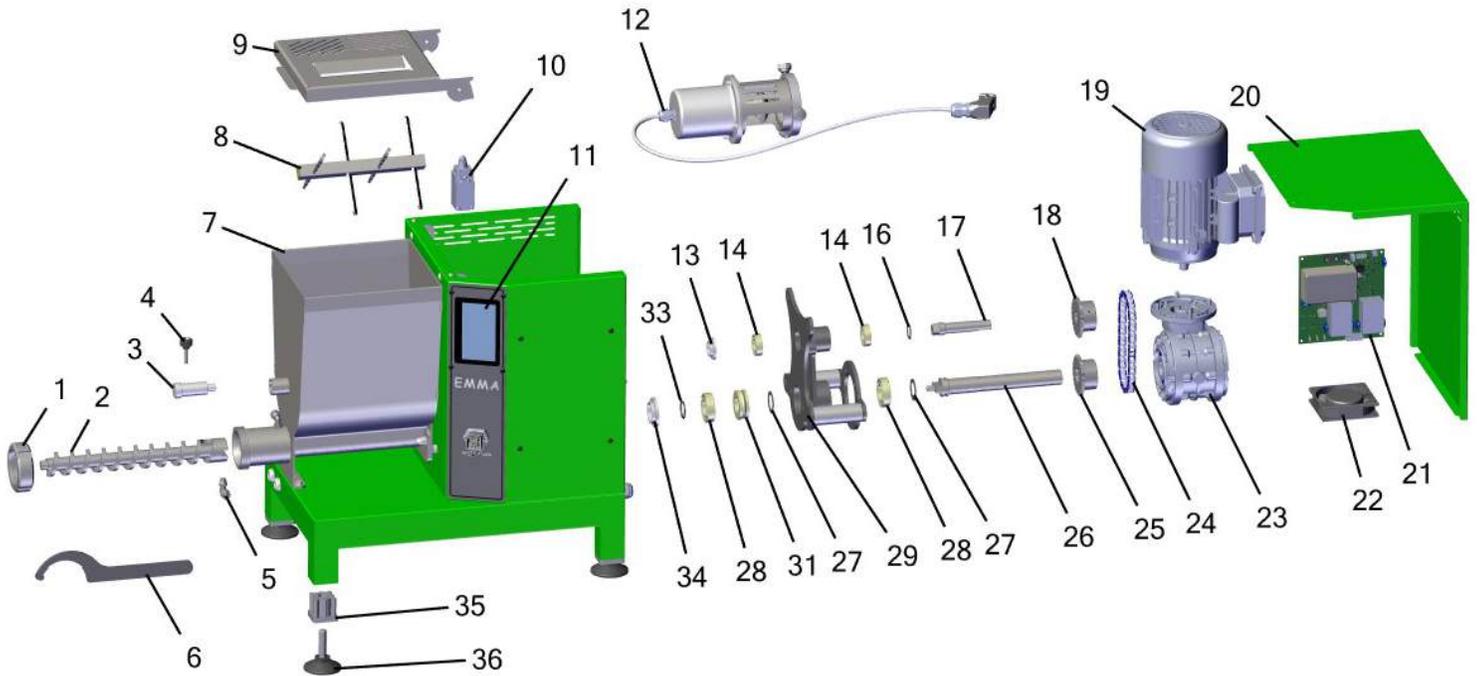
WARNING: Don't drop the machine in very busy areas as it might endanger persons lives, minors and animals in particular; the owner of the machine shall be held responsible for any claims arising in connection with the above.



**SCRAPPING & DISPOSAL,
SPARE PARTS DIAGRAM
MODEL AEX20**

7.2 SPARE PARTS

TABLE 1



BOM ID	Description	Part Number
1	Die Ring	APA28M00064
2	Auger	APA28M00102
3	Mixing Arm Bushing	APA28M00106
4	Mixing Arm Knob	ACAEL000089
5	Water Hose Fitting	ACPRA000056
6	Die Wrench	APA28C00071
7	Hopper	APA28A00097
8	Mixing Arm	APA28A00099
9	Lid	APA28C00103
10	Lid Safety	ACYBM000019
11	Touchscreen	APA28X00076
12	Cutting Knife Assembly	APA28A00004

BOM ID	Description	Part Number
13	Mixer Shaft Seal	APA28M00046
14	Bearing	ACACU000008
16	Mixer Spacer	APA28C00044
17	Mixer Driveshaft	APA28M00041
18	Auger Gear	ACAPG000030
19	Motor	ACYAT000203
20	Rear Cover	APA28C00008
21	Main Electric Board	APA28X00075
22	Cooling Fan	ACYAT000001
23	Gearbox	ACARI000166
24	Roller Chain	APA28A00092
25	Mixer Gear	ACAPG000031

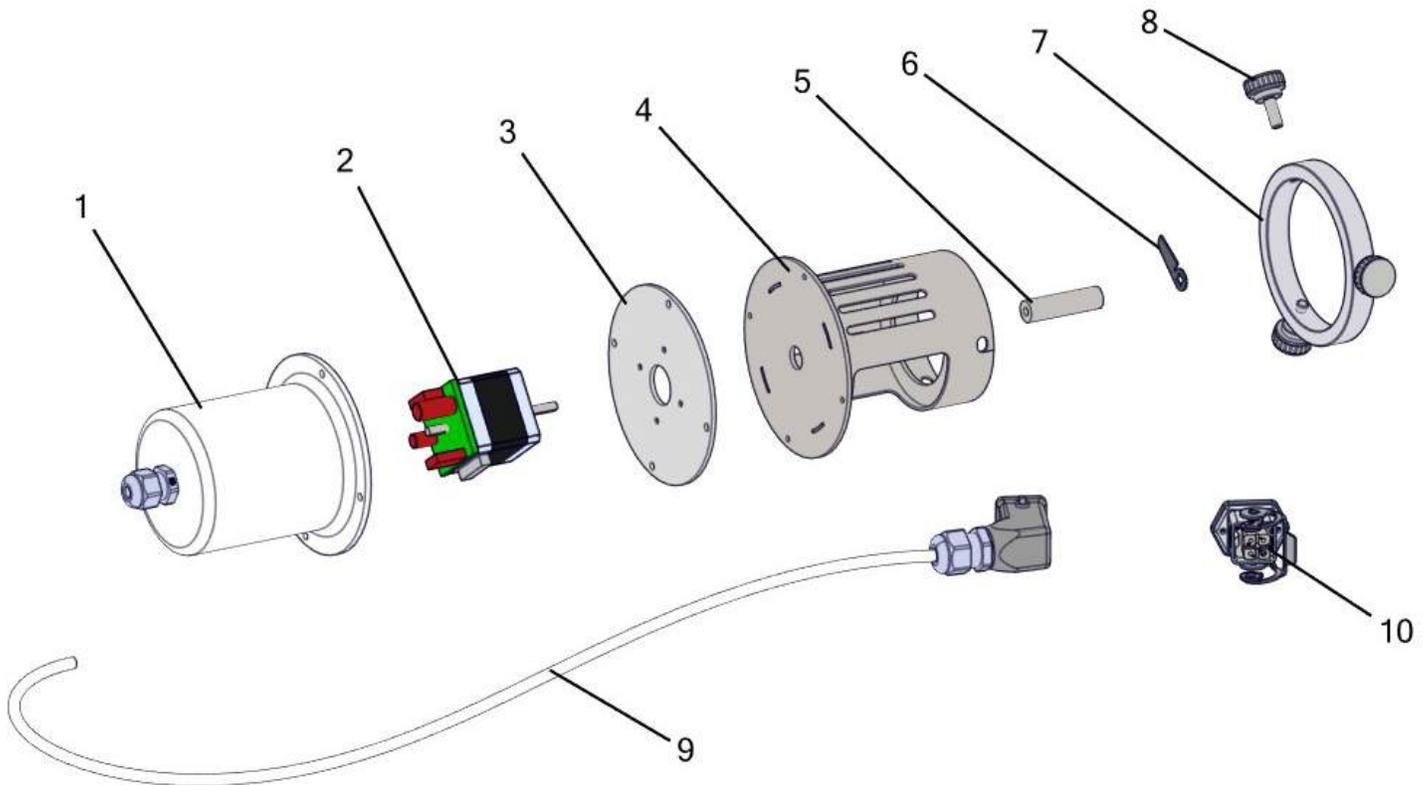
BOM ID	Description	Part Number
26	Auger Driveshaft	APA28M00070
27	Auger Spacer	APA28C00040
28	Bearing	ACACU000007
29	Bearing Plate	APA28A00068
31	Thrust Bearing	ACARS000002
33	O-Ring for Auger Seal	ACAOR000049
34	Auger Shaft Seal	APA28M00045
35	Foot Insert	ACAEL000037
36	Foot	ACAEL000083



**SCRAPPING & DISPOSAL,
SPARE PARTS DIAGRAM**
MODEL AEX20

7.2 SPARE PARTS

TABLE 1



BOM ID	Description	Part Number
1	Cutting Knife Cover	ASP30000020
2	Cutter Motor	ACYAT000204
3	Cutter Motor Fixture Plate	APA28C00021
4	Cutting Knife Frame	APA28A00009

BOM ID	Description	Part Number
5	Cutting Knife Shaft	APA28M00089
6	Cutting Knife Blade	APA28C00024
7	Cutting Knife Collar	APA28M00025
8	Cutting Knife Knob	ACAEL000081

BOM ID	Description	Part Number
9	Cutting Knife Cord and Plug	APA25A00020
10	Cutting Knife Outlet	ACYBM000077