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**INSTRUCTION MANUAL**

**PIZZA XPRESS**

**COMBINATION DOUGH DIVIDER/ROUNDER CDR23 & CDR11  
DOUGH ROUNDER DR42  
DOUGH DIVIDER DD23**

**PATENTED**

**CE - NSF - UL APPROVED**

**MAKES DOUGH PORTIONS AND ROUNDS THEM**

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*Persons under age 18 are not permitted to operate or have accessibility to operate this equipment per U.S. Dept. of Labor Employment Standards Administration Fact Sheet No. ESA91-3.*

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## **DOUGH DIVIDER/ROUNDER CDR 25**

### **DOUGH ROUNDER DR42**

#### **CAUTION:**

This machine is basically the same as the CDR11 which handles dough portions from 2 oz. to 11 oz.

Only the following modifications are applied:

- the adjustable head is replaced by a fixed opening head.
- the motor is two-speed: speed 1 is for small portions; speed 2 is for bigger portions.
- a dough support is added.
- the small dough rounder is replaced by the large dough rounder DR42.

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A)

## 1. EMPLOYMENT OF THE MACHINE

The Dough Divider/Rounder CDR25 has been designed and manufactured to make dough portions and to round them (at room temperature).

**Warning: Do not introduce into the machine frozen, half-frozen dough, or other products which are not foreseen in these instructions.**

## 2. WORKING PLACES

The machine has to be placed on a horizontal working plane as indicated on Drawing 1, page 7, and be used by a single person.

## 3. STARTING UP

3.1 The machine is provided with three single-phase motors and a NEMA plug.

Before connecting the machine, be sure that the voltage and the frequency correspond to those indicated on the machine data plate, and that the intake is grounded and properly protected from overloading.

3.2 Once the machine is installed, be sure that the Cover A (Drawing 1, Page 7), and the Side Chute R (Drawing 1, Page 7) are correctly placed and are working properly.

3.3 Be sure that the rounder is correctly placed under the dough divider, otherwise the machine cannot start.

3.4 Furthermore, be sure that the Moveable Doors B-C (Drawing 1) are also closed, otherwise the machine cannot start.

3.5 Before working with the dough, start the machine without dough in order to check that everything is in order.

3.6 To start the dough divider:

3.6.1 Turn on Switch D (Drawing 3, Page 9) to give current to the electrical circuits.

3.6.2 Push on the Button F (Drawing 3, Page 9), and the machine will start working.

3.6.3 Once the machine has finished to work, or once you have finished trying it, turn the Switch D (Drawing 3, Page 9) on position O.

3.6.4 The Red Alarm Push Button U (Drawing 2, Page 8) stops the machine. It will then remain blocked; to unlock it you just need to turn it counterclockwise.

3.7 To start the dough rounder:

3.7.1 Start the machine with the Switch T on position 1 (Drawing 2, Page 8).

3.7.2 Once the machine has finished to work, or once you have finished trying it, place the Switch T on position O (Drawing 2, Page 8).

3.7.3 The Red Alarm Push Button G (Drawing 3, Page 9) stops the machine. It will then remain blocked; to unblock it you just need to turn it counterclockwise.

## 4. USE AND REGULATION

4.1 For portions weights, hourly production, volume of the dough container, see back of the brochure.

**Attention:** The data regarding PORTIONS WEIGHTS-CAPACITY-HOURLY PRODUCTION are purely indicative since the doughs vary from each other according to the ingredients (quantity of water contained, of yeast, type of dough, etc.).

4.2 The dough has to be prepared first in a dough mixer.

4.3 Once the dough is ready, you can introduce it immediately into the container of the dough divider.

4.4 Before beginning to regulate the dough weight, be sure that the Cut Control Lever (Item 1, Drawing 6) is correctly placed in front of the hole from which the dough comes out, and that the Opening Hole Control Lever (Item 5, Drawing 6) is properly placed in the Flange (Item 6, Drawing 6).

4.5 With the fixed cone, you just have to regulate the distance between the cone and the feeler, while with the adjustable cone you begin to regulate the dough weight with the Cut Control Lever L (Drawing 3, Page 9) in a middle position, and then open and close slowly the exit dough hole with Handle M (Drawing 3, Page 9).

**Remember** that the more you open the exit dough hole the heavier the portion gets, and the more you push away the Cut Control Lever L (Drawing 3, Page 9) from the exit dough hole the heavier the portion gets.

4.6 For a better use of the machine, the distance between the exit dough hole and the Cut Control Lever (Item 1, Drawing 6) should be equal to the diameter of the exit dough hole with the adjustable cone.

4.7 The dough rounder does not need any peculiar regulation. Indeed, it can work with portions from 2.5 oz. up to 23 oz. without any change of accessories.

## 5. TRANSPORTATION

The machine is packed into a cardboard box and put on a wooden pallet. Each cardboard box contains a complete machine. Due to its weight, the machine can be extracted out of its packing tearing this down taking care not to damage the cover and movable parts. For weights and sizes of the package, see the attached spec sheet.

## 6. INSTALLATION

6.1 Place the machine far from any heat sources. The temperature around the machine should never be higher than 131°F.

6.2 Take care of leaving sufficient space near the motor ventilation openings so that they might function properly.

## 7. ASSEMBLING

7.1 The dough rounder/dough divider is packed ready to be used.

**Warning: Check the fixing of the Chute R.**

## 8. DISASSEMBLING AND CLEANING

All removable parts can be washed with water and liquid detergent for dishes. As far as the housing is concerned, we remind you not to clean it with neither sodium hypochlorite-based solutions nor with abrasive detergents since they could damage the external parts of the machine.

### **DOUGH DIVIDER:**

**8.1 Stop the machine and turn off the Switch D (Drawing 3, Page 9) and unplug the machine.**

8.2 Anterior cleaning:

8.2.1 Open the Front Door C (Drawing 1, Page 7).

8.2.2 Slip off upwards the Cut Control Lever A.

8.2.3 Turn towards the hopper the Lever (Item 5, Drawing 6).

8.2.4 Unscrew the two Knobs (Item 4, Drawing 6) to free the removable adjustable or Fixed Cone (Item 1, Drawing 7).

8.2.5 Turn slowly (counterclockwise) the removable adjustable or Fixed Cone and take it out of its place.

8.3 Cleaning of the removable adjustable or Fixed Cone (Item 1, Drawing 7):

8.3.1 Unscrew the two Knobs (Item 2, Drawing 7) and open the whole device.

8.3.2 Before reassembling everything, remove possible dough remains from the slot areas.

8.3.3 Reassemble everything proceeding in the opposite way from the disassembling one.

8.4 Cleaning of the spiral:

8.4.1 Remove the Cover A (Item 7, Drawing 4).

8.4.2 Unscrew the Handle (Item 2, Drawing 4) which is place at the back of the machine.

8.4.3 Take out the Central Section Bar (Item 15, Drawing 4).

8.4.4 Take out the Spiral A (Drawing 4).

8.4.5 Clean everything and before reassembling, remove possible dough remains from the slot areas. Reassemble the Spiral A (Drawing 4) fitting it at the two pins; replace the Central Bar (Item 15, Drawing 4) **and be sure that it is correctly fitted in the suitable groove of the Reducer Bridge** (Drawing 4), and fix with the Back Knob (Item 2, Drawing 4).

8.5 Cleaning of the dough container:

8.5.1 Clean and remove all possible remains of dough or flour.

8.6 Cleaning of the funnel:

8.6.1 Unscrew the knobs counterclockwise, so that you might unblock the Funnel B (Drawing 6).

### **DOUGH ROUNDER**

**8.7 Stop the machine with the Switch T (Drawing 2) on position O and unplug the machine.**

8.8 Pull the machine towards the operator in the direction indicated by the arrow in order to take out the Cone Trunk V (Drawing 2, Page 8)

8.9 Unscrew the Knobs P (Drawing 2, Page 8) and take out the movable Cone Trunk V by its handle.

8.10 The part V and the container Z may be cleaned with a wet cloth with water and food sanitizer.

8.11 Always remember to reassemble everything in the opposite way of disassembling one.

Always remember to try the machine without dough after each cleaning.

## 9. MAINTENANCE AND REPAIR

### 9.1 Maintenance:

To keep the machine well functioning, you just need to clean daily all dough and flour remainings. For the disassembling, see Point 8, Page 5. The machine does not need any peculiar lubrications.

**Warning: Do not wash the machine with water jets for safe working.**

### 9.2 Repairs:

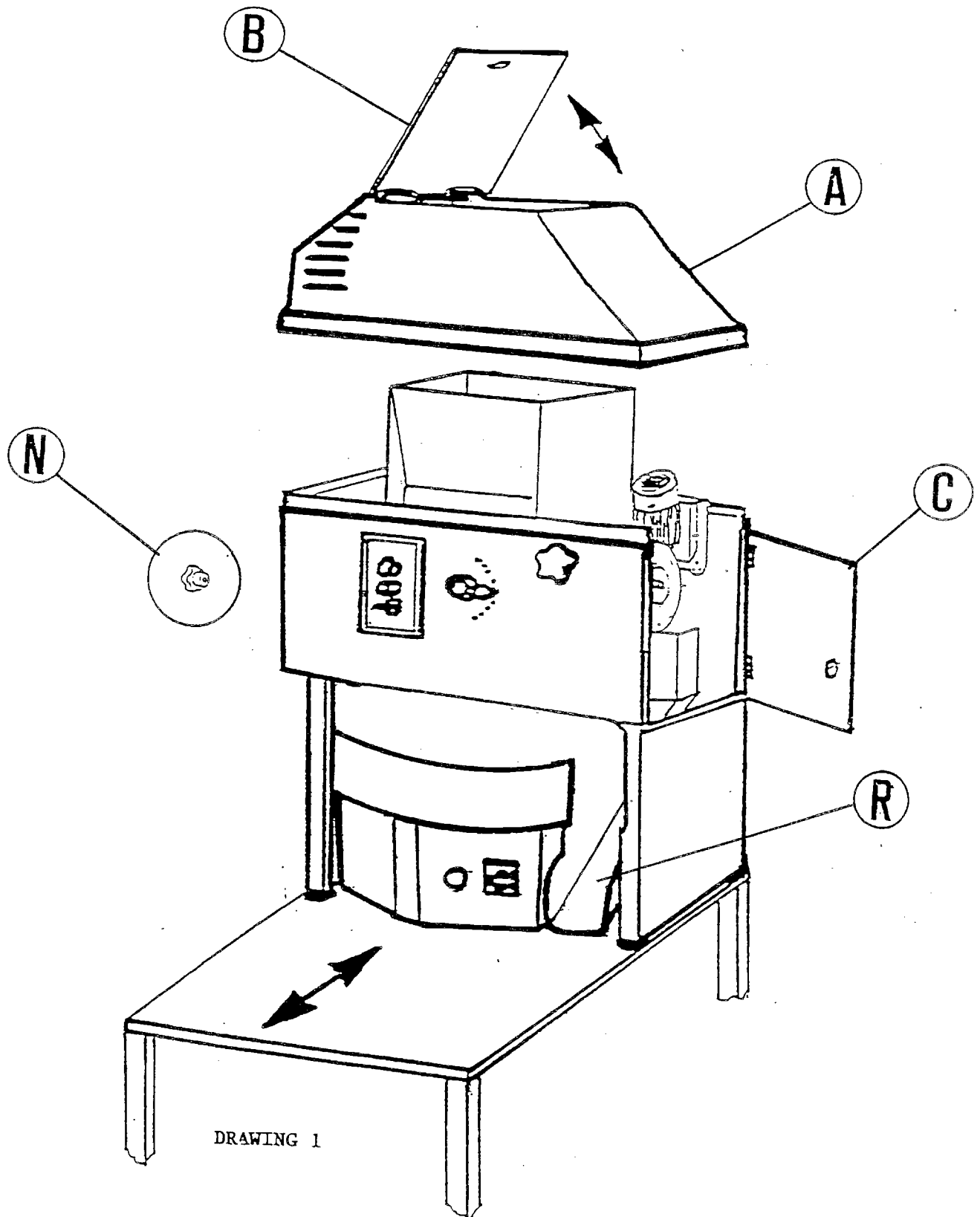
For repairs, controls, or replacement of damaged parts, we suggest you apply to the retailer or directly to the manufacturer, or to replace the damaged parts with equivalent materials especially as far as safety is concerned:

- electrical cable with plug (2 phases and ground)
- switch (Push Buttons)

Before any mechanical or electrical maintenance, it is compulsory to switch the machine off and to pull out the plug.

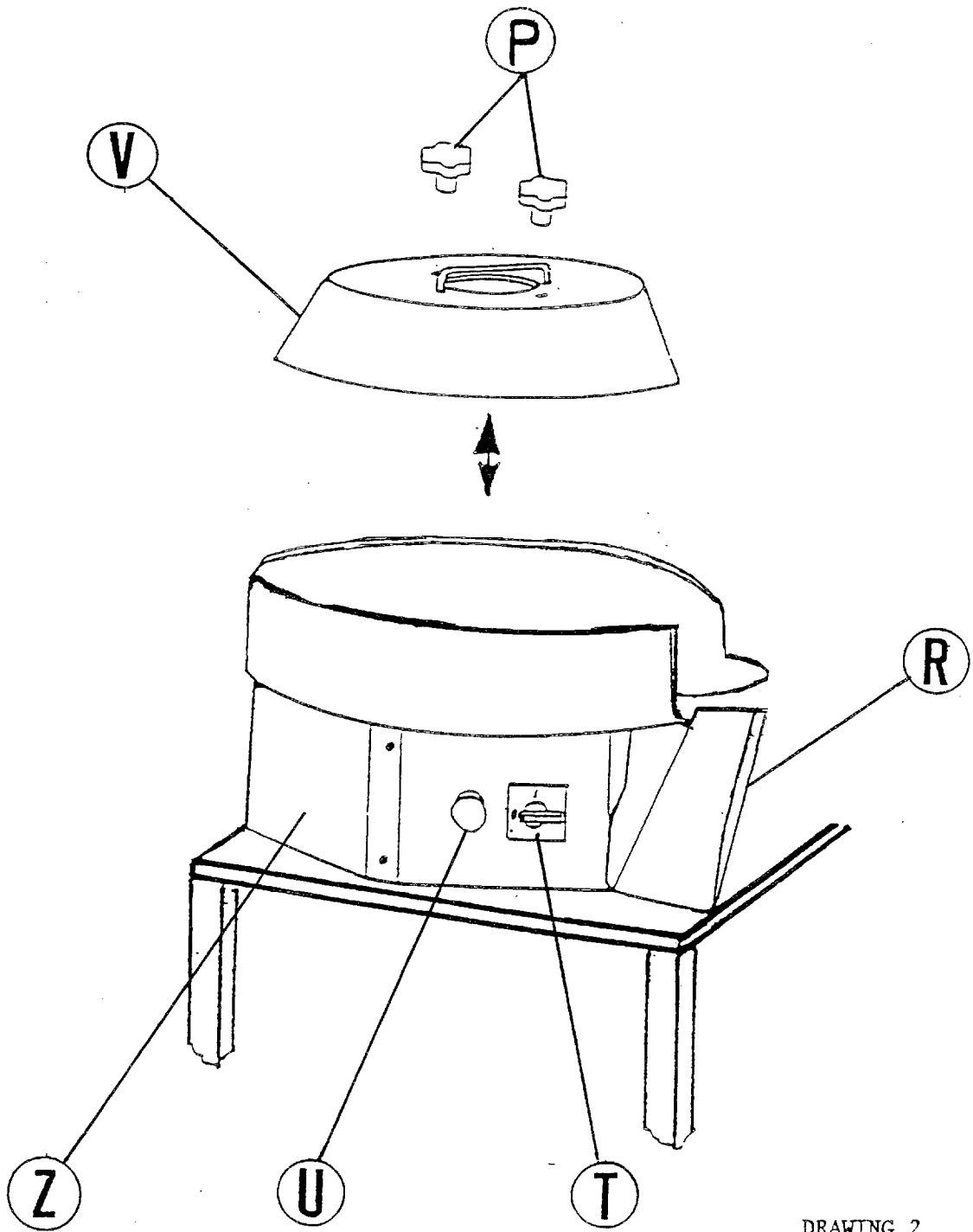
**Warning: The repairs are to be carried out by qualified people. Periodically check the good conditions of the machine, of the cover and doors, of the emergency button, and of the cable and plug.**

**B) ELECTRICAL SCHEME** (See Drawing 9, Page 14; Drawing 10, Page 15; Drawing 11, Page 16).

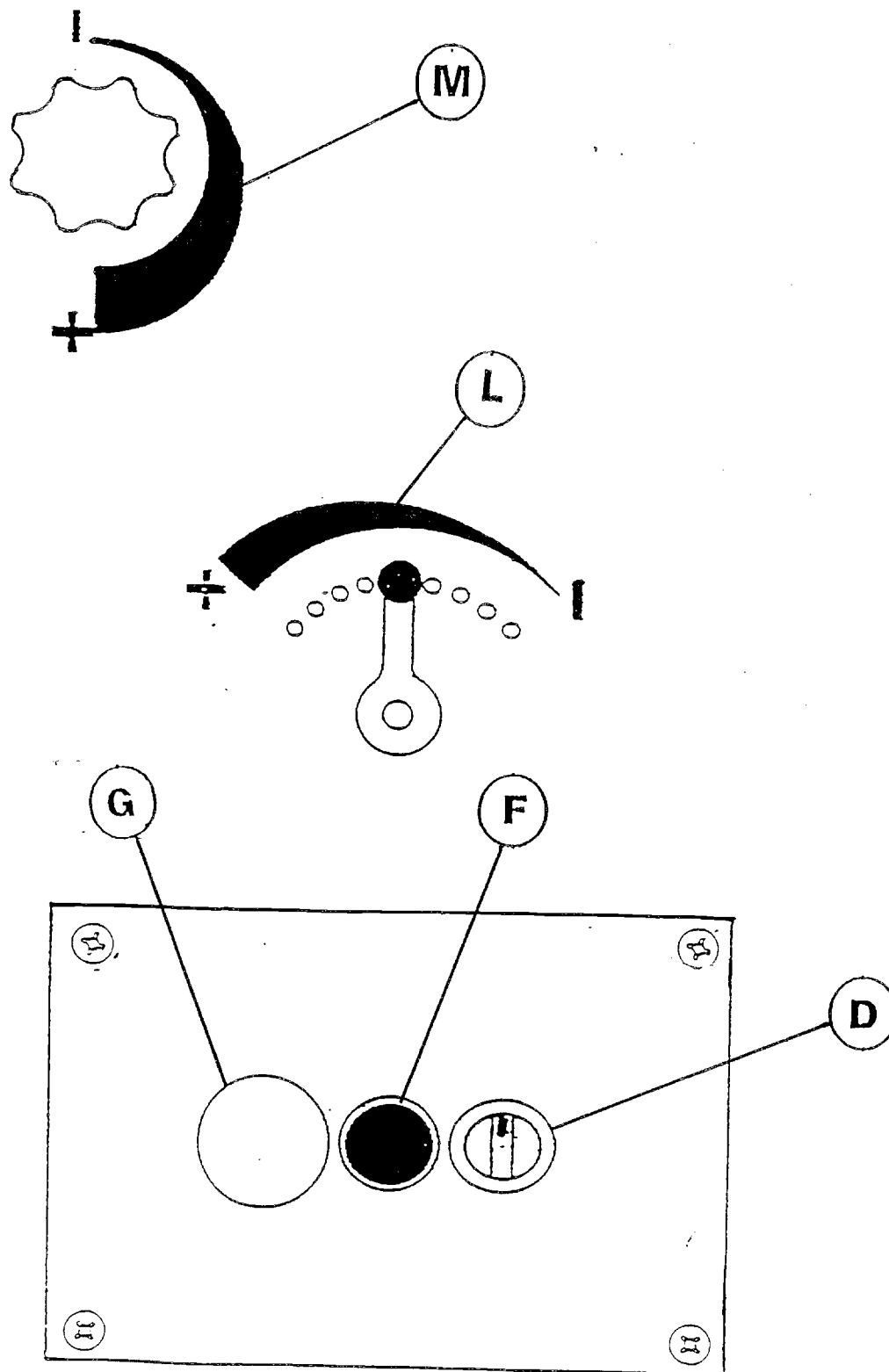


DRAWING 1





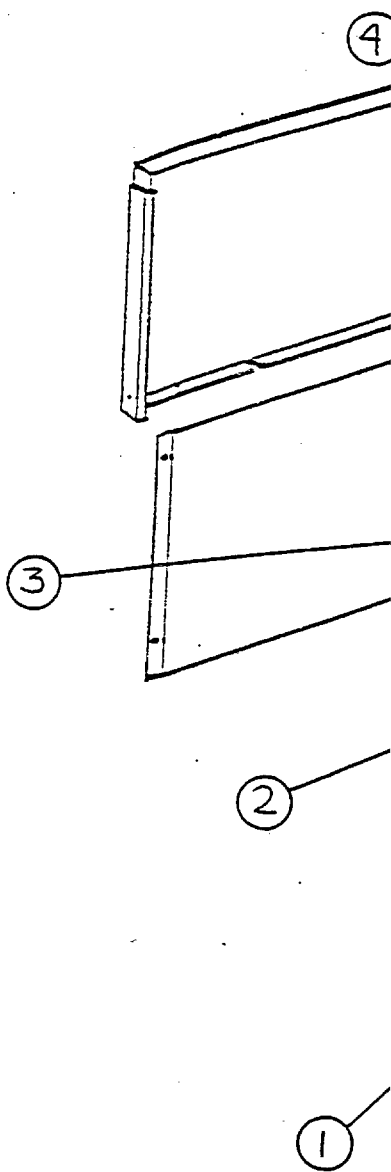
DRAWING 2



DRAWING 3

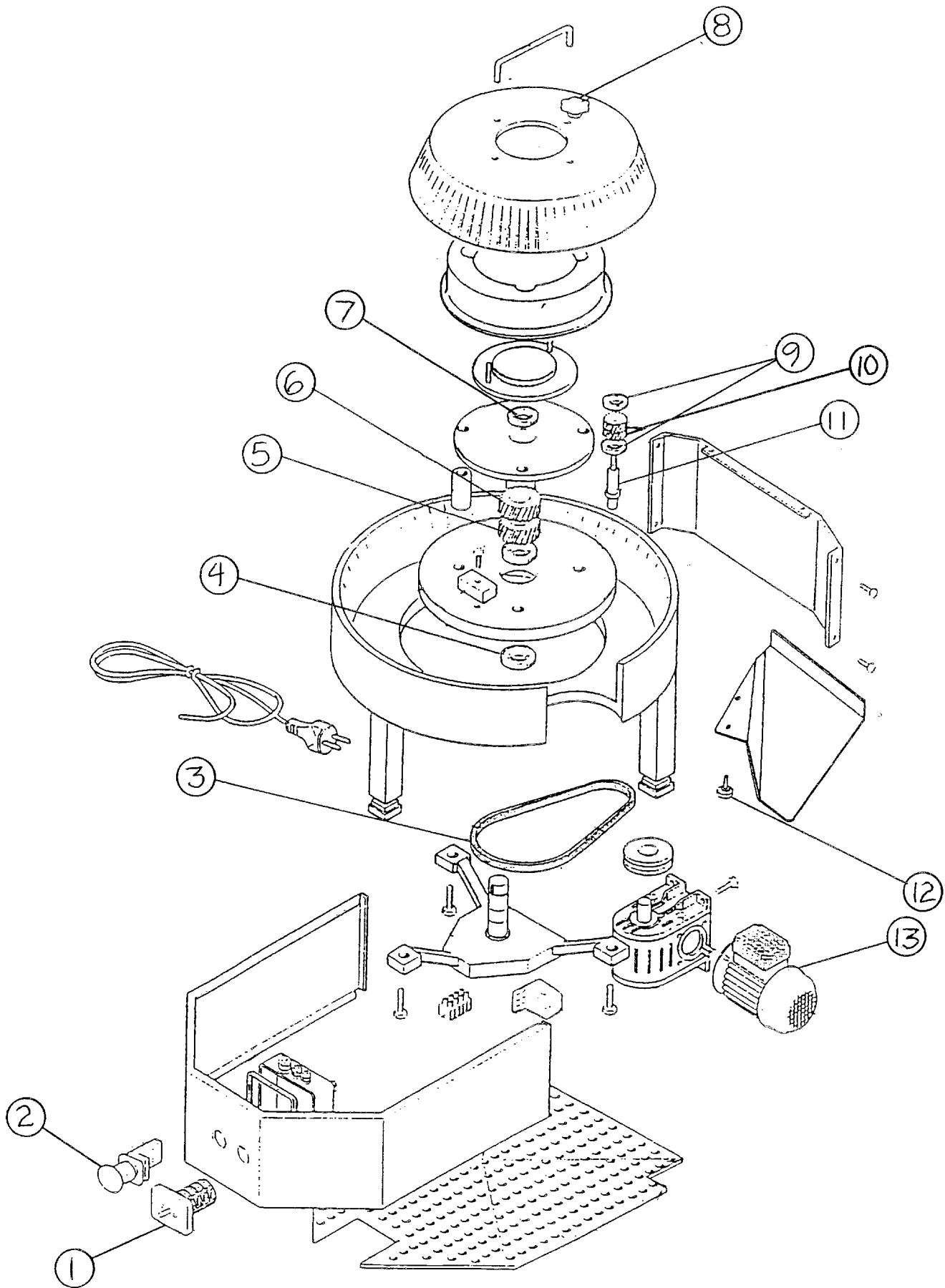
**DOUGH DIVIDER  
DRAWING 4**

<b>Illus.</b>	<b>Part No.</b>	<b>Description</b>
1	3110302	Flanged Bushing
2	6509153	Knob
3	3110304	Reducer
4	3110306	Motor
5	3110308	Circuit Board with Box
6	3110310	Door, Front
7	3110312	Door, Dough Container
8	3110314	Cover
9	3110316	Magnetic Detector
10	3110318	Microswitch
11	3110320	Pulley, Knife
12	3110322	Shaped Knife
13	3110324	Bushing, Knife
14	3110326	Knife Reducer
15	3110328	Central Shaft Assembly
16	3110330	Collar, Bronze
17	3110332	Feeler
18	3110334	Microswitch, Feeler
19	3110336	Moveable Lever
20	3110338	Hole Regulator
21	3110340	Pin, Regulation Lever
22	3110342	Knob
23	3110344	Knob, Feeler
24	3110346	Guide Bushing
25	3110348	Gear
26	3110350	Feeler Support
27	3110352	Micro Start Shaft
28	3110354	Rack Support
29	3110356	Rod



**DOUGH ROUNDER  
DRAWING 5**

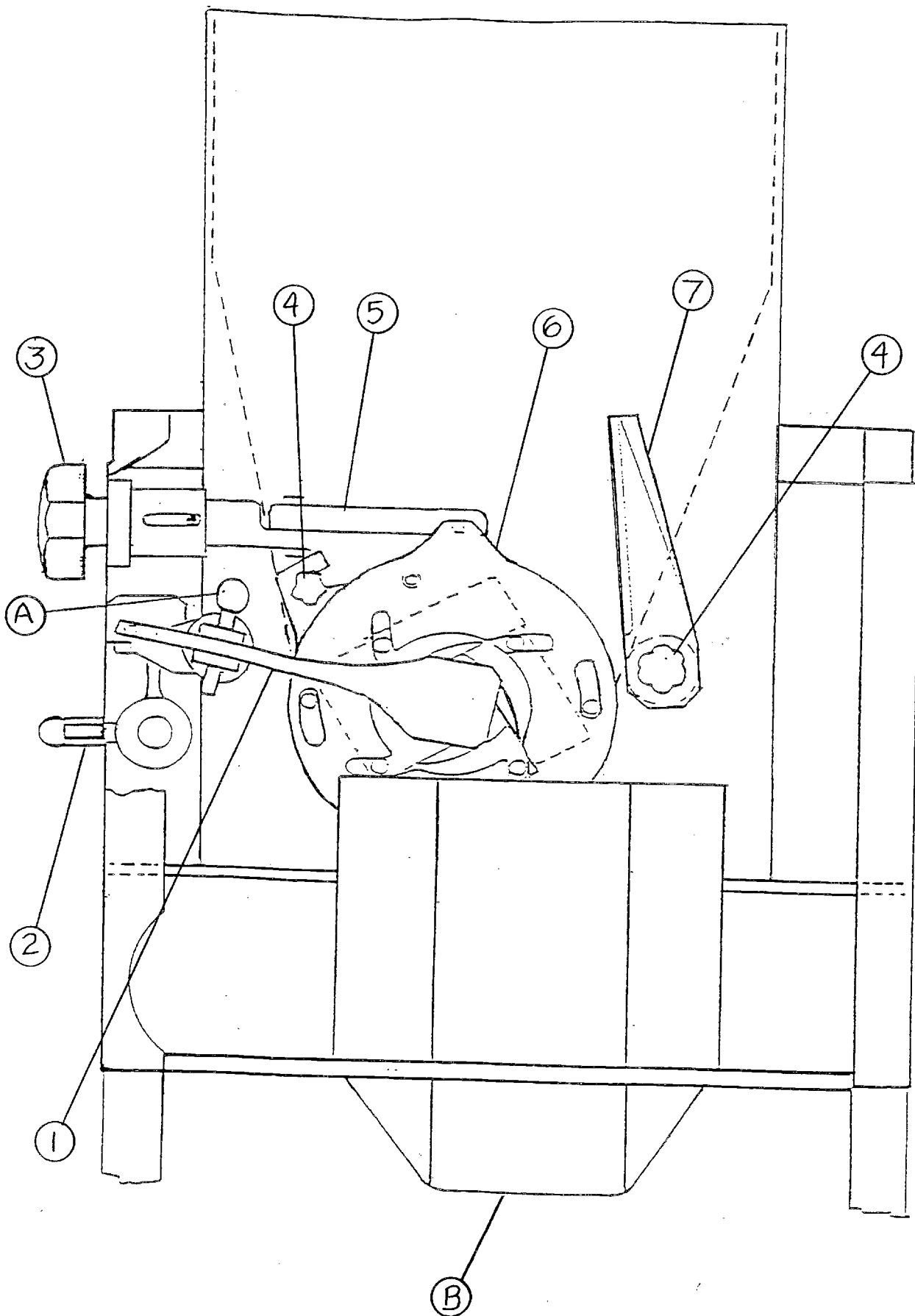
<b>Illus.</b>	<b>Part No.</b>	<b>Description</b>
1	3110018	Switch
2	3110016	Emergency Pushbutton
3	3110358	Belt
4	1064501	Bearing (6206LL)
5	3110532	Gear
6	3110537	Gear
7	3110360	Bearing
8	6509153	Knob
9	1012167	Bearing (6203LL)
10	3110508	Gear
11	3110362	Gear Support
12	3110364	Knob
13	3110366	Motor



DRAWING 5

**DOUGH DIVIDER  
DRAWING 6**

<b>Illus. .</b>	<b>Part No.</b>	<b>Description</b>
1	3110332	Feeler
2	3110344	Knob, Feeler
3	3110342	Knob
4	6509153	Knob
5	3110336	Moveable Lever
6	3110368	Regulation Flange
7	3110322	Shaped Knife

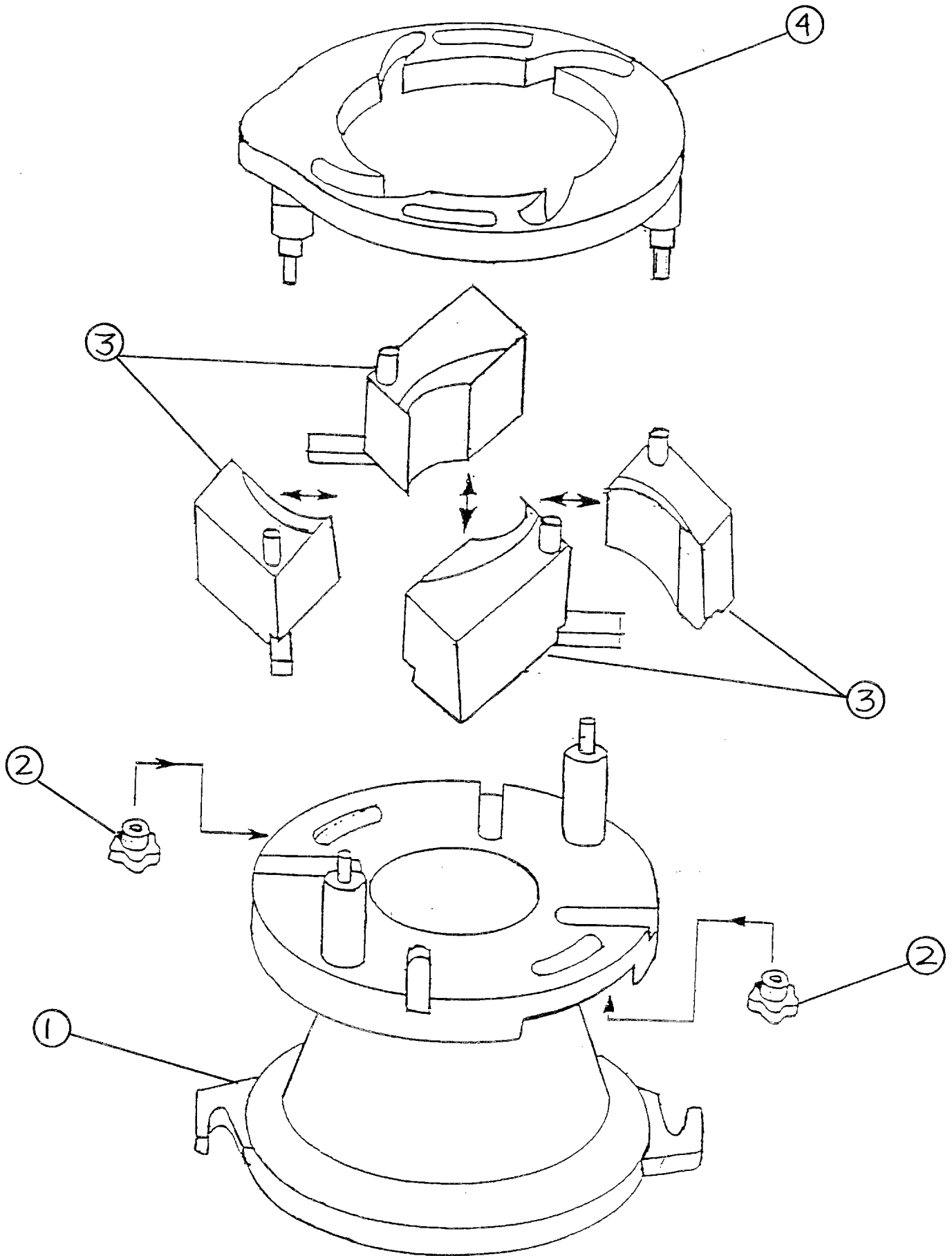


DRAWING 6

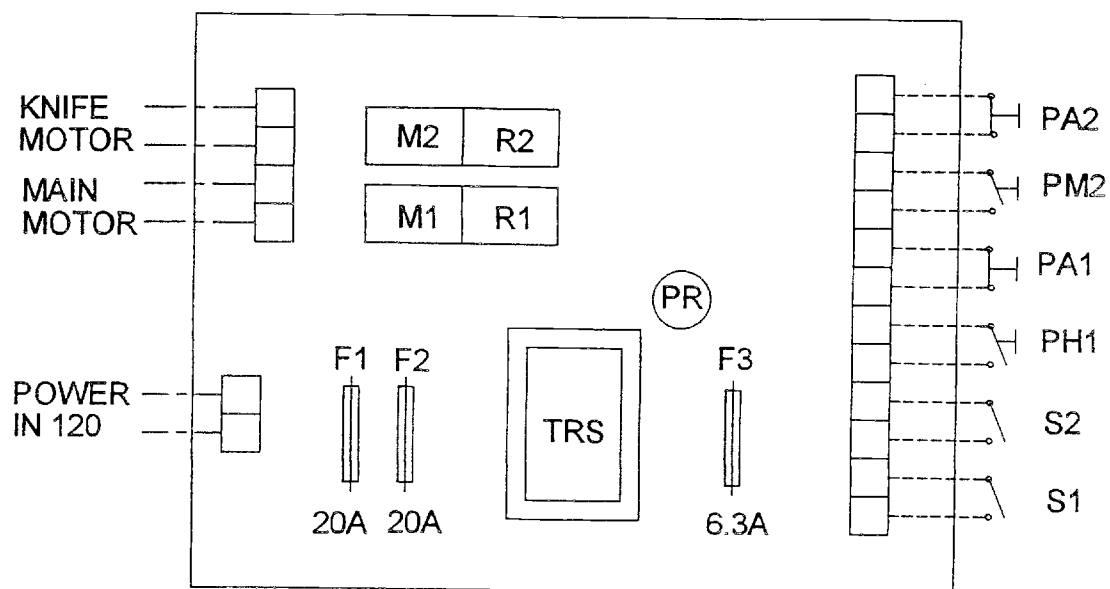


**DOUGH DIVIDER  
DRAWING 7**

<b>Illus.</b>	<b>Part No.</b>	<b>Description</b>
1	3110370	Flanged Cone
2	6509153	Knob
3	3110372	Moveable Sector
4	3110368	Regulation Flange

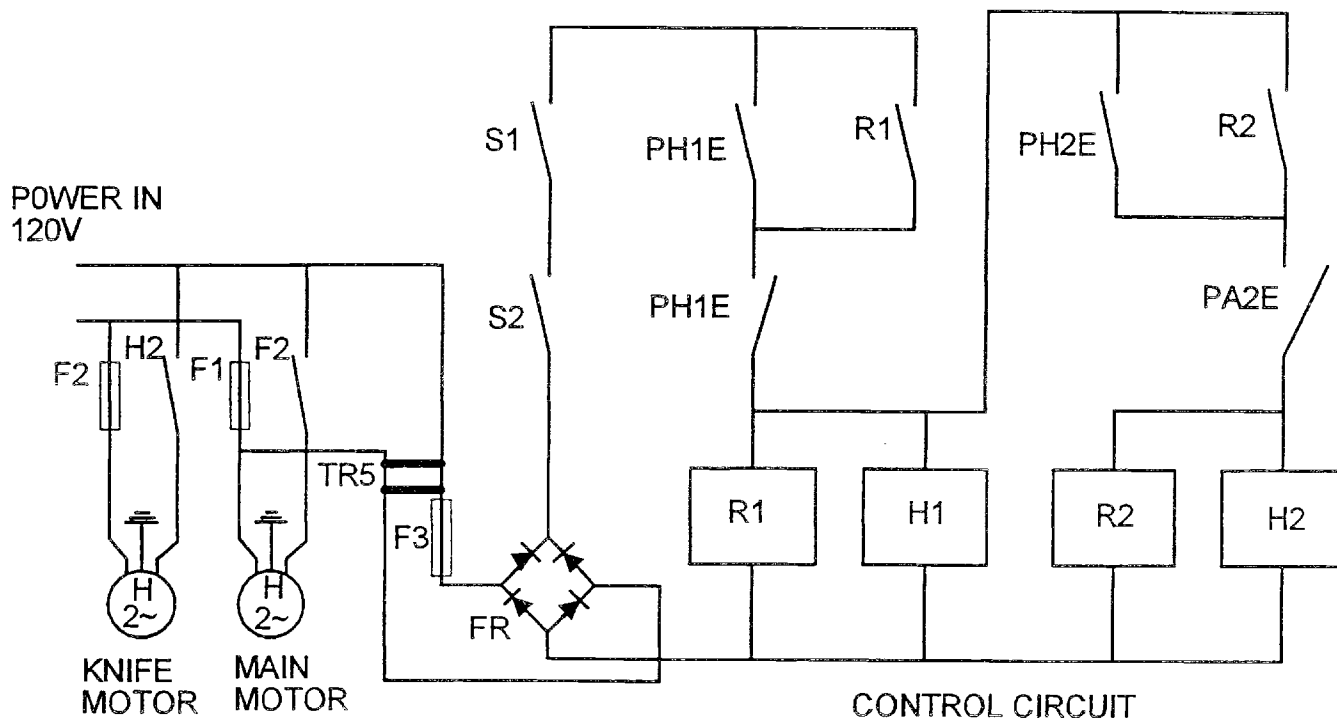


DRAWING 7



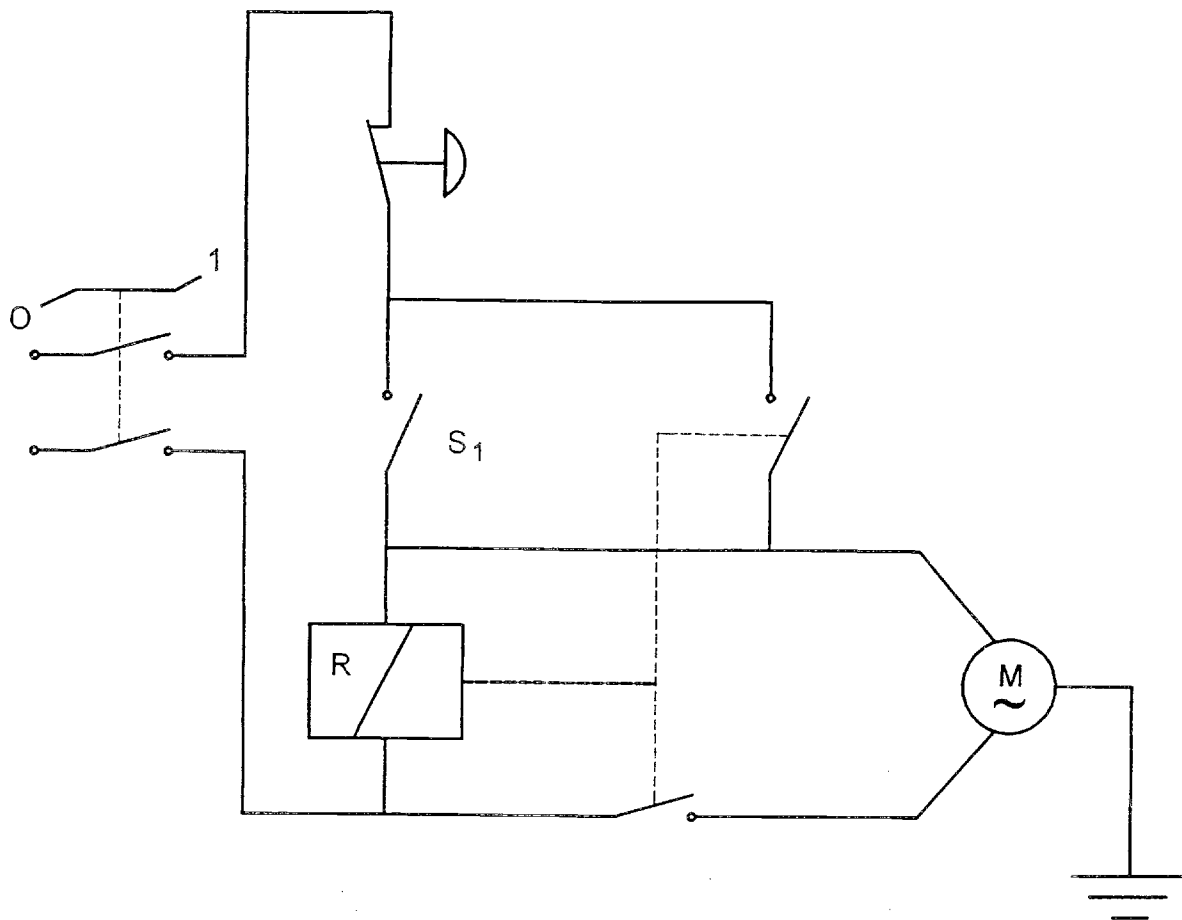
CDR 25, DIVIDER SCHEMATIC  
DRAWING 8

M1, M2, R1, R2 - Relays  
 F1, F2, F3 = Fuses  
 S1, S2 = Magnetic Sensors  
 PH1, PM2 = Start Pushbuttons  
 PA1, PA2 = Stop Pushbuttons  
 TRS = Transformer  
 PR = Rectifier Bridge



CDR 25 DIVIDER SCHEMATIC

DRAWING 9



DR42 DOUGH ROUNDER

DRAWING 10

M = Motor  
 R = Relay  
 S = Magnetic Sensor