

Risco Patty Former

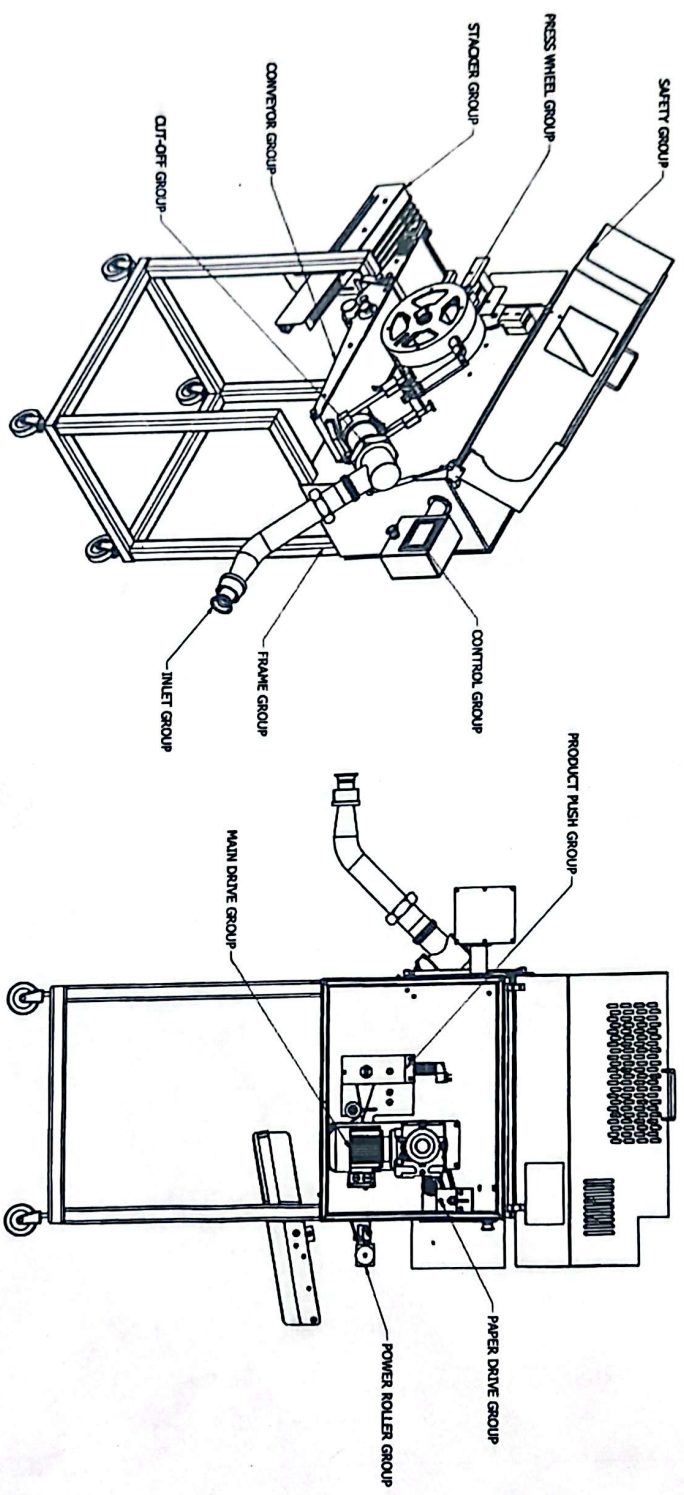
Mod. ARP125

gasket

***PARTI DI RICAMBIO
SPARE PARTS***

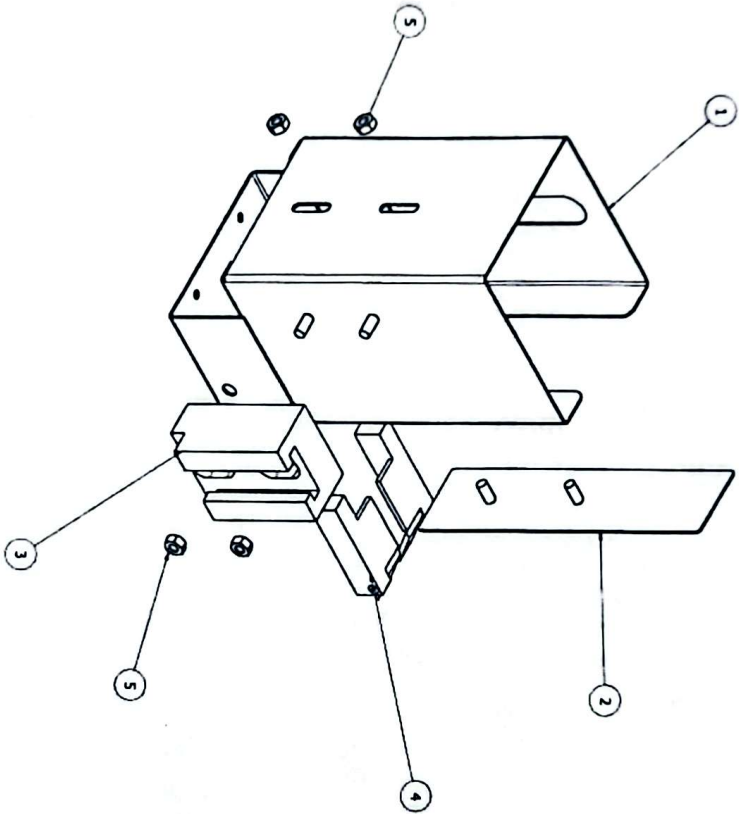
RISCO USA - 60 Bristol Drive, So Easton, MA 02375
Tel: 888-474-7267 Fax: 508-230-5345





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DRAWN	3/15/2016	RISCO USA CORPORATION	
CHECKED		TITLE	
QA		FULL ASSEMBLY	
DESIGNED		SIZE	DWG NO.
APPROVED		C	R036000-A-REV2
		SCALE	SHEET 2 OF 2

ITEM	QTY	PART / DET	DESCRIPTION
1	1	ROVERSAN	PAPER CANNISTER
2	1	ROVERSAN	PAPER BEAK
3	1	ROVERSAN	BASKET SPACER
4	1	ROVERSAN	GLIDE SET COMMITTEE
5	4	1/4" X 20	NUT

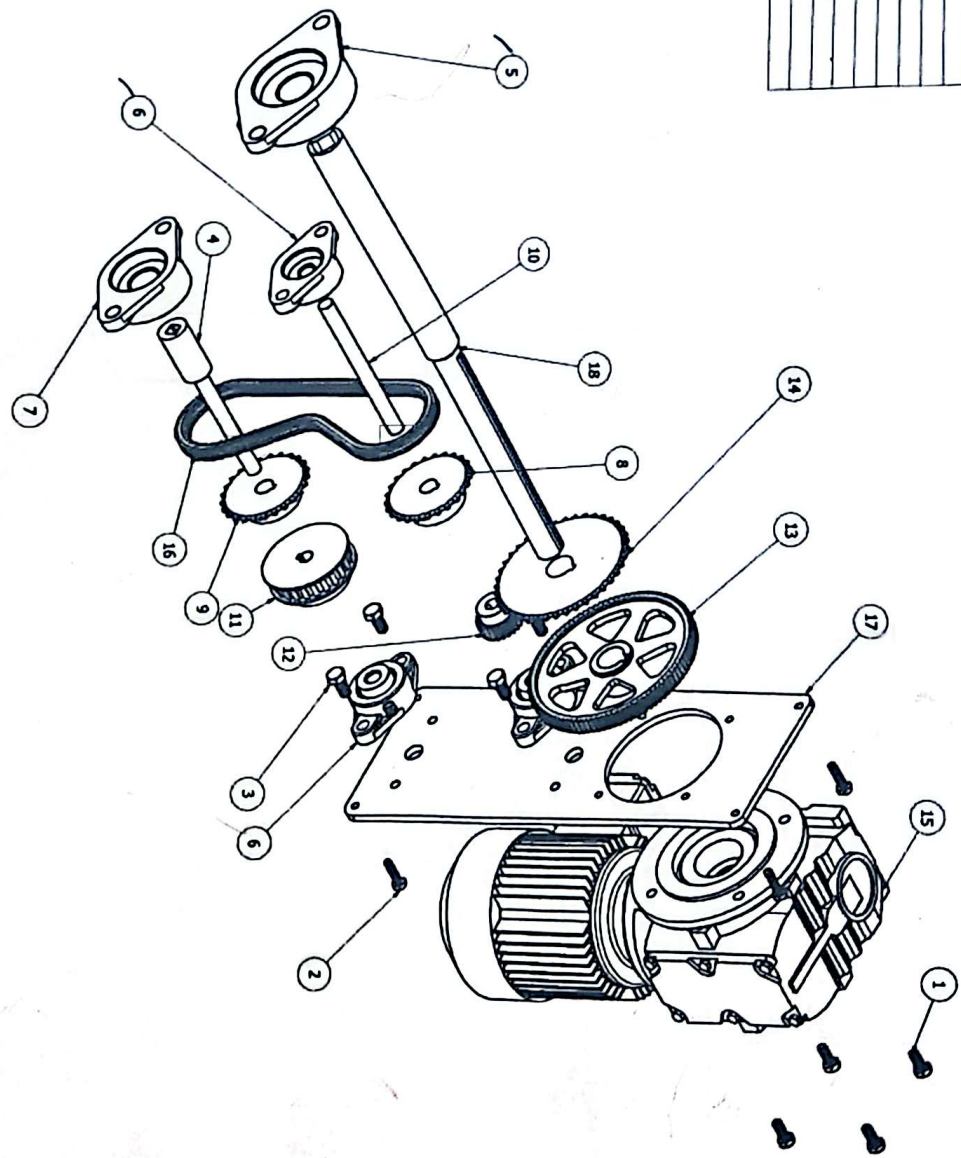
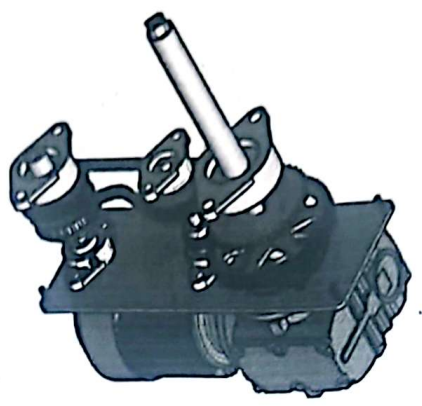


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DESIGNED	1/11/2018	Risco USA Corporation	
CHECKED		TITLE	
APPROVED		PAPER BASKET ASSEMBLY	
DATE		SIZE	DWG NO
		C	R009300-XX
		SCALE	REV

1	4	6236912	1/4-20 1.0 CAP SCREW 92240A542
2	4	G036927	BOLT 3/8-16 0.75 92240A622
3	1	R009508	SHAFT
4	1	R009508	MAIN SHAFT BEARING 5968K770
5	3	R009509	0.5 INCH BEARING 5968K710
6	1	R009510	CONVECTOR DRIVE BEARING 5968K750
7	1	R009514	SPROCKET 6236K24
8	1	R009515	SPROCKET MODIFIED 6236K224
9	1	R009529	SHAFT
10	1	R009530	PULLEY 6495K19
11	1	R009532	SECONDARY GEAR NB240-1,2
12	1	R036165	LARGE GEAR NB96
13	1	R036172	LARGE SPROCKET 6236K251
14	1	R036192	MAIN MOTOR SAF-47
15	1	R036254	ROLLER CHAIN 3FT 6261K172
16	1	R036401	PLATE
17	1	R037168	MAIN SHAFT
18	1	R037168	MAIN SHAFT



NOTE: DRIVE CHAIN ITEM 4, SHOULD INCLUDE ONE SPLIT LINK #6261K261 AND LENGTH OF APPROX 62 LINKS



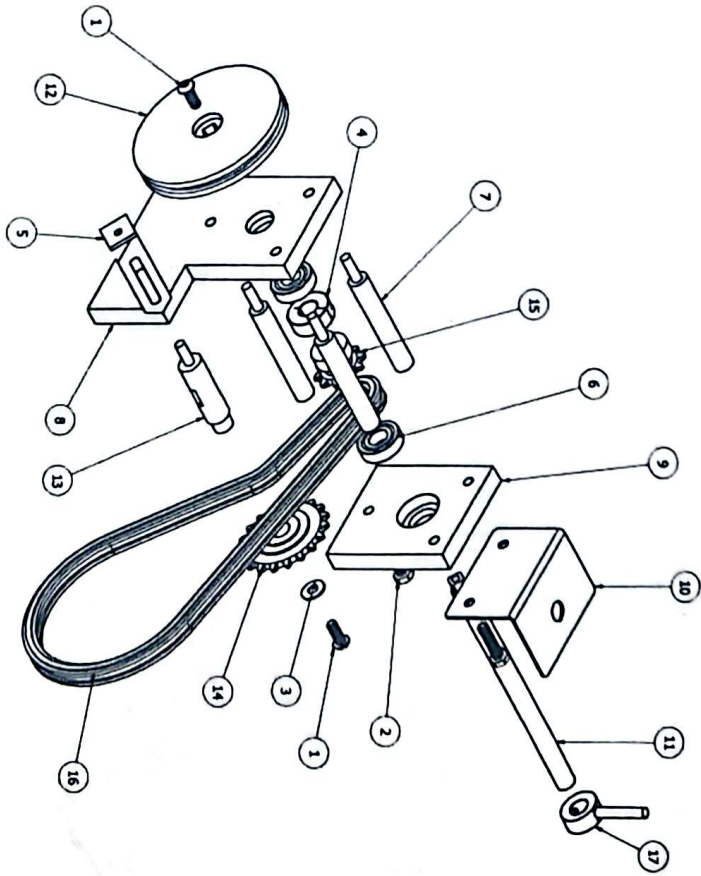
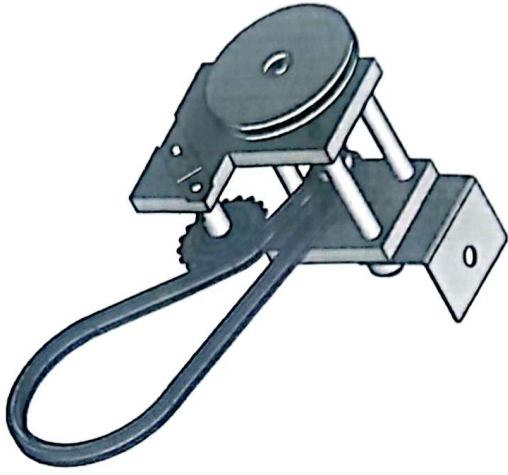
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DATE	12/19/2012	TITLE	Risco USA Corporation	
DESIGNED				
BY				
APPROVED				
SCALE	C	DWG NO	R036020-X	
REV				

Part number

ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	626112	PLATE HEAD 1/4-20 X 0.625 922906539
2	1	626112	1/4-20 L.O. CAP SCREW 922906542
3	1	626114	1/4-20 MAIN WASHER 966596106
4	1	626129	COLLAR 64158X40
5	1	626136	FLAT NUT
6	2	626137	BEARING 6138X7
7	1	626137	STAND-OFF
8	1	626138	PLATE
9	1	626139	PLATE
10	1	626141	TRIGGER PROX MOUNT
11	1	626173	SHAFT
12	1	626174	PAPER CRANE INNER
13	1	626176	CHAIN TENSION SHAFT
14	1	626251	SPROCKET 666X230
15	1	626251	SMALL SPROCKET 6260X22
16	1	626254	DRIVE CHAIN 6261X172
17	1	626513A	CUT TRIGGER



NOTE: DRIVE CHAIN ITEM 16 SHOULD INCLUDE ONE SPLIT LINK #62611261 AND LENGTH OF APPROX 84 LINKS

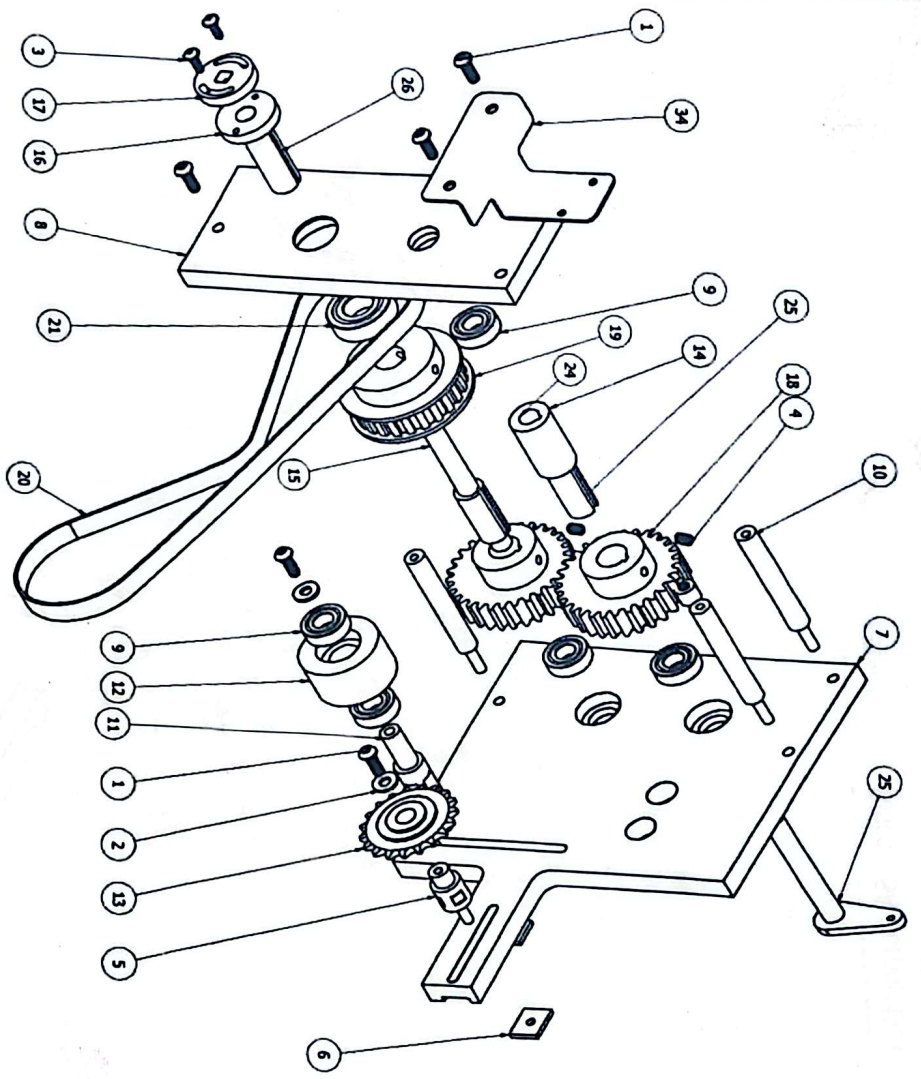
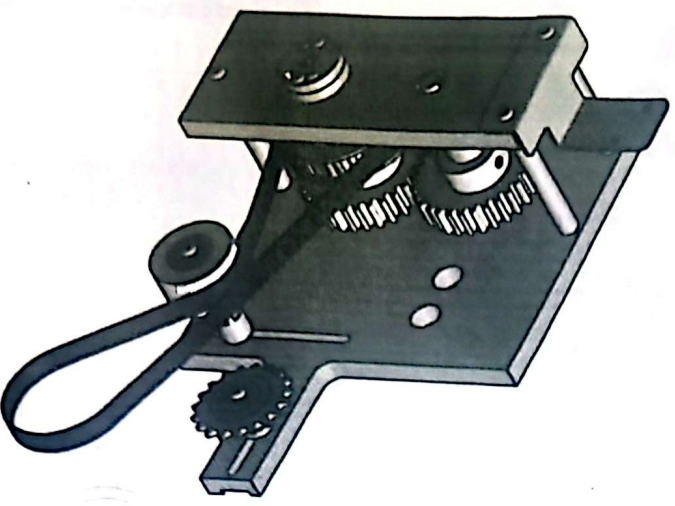
RISCO

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DESIGNED BY ALAN MILLER	DATE 12/19/2012	TITLE Risco USA Corporation PAPER DRIVE PARTS
APPROVED BY ALAN MILLER		SCALE C
		DWG NO R036030-X
		REV

PARTS LIST			
QTY	PART NUMBER	DESCRIPTION	
5	6036909	PAN HEAD 1-4 20 0.625 92949A339	
2	6036914	1-4 20 PLAIN WASHER 96659A106	
2	6036926	10-24 0.5 DOME HEX 97659A142	
2	6036944	SET SCREW 1-4 20 94355A535	
1	R009517	POST	
2	R009536	FLAT NUT	
1	R009601	PLATE	
1	R009607	BEARING 6138K67	
5	R009608	STAND OFF	
3	R009621	PUSHER BELT TENSION SHAFT	
1	R009635	TENSION PULLY	
1	R036169	SPROCKET 6663K220	
1	R036176	ELLIPTICAL GEAR ADAPTOR	
1	R036179	ELLIPTICAL GEAR LOWER SHAFT	
1	R036180	PRODUCT PUSH TIMING SHAFT	
1	R036181	PRODUCT PUSH TIMING PLATE	
1	R036182	SPECIAL GEAR	
2	R036183	DRIVE PULLY 0.75 SHAFT 6499K19	
1	R036188	BELT 6444K153 300L50	
1	R036190	LOWER ELLIPTICAL BEARING 60355K706	
1	R036250	KEY 3/16 X 1.25 (NOT SHOWN)	
1	R036255	KEY 1/8 X 1.25 (NOT SHOWN)	
1	R036256	KEY 1/8 X 0.5 (NOT SHOWN)	
1	R036257	PUSHER CRANK ASSEMBLY	
1	R036513-A	VALVE SUPPORT	
1	R036170		



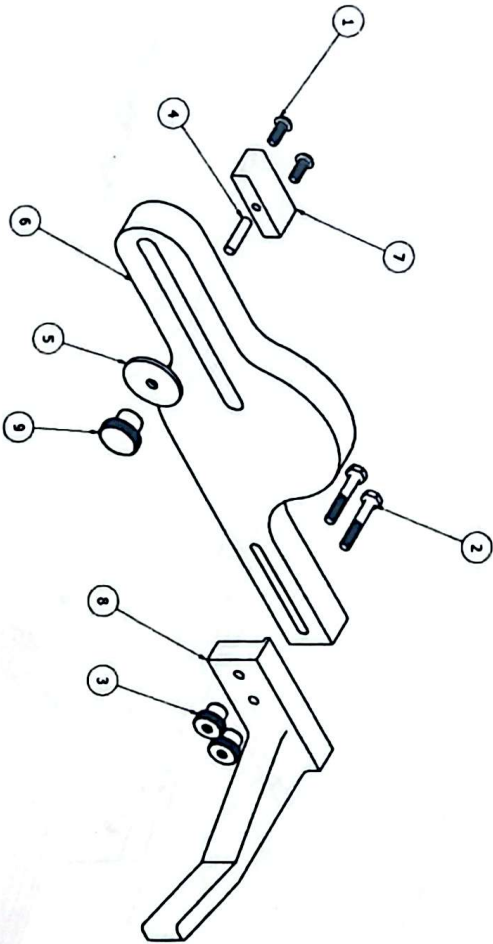
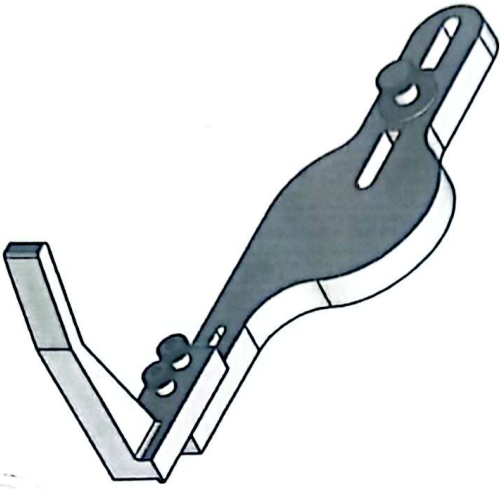
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DESIGNER	DATE	TITLE
1/15/2013		Risco USA Corporation
CHECKED		PRODUCT PUSH DRIVE
APPROVED		
SCALE	SIZE	DWG NO.
	C	R036040-A
		REV

ITEM	QTY	PART NUMBER	DESCRIPTION
1	2	G036909 PAN HEAD 1-4 20 0.625 9299A4319	
2	2	G036936 1-4 20 1.5 CAP HEAD 92186A466	
3	2	G036937 THROUGH RNOB 60295K221	
4	1	G036938 STD 9075A442	
5	1	G036940 PRODUCT PUSH WASHER 92306A152	
6	1	R036134 RISSER ARM	
7	1	R036135 RISSER GUIDE	
8	1	R036136 PICK ARM	
9	1	R036138 RNOB 1 INCH 60295K650	



Risco

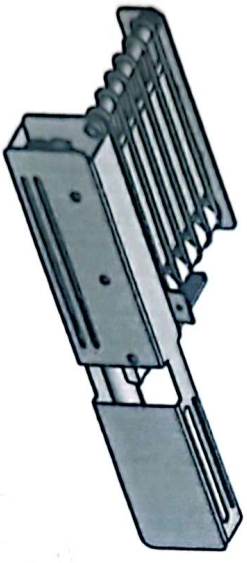
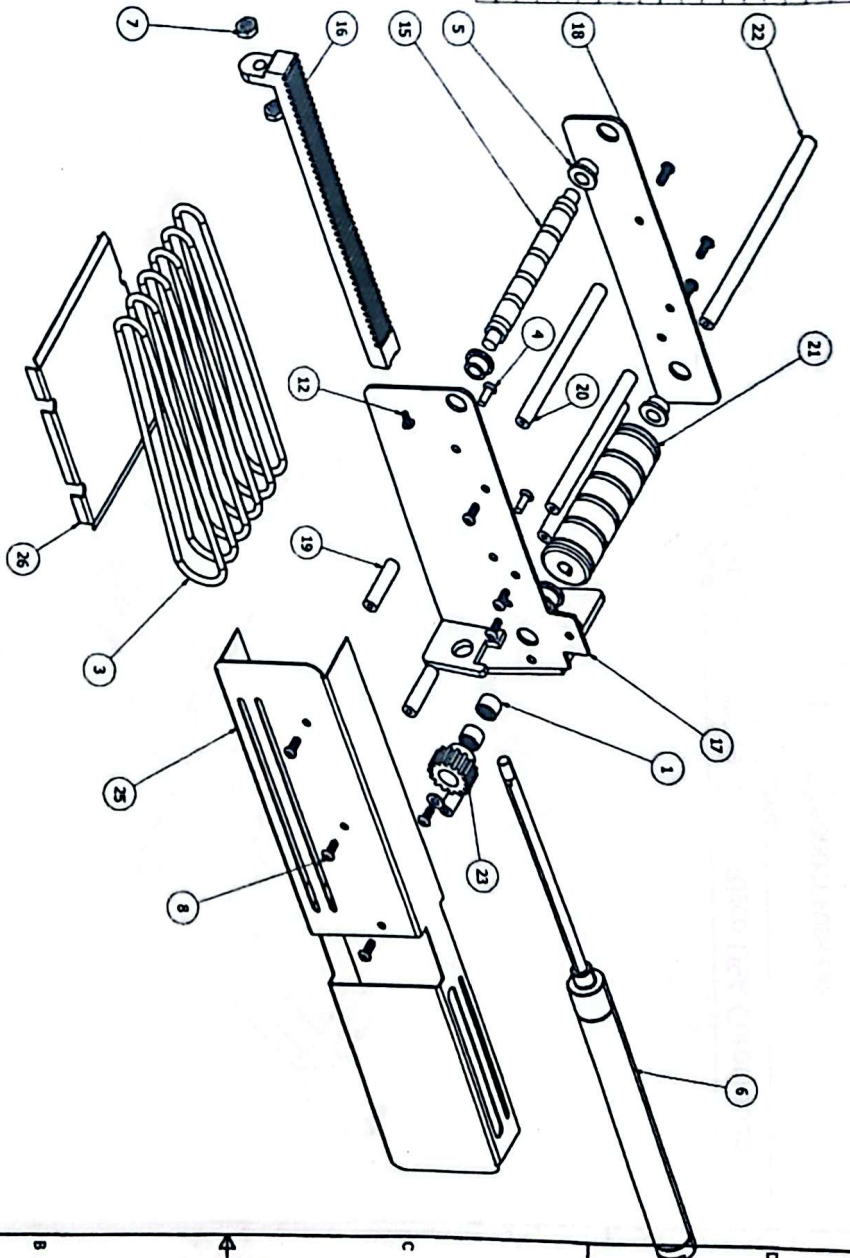
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DATE	1/7/2013	Risco USA Corporation	
ENGINEER		TITLE	
SA		PRODUCT PUSH BAR	
DATE		SIZE	DWG NO.
APPROVED		C	R036041-X
		SCALE	REV

QTY	PART NUMBER	DESCRIPTION
2	2489K310	ONE-WAY BEARING
6	9396K383	LARGE O-RING
3	1/4-20 UNC X 0.75	Slotted Undercut Flat
4	2706T31	RUSHING
5	M-1210-D	CYLINDER
2	G036546	7-16 LOCK NUT 91047A515
10	G036909	PAN HEAD 1-4 20 0.625 92949A539
2	G036914	1-4 20 PLAIN WASHER 96659A106
1	G036926	10-24 0.5 DOME HEX 97654A142
1	R036401	FRONT ROLLER
1	R036403-2	FRONT SIDE ASSEMBLY
1	R036405	REAR SIDE
1	R036406	REAR SIDE
3	R036408	GUARD STAND-OFF
3	R036409	BELT SPACER
1	R036410	REAR ROLLER
1	R036411	ROLLER DRIVE SHAFT
1	R036412	GEAR
1	R036415	GUARD
1	R036418	PLATE



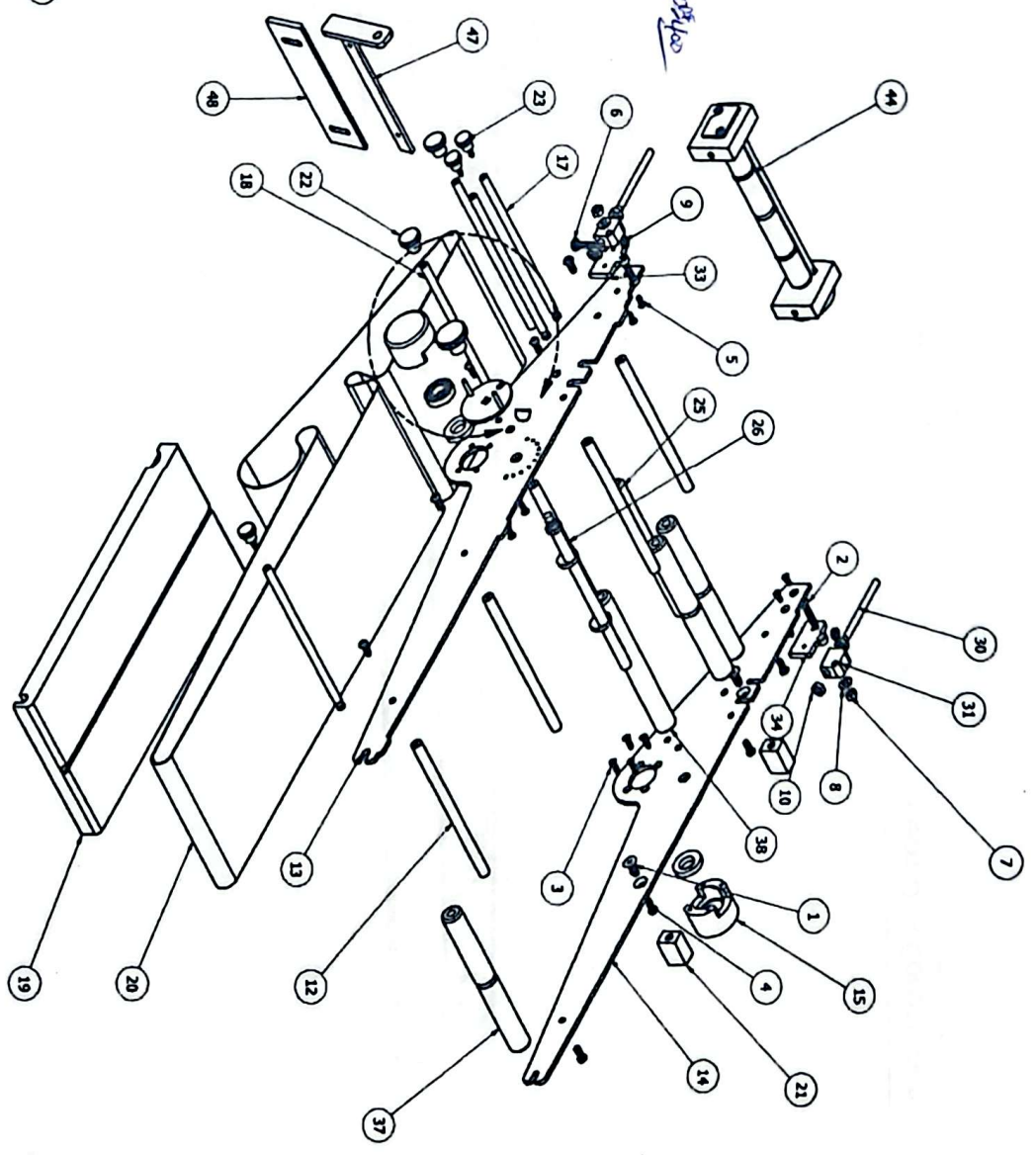
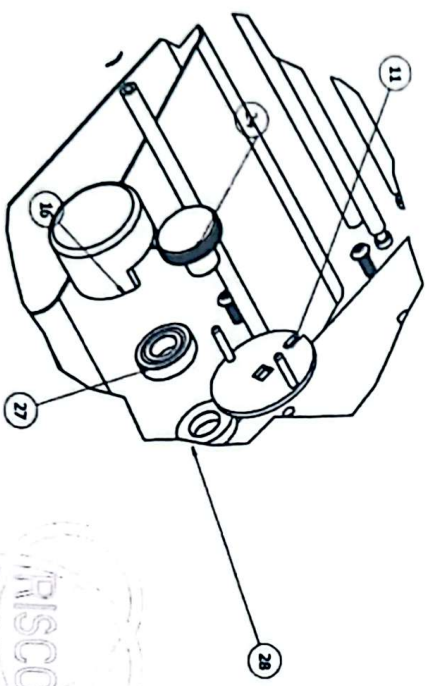
ZONE	REV	DESCRIPTION	DATE	APPROVED
1	1	Cylinder changed from SS-1210-D TO M-1210-D machined piston	3/7/2014	A Miller



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DRAWN 2 Miller CHECKED 7 10/26/2012	TITLE Stacker Assembly Risco USA Corporation
APPROVED A Miller	DATE 3/7/2014
SIZE C	DWG NO R036400-X
SCALE	REV 1

ITEM	QTY	PART NUMBER	DESCRIPTION
1	2	G016017	5/16 18 0.75 SOCKET HEAD 92805A624
2	2	G016546	1-4 20 1.5 FLAT HEAD 9185A546
3	8	G016547	10-24 0.625 FLAT HEAD 91781A244
4	10	G016908	PAW HEAD 1/4 20 0.625 92999A539
5	4	G016910	1/24 0.5 FLAT HEAD 91781A242
6	2	G016912	1/4 20 1.0 CAM SCREW 92240A542
7	2	G016913	1-4 20 LOCK NUT 91831A029
8	2	G016914	1/20 PLAIN WASHER 90659A106
9	2	G016916	1-4 20 PLAIN NUT 91847A029
10	4	G036925	5-16 24 PLAIN NUT 91841A225
11	1	R036110	SPACER
12	5	R036111-4	CONVEYOR FRONT
13	1	R036112-4	CONVEYOR REAR
14	1	R036113	THROUGH BEARING SUPPORT
15	1	R036114	OUTER BEARING CAP
16	1	R036116	SHAFT
17	3	R036117	THREADED SHAFT
18	1	R036118	PLATE
19	1	R036133	BELT LONG - BLDE
20	1	R036153	BELT STAND-OFF
21	2	R036163	KNOB 1 INCH 60205K660 1/4 20 X .75
22	3	R036164	KNOB 3/4 INCH 6091K410 10/24 X 0.5
23	1	R036166	HEIGHT KNOB 60205K690-41
24	1	R036167	THIN ROLLER
25	1	R036511	PLATE LIFT
26	1	R070125	BEARING 4668R160
27	2	R070127	SEAL 5154716
28	2	R070147	ROLLER 3 INCH
29	1	R070185	TRACKING THREAD
30	2	R070187	TRACKING BLOCK
31	1	R070189	RIGHT PIVOT
32	1	R070190	LEFT PIVOT
33	3	R070194	ROLLER GROOVED
34	1	R070195	ROLLER
38	1	R036810	POWER SHAFT ASSEMBLY
44	1		SCRAPER SUPPORT
46	1		SCRAPER



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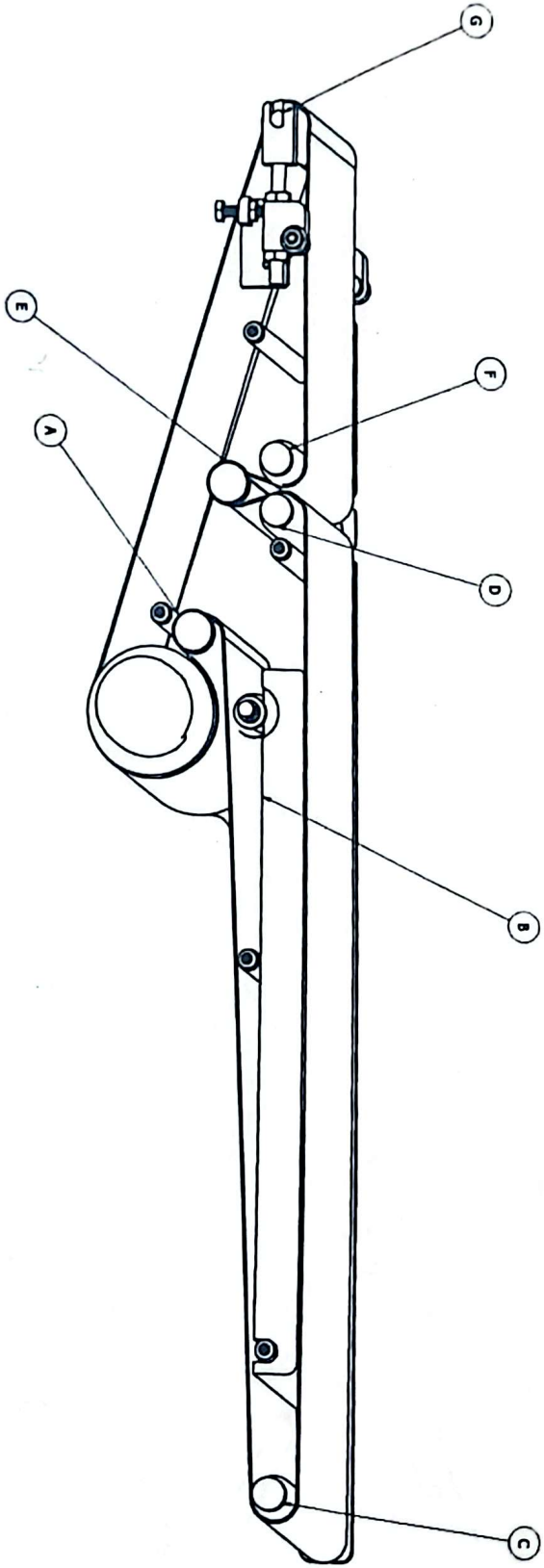
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DATE	11/2/2013	Risco USA Corporation	
BY		TITLE	
CHKD		CONVEYOR PARTS	
APPROVED		SIZE	DWG NO
		C	R036510-A
		SCALE	REV

BELT INSTALLATION

1. WITH THE TENSIONERS IN THE UP POSITION, PLACE THE BELT OVER THE CONVEYOR FRAME
2. FOLD THE LOWER HALF OF THE BELT DOWN AND UNDER THE LEFT CAM AND PULL THE EXCESS THROUGH
3. INSERT THE NON-GROOVED PINCH ROLLER (A) THROUGH THE BELT AND SECURE USING THE THREADED SHAFT
4. PLACE THE LIFT PLATE (B) UNDER THE TOP OF THE BELT AND LOCATE ON THE CONVEYOR FRAME
5. SLIDE THE REAR ROLLER (C) ONTO A STAGGERED, INSERT IT THROUGH THE REAR OF THE BELT AND LOCATE ITS IN THE RECEIVING SLOTS
6. SLIDE THE FIRST DROP ROLLER (D) ONTO ITS SHAFT AND LOCATE IN THE REAR OF THE TWO RECEIVING SLOTS
7. PLACE THE THIN ROLLER (E) ON TOP OF THE BELT AND PUSH DOWN TO ALIGN WITH THE SHAFT HOLES AND SECURE WITH A THREADED SHAFT
8. LIFTING THE BELT SLIDE THE FORWARD DROP ROLLER (F) WITH STAGGERED SHAFT INTO THE FORWARD RECEIVING SLOTS
9. PLACE THE FRONT ROLLER (G) WITH SHAFT INTO THE TENSIONERS.
10. LOWER THE TENSIONERS TO SECURE THE BELT, ENSURING THAT THE BELT SPINE IS CORRECTLY LOCATED IN THE GROOVES OF THE ROLLERS AND LIFT PLATE.



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DESIGNER	BRILLIAR																		
CHECKED																			
DATE	12/22/2012																		
APPROVED																			
TITLE	Risco USA Corporation																		
SIZE	C																		
SCALE																			
DWG NO.	BELT INSTALLATION																		
REV																			

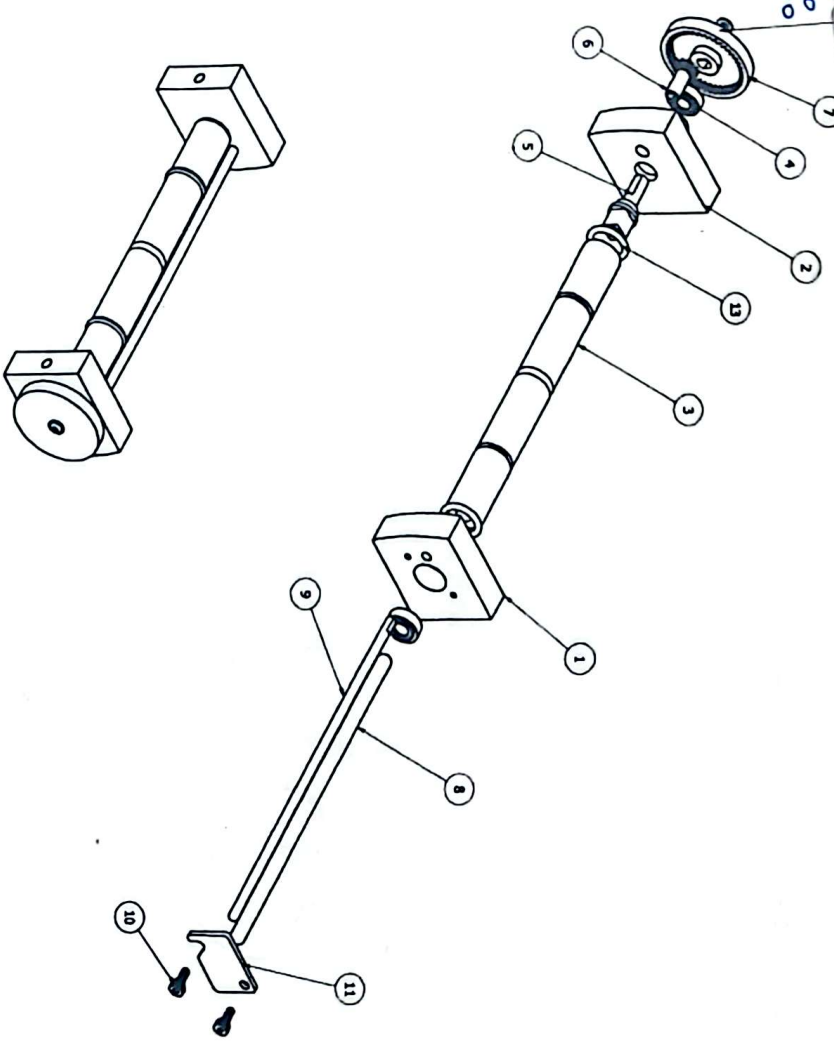
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	R016A02	PR FRONT BLOCK
2	1	R016A01	PR REAR BLOCK
3	1	R070192	FRONT ROLLER
4	1	64SKC00	BEARING
5	1	R016A04	STUB SHAFT
6	1	R016A01	INNER GEAR
7	1	R016A05	OUTER DRIVE GEAR
8	1	R016A06	ROLLER SHAFT
9	1	R016A08	THIN SHAFT
10	2	90296A525	SHOULDER SCREW
11	1	R016A07	SHAFT COVER
12	1	C0316926	10-24 DOME SCREW
13	2	R016A09	O-RING

* 200 ordered on 4/20/21

ordered on 9/17

\$ 415.00

12.44
200.00
200.00



0320
50823200



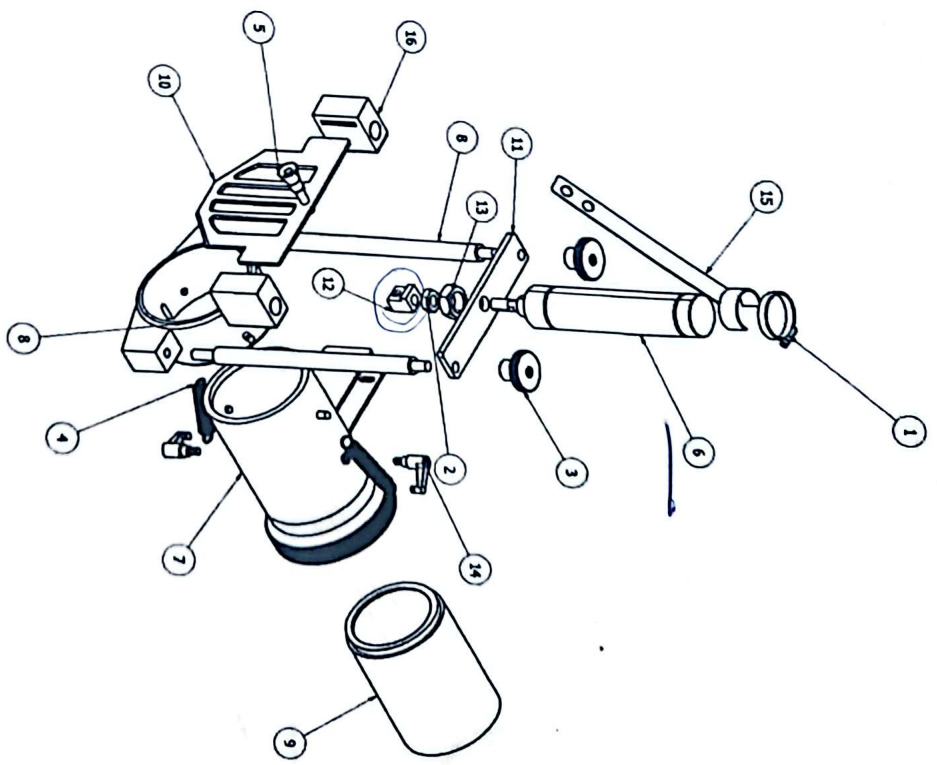
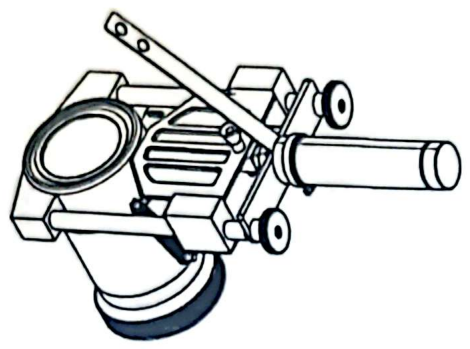
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DESIGNER	3/14/2016
CHKD	
QA	
APPROVED	

RISCO USA CORPORATION	
TITLE POWERSHAFT ASSEMBLY	
SIZE C	DWG NO R036810
SCALE	REV

BELT

QTY	PART NUMBER	DESCRIPTION
1	7/16 - 20	CLAMP 1.5 INCH
1	60X5X261	JAM NUT
1	9065X369	KNOB
1	92385A051	SPRING
1	CM174-S-D	PIN
1	R009001	CYLINDER
1	R009202-A	SHELL
1	R009203-XX	FRONT RING ASS
1	R009204	INSERT (SIZE)
1	R009205	KNIFE
1	R009206	CYLINDER MOUNT
1	R009208	KNIFE COUPLING
1	R009209	NUT
1	R009212	LEVER LOCK
2	R009215	SPRAY BAR
2	R009215	KNIFE BLOCK

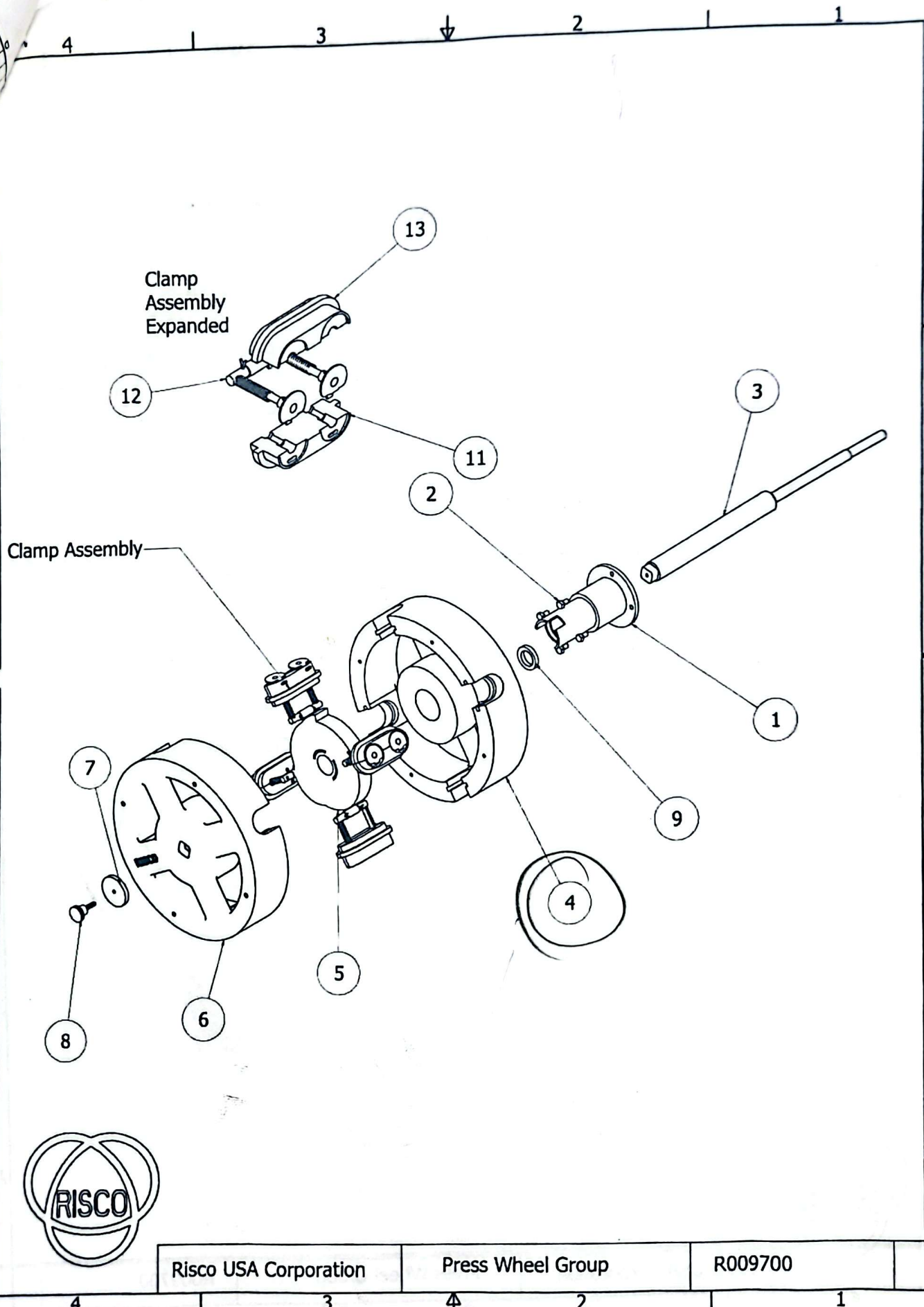
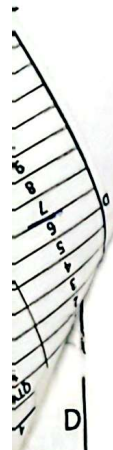


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DATE	3/14/2016
BY	
CHKD	
APP'D	
TITLE	RISCO USA CORPORATION
SIZE	C
SCALE	1:1
REV	
DATE	
BY	
CHKD	
APP'D	
TITLE	AR20-4 INCH ASSEMBLY
SIZE	C
SCALE	1:1
REV	
DATE	
BY	
CHKD	
APP'D	
TITLE	RISCO USA CORPORATION
SIZE	C
SCALE	1:1
REV	
DATE	
BY	
CHKD	
APP'D	
TITLE	AR20-4 INCH ASSEMBLY
SIZE	C
SCALE	1:1
REV	
DATE	
BY	
CHKD	
APP'D	
TITLE	RISCO USA CORPORATION
SIZE	C
SCALE	1:1
REV	



Risco USA Corporation	Press Wheel Group	R009700	
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PARTS LIST

ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	R009701	Main Bushing
2	4	R009702	Hex Bolt - 1/4-20 UNC
3	1	R009703	Main shaft
4	1	R009704	Press wheel rear \$4000
5	1	R009705	Central Cam
6	1	R009706	press wheel front
7	1	R009707	lock plate
8	1	R009708	Knob 6890K100
9	1	R009709	Seal
10	4	R009710	Clamp Shell rear
11	4	R009711	Clamp assembly
12	4	R009712	Clamp shell front

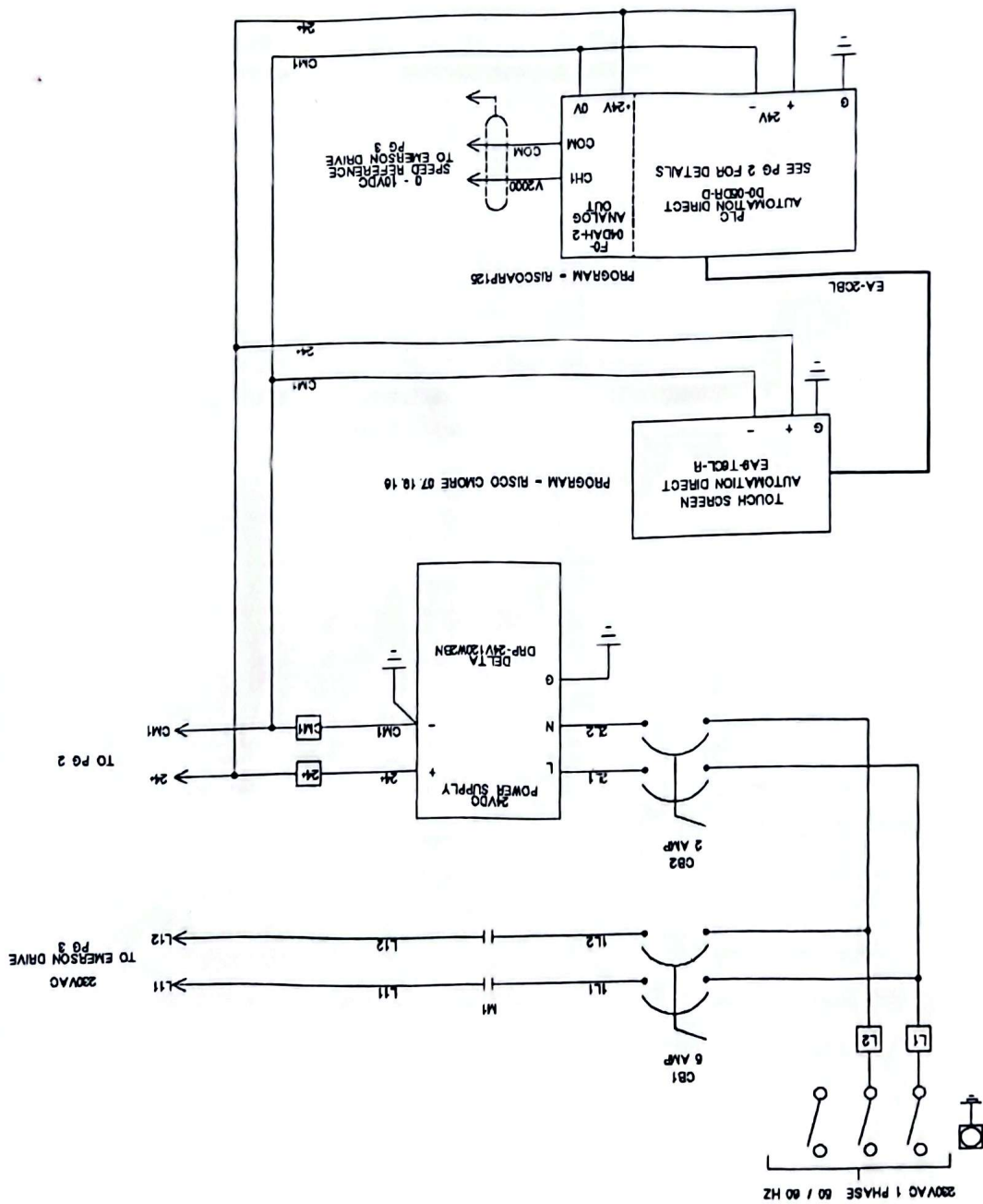


Risco USA Corporation

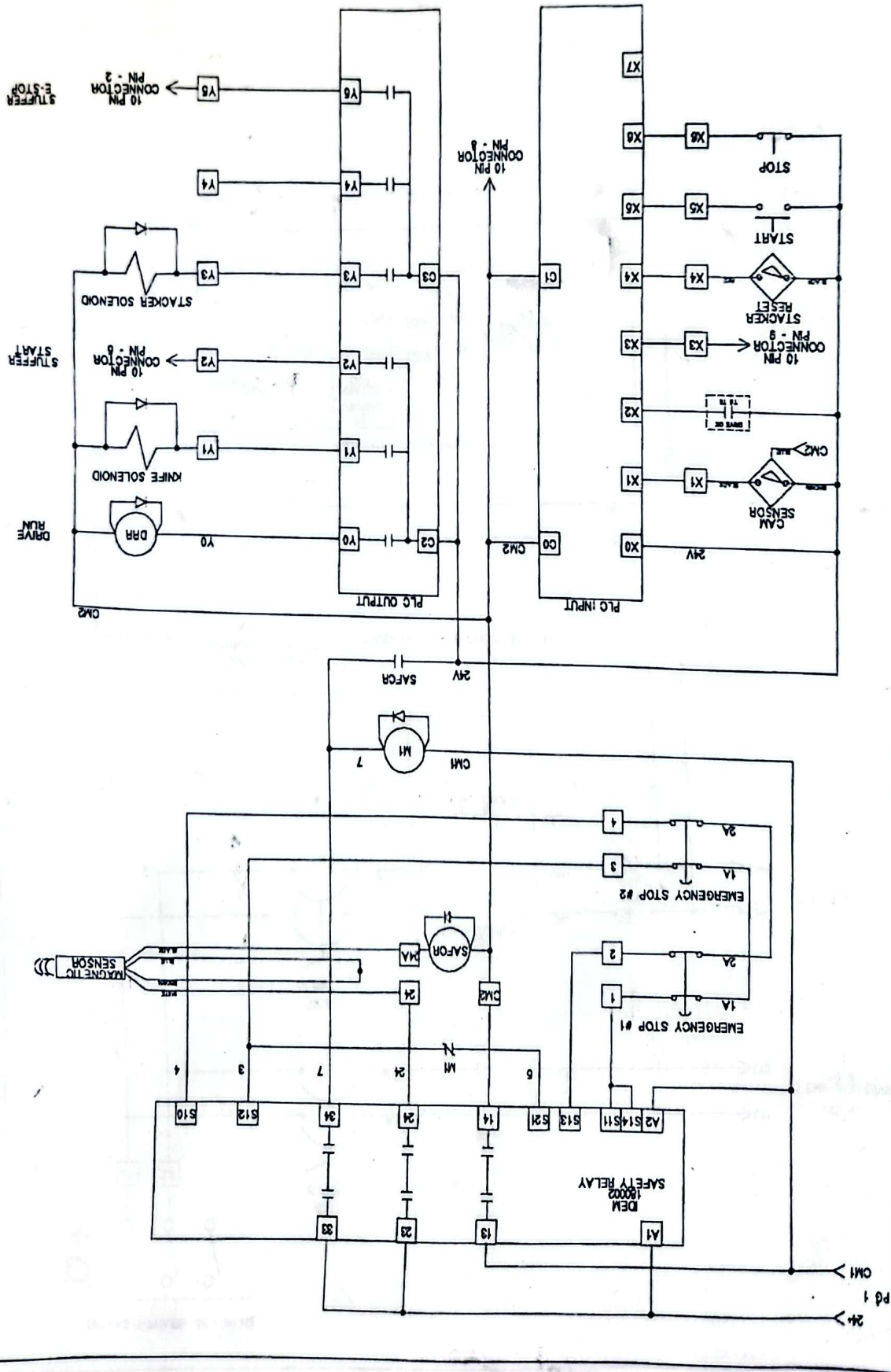
Press Wheel Group

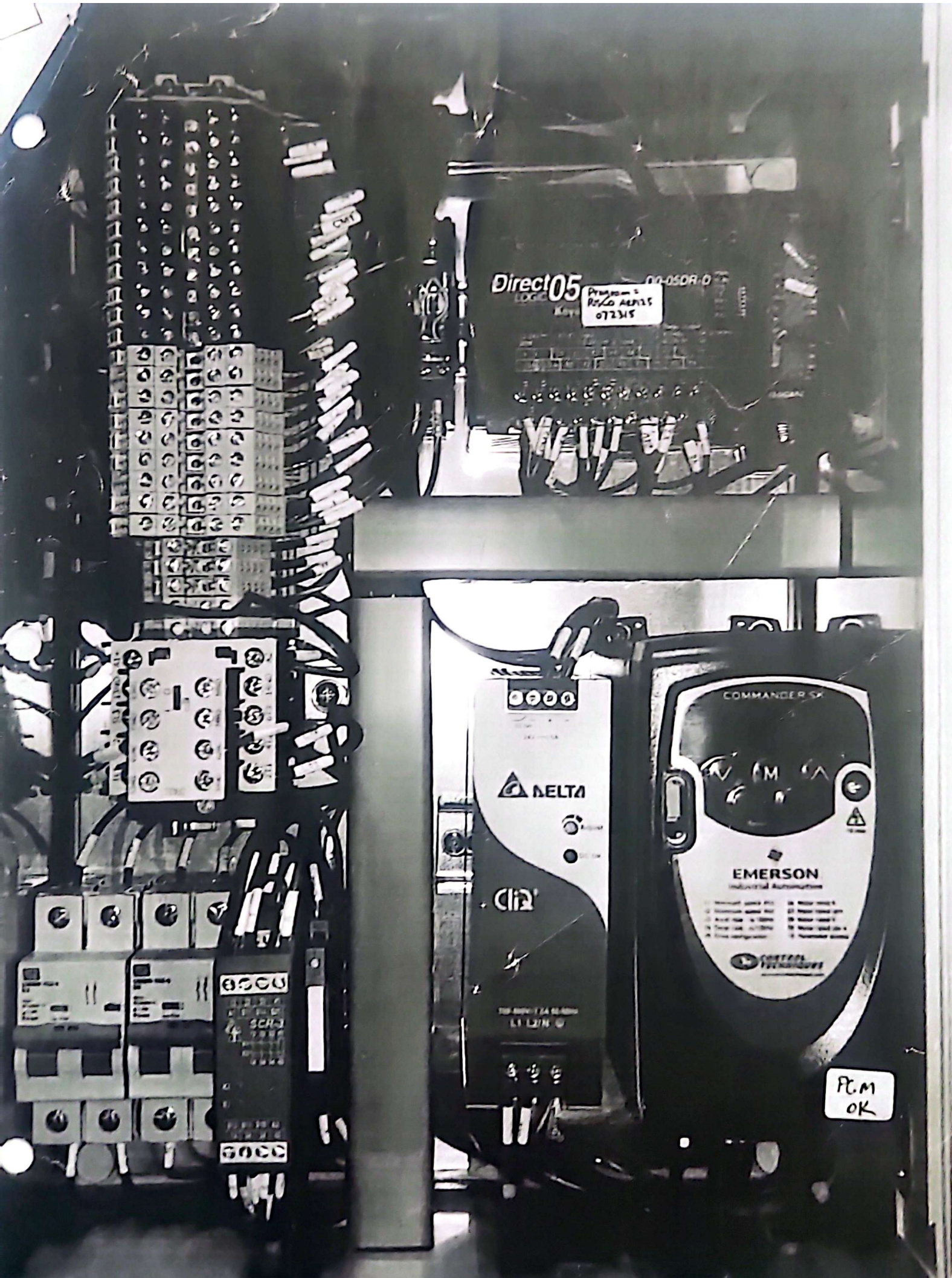
R009700

RISCO		DATE	7/20/16
APPROVED BY	DA	DRAWING NUMBER	R1071601
FORMER-2			
SHEET		1 OF 3	



RISCO		DATE	7/20/16
POWER DISTRIBUTION		DRAWING NUMBER	FORMER-2
DRAWN BY		APPROVED BY	
DA			
		SHEET	2 OF 3





Direct05
LOGIC

Program: P050 A0115
072115

00-05DR-0

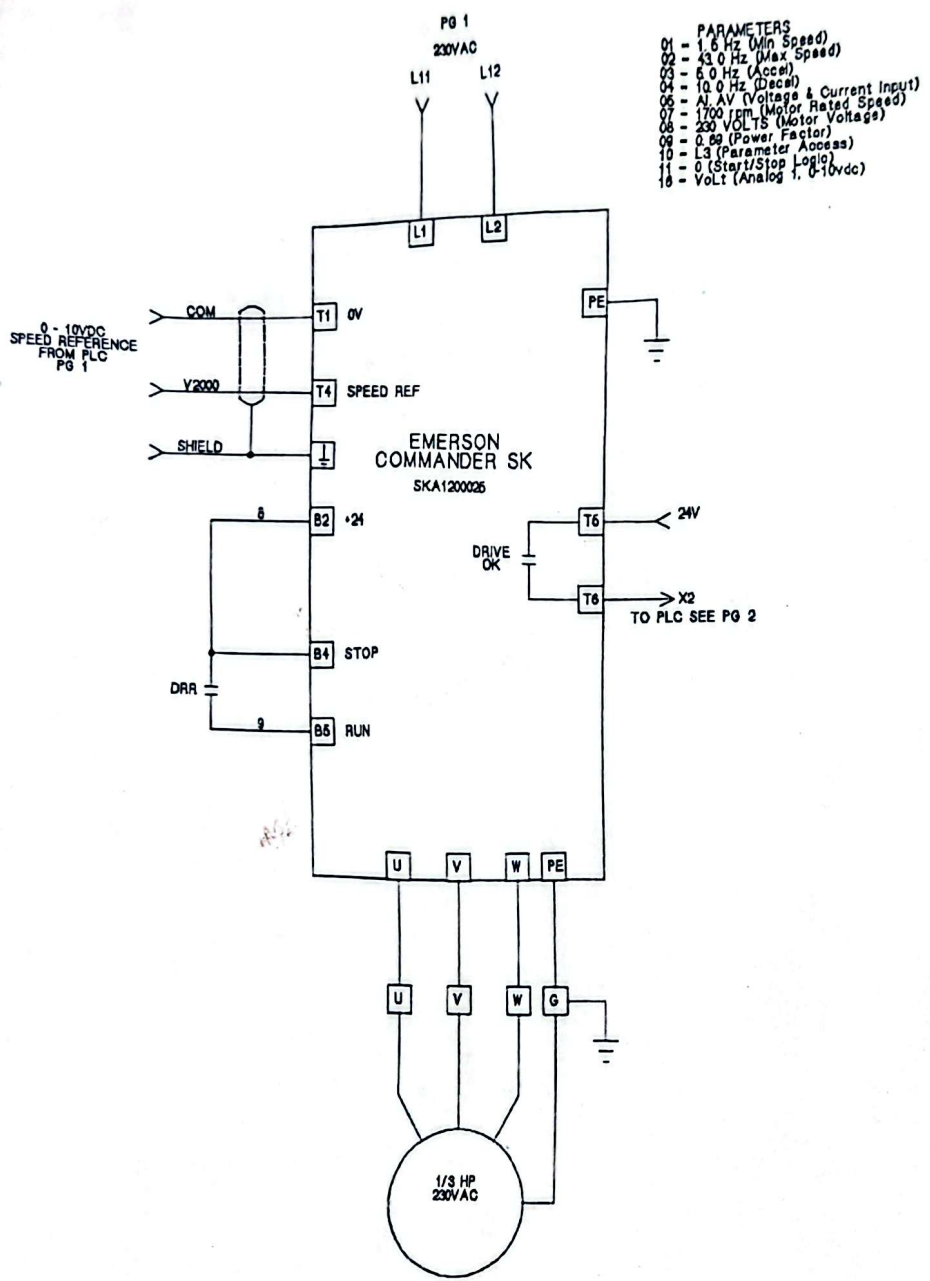
DELTA

VFD

COMMANDER SX

EMERSON
Industrial Automation

PLC OK



RISCO		
POWER DISTRIBUTION	DRAWN BY	DA
	APPROVED BY	
TITLE		
FORMER-2		
DATE	DRAWING NUMBER	SHEET
7/20/16	RI071603	3 OF 3

Patty former Set up instructions

Here are some of the operation techniques we recommend

- Install the machine belt.
- while running the machine, make sure belt is tracked correctly
- Lubricate the pusher arm cam.
- Install the pusher arm.
- Install the head cutoff assembly.
- Lubricate the wheel shaft.
- Install the back side of wheel.
- Install the wheel/frog cam making sure the writing front is facing out.
- Install each frog assembly.
- Install the front side of wheel and fasten the wheel tightening nut with washer.
- Install paper stacker with pusher arm.
- Set up the air supply.

Adjusting the wheel/pusher arm sync position

- The pusher arm and the wheel need to be synchronized so the patty and the paper meet at the right spot.
- Set the delay on the screen to 50 percent
- When the pusher arm and the wheel are synchronized, while the frog is facing straight down towards the belt (12 o' clock), the pusher arm cam should be at 2 o' clock position. If that isn't so, you need to get to the back of the machine and loosen the two set screws that hold the cam plate in place and turn the cam plate until the pusher arm most upper position is met while the frog is straight down towards the belt.

Adjusting the paper with the frogs

- Set machine speed to the slowest possible, and jog the machine until the frogs extends out right before closing.
- Loosen the paper cam adjustment knob and turn the cam until the pusher arm takes the paper and meets the frog on the wheel.
- Tighten the paper cam adjustment knob and test run the machine.
- make fine adjustment to the paper cam to adjust paper positioning, the paper should be going all the way out to meet the frog shaft.