



Installation, Operation, and Maintenance Manual

Installation, Operation, and Maintenance Manual for the Celorio Tortilla Machine

It is very important to carefully read and become familiar with the manual before operating the Celorio Tortilla Machine.

Once reading the manual in its entirety you will understand the equipment and be able to operate it in the safest and most efficient way.

Besides the manual, you should schedule a training by an authorized Celorio technician for at least three days, allowing your company to address any questions or concerns you may have.



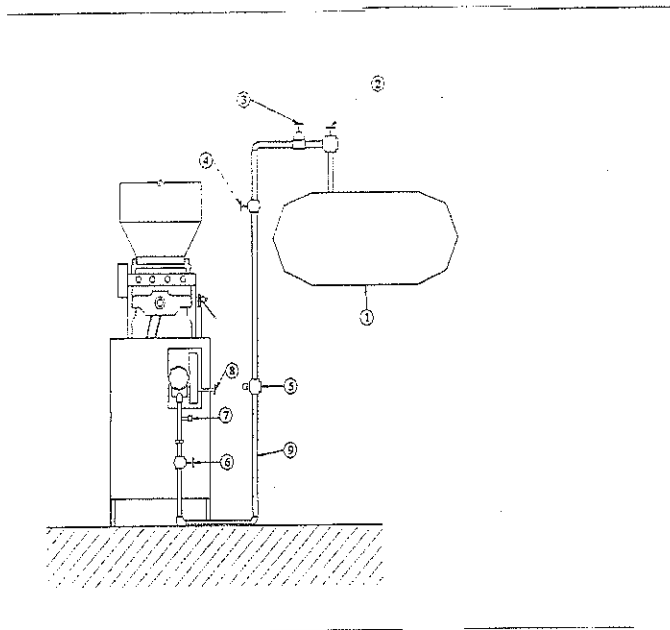
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To install the Celorio tortilla machine, first the site must be properly prepared.

To prepare the site, your company must install electricity and gas. Celorio is not responsible for the installation and urges your company to contract a qualified company.

To install the gas, we recommend installing it as indicated in the diagram below.

Gas Installation for Celorio Tortilla Machine



Note the low pressure regulator and the general valve should be no more than 5 meters and no less than 3 meters.

Working pressure of gas from 7-10 ounces.

1. Stationary Tank
2. Valve
3. Fisher High Pressure Regulator
4. Security Lever
5. Low Pressure Regulator
6. Open/Close Valve
7. "T" To Measure Pressure
8. Carburetor Valve
9. $\frac{3}{4}$ inch Tubing



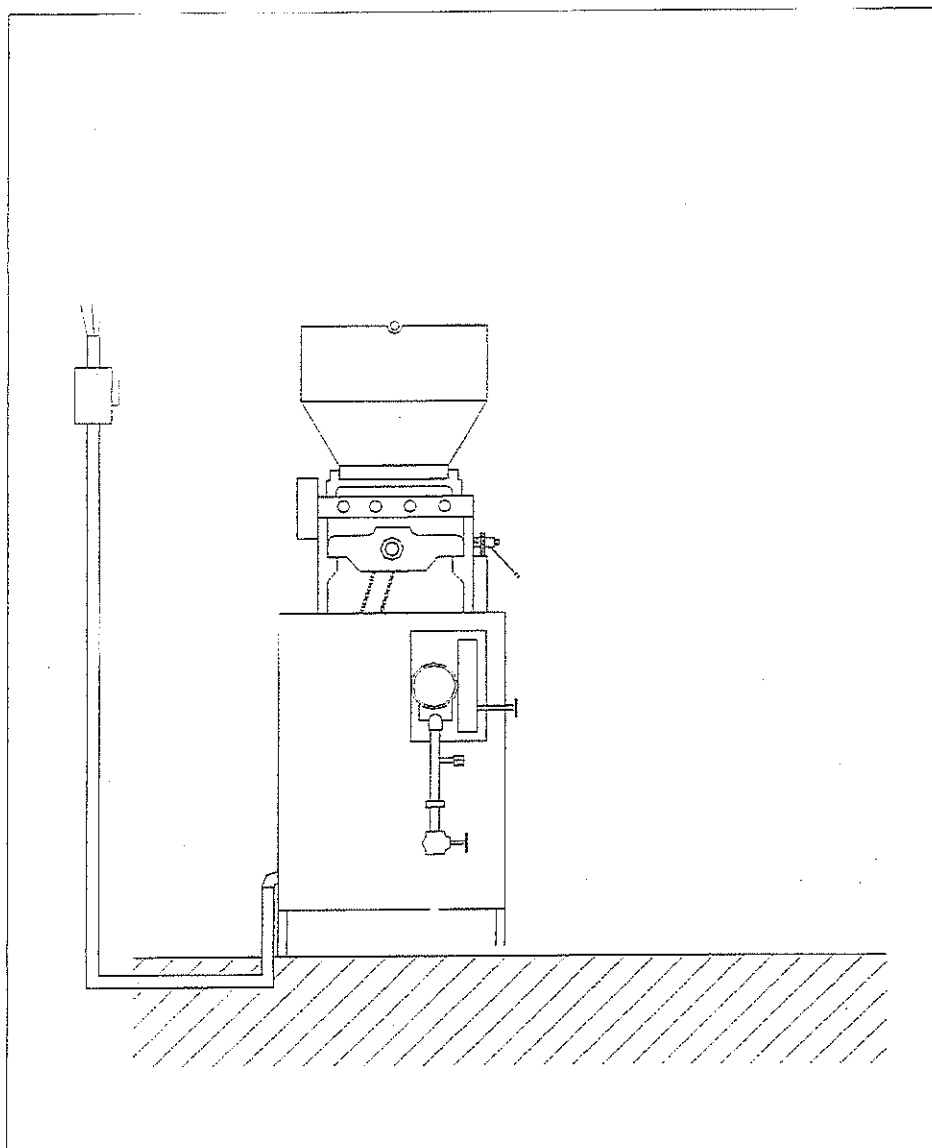
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For the electrical installation, your company should hire a qualified electrician who can install it based on your state building codes. There are some places with three-phase current and others with just monophasic.

We have various models of machines that we can deliver with three-phase current 220 volts, two-phase current 220 volts and monophasic currents 110 volts.

We recommend that the electrical installation follow the diagram below.

Electrical Installation of Celorio Tortilla Machine





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The Celorio Tortilla Machine has three main parts:

1. The Head
2. Chassis
3. Cooler

First, connect the head and the chassis.

Remove the screws from the chassis to connect it with the head.

Remove all of the white covers, ensure all gears are with the level of oil, if not, add additional oil in the following way. Remove the lateral plug that is at the oil level. If it spills over a bit that is okay, if not, remove the main plug and had oil until it spills over a bit into the lateral bore and firmly re-plug with holes.

Finding the gas line:

Remove the valve screws and the four screws on the chassis and throw out the cardboard cover. Assemble the line tightening the valve screws and the four chassis screws.

Connect the gas tubing really tightening the connections.

Install the swing in the head with the nuts and bolts. Adjust the height of the swing with the leveling bolts so that they don't rub on the cooker belt. Install the screen and tighten it with the wing nuts.



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Placement of Rollers:

Remove all covers the chassis and place the slices on the bolts. The two large slices are on the long bolts in the bottom of the first band near the head, two slices girls below the other four girls are rollers in front of the machine in its bolts. Two at the top and two at the bottom.

Lamina Slider:

Straightens a little slider up the swing and put the slider into the slots of the comb, adjust the distance of the slider with the band about 2 inches with the leveling screw.

Place the head string to the frame, going from top gear sprocket to sprocket head twice the frame and tensioned with the bearing.

Cooler Placement:

It takes 30-tooth sprocket and placed on the roll of the cooler, place the oppressors sprocket loosely. The mesh is placed in the cooler just leaving it as much as possible.

Now, to put the usher removed the bottom screws of the cooler bearings, they get the straps and put the screws in place leaving the straps down (vertically). Dual shoulder straps up leaving them approximately horizontally, place the usher adjusting the opening of the braces and holding it with its screws. Long strap is placed in the bottom of the setter and is screwed, the usher must be separated from the mesh approximately (1 centimeter).



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The surplus of cooling mesh is placed at the exit of the machine.

Loosen the bearings of 45 ° and are traversed back and place the mesh, for tensioning the mesh are traversed forwards the bearings of 45 ° and when the machine starts up the mesh is leveled.

To attach the cooler to the machine screw is removed $\frac{1}{2}$, the flat washer, the lock washer, nut and spacer and placed tightening the nut.

To attach the chassis to the cooler chain is separated as far as possible the cooler chassis from the usher, the chain is measured, cut and placed. Aligns the cooler back to the chassis. The sprocket 30 teeth stay loose, putting to work the machine aligns the chain alone, up to the machine and then tighten the oppressors of the ladybug.

Finally the cam is positioned in place. The arrow has previously being marked, put the cam by matching the oppressors and the marks and tighten, you put all the caps in place.

This is done installing the machine.

Operation Manual

Since the machine is installed is reviewed not have any foreign object or a tool forgotten.

Caps are removed from the chassis and checked that everything is in place and no foreign object inside it, put back caps.



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To check the head has to be disassembled as follows:

Remove the nut and remove the cross bar.

Remove the center support by first loosening the nuts inside and then outside.

Remove the tab along with the knob.

Remove the worm shaft by pressing down and turning left arrow to unlock the bayonet, it is recommended to have a band of approximately 40 centimeters.

Loosen the knobs of the pressure chamber evenly.

Lowering the tube coupling recirculating the hopper to rotate clockwise to unlock and remove base.

Loosen the knobs up to release the pressure chamber.

Similarly knobs are loosened uniformly from the upper base and removed.

We review the augers are in correct position for this augers are marked on the side of the slot, with a number as the lower base and these must match.

It was verified that no foreign body inside the machine, now it is then armed.

Place gently squeezing the upper base their knobs.



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Place the pressure chamber to the knobs in place without pinching.

Placing the hopper in position.

The coupling rises to its place, to secure the bottom and the top of the recirculation pipe.

Proceed to tighten knobs and uniformly upper base is equally applicable to tighten knobs evenly the pressure chamber.

Place the auger shaft to easily use a bank of approximately 40 centimeters high, pressed down the auger shaft and turn right on the arrow to lock bayonet.

Place the center support, taking care to center the arrow worm that rose in the hopper.

Place the rod with nut securing crossbar.

And finally put the tab with his goatee.

The machine is ready to work.

First to place the profiler provide lubrication in the flat, wall plates are removed to release the lifting lug the car, the car is run by matching the slot on the guide carriage to move freely profiler with the flat side up and groove to be sure the right side, push the safety (or screw) of the car taking care that it remains within the groove of the profiler but without reaching the bottom, and placed



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the profiler put their screeds elevation.

We proceed to put dough into the hopper of the machine, if you use a whisk flour is recommended Celorio camera, if you use corn dough is not necessary.

It gives movement to the head, we proceed to give a product with uniform mixing throughout the ratchet open, then closed the ratchet to give the desired thickness of the tortilla, with the help of the tongue achieving roundness of tortillas, If the tortilla tucking and pulling out oval if the tortilla out long, and obtained the desired quality of the tables in both thickness and its round shape. Stop the head.

The quadrant carburetor valve is placed in the no. 4
Recommended by mechanical automatic ignition depending on the model of the machine.

It passes 10 to 15 seconds after opening the valve of the gas and pressing the power button.

We removed the top cover and side cover central to check that all nozzles are turned on. If all nozzles are turned on closing the key drivers and put on their caps. In case some do not turn off the faucet of the pilot, open again and press the power button automatic. In case you do not turn on, shut off the gas and start over again on.



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Preheat the machine one minute maximum then turn off the gas, remove the front cover and put the three belt nonstick cookers if normal machine, the second and third if the 1st belt is Teflon.

Place the lid is turned back against the tip of the chassis following the above procedure, allow at least five minutes to achieve operating temperature of the machine, after these are missed about 3 or 4 tortillas test if you lack cooking leave a little more time and re-do the test. If cooking is not good re-check the carburation, if good cooking is achieved proceed with the production of tortillas

Already in production if the tables were to go broken and torn it is because of no grain. To remove the procedure is as follows:

The blades are opened the entire pawl to obtain thick tortillas and pass the grain. Then you climb back into position ratchet until to obtain the desire thickness in the tortilla.

At the end of the day, when completed the production of tortillas head stops, close the main gas valve and wait for it to empty the gas from the pipe. This is when all nozzles turn off. Then close the gas valve to turn off the machine.

Leave the chassis working at least ten minutes to cool bands while moving then proceed to turn the machine off.



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To clean the machine:

Make sure the power switch is in the **off position**.

Screeds are removed to release the spring lifting the car, remove the profiler insurance and matches the slot on the carriage guide to sacred freely shaped.

Remove the knob with reed.

Remove the locking pin (rod).

Remove center support.

Using the 3-foot step. Removed the worm shaft, pressing down and turning left.

Loosen the knobs on the camera, gradually.

Bent down the coupling, spin the hopper to the right and remove.

Remove the coupling.

Loosen gradually knobs and remove the upper base.

Remove the small grinders, the two ends (left) the turn right and take off, both the center (right) will go toward the left and removed.

If your machine has four small grinders (duplex machines have 6 small grinders) both the center and the two outer grinders are remove by turning counter clock wise.



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Perfectly cleaned the lower base and bronzes of the mass surplus, for cleaning of bronze recommend doing this with a damp cloth and a piece of wood "ever with a metal object."

The upper base, hopper, the larger grinder, the pressure chamber, the central support, cross rod, the coupling and the small grinders thoroughly with water and a brush, removing very well all the waste mass, and mass, and dry cough parts perfectly so that they are ready to work the next day.



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By following the information in this manual you will prolong the life of your equipment and it will be maintain for many year of great use.

A. - You need to begin by knowing and become familiar with the lubrication points on the head, supported by a descriptive drawing attached.

Lubricate with lithium multiple daily fat.

- A) Arrows bayonets girls.
 - B) Arrow armed bayonets.
 - C) Oil pipes crown and pinion.
 - D) Square greaser right and left.
 - E) Left and right square Bearings.
 - F) Bearings top right and left.
 - G) Bearings arrow lefts and right cam.
 - H) Valve Carburetor (for chain guard eagle hole once a week).
2. - Lubrication point on the head every day.

Lubricate with SAE 40 oil



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- I) Chain of main bridge
 - J) Chain to the main shaft camshaft.
 - K) Oilers of the guides of the carriage 2 times per day.
 - L) Cam follower bearings 2 times per day.
 - M) Roller bushings swing.
 - N) Chain of clutch, when I get the machine.
 - O) Clutch, 2 times per day.
 - P) Gearbox oil change is recommended to change the first 5 days of work, removing the top cap and lower the gear, leaving out all the dirty oil, then fill the gear unit with diesel oil and drain it again, to remove the slices and dirty oil that is left, put bottom plug and refill the gearbox with oil through the side hole, put plug and tighten securely to prevent leakage.
 - Q) After recommends changing oil every ninety days (3 months) and without washing.
3. - Lubrication of the chassis with multiple lithium grease and oil SAE 40 removing covers the chassis.
- R) Lubricate the slider mechanic in his three points per side, lateral bronze, bronze bushing support bracket, if the machine model to drive with SAE 40 oil daily.
- R) Bronze Bearing armed, fat daily.
- S) Table 45 bronze bearing, grease daily.
- T) Lubricate chassis chains with graphite or graphite liquid diesel daily the first 15 days, then 2 times per week.



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U) Lubricate hinges with graphite bands knowledgeable liquid food grade daily the first 15 days, then twice a week

Cooler

V) Lubricate 4 bearings (2 per roll) multiple lithium grease.