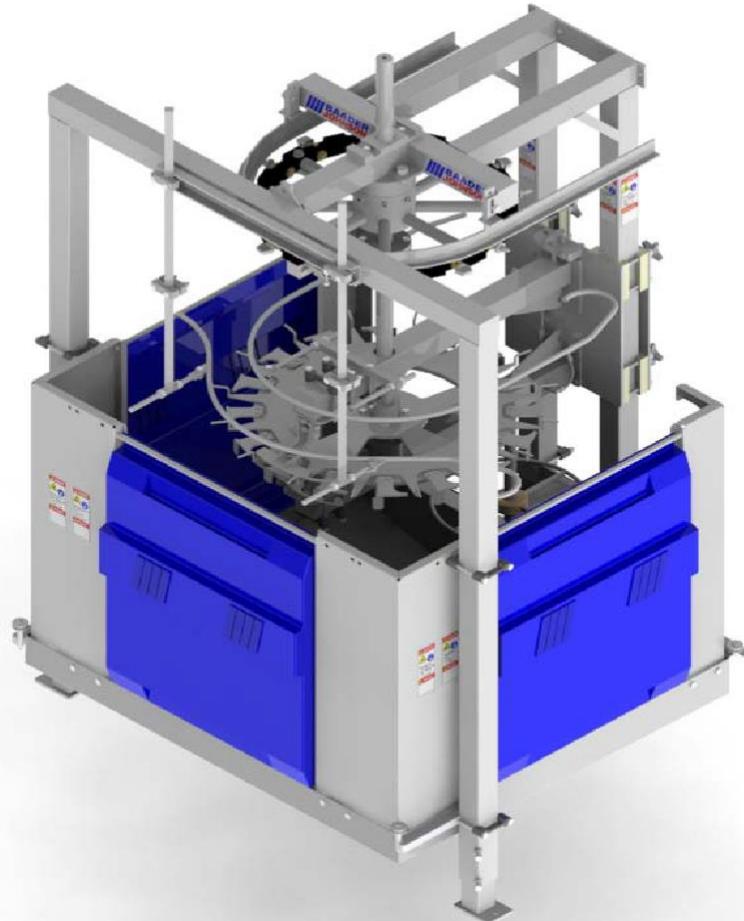


BAADER 1279.1-180

Oil Sac Cutter



Operation and Parts Manual

Ver1



INSTRUCT ALL PERSONS
WORKING ON OR NEAR
THE MACHINE DESCRIBED
IN THIS MANUAL TO CARE-
FULLY READ THIS ENTIRE MANUAL
BEFORE INSTALLING, OPERATING OR
MAINTAINING THIS MACHINE.

Serial No._____

Installation Date_____

Line No._____

Please distribute to the Maintenance, Spare Parts, Safety and Training Departments.



Baader-Linco, with corporate offices and a manufacturing facility in Kansas City, is a leading designer, manufacturer, and distributor of Baader-Linco poultry processing equipment worldwide. With more than 54 years of experience in the industry, we maintain a reputation for manufacturing high-quality, dependable products. Using the highest quality stainless steel and engineered plastics in the construction of our equipment, Baader-Linco machines are carefully constructed and designed to withstand the harsh environment of the processing plant.

Our parent company, Baader North America, is also headquartered in Kansas City. Their skill as a premier manufacturer of fish processing equipment adds engineering and design synergy that benefits all of our food processing customers.

Our staff continually strives to provide quality, value, and service to meet the ever-changing needs of our customers. From Scalding and de-feathering to cutup and packaging, Baader-Linco processing machines provide maximum quality and yield with minimum maintenance and supervision.



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1. SAFETY

DANGER

INSTRUCT ALL PERSONS WORKING ON OR
NEAR THE MACHINE DESCRIBED IN THIS
MANUAL TO CAREFULLY READ THIS ENTIRE

MANUAL BEFORE INSTALLING, OPERATING, OR MAINTAINING THIS MACHINE.
FAILURE TO FOLLOW THE INSTRUCTIONS IN THIS MANUAL MAY RESULT IN
SERIOUS PERSONAL INJURY, OR DEATH, MALFUNCTION OF THE MACHINE,
PROPERTY DAMAGE, and VOIDS ALL WARRANTIES

1.1 SAFETY ALERT SYMBOLS

Some of the following safety alert symbols have been used throughout this manual for your protection. When you see these symbols, please read carefully!



General Danger



Electrical Shock/Electrocution



Crush Hazard Overhead Load



Cutting of Fingers or Hand/Rotating
Blade



Hand, Arm or Body Entanglement



Lifting Hazard



No Access for Unqualified Personnel



Do Not Operate With Guards
Removed



Read Technical Manual before
Servicing



General Mandatory Action



Lockout/Tagout



Disconnect Power before Servicing



Wear Hardhat



Wear Ear Protection



Wear Eye Protection



Use Two Person Lift



1.2. SIGNAL WORDS

Signal words are used throughout this manual to call attention to the degree or level of the hazard seriousness.

DANGER: Indicates an imminently hazardous situation, which, if not avoided, will result in death or serious injury.

WARNING: Indicates a potentially hazardous situation, which if not avoided, may result in death or serious injury.

CAUTION: Indicates a potentially hazardous situation, which, if not avoided, may result in minor or moderate injury.

NOTICE: Indicates information or a company policy that relates directly or indirectly to the safety of personnel or protection of property.



1.3.SAFETY TIPS



CAUTION: USE PROPER LOCK AND TAGOUT PROCEDURES TO ELIMINATE POWER SOURCE PRIOR TO DISENGAGING MACHINE FROM DRIVE MECHANISM. FOLLOWING DISENGAGEMENT THE MACHINE MAY BE SERVICED.



- Keep long hair tied back and covered.
- Avoid wearing loose clothing, jewelry, or accessories around moving machine parts. This includes ties, shirtsleeves, rings, watches, and other loose fitting items.
- Never work without another person in the vicinity.
- Wear a safety helmet during installation or when working with or close to ladders, platforms, and forklifts.
- Wear safety glasses when performing any of the following operations.
 - 1) Using a hammer to drive pins, riveting, staking, etc.
 - 2) Power or hand drilling, grinding, reaming, etc.
 - 3) Using spring hooks or attaching springs.
 - 4) Soldering, cutting wire, removing steel bands, etc.
 - 5) Cleaning parts with solvents, sprays, or cleaners.
- After cleaning or maintenance, restore all safety devices such as guards, shields, signs, and grounding wires.
- Wear ear protection when exposed to noise exceeding 85 dB, such as when using a grinder, band saw, or hammer.
- Lift items with a straight back, pushing up with the leg muscles, to prevent back strain. Do not lift any equipment or parts weighing more than 30 kg (60 lbs) without assistance.

Use only USDA approved solvents, greases, or oils if there is any chance of product contact.



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1.4. SAFETY AND SERIAL #LABELS

The machine described in this manual has been supplied with safety labels placed in important locations on various parts of the machine to draw attention to potential safety hazards. The serial number label, along with company logo stickers, have also been placed on the machine and are part of the Safety and Serial # Label Kit.

The safety labels are an integral part of the safety features of this machine; therefore it is imperative that the safety labels remain on the machine and are well maintained, replace any worn, damaged or missing labels immediately. All safety labels must remain on the machine for the lifetime of the machine. Replacement labels can be ordered from your Baader-Linco® representative.

The safety labels are available as a kit or may be ordered as individual labels.

English/Spanish Kit 93880279

- 1) 93881602 - Label, Moving Parts S
- 2) 93881603 - Label, Entanglement S
- 3) 93881603 - Serial Plate, Generic
- 4) 93880774 – Baader logo
- 5) 93880775 – Linco Logo

English/French Kit 93881279

- 1) 93881612 - Label, Moving Parts F
- 2) 93881613 - Label, Entanglement F
- 3) 93881603 - Serial Plate, Generic
- 4) 93880774 – Baader Logo
- 5) 93880775 – Linco Logo



1.5. LABELS SUPPLIED WITH MACHINE



1

93881602
93881612

2

93881603
93881613

3

93881601



BAADER LINCO INC.
2955 Fairfax Trafficway, Kansas City KS 66115

Type

Date

Project/Serial#

Electrical V Ph Hz
 hp kW A

Wiring Diagram #

Air

Vacuum

Pneum. Diagram #

Oil

Hydr. Diagram #

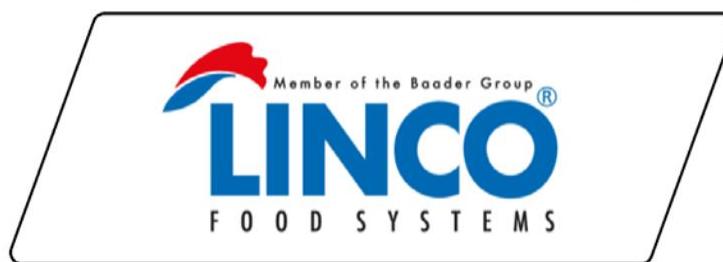
Water

Weight Made In U.S.A.

3 93880749



4 93880774

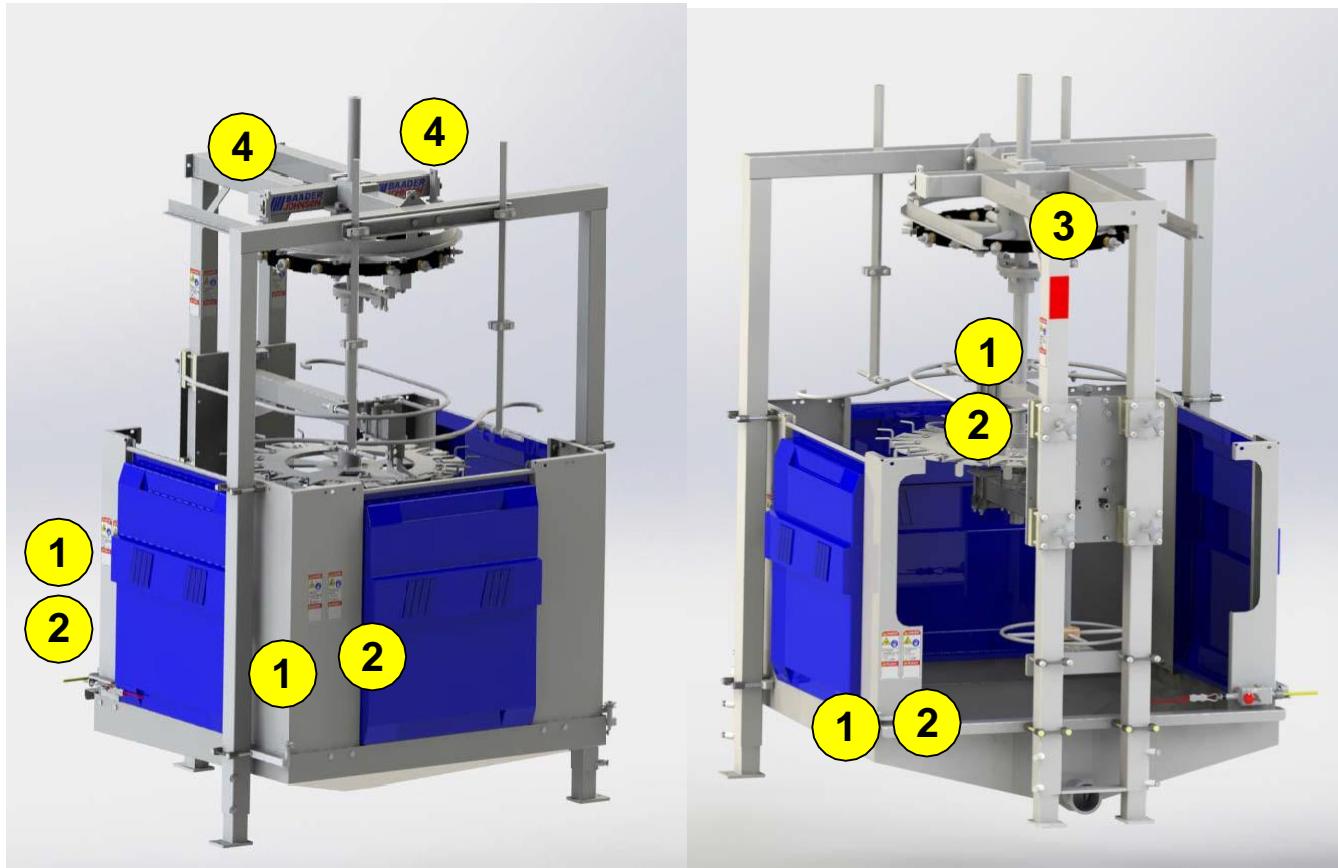


5 93880775

1-800-288-3434



1.6. LOCATION OF SAFETY LABELS





2. CUSTOMER SERVICE

BAADER-LINCO® SERVICE - Please let us know of any questions or problems you may have. We want to answer or correct them as quickly as possible. Our service staff is available in the home office and in the field to assist you in analyzing performance-related issues. Please conduct a performance check of the machine before calling our office.

PARTS LISTS - These documents will facilitate the identification and correct ordering of spare parts for a BAADER-Linco® machine. A stock of spare parts is kept for all ordinary requirements and every effort is made to complete deliveries in the shortest possible time. Special attention is given to emergency requests in the case of a major spares order such as parts for a rebuild, we ask that you allow four weeks to complete the delivery.

ORDERING - For ease of ordering, a copy of the parts list can be made and the "Customer Use" column can be used for quantity required or other remarks. When ordering parts, please give the following information:

- 1) Model Number and machine Serial Number
- 2) Part Number and description of each part
- 3) Quantity required for each part ordered

PROPRIETARY EQUIPMENT - BAADER-Linco® parts are manufactured to exact specifications using high quality materials. Because of customer preference, some components listed may have been replaced on the machine by a comparable unit of similar specification. We will only be responsible for genuine BAADER-Linco® parts available from BAADER-Linco Food Equipment and our official agents.

ADDITIONAL MANUALS - Additional copies of this manual may be ordered by contacting our customer service department at 1-800-288-3434



CAUTION:

**MODIFICATIONS TO MACHINE ARE PROHIBITED.
MODIFICATIONS MAY CAUSE UNEXPECTED
CONSEQUENCES, HAZARDS OR SAFETY ISSUES.**



OFFICE - All orders, questions and inquiries should be directed to one of the offices listed below, or we can supply the name and address of our nearest agent. Office hours are 7:30 to 4:00 (Central Time) Monday through Friday.

BAADER-Linco® Food Processing Machinery, Kansas City
(800) 288-3434 (Toll free) (913) 621-3366 (913)621-1729 (Fax)
2955 Fairfax Trafficway Kansas City Kansas, 66115

BAADER-Linco® Ltd, Toronto
(800) 288-3434 (Toll Free) (913) 621-3366 (913) 621-1729 (Fax)
P.O. Box 9717 Toronto Ontario, Canada, M5W 1R6

BAADER® Auburn, Washington
(800) 835-8856 (Toll Free) (253) 333-0422 (253) 735-9420 (Fax)
1512 Boundary Blvd. Suite 102, Auburn, WA 98001

BAADER® Indianola, Mississippi
(800) 249-3952 (Toll Free) (662) 887-5841 (662) 887-3686 (Fax)
1457 Highway 82 East Indianola Mississippi, 38751

BAADER® Canada Ltd, Newfoundland
(800) 565-2753 (Toll free) (709) 738-3414 (709) 738-3417 (Fax)
702 Water Street St. John's Newfoundland Labrador, Canada, A1E1C1

BAADER® Canpolar, Newfoundland
(709) 722-4200 (709) 722-4212 (Fax)
702 Water Street St. John's Newfoundland Labrador, Canada, A1E1C1



3. CHECK COMPLETENESS OF DELIVERY

3.2. CHECK SHIPMENT

Check for damage to the machine. If any damage has occurred, notify the Baader-Linco® Customer Service department immediately.

3.3. SHIPMENT CHECKLIST (SHIPPED WITH YOUR MACHINE)

Downtime Prevention Kits and other parts are shipped in a separate box tied to the machine pallet. Please open the box and check for missing parts. Refer to the Shipment Checklist. If any of these parts are missing, notify the Baader-Linco® Customer Service department immediately.

3.4. FILL IN INFORMATION ON MANUAL COVER

Ensure that the machine serial number, installation date, and line number where the machine is installed are written in the blank provided on the cover page of the manual.



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4. MACHINE FUNCTION

The BAADER-Linco® Oil Sac Cuter Machine (BAADER 1279.1) unique features include:

- Increased dwell time
- Consistent performance
- Simple to adjust and maintain
- 24" to 36" shackle make-ups
- Bird positioning finger eliminates drag back.
- On-the-fly adjustability



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5. TECHNICAL SPECIFICATIONS

	US	Metric
<u>Operating Range</u>	Min 3 Lb	1.4 Kg
	Max 8 Lb	4 Kg

Note: The indicated limits of the working ranges may vary as a function of the proportion, quality and nutritional condition of the product. In order to achieve an optimal result, the machine should be adjusted within its working range to the product size principally processed.

<u>Capacity</u>	Min	42bpm (2,500bph)
	Max	160bpm (9,600bph)

Note: All others subject to approval by Baader-Linco

Weights, Dims & Volume

<i>Machine Weight</i>	550 Lb	250 Kg
<i>Shipping Weight</i>	750 Lb	350 Kg
<i>Shipping Dimension</i>	L 121 "	3100 mm
	W 82 "	2100 mm
	H 75 "	2000 mm
<i>Shipping Volume</i>	431 ft ³	12 m ³

WATER

<i>Process Water Requirement</i>	V 2 GPM	8 l/min
	P 40 PSI	3 bar 16 °C
	T 60 °F	

Process Water Connection 1/4 "FNPT 1/4 "FNPT

MECHANICAL

Torque Requirements 50 ft lb 70 Nm

Shackle Length

Min 26 " 665 mm

Max 34 " 865 mm

Track Height Min Min 84 " 2150 mm

Max 115 " 2950 mm

Shackle Types

Plastic BLI rigid shackle

Plastic & Stainless BLI 2-piece

Note: All others subject to approval by Baader-Linco Note: All rigid shackles to be mounted with neutral clips or clips pointing away from the machine.

Track Types

T-rail (50mm)

I-Beam (3")

Round Pipe 1 1/4" Sch 80

Note: All others subject to approval by Baader-Linco

Chain Types Log chain (1")

Log chain (1 1/2") X 348

Note: All others subject to approval by Baader-Linco Note: Chain stretch not to exceed 4%



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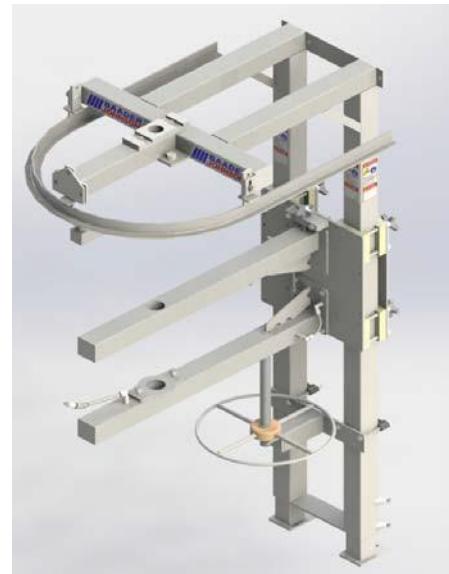
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6. MACHINE COMPONENTS

6.1. FRAME ASSEMBLY

The frame of the Oil Sac Cutter consists of three main components.



6.1.1. TOP FRAME

This is the horizontal member of the frame. It has to be supported from the roof structure or another structure stable enough to withstand the forces that can occur in the track. The top frame supports the track member, the drive wheel and the barrel.



6.1.2. REAR LEGS

The rear legs are the vertical members of the frame, which support the top frame. They also support the barrel and main plates. Frame leg extensions are available if required.





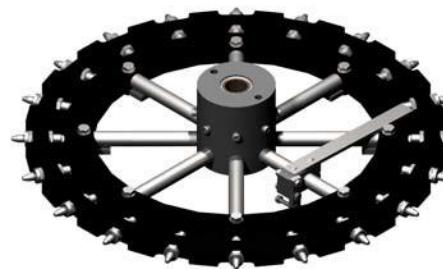
6.1.3. TRACK

The track is mounted to the top frame and adjustable in height to accommodate trolley variances. See the technical specifications for standard available track options.



6.1. DRIVE WHEEL

The drive wheel consists of three main components.



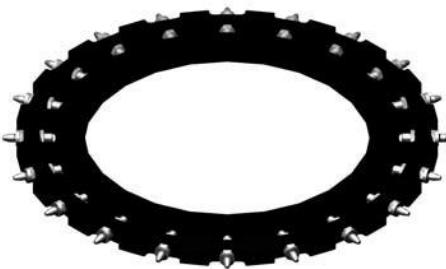
6.2.1. HUB WITH SPOKES

This hub contains two tapered roller bearings to withstand the forces of the overhead chain.



6.2.2. DRIVE WHEEL RIM

This nylon rim is driven from the conveyor chain by means of teeth. The teeth differ in shape and material depending on the type of chain that is used. See technical specifications for the standard available chain options.



6.2.3. SHEAR PIN ASSEMBLY

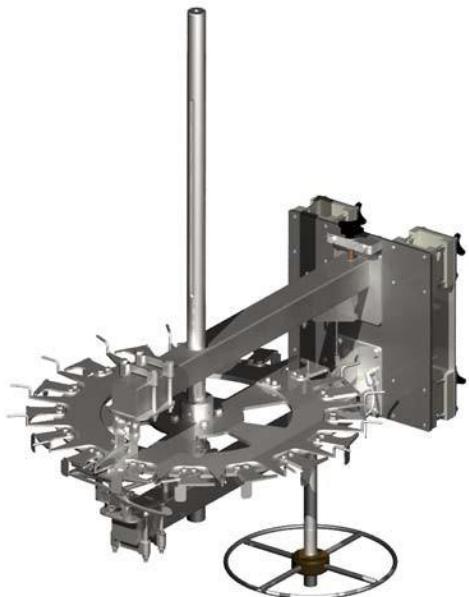
This assembly is clamped on one of the eight spokes and matches the radius of the drive pin on the barrel. It causes the barrel to rotate in time with the conveyor. In an overload situation, a shear bolt will break to protect the machine from being damaged.





6.3. BARREL ASSEMBLY

The barrel assembly moves up and down relative to the track by means of a turn wheel/lift assembly to accommodate operational variance. It contains all of the functional machine components.



6.3.1. MAIN SHAFT ASSEMBLY

The main shaft assembly contains all components that directly mount to the main shaft. This includes the main machine bearings, adjustment ring, cutters (bird positioner), vee blade and the tail press.





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7. INSTALLATION

7.1. INTRODUCTION

BAADER-Linco® Field Service Technicians are available to supervise the installation. These technicians will not install the machine, but will ensure proper placement, adjustment and start-up procedures are maintained. The technicians are also available to provide training and guidance on maintenance, servicing and safety and that the installation is done according to BAADER-Linco® standards.



NOTICE:

FAILURE TO FOLLOW THE RECOMMENDATIONS OF THE BAADER-LINCO® TECHNICIAN CAN VOID THE WARRANTY ON THE EQUIPMENT INSTALLED!

7.2. GENERAL SAFETY INSTRUCTIONS



NOTICE:

MECHANICAL AND/OR ELECTRICAL OPERATIONS DESCRIBED IN THE INSTALLATION SECTION MUST BE MADE BY A QUALIFIED ELECTRICIAN, MAINTENANCE PERSON, OR SUPERVISOR FOR THIS EQUIPMENT. THE INSTALLATION AND USE OF THIS PRODUCT MUST COMPLY WITH ALL APPLICABLE NATIONAL, STATE, AND LOCAL CODES.



CAUTION:

SINCE THE MACHINE IS DRIVEN BY AN OVERHEAD CONVEYOR; IT IS MANDATORY FOR THE OVERHEAD CONVEYOR TO HAVE A STOP SWITCH WITH A MECHANICAL LOCKOUT! A WRITTEN LOCKOUT/TAG OUT PROCEDURE MUST ALSO BE IN PLACE TO PREVENT OPERATION OF THE OVERHEAD CONVEYOR!



DANGER:

DISCONNECT THE POWER TO THE OVERHEAD CONVEYOR BY FOLLOWING THE PLANT LOCKOUT/TAGOUT PROCEDURE. THIS IS NECESSARY TO ELIMINATE ACCIDENTAL START-UP OF THE CONVEYOR WHILE THE MACHINE IS BEING INSTALLED OR ADJUSTMENTS ARE BEING MADE. FAILURE TO DO SO MAY RESULT IN MALFUNCTION OF THE MACHINE, PROPERTY DAMAGE, AND SUBJECTS' PERSONNEL TO SERIOUS PERSONAL INJURY, OR DEATH

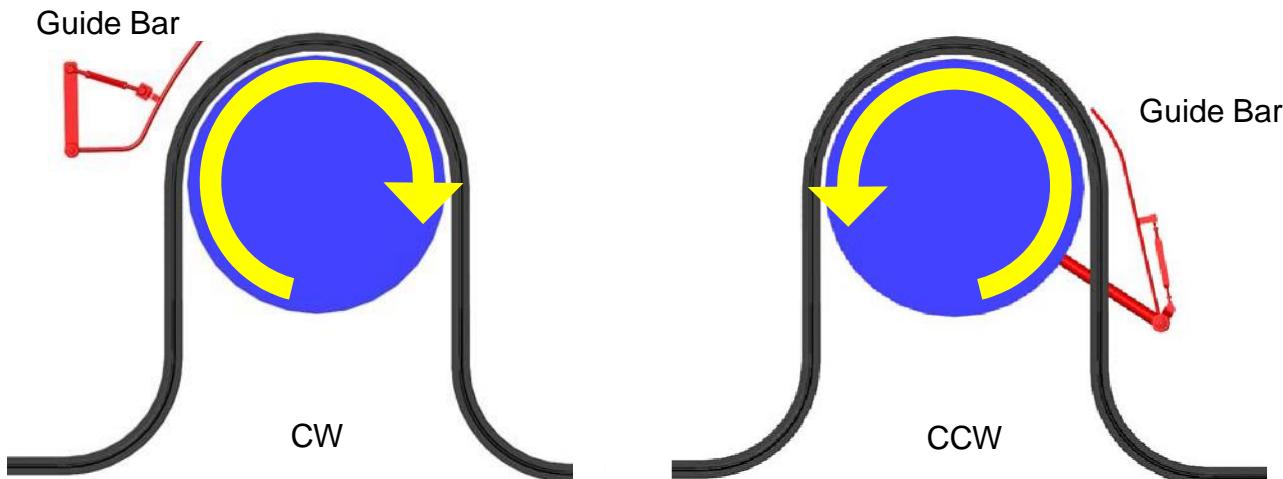


7.3. ESTIMATED INSTALLATION TIME

Check Shipment	1/2 hour, 1 person
Prepare Machine	1 hour, 1 person
Install Machine	12 hours, 8 persons
Utility & Air Hookup	2 hour, 2 persons
Pre-start-up Prep	3 hour, 2 persons
Above required times can vary depending on the situation.	

7.4. CHECK LAYOUT & MACHINE ROTATION

Check the layout drawing and compare it to the actual situation. Determine the rotation of the machine. The rotation of the machine is determined by the location of the infeed guide bars.



Ensure that the birds will enter the machine with the back out.

Locate the exact position where the machine will be installed. The area from the floor to the track must be free of any obstructions such as water lines, water flush trough, water rail etc.



7.5. CHECK TRACK HEIGHT

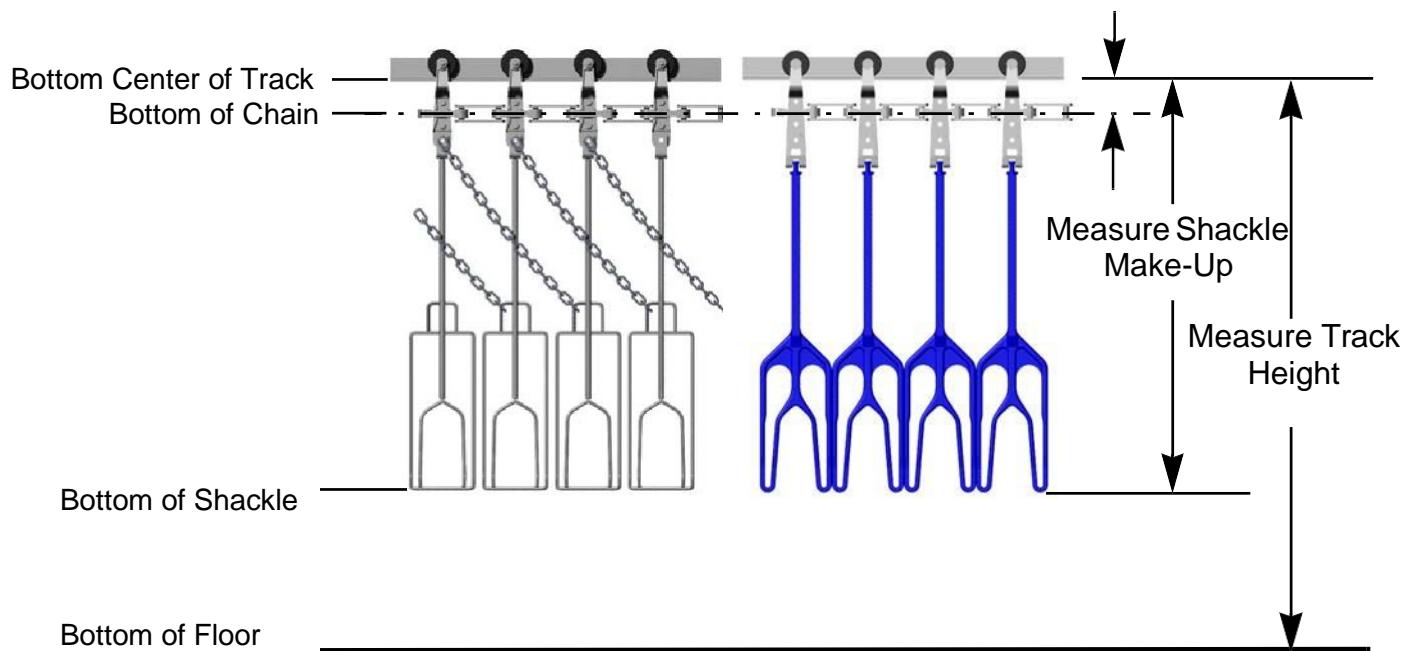
Measure the track heights at the location where the machine will be installed.
Track height is measured from the bottom of the track to the floor.

7.6. CHECK SHACKLE MAKEUP & TRACK

The shackle makeup is the distance from the bottom of the track to the bottom of the shackle. For optimum performance, shackle make-up variation must not be more than +/-3mm.

7.7. MEASURE TRACK TO CENTER OF CHAIN

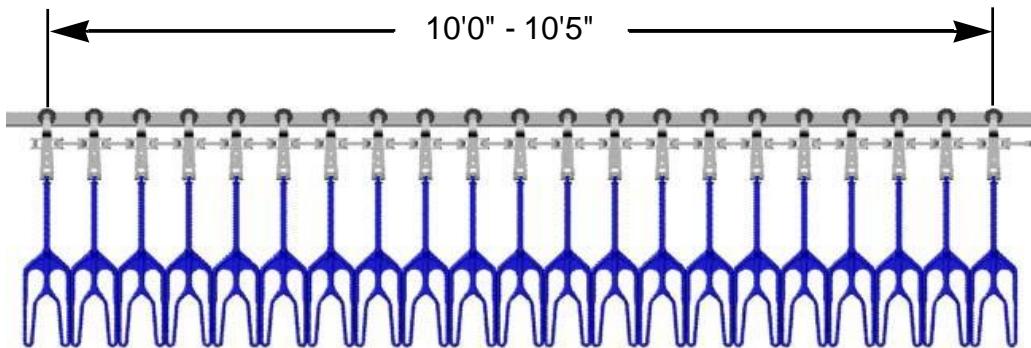
The distance from the bottom of the track to the center of the chain is critical for proper engagement of the drive rim by the chain. Measure this distance where the machine will be installed. Record your measurement in the Shackle Table.





7.8. MEASURE CHAIN STRETCH

Measure the chain length with a tape ruler over 20 (center to center of 21) trolleys. Measure in different locations as the conveyor stretch may vary. The dimension over 20 trolleys should be between 10'0" and 10'5". If your chain length (measured over the 20 trolleys) is more than 10'5" (4% stretch) new chain is required for proper operation of the machine. Record your measurement in the Shackle Table.



NOTICE:

More than 4% chain stretch will cause performance problems.
(5" per 10' section)

Item	Measurement
Track Height	
Shackle Makeup	
Makeup Variation	
Track to Chain Center	
20 Trolley Chain Length	

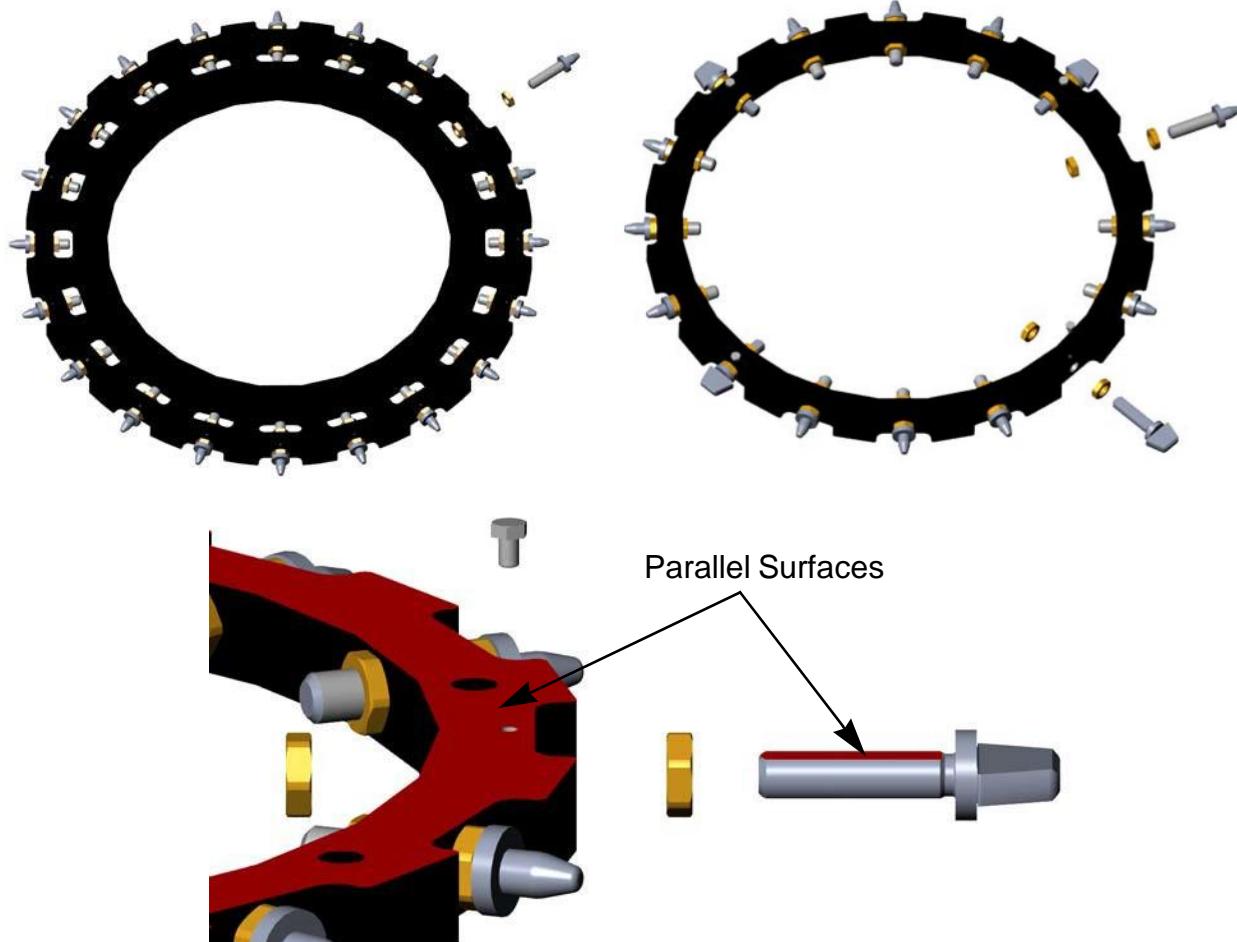


7.9. SET DRIVE WHEEL TEETH (X348 ONLY)

Only drive wheels designed for X348 chain needs to be set up as shown and as described below:

This drive wheel comes with 16, 20 or 24 stainless steel teeth (depending on the size) that are independently adjusted to account for chain stretch.

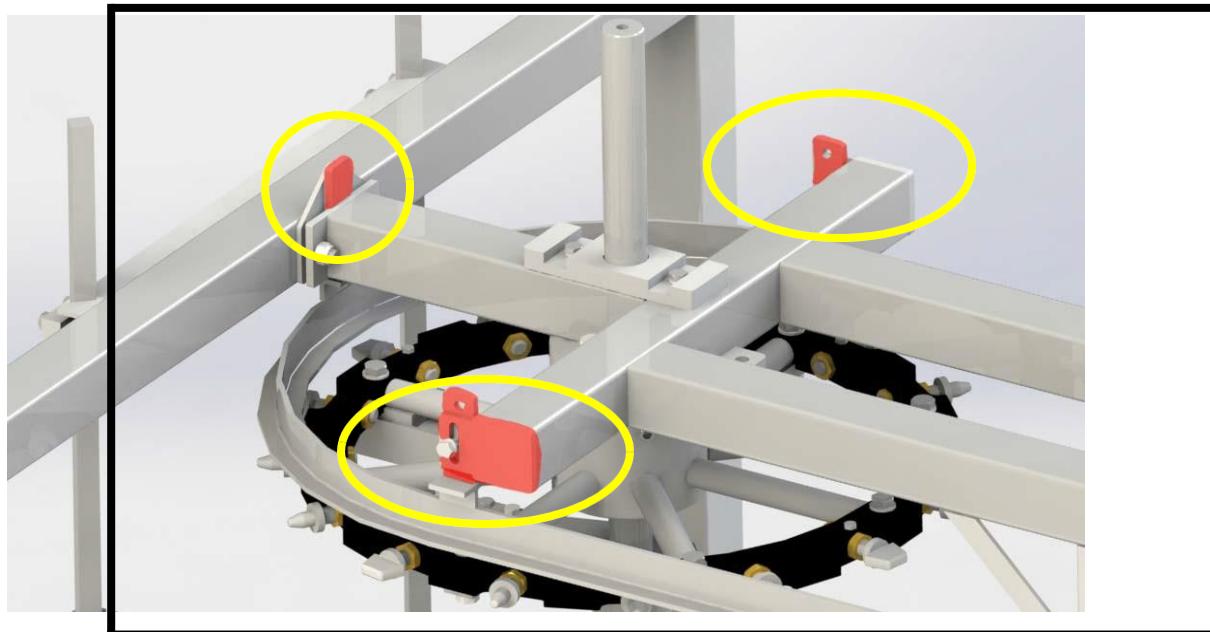
To adjust, loosen the tooth CCW to back it out for stretched chain. (New chain generally requires the teeth and the brass nuts to be screwed in fully.) Go one revolution per tooth and test run the wheel. Repeat if more adjustment is necessary. Be sure to retighten the brass nuts against the drive rim to lock the teeth in place. Drive wheels with additional flat teeth will need to have their machined flat surface parallel with the flat surface of the drive wheel before tightening the M8 lock bolts just snug.



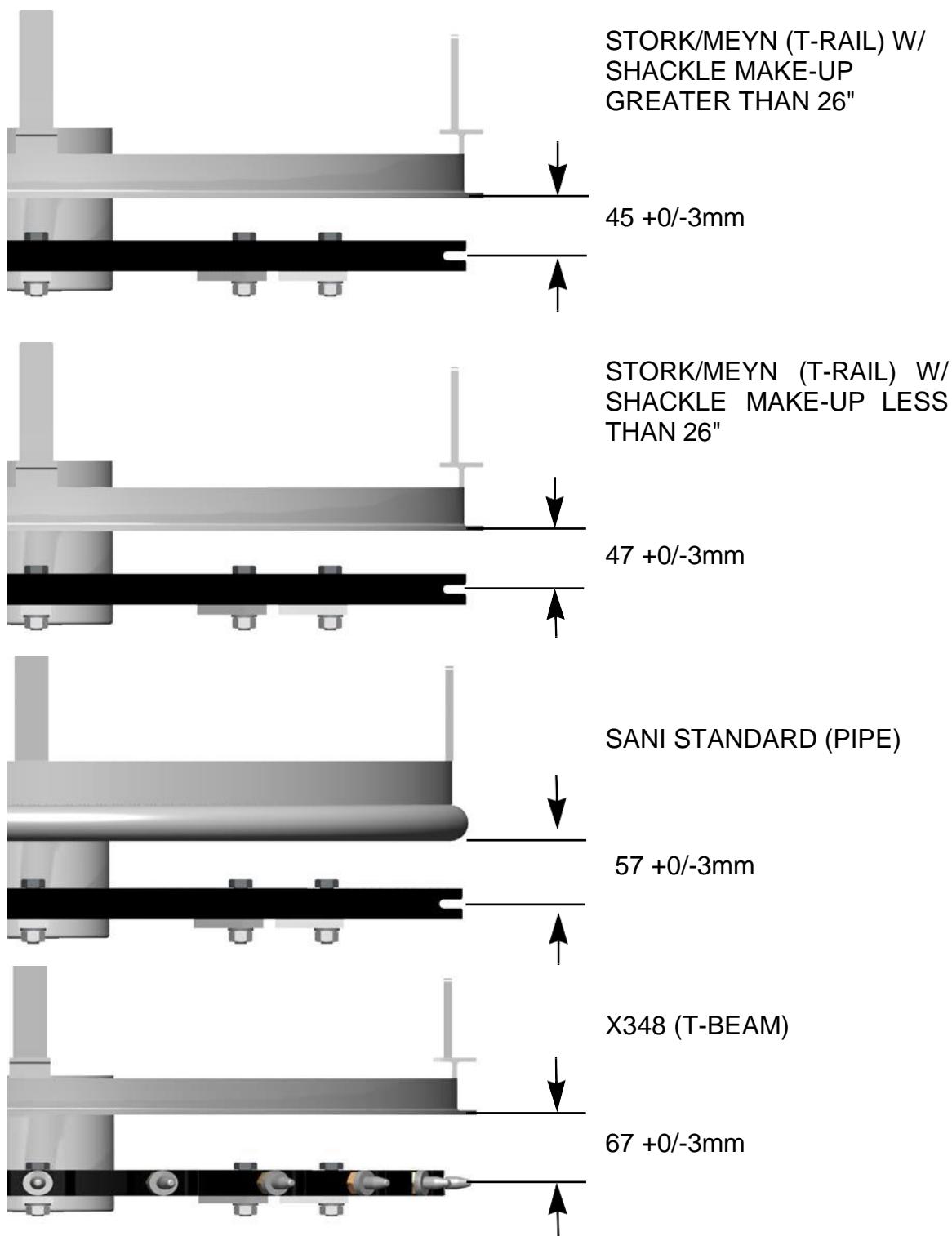


7.10. CHECK TRACK HEIGHT

The track is preset at the factory. Check the track adjustment on the machine at all three locations to the required dimension. If setting is incorrect make adjustments as necessary.



! NOTICE: INCORRECT TRACK SETTING CAN CAUSE UNNECESSARY WEAR OF THE TROLLEY WHEELS. IT CAN ALSO CAUSE SCRAPING OF THE TROLLEY OVER THE TRACK, RESULTING IN METAL DUST OR SHAVINGS IN BIRDS.





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8. INSTALLATION INSTRUCTIONS



WARNING:

WEAR A SAFETY HELMET DURING INSTALLATION OR WHEN WORKING WITH OR CLOSE TO LADDERS, PLATFORMS, AND FORKLIFTS.



WARNING:

WEAR SAFETY GLASSES WHEN PERFORMING ANY OF THE FOLLOWING OPERATIONS.



CAUTION:

WEAR EAR PROTECTION WHEN EXPOSED TO NOISE EXCEEDING 90 DB, SUCH AS WHEN USING A GRINDER, BAND SAW, OR HAMMER.

8.1. POSITION MACHINE ACCORDING TO LAYOUT

Modify the track according to the plant/line layout. Ensure straight cuts of the track where the machine hooks up.

Place the pallet containing the machine in such a position that the upper frame assembly is in the correct location.

Use caution when transporting the machine. Lift only the pallet; with care taken that no machine components are damaged.



8.2. CONNECT OVERHEAD CONVEYOR



DANGER: AN IMPROPER HOIST OR A WEAK STRUCTURE CAN CAUSE THE MACHINE TO DROP, RESULTING IN SERIOUS INJURY OR DEATH!



NOTICE: COVER THE BARRELS WITH FIRE RESISTANT MATERIAL BEFORE WELDING OR GRINDING TO THE TRACK OR THE SUPPORTS TO PREVENT ANY DAMAGE TO THE PLASTIC COMPONENTS AND TO PREVENT DUST ENTERING CRITICAL AREAS WITH MOVING PARTS. A SMOOTH TRACK IS VERY IMPORTANT FOR THE LIFE OF THE CONVEYOR WHEELS.



NOTICE: ONLY HOIST THE MACHINE BY STRUCTURAL FRAME MEMBERS.



NOTICE: ATTACH A GROUNDING ELECTRODE NEAR THE POINT OF WELDING TO PREVENT WELDING CURRENT FROM PASSING THROUGH COMPONENTS SUCH AS BEARINGS.

Consult the plant engineer for hanging a hoist from the roof or other support structure capable of handling a 2000-pound (900 kg) load at the location above the upper frame of the machine. Ensure the hoist is capable of lifting 2000 pounds (900 kg) and that the hoist is in good condition. Hook the hoist cable to straps around the upper frame. Lift the machine slowly into position. When the machine is close to its final position and is upright, carefully remove the shipping pallet and braces. Use caution and ensure that the machine is adequately strapped to support members and will not fall. Make sure the track on the machine matches the conveyor track. Make height corrections with the floor pads and ensure that the top frame of the machine is level in both directions.

Clamp the machine track end to the track end of the line by means of a long thick flat bar in case of I-Beam track or T-Rail. Use a 2" angle iron in case of round pipe track. Weld the track together. After welding, grind the conveyor track smooth where the trolley wheels ride.



8.3. FRAME BRACING



DANGER:

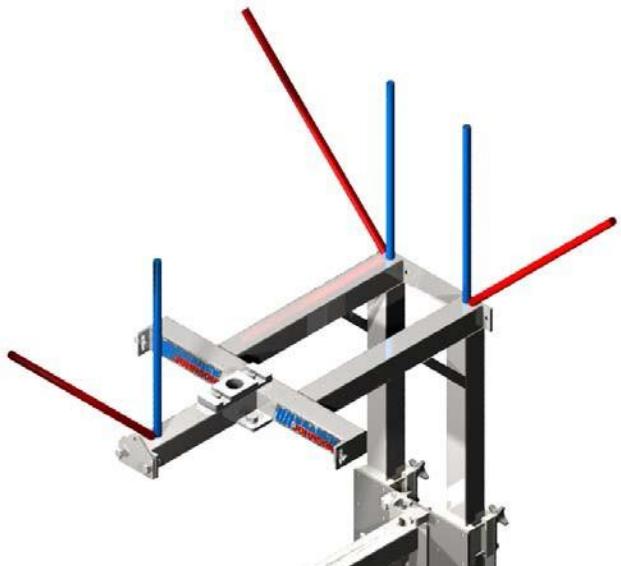
IMPROPER STRUCTURAL SUPPORT CAN CAUSE THE MACHINE TO BE PULLED OUT OF THE LINE AND RESULT IN SERIOUS PERSONAL INJURY OR DEATH!



NOTICE:

WIPE OFF ALL METAL SHAVINGS AND GRINDING DUST FROM THE TRACK AND THE TOP FRAME. THIS SHOULD PREVENT METAL PARTICLES FROM BEING CARRIED TO OTHER PLACES WHERE EVENTUALLY THEY MAY DROP INTO A BIRD. CHECK THE MACHINE THOROUGHLY FOR GRINDING DUST AND OTHER FOREIGN OBJECTS. WIPE THE BARREL PARTS AND USE A HIGH-PRESSURE HOSE TO FINISH CLEANING. GRINDING DUST IN MOVING PARTS WILL CAUSE INCREASED WEAR, SHORTEN THE LIFE OF THE MACHINE AND MAY VOID THE WARRANTY.

Check again to be sure the frame is plumb and level in all directions. Cross brace the machine to the roof or other support structure in at least two directions (depending on the rigidity of the structure) from the provided support plates on the top frame. One inch SCH 40 pipe is recommended. Consult a Plant Engineer to determine the location of the supports on the structure.



NOTICE:

DO NOT BRACE THE TRACK SECTION OF THE MACHINE. KEEP IN MIND THAT A STRUCTURAL TRIANGLE SUPPORT CONFIGURATION IS THE STRONGEST.

8.4. CONNECT OVERHEAD CHAIN

If you use X348 chain ensure that the correct number of tooth spacers were selected for the amount of chain stretch (see "SET DRIVE WHEEL"). The selection is correct if the teeth feed into the chain without bumping at the infeed side of the chain. Connect the chain together and tension the overhead chain.



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9. UTILITIES INSTALLATION

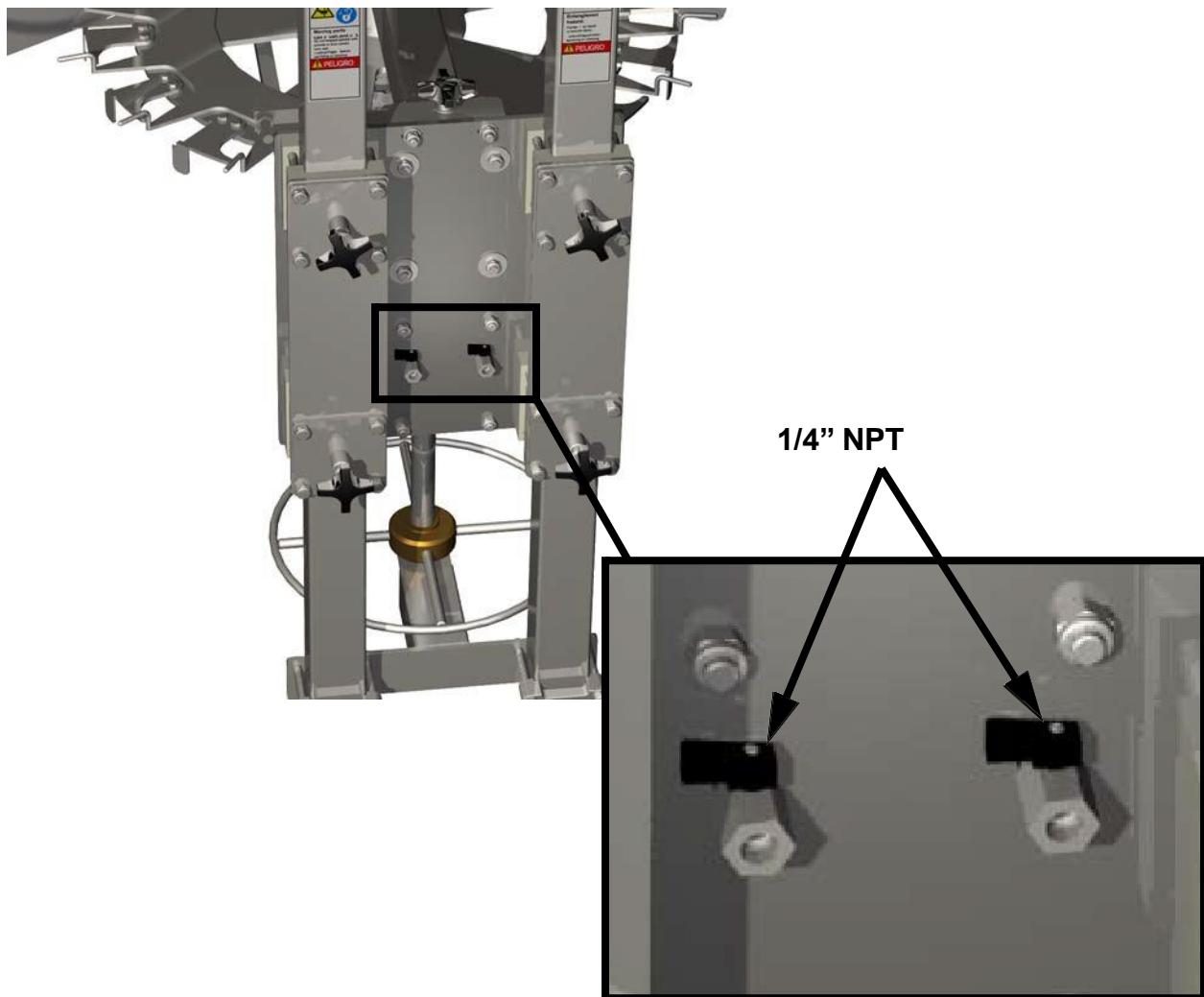


CAUTION:

STOP THE OVERHEAD CONVEYOR AT THE MACHINE AND IMPLEMENT THE PLANT LOCK/TAGOUT PROCEDURE TO PREVENT ACCIDENTAL STARTING. FAILURE TO DO SO MAY RESULT IN MALFUNCTION OF THE MACHINE, PROPERTY DAMAGE, AND SUBJECTS' PERSONNEL TO SERIOUS PERSONAL INJURY, OR DEATH.

9.1. WATER

Run water supply lines to the two 1/4" NPT ball valves located at the back of the machine. Water pressure can be regulated at this location.





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10. BASIC MACHINE SETTINGS



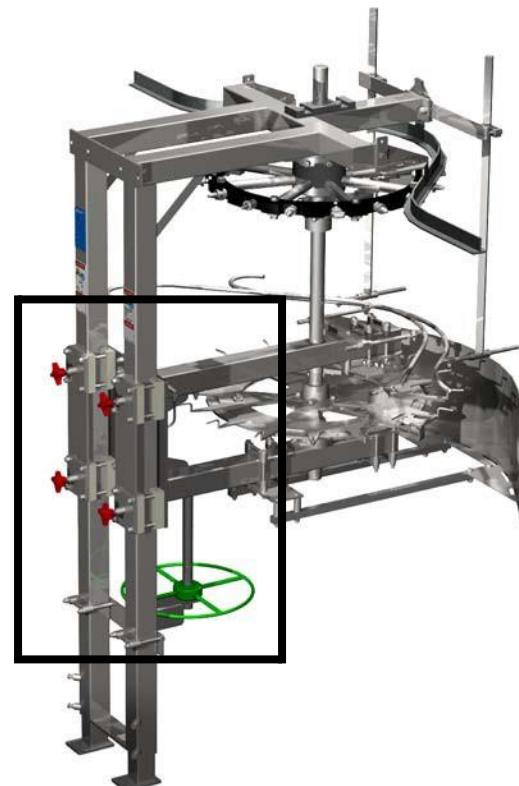
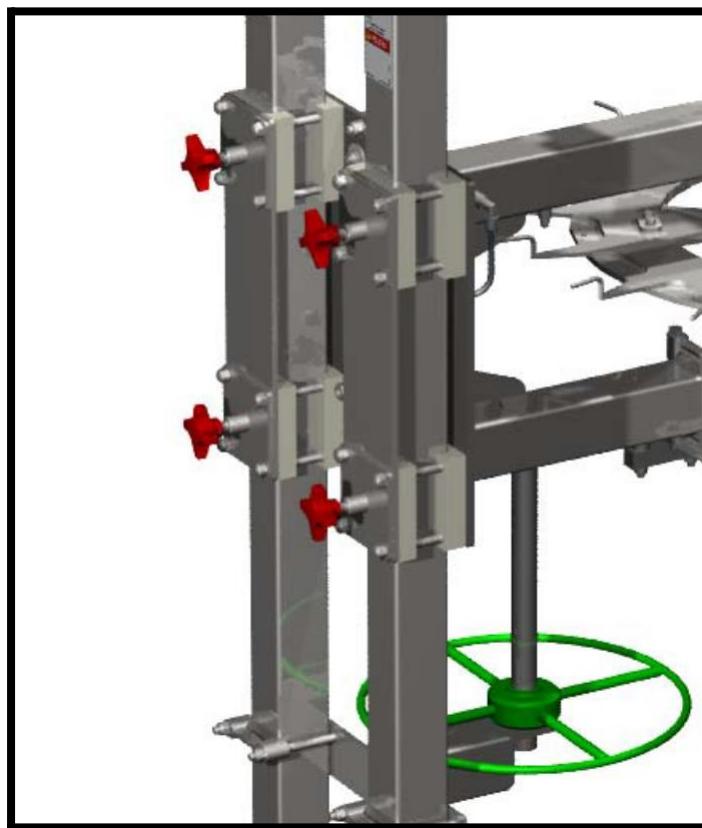
CAUTION:

STOP THE OVERHEAD CONVEYOR AT THE MACHINE AND IMPLEMENT THE PLANT LOCK/TAGOUT PROCEDURE TO PREVENT ACCIDENTAL STARTING. FAILURE TO DO SO MAY RESULT IN MALFUNCTION OF THE MACHINE, PROPERTY DAMAGE, AND SUBJECTS PERSONNEL TO SERIOUS PERSONAL INJURY, OR DEATH.

10.1. HEIGHT ADJUSTMENT

The hand wheel is used to lower and raise the machine in/out of line. It is also used for height adjustments.

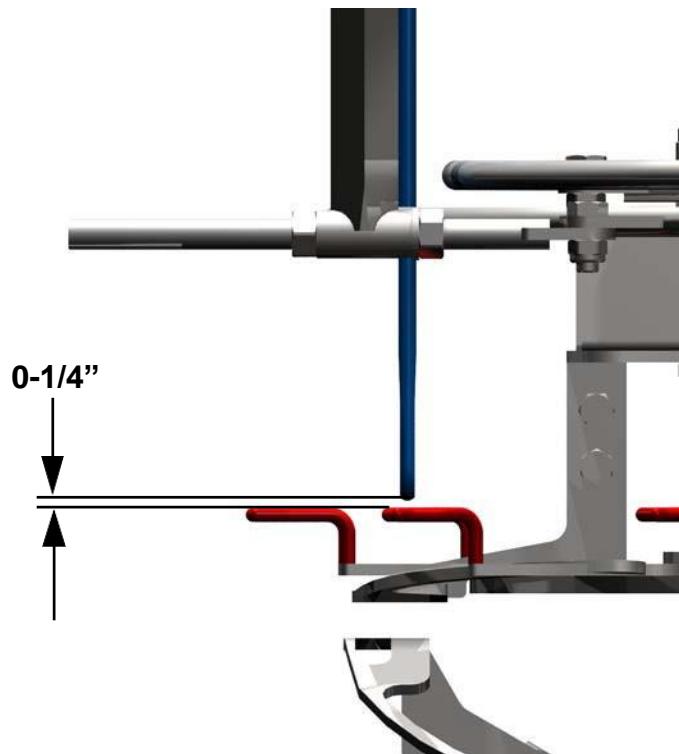
To make height adjustments, first loosen the four hand knobs on the back of the machine. To raise the machine turn the hand wheel clockwise, to lower the machine turn the hand wheel counterclockwise. After height adjustments have been made retighten the hand knobs.





10.2. SHACKLE HEIGHT ADJUSTMENT

With the machine in-line, the bottom of the shackle should be between 0 and 1/4" above the top edge of the pick-up finger. Use the procedure in the "HEIGHT ADJUSTMENT" section to make this adjustment.



CAUTION:

NEVER LIFT THE MACHINE UP WHERE A SHACKLE CAN BE HOOKED BY A PICK-UP FINGER. DOING SO MAY RESULT IN MALFUNCTION OF THE MACHINE AND/OR PROPERTY DAMAGE.



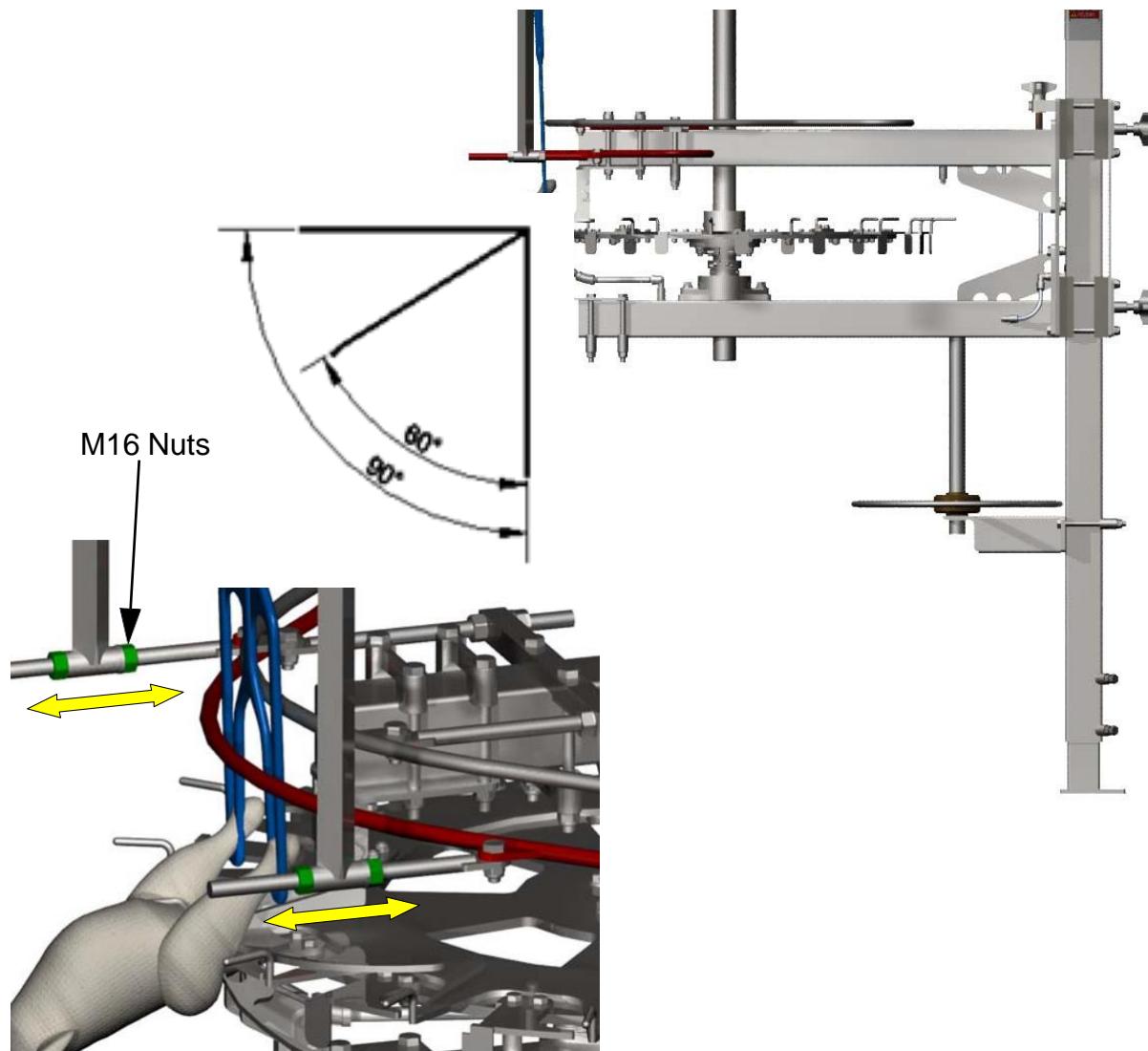


10.3. SHACKLE GUIDE BARS

10.4.1. OUTSIDE GUIDE BAR

This guide bar controls the pressure used to tilt the birds. When the bar is set too far back (away from the machine) the birds will not be tilted enough to achieve a good cut on the tail, some will pop out of the unit. The birds should tilt up 60 to 90 degrees while in the cutter assembly.

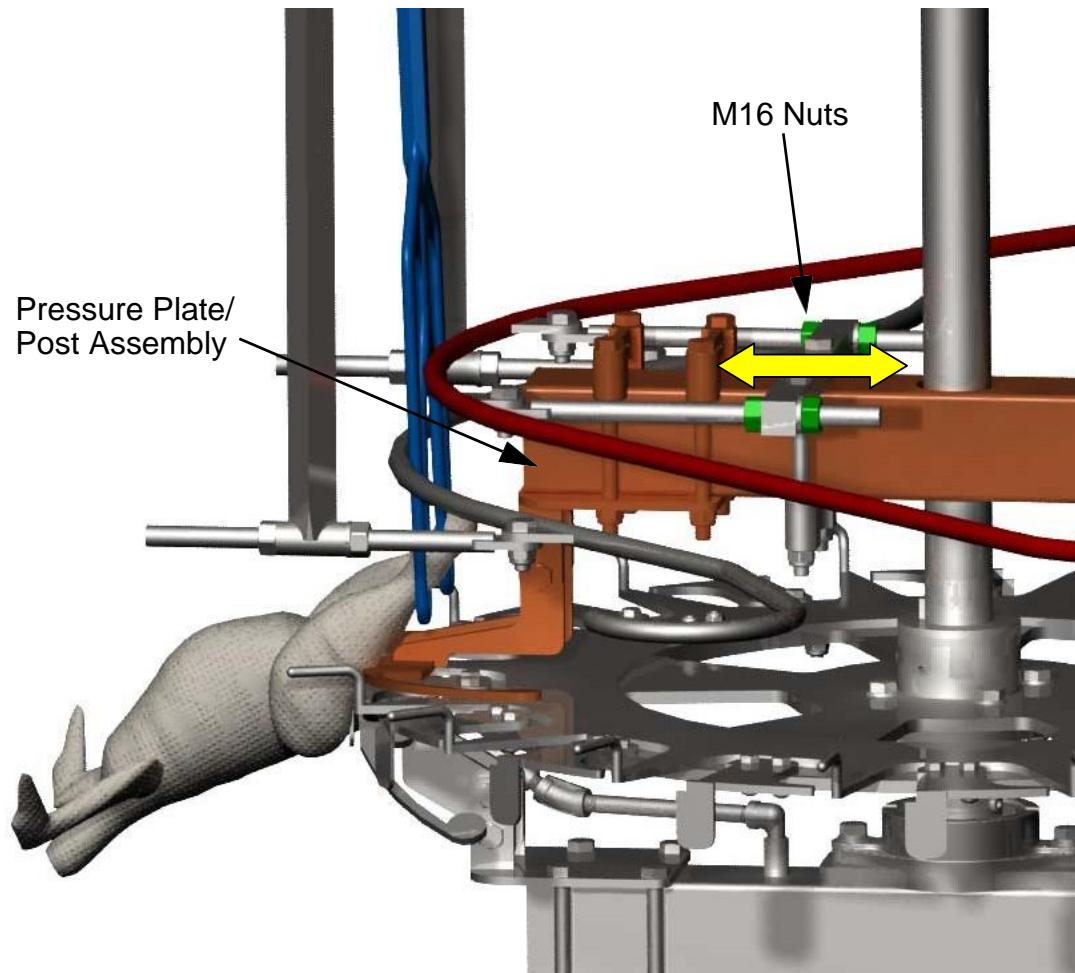
To adjust the guide bar, loosen the M16 nuts move the guide bar forward or back until the desired location is achieved. Retighten hardware.





10.4. INSIDE GUIDE BAR

The inside guide bar is used to keep the shackles from colliding with the top pressure plate/post assembly. Adjust the bar so that the shackles just clear (NO CONTACT) the top pressure plate/post assembly.





11. TEST RUN



DANGER:

RESTORE ALL SAFETY DEVICES SUCH AS GUARDS, SHIELDS, SIGNS, AND GROUNDING WIRES. FAILURE TO DO SO MAY RESULT IN MALFUNCTION OF THE MACHINE, PROPERTY DAMAGE, AND SUBJECTS PERSONNEL TO SERIOUS PERSONAL INJURY, OR DEATH.



NOTICE:

DO NOT RUN MACHINE WITHOUT WATER HOOK-UP IN PLACE AND PROPER WATER PRESSURE TO THE GUIDE BAR.



DANGER: THE BARREL CAN BE ROTATED BY HAND WITH THE DRIVE RODS DISENGAGED FROM THE LINE. NEVER PLACE A HAND OR OTHER LIMB IN THE MACHINE UNLESS THE OVERHEAD CONVEYER IS LOCKED OUT. DOING SO CAN RESULT IN SERIOUS INJURY OR DEATH.

11.1. PREPARATION FOR FIRST TEST RUN

- 1) Remove all tools, equipment and other debris from in and around machine.
- 2) Wash the machine down thoroughly to remove all dust and grinding debris.
- 3) Spin the machine by hand to ensure that it turns properly.
- 4) Raise the machine into line.

11.2. TEST RUN LINE

- 1) Remove Lockout/Tagout following recommended procedures.
- 2) Start line at a slow speed.
- 3) Ensure that the machine turns smoothly.
- 4) Gradually increase the line speed to the normal operating production speed.
- 5) If a bird is available check infeed timing and guide bars.



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12. OPERATIONAL MACHINE SETTINGS



CAUTION:

STOP THE OVERHEAD CONVEYOR AT THE MACHINE AND IMPLEMENT THE PLANT LOCK/TAGOUT PROCEDURE TO PREVENT ACCIDENTAL STARTING. FAILURE TO DO SO MAY RESULT IN MALFUNCTION OF THE MACHINE, PROPERTY DAMAGE, AND SUBJECTS' PERSONNEL TO SERIOUS PERSONAL INJURY, OR DEATH.



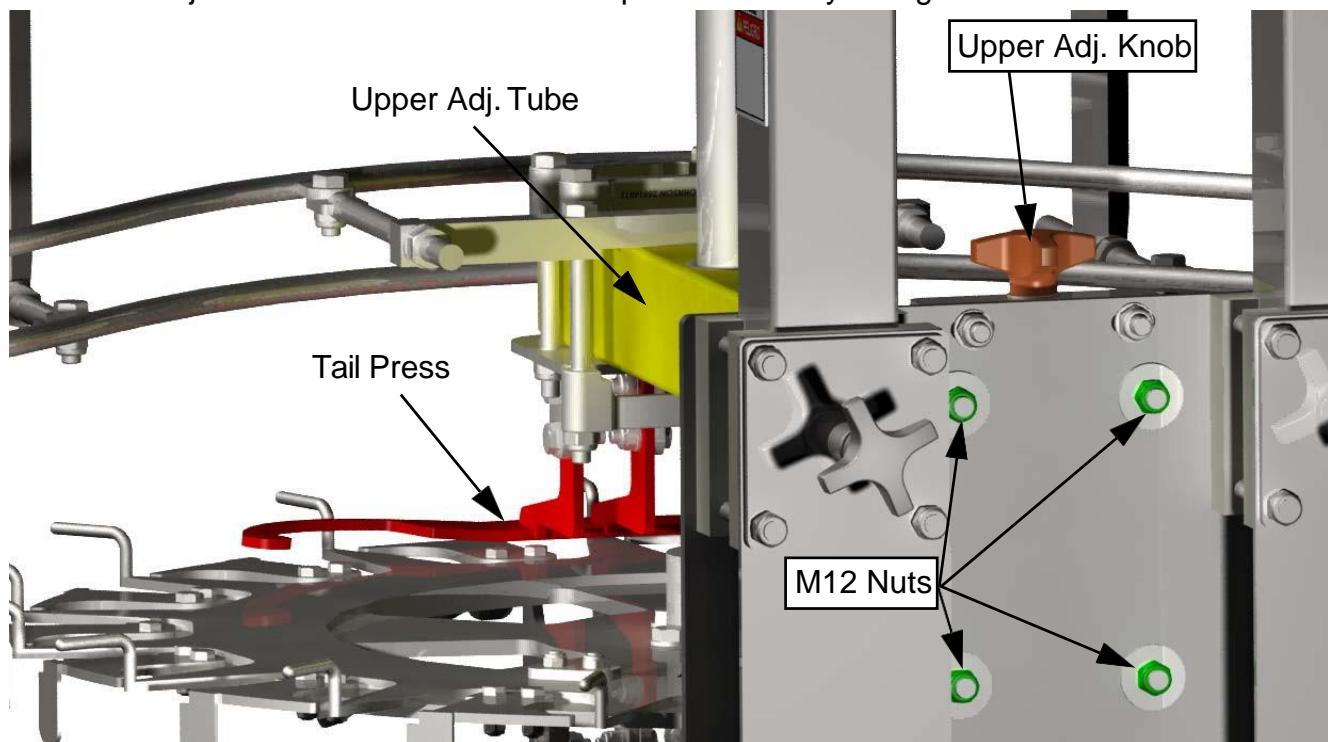
DANGER:

THE BARREL CAN BE ROTATED BY HAND WITH THE DRIVE RODS DISENGAGED FROM THE LINE. NEVER PLACE A HAND OR OTHER LIMB IN THE MACHINE UNLESS THE OVERHEAD CONVEYER IS LOCKED OUT. DOING SO CAN RESULT IN SERIOUS INJURY OR DEATH.

12.1. OIL SAC CUT DEPTH

Adjusting the press/plate assembly will determine how much of the tail (oil sac) is removed (cut depth). More of the tail (oil sac) is removed with greater pressure, a smaller amount is removed with less pressure.

If the cut is not deep enough, resulting in partial oil sac removal, the tail press will need to be lowered. To lower the press loosen the four M12 nuts that hold the upper adjustment tube in place. Once loosened, turn the upper adjustment knob to lower the tail press assembly. Retighten all hardware.





If the cut is too deep, resulting in yield loss, the tail press will need to be raised. To raise the press loosen the four M12 nuts that hold the upper adjustment tube in place. Once loosened, turn the upper adjustment knob to raise the tail press assembly. Retighten all hardware.

12.2. CUT POSITION

The location of the tail cut (front to back) is adjusted by moving the outer guide bar in or out. If the cut is too far up the tail adjust the guide bar in toward the machine. If the cut is too far down the back adjust the guide bar away from the machine. See “Basic Machine Settings” for detailed instructions.



13. DAILY STARTUP

The following checks should be made prior to start of production. BAADER-Linco® recommends that you keep a Log Book where you can verify that these checks are made on a daily basis.

13.1. PRE-START UP PROCEDURES



DANGER:

MACHINE IS NOT DESIGNED FOR HUMAN INTERACTION. STOP THE OVERHEAD CONVEYORS AT THE MACHINE AND FOLLOW LOCKOUT/TAGOUT PROCEDURES TO PREVENT ACCIDENTAL STARTING. FAILURE TO DO SO MAY RESULT IN MALFUNCTION OF THE MACHINE, PROPERTY DAMAGE, AND SUBJECTS PERSONNEL TO SERIOUS PERSONAL INJURY, OR DEATH.

- Check that all machine parts are moving smoothly and freely.
- Turn on the water and verify that the spray nozzles are aimed correctly and unclogged.
- Verify that the guide bars and press are in the correct position.
- Make sure all safety devices are in place.

13.2. START-UP PROCEDURES



DANGER:

AFTER CLEANING OR MAINTENANCE, RESTORE ALL SAFETY DEVICES SUCH AS GUARDS, SHIELDS, SIGNS, AND GROUNDING WIRES. FAILURE TO DO SO MAY RESULT IN MALFUNCTION OF THE MACHINE, PROPERTY DAMAGE, AND SUBJECTS PERSONNEL TO SERIOUS PERSONAL INJURY, OR DEATH.

- Verify that the machine is raised to the correct height.
- Start the overhead line.
- Verify that the machine is timed correctly and that the chain feeds smoothly onto the drive wheel.
- Check the condition of the shackles. When it is safe to do so, repair or replace bent or otherwise irregular shackles.
- Verify that the infeed guide bars are properly positioned when birds start entering the machine.



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14. CLEANUP

14.1. BREAK WASH-DOWN



DANGER:

MACHINE IS NOT DESIGNED FOR HUMAN INTERACTION, CHOOSING TO CLEAN OR RINSE THE MACHINE WHILE IN OPERATION SUBJECTS PERSONNEL TO SERIOUS PERSONAL INJURY OR DEATH. DO NOT REMOVE SAFETY GUARD'S DURING BREAK WASH-DOWN.



DANGER:

MEAT RESIDUALS REMAINING ON MACHINE WILL NOT INFLUENCE MACHINE OPERATION. STUBBORN RESIDUALS SHOULD BE LEFT UNTIL THE PLANT LOCKOUT/TAGOUT PROCEDURE CAN BE FULLY IMPLEMENTED TO AVOID SERIOUS INJURY OR DEATH.

The machine should be rinsed down with hot (120° F/50° C) water during each break and at the end of the shift to prevent excessive accumulation of blood and other poultry residues. While machine is active no body part should come within one foot of the frame.

14.2. CLEAN AND SANITIZE



DANGER:

MACHINE IS NOT DESIGNED FOR HUMAN INTERACTION. STOP THE OVERHEAD CONVEYORS AT THE MACHINE AND FOLLOW LOCKOUT/TAGOUT PROCEDURES TO PREVENT ACCIDENTAL STARTING. FAILURE TO DO SO MAY RESULT IN MALFUNCTION OF THE MACHINE, PROPERTY DAMAGE, AND SUBJECTS PERSONNEL TO SERIOUS PERSONAL INJURY, OR DEATH.

Cleanup should begin immediately after bird processing has finished for the day. Any delay will only increase the difficulty and length of time required for proper clean up.

The following procedures must be done with the machine dropped out of line:

- Remove any accumulated solids from the machine and bottom tray.
- Spray the machine and doors using a self-foaming, alkaline/chlorinated cleaner.
- Allow sufficient time for cleaner to penetrate and loosen soiled areas with hand washing where necessary.
- Thoroughly rinse the machine and doors.



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15. PREVENTIVE MAINTENANCE



DANGER:

DISCONNECT THE POWER TO THE OVERHEAD CONVEYOR BY FOLLOWING THE PLANT LOCKOUT/ TAGOUT PROCEDURE.

THIS IS NECESSARY TO ELIMINATE ACCIDENTAL START-UP OF THE CONVEYOR WHILE THE MACHINE ADJUSTMENTS ARE MADE. ALWAYS PERFORM MAINTENANCE OR REPAIRS WITH THE MACHINE DISENGAGED FROM THE LINE. FAILURE TO DO SO CAN RESULT IN SERIOUS INJURY OR DEATH.



CAUTION:

WORK IS TO BE PERFORMED BY QUALIFIED PERSONNEL ONLY.



DANGER:

THE BARREL(S) CAN BE ROTATED BY HAND WITH THE DRIVE RODS DISENGAGED FROM THE LINE. NEVER PLACE A HAND OR

OTHER LIMB IN THE MACHINE UNLESS THE OVERHEAD CONVEYER IS LOCKED OUT. DOING SO CAN RESULT IN SERIOUS INJURY OR DEATH.



NOTICE:

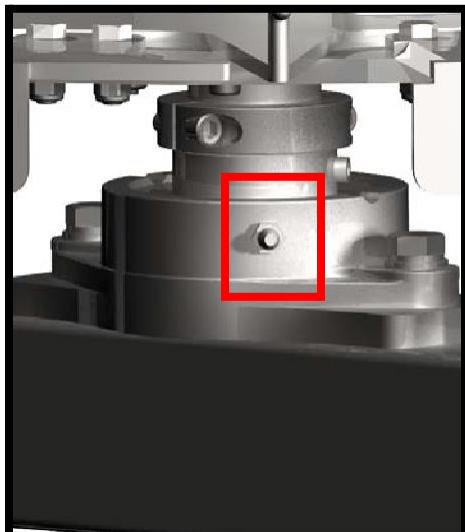
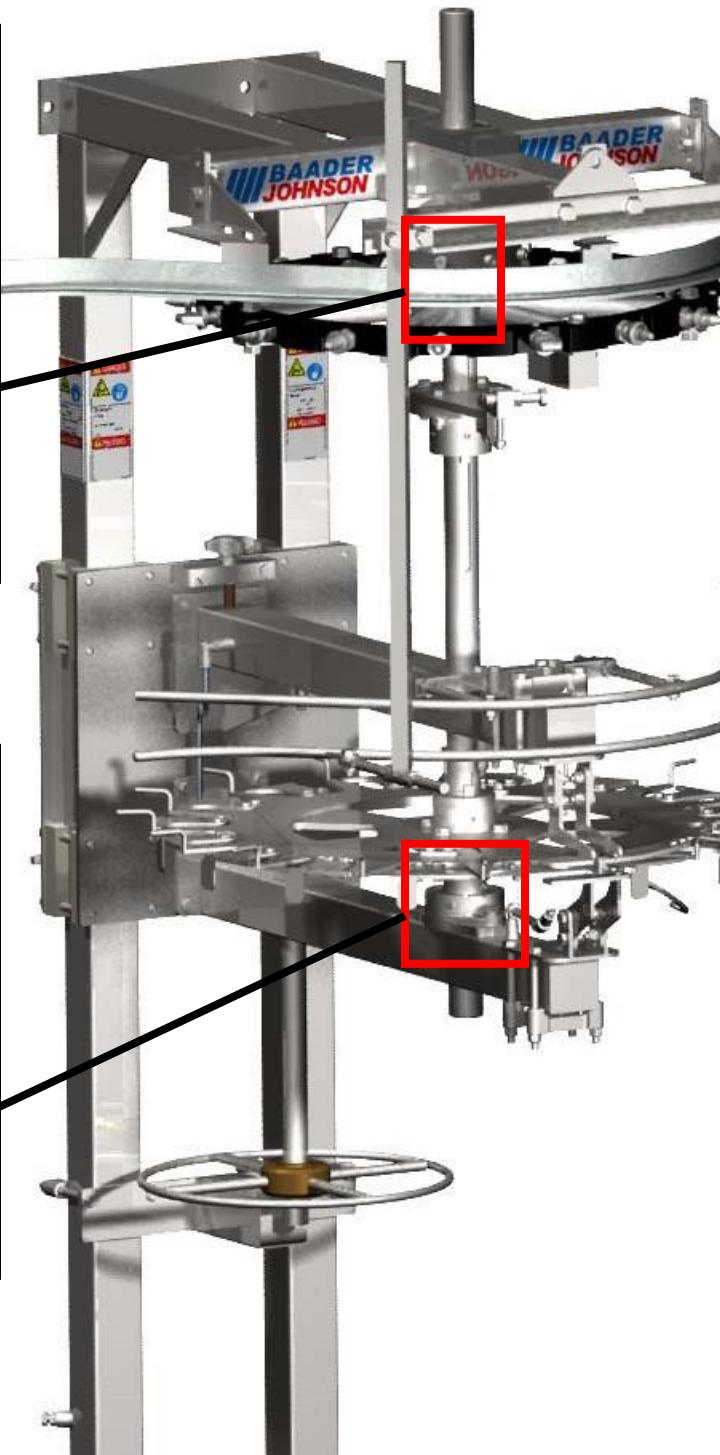
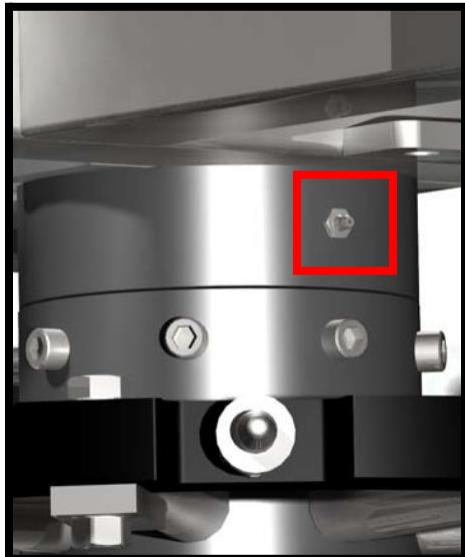
USE ONLY USDA APPROVED SOLVENTS, GREASES, OR OILS IF THERE IS ANY CHANCE OF PRODUCT CONTACT.

Proper preventive maintenance is very important to the operation and longevity of your machine. A properly maintained machine will reduce down time, line pull, and repair costs, and will keep machine performance at its optimum. The following procedures will aid in maintaining your machine. BAADER-Linco® recommends that you keep a Log Book where you can verify that these procedures are performed on a weekly basis. Check all adjustments covered in Operational Settings. Adjust as necessary.

- Inspect all moving components for unusual wear or damage.
- Lubricate machine.
- Check hardware for tightness.
- Check for damaged or leaking water lines.
- Check for clogged spray nozzles.
- Check drive wheel for worn or damaged teeth.



15.1. LUBRICATION POINTS (2)





16. TROUBLESHOOTING



DANGER:

DISCONNECT THE POWER TO THE OVERHEAD CONVEYOR BY FOLLOWING THE PLANT LOCKOUT/TAGOUT PROCEDURE. THIS IS NECESSARY TO ELIMINATE ACCIDENTAL START-UP OF THE CONVEYOR WHILE THE MACHINE ADJUSTMENTS ARE MADE. ALWAYS PERFORM MAINTENANCE OR REPAIRS WITH THE MACHINE DISENGAGED FROM THE LINE. FAILURE TO DO SO CAN RESULT IN SERIOUS INJURY OR DEATH.



NOTICE:

CERTAIN SAFETY PRECAUTIONS SHOULD ALWAYS BE FOLLOWED WHEN PERFORMING MAINTENANCE OR REPAIRS TO THIS MACHINE. READ THE "SAFETY" SECTION IN THE FRONT OF THIS MANUAL.



CAUTION:

WORK IS TO BE PERFORMED BY QUALIFIED PERSONNEL ONLY.



DANGER:

THE BARREL(S) CAN BE ROTATED BY HAND WITH THE DRIVE RODS DISENGAGED FROM THE LINE. NEVER PLACE A HAND OR OTHER LIMB IN THE MACHINE UNLESS THE OVERHEAD CONVEYER IS LOCKED OUT. DOING SO CAN RESULT IN SERIOUS INJURY OR DEATH.

PROBLEM

CORRECTION

Oil sac not removed

- a. Check infeed timing. With no birds on the line, the bird tabs should just feed in behind the leading shackle leg. The shackle should be just above the tabs. The pick-up tabs should feed in between the birds legs at entrance, then pull each bird through the machine.
- b. Tails should be at a 30° to 60° angle. Birds with tails over 60° vertical will not feed into the machine correctly. Check pickers and hock cutter for adjustments. These machines can be adjusted to help position tails.
- c. Check guide bars and shackles. Guide bars should hold shackles in a vertical position with very little angle on them, just enough to stop any free swinging.



PROBLEM

CORRECTION

Oil sac not removed (cont.)

d. Dull blades could also be the problem. Check cutter blades twice a week. Hone the edge with a flat file if chipped or rolled on edge.

Note: Cutters do not have to be razor sharp. The unit will pinch off the gland, not cut it.

e. Incorrect operating height could be the problem. Oil sac remover should be adjusted so that the tail is just even the top pressure plate and tails are pushed down to feed in between the top and bottom plates. Birds are not lifted to remove the tail's oil gland, but they will tilt upward as the oil sac is removed.

f. Inside/outside shackle guide bars-

Inside should be set so that the shackles hang vertical and do not make contact with pressure plate braces.

Outside should be set so that when a bird is in a shackle it will be tilted breast upward as the oil sac is removed.

Incorrect in and out location of machine.

The Oil Sac Cutter should be adjusted so that birds are gently pushed over the unit into the entrance end by on-line shackle guide bars.

Too much tail removed.

Adjust the pressure plate upward. Give tails more room between the top and bottom pressure plates.

Not enough tail removed.

Adjust the pressure plate downward. Put less gap between the plates.

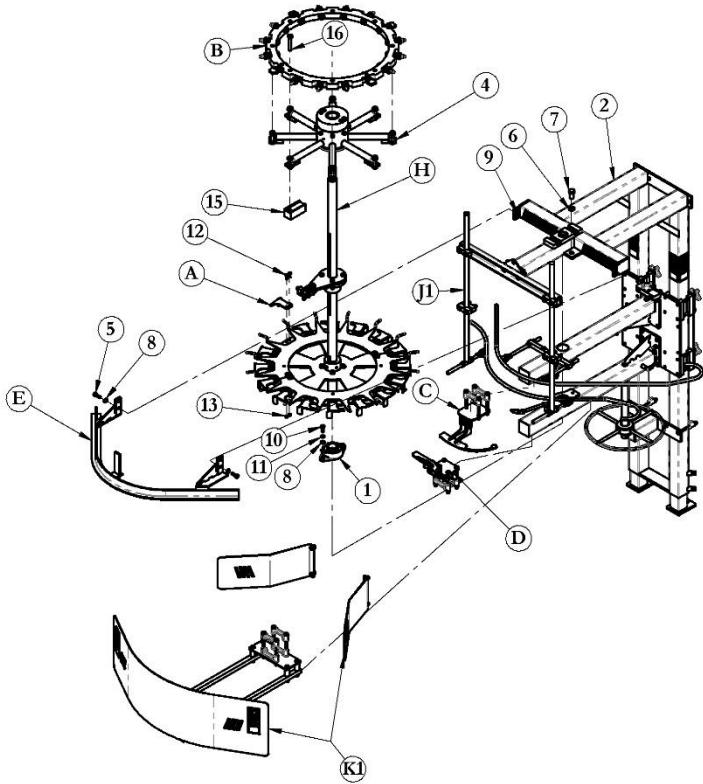
Note: Turn pressure plate adjustment knob (located at backside of machine, about 1/4 to 1/2 turn and check the results.



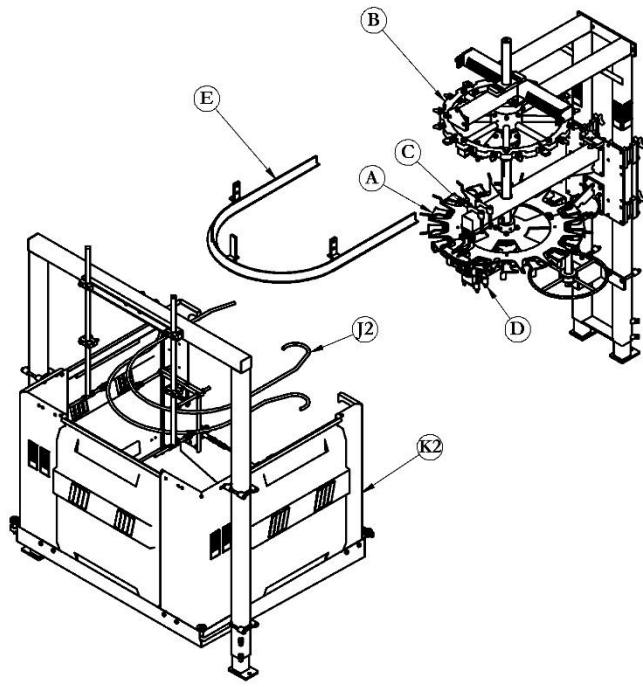
17. PARTS LIST



OIL SAC CUTTER ASSEMBLY



90° CONSTRUCTION



180° CONSTRUCTION



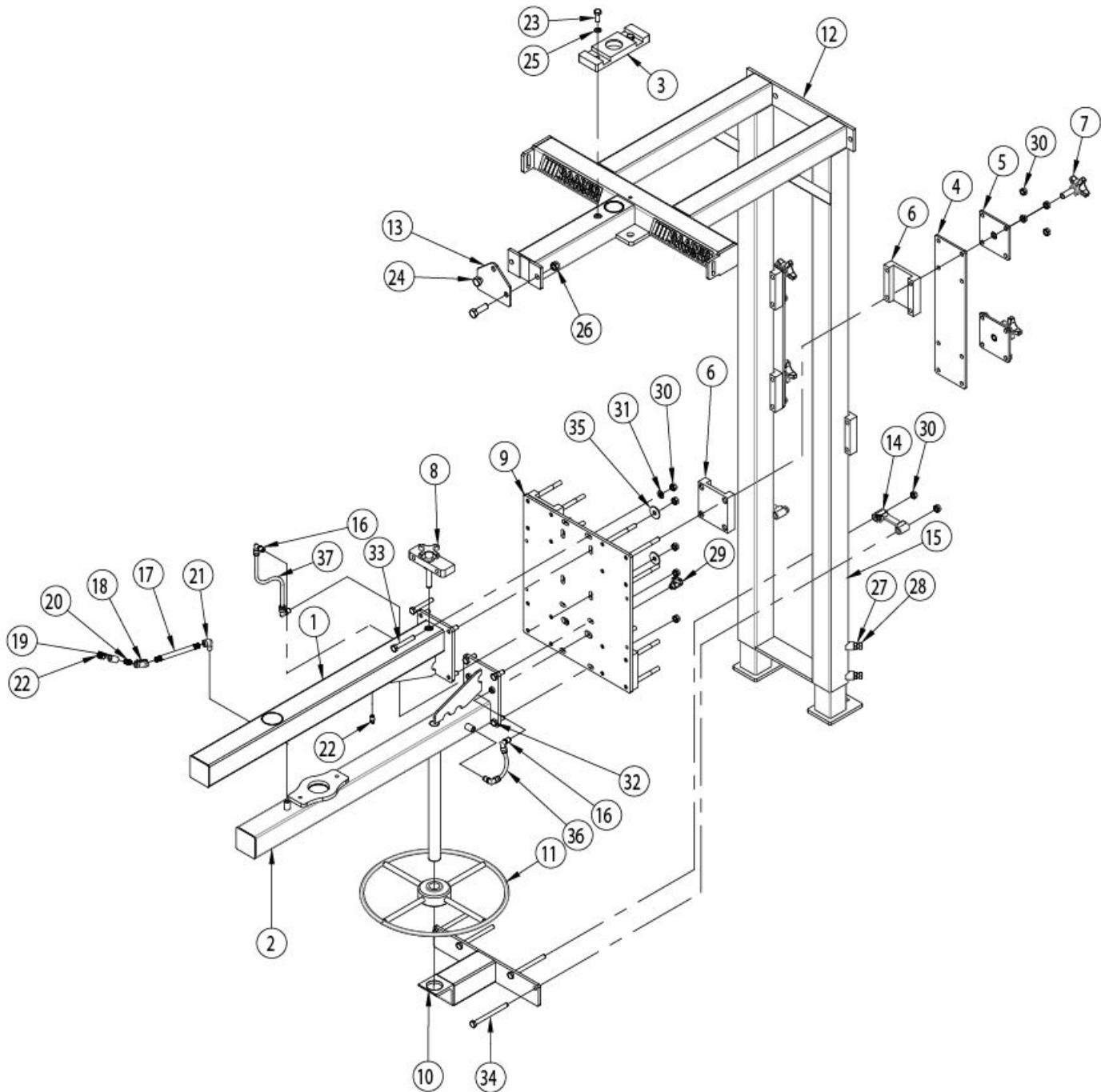
ASSY OIL SACK CUTTER (2796000000)				
FOR CUSTOMER USE	ITEM	PART No	DESCRIPTION	QTY
	1	2300660500	BEARING ALTERNATION	1
	2	2796400000	ASSY, FRAME OIL SACK	1
	3	2796403400	ASSY SHIELD, 90 DEGREE	1
	4	2885200000	ASSY DR WH HUB 16-20/6" 50mm	1
	5	95161235	SCR M12x35 HEX CAP SS DIN933	2
	6	95182000	WASHER M20 LOCK SS DIN127B	2
	7	95162040	SCR M20x40 HEX CAP SS DIN933	2
	8	95180012	WASHER M12 FLAT SS DIN125A	4
	9	95171200	NUT M12 HEX SS LOCK DIN 985	2
	10	95161231	SCR M12x30 HEX CAP SS DIN933	2
	11	95181200	WASHER M12 LOCK SS DIN127B	2
	12	95160825	SCR M8x25 HEX CAP SS DIN933	32
	13	95170800	NUT M8 HEX SS LOCK DIN 985	32
	14	2885002796	SHIPPING COMPONENTS	1
	15	2796750125	DRIVE BLOCK	1
	16	95161690	SCR M16x90 HEX CAP SS DIN931	1
	17	2796500000	ASSY, TAIL PRESS CW	1

OPTIONS TABLE				
	ITEM	PART No	DESCRIPTION	QTY
	A	WLD'T BIRD POSI	CHOOSE BASED ON ROTATION	
		2796600500	CW,WELD'T BIRD POSITIONER	16
		2796600510	CCW,WELD'T BIRD POSITIONER	16
		2796600511	CW,WELD'T BIRD POSITIONER 8IN	12
		2796600512	CCW,WELD'T BIRD POSITIONER 8IN	12
	B	ASSY,DRIVE RIM	CHOOSE BASED ON CHAIN TYPE	
		00952741	ASSY,DR RIM 16/6x348 STANDARD LUG	1
		0095274101	ASSY,DR RIM 16/6x348 EXT LUG	1
		0095294	DRIVE WHEEL RIM 16/6 LOG	1
		00951543	DRIVE WHEEL RIM 16/6 SANI	1
	C	ASSY,TAIL PRESS	CHOOSE BASED ON ROTATION	
		2796500000	CW,ASSY TAIL PRESS	1
		2796500001	CCW,ASSY TAIL PRESS	1
	D	ASSY,VEE BLADE	CHOOSE BASED ON ROTATION	
		2796504000	CW,ASSY VEE BLADE	1
		2796504001	CCW,ASSY VEE BLADE	1
		2796504002	ASSY, VEE BLADE CW 16	1
		2796504003	ASSY, VEE BLADE CCW 16	1
	E	TRACK	CHOOSE BASED ON CHAIN TYPE	
		2796700000	WLDT,T-BEAM 90 DEG	1
		2796700100	WLDT,T-RAIL 90 DEG	1
		2796700200	WLDT,SANI-TUBE 90 DEG	1
		28816101	WLDT,TRACK T-BEAM 180DEG 16HD	1
		28816111	WLDT,TRACK WELD SANI 180 DEG 16HD	1
		28816121	WLDT,TRACK T-RAIL 180 DEG 16HD	1
	F	SAFETY LABELS	CHOOSE BASED ON LOCATION	
		93880279	KIT,LABEL 1279 SPANISH	1
		93881279	KIT,LABEL 1279 FRENCH	1
	G	SPARE PARTS	CHOOSE BASED ON ROTATION	
		2791700000	SPARE PART KIT CW	1
		2791700010	SPARE PART KIT CCW	1
	H	ASSY BARREL	CHOOSE 6IN OR 8IN	
		2796600000	ASSY, BARREL 6IN	1
		2796600080	ASSY, BARREL 8IN	1
	J	GUIDE BAR ASSY		
		2796750130	ASSY, GUIDE BAR, 90 DEG	1
		2796750135	ASSY, GUIDE BAR, 180 DEG	1
	K	FULL ENCLOSURE		
		2796403400	ASSY SHIELD 90 DEGREE	1
		2883520200	ASSY ENCLOSURE, 180 DEG	1

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OIL SAC CUTTER FRAME ASSEMBLY

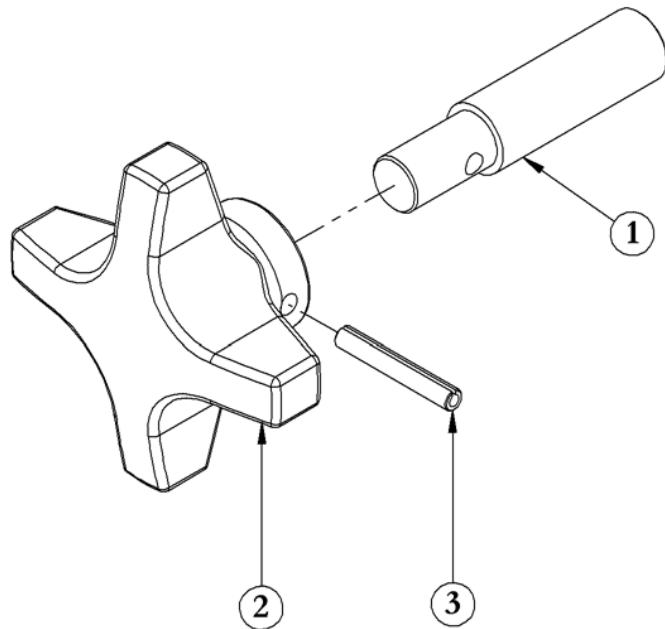




OIL SAC CUTTER FRAME ASSEMBLY				
For Customer Use	Pos.	Part No.	Description	Qty
	1	2796401000	WELD, UPPER ADJ TUBE	1
	2	2796400200	WELD, SHAFT SUPPORT	1
	3	2796400100	BEARING PLATE	1
	4	2796400400	SECURING STRAP	2
	5	2796400500	WELD, PRESSURE PLATE	4
	6	2796400600	SLIDE BRG	8
	7	2796400700	ASSY, ADJ KNOB	4
	8	2796400800	ASSY, VERT ADJ KNOB	1
	9	2796401100	WELD, BACK PLATE	1
	10	2796402010	WELD, LOWER SUPPORT	1
	11	2796403000	WELD, HAND WHEEL	1
	12	2880200101	FRAME WELD'T 16HD	1
	13	28802800	CLAMP PLATE-TRACK SUPPORT	1
	14	28814812	CLAMP 80mm TUBE	2
	15	2880400340	ADJUSTING LEG	2
	16	93400260	ELBOW SWIVEL 1/4 NPT X 3/8 TUB	4
	17	93400812	NIPPLE 1/4" PIPE SCH 40 X 6" LG	1
	18	93410053	ELBOW, 30, 1/4 NPT	1
	19	93440150	COUPLING, 1/4 NPT	1
	20	93400302	NIPPLE 1/4 NPT X CLOSE SS	1
	21	93411362	STREET ELBOW, 1/4 NPT	1
	22	93860993	NOZZLE, H1/4VV-SS8004	2
	23	95161231	SCR M12x30 HEX CAP SS DIN933	2
	24	95161684	SCR M16x50 HEX CAP SS DIN933	2
	25	95181200	WASHER M12 LOCK SS DIN127B	2
	26	95171600	NUT M16 HEX SS LOCK DIN 985	2
	27	95170012	NUT M12 HEX SS DIN 934	4
	28	95161240	SCR M12x40 HEX CAP SS DIN933	4
	29	94020883	VALVE BALL 1/4 NPTM 1/4 NPTF	2
	30	95171200	NUT M12 HEX SS LOCK DIN 985	30
	31	95180012	WASHER M12 FLAT SS DIN125A	2
	32	95161235	SCR M12x35 HEX CAP SS DIN933	4
	33	95161280	SCR M12x80 HEX CAP SS DIN931	2
	34	95161214	SCR M12x140 HEX CAP SS DIN931	4
	35	95180013	WASHER M12 FENDER SS DIN902	4
	36	90771030	TUBE,3/8,POLY FLO,14"LG	1
	37	90771030	TUBE,3/8,POLY FLO,18"LG	1

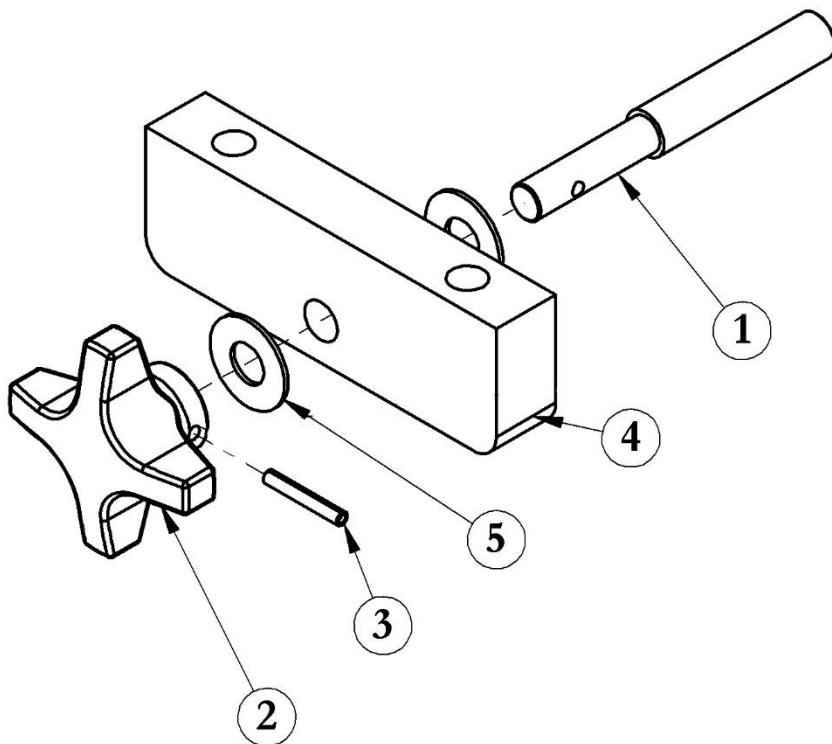


ADJUSTMENT KNOB ASSEMBLY				
For Customer Use	Pos.	Part No.	Description	Qty
	1	2796400701	ADJ ROD, HAND KNOB	1
	2	93150088	HAND KNOB 1/2x3	1
	3	95091130	ROLL PIN 3/16 x 1 1/4	1



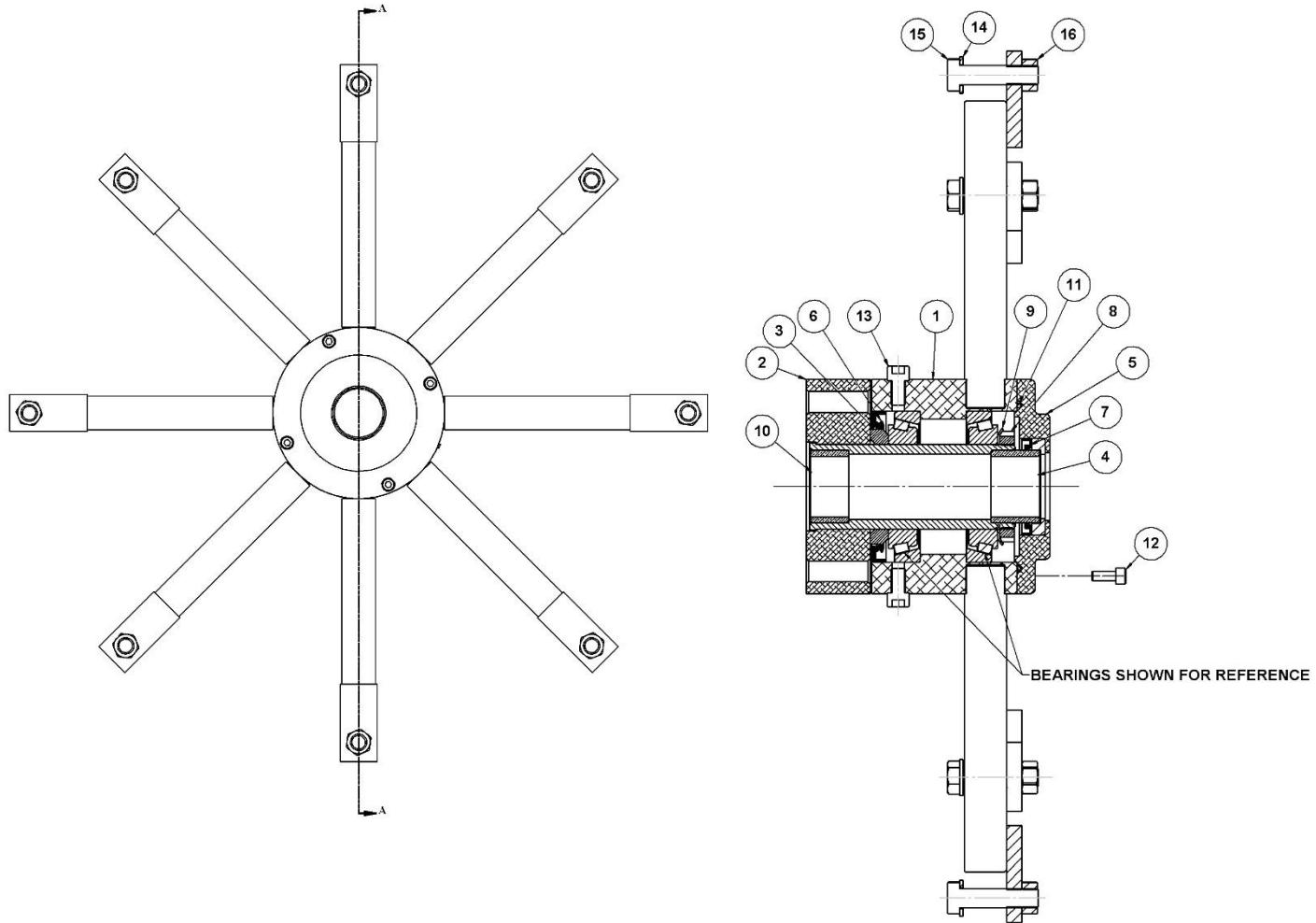


VERTICAL ADJUSTMENT KNOB ASSEMBLY				
For Customer Use	Pos.	Part No.	Description	Qty
	1	2796400801	ADJ ROD, VERT	1
	2	93150088	HAND KNOB 1/2x3	1
	3	95091130	ROLL PIN 3/16 x 1 1/4	1
	4	2796400900	VERT ADJ BLOCK	1
	5	95080405	WASHER FLAT 1/2 SS	1



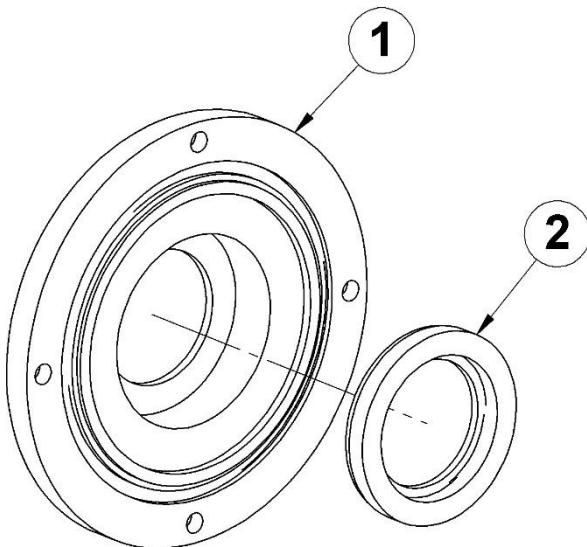


ASSY DR WH HUB 16-20/6" 50mm (2885200000)				
FOR CUSTOMER USE	ITEM	PART No	DESCRIPTION	QTY
	1	2885201000	WELD HUB DRIVE WHEEL	1
	2	2885200100	DRIVE WHEEL FLANGE	1
	3	2885200006	DRIVE WHEEL SPACER	1
	4	2885200007	BEARING BUSHING	1
	5	2885200040	ASSY, COVER DRIVE WHEEL	1
	6	002074	SEAL, LIP	1
	7	002072	SEAL, LIP	1
	8	005220	NUT LOCKING	1
	9	005222	LOCK WASHER	1
	10	009331	BEARING BUSHING	1
	11	93800500	O-RING	1
	12	95160821	SCR M8 X 20 SOC HD CAP SS DIN912	4
	13	95161219	SCR M12 X 20 SOC HD CAP SS DIN912	8
	14	95180016	WASHER M16 FLAT SS DIN125A	8
	15	95161665	SCR M16x65 HEX CAP SS DIN931	8
	16	95170016	NUT M16 HEX SS DIN 934	8
	17	93920558	GREASE ZERK 1/8 NPT	1



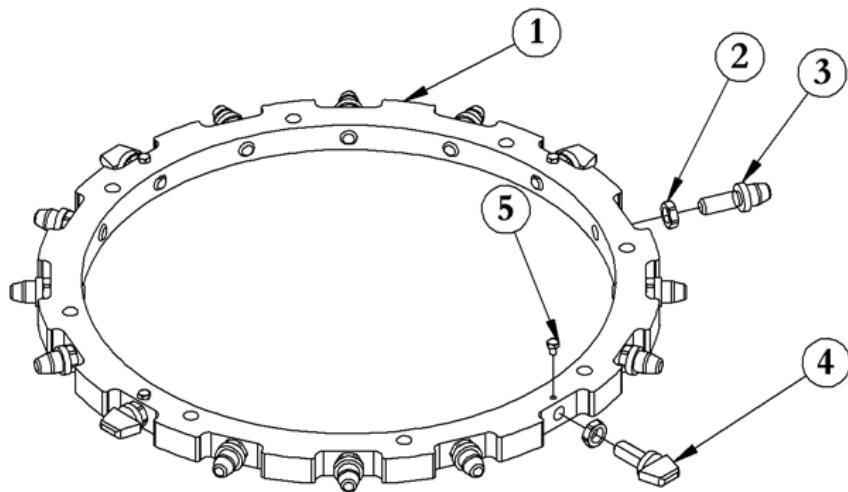


ASSY COVER DRIVE WHEEL				
FOR CUSTOMER USE	ITEM	PART No	DESCRIPTION	QTY
	1	2885200035	RETAINING COVER DR WHEEL	1
	2	2885200030	BUSHING RETAINING RING	1



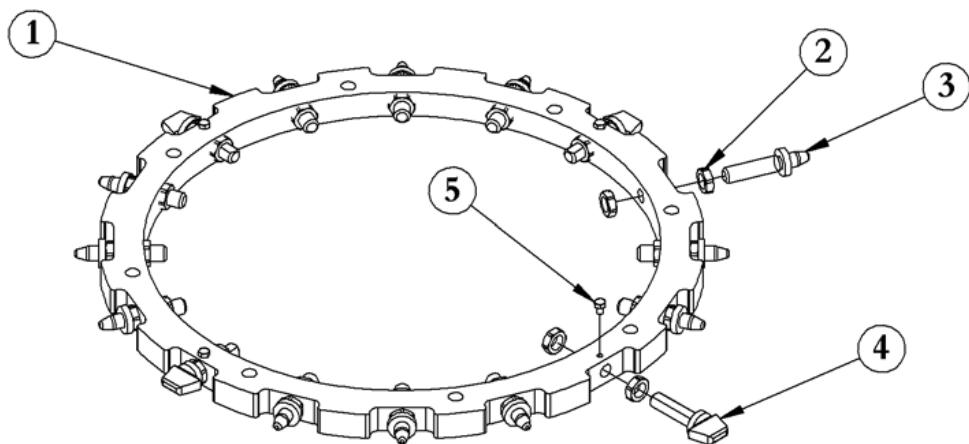


ASSY DR RIM 16/6 X348 STANDARD LUG (00952741)				
For Customer Use	Pos.	Part No.	Description	Qty.
	1	0095274	DRIVE WHEEL RIM X348 16/6"	1
	2	95170021	NUT M20 JAM BRASS	16
	3	0095160	DRIVE WHEEL LUG	12
	4	0095163	WIDE DRIVE WHEEL LUG	4
	5	95160812	SCR M8x12 HEX CAP SS	4



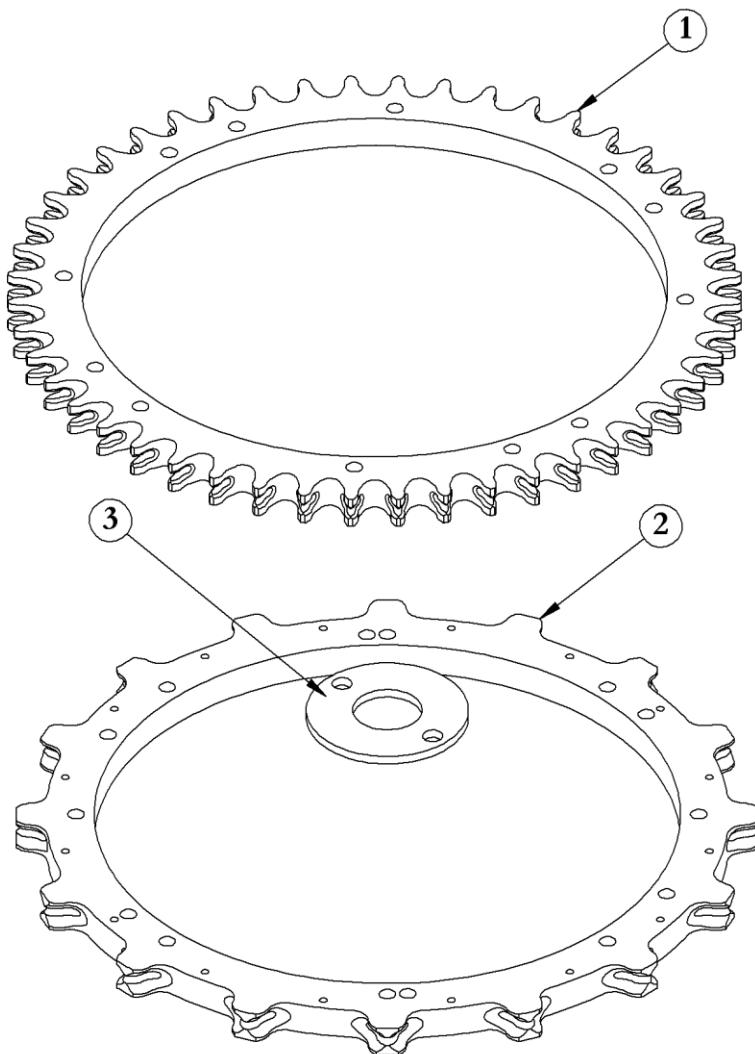


ASSY DR RIM 16/6 X348 (0095274101)				
For Customer Use	Pos.	Part No.	Description	Qty.
	1	0095274	DRIVE WHEEL RIM X348 16/6"	1
	2	95170021	NUT M20 JAM BRASS	32
	3	00951602	LUG, DRIVE EXTENDED	12
	4	0095163001	WIDE DRIVE WHEEL LUG	4
	5	95160812	SCR M8x12 HEX CAP SS	4





BA1250-16 DRIVE WHEELS				
For Customer Use	Pos.	Part No.	Description	Qty.
	1	0095294	DRIVE WHEEL RIM 16/6 LOG	1
	2	0095154	DRIVE WHEEL RIM 16/6 SANI	1
	3	2885201002	SPACER	1
	4	009515401	DRIVE WHEEL RIM 16/6 CAD	1





CW VEE BLADE ASSEMBLY (2796504000)				
For Customer Use	Pos.	Part No.	Description	Qty
	1	2796504100	WELD, VEE BLADE CW	1
	2	2796503000	WELD, MOUNTING BRKT	1
	3	28814812	CLAMP 80mm TUBE	2
	4	95161028	SCR M10x30 HEX CAP SS	4
	5	95161214	SCR M12x140 HEX CAP SS	4
	6	95171000	NUT M10 HEX SS LOCK	4
	7	95171200	NUT M12 HEX SS LOCK	4
	8	95180010	WASHER M10 FLAT SS	4

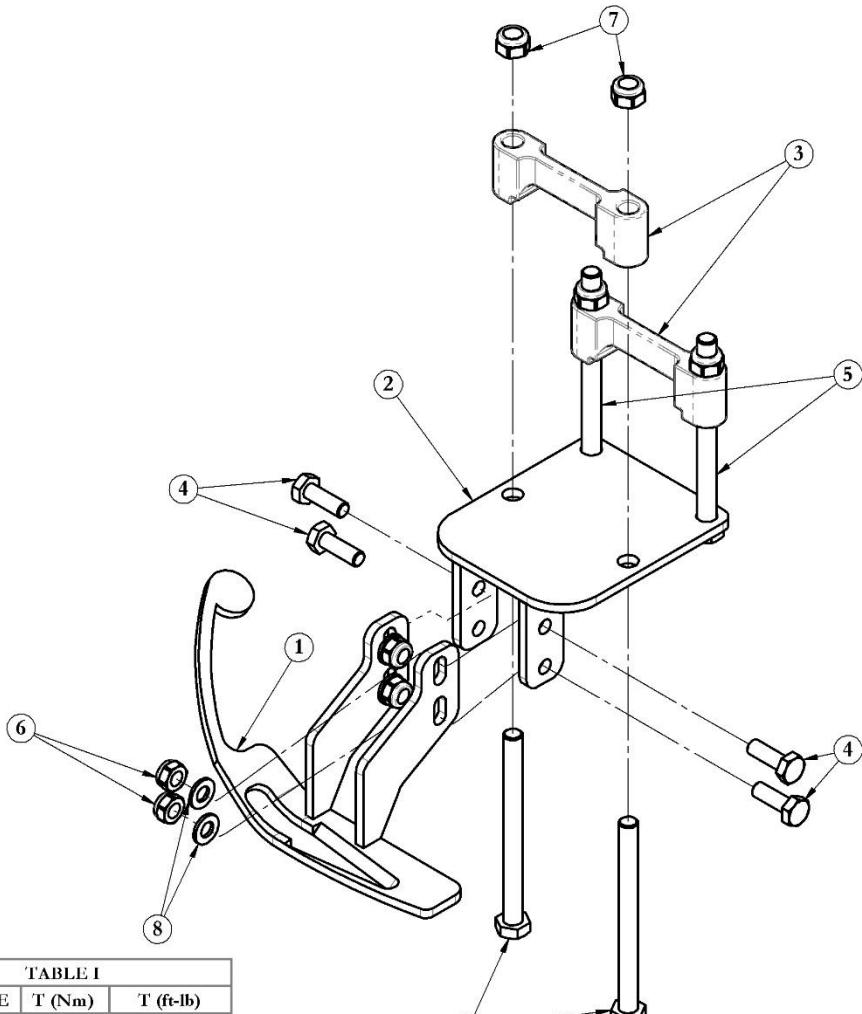


TABLE I		
BOLT SIZE	T (Nm)	T (ft-lb)
M6	11	8
M8	27	20
M10	56	41
M12	96	71
M16	237	175
M20	479	353
M24	458	338

1. GREASE ALL FASTENERS USING ANTI-SEIZE LUBRICANT PRIOR TO ASSEMBLY.
TORQUE ALL FASTENERS WITHIN $\pm 10\%$ OF THE VALUE LISTED IN TABLE 1.



CCW VEE BLADE ASSEMBLY (2796504001)				
For Customer Use	Pos.	Part No.	Description	Qty
	1	2796504101	WELD, VEE BLADE CCW	1
	2	2796503000	WELD, MOUNTING BRKT	1
	3	28814812	CLAMP 80mm TUBE	2
	4	95161028	SCR M10x30 HEX CAP SS	4
	5	95161214	SCR M12x140 HEX CAP SS	4
	6	95171000	NUT M10 HEX SS LOCK	4
	7	95171200	NUT M12 HEX SS LOCK	4
	8	95180010	WASHER M10 FLAT SS	4

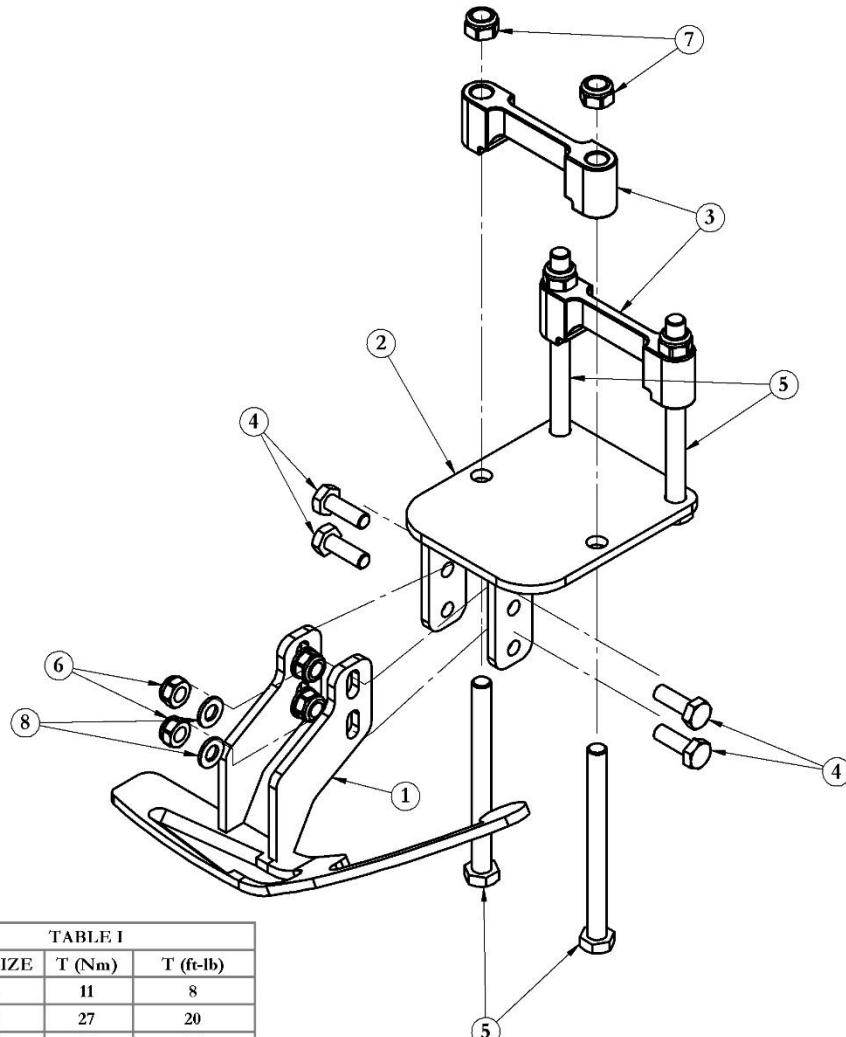


TABLE I		
BOLT SIZE	T (Nm)	T (ft-lb)
M6	11	8
M8	27	20
M10	56	41
M12	96	71
M16	237	175
M20	479	353
M24	458	338

1. GREASE ALL FASTENERS USING ANTI-SEIZE LUBRICANT PRIOR TO ASSEMBLY.
TORQUE ALL FASTENERS WITHIN $\pm 10\%$ OF THE VALUE LISTED IN TABLE 1.



ASSY VEE BLADE CW 16 (2796504002)				
FOR CUSTOMER USE	ITEM	PART No	DESCRIPTION	QTY
	1	2796504200	WELD, V BLADE CW 16	1
	2	2796503000	WELD, MOUNTING BRKT	1
	3	28814812	CLAMP 80mm TUBE	2
	4	95161028	SCR M10x30 HEX CAP SS DIN933	4
	5	95161214	SCR M12x140 HEX CAP SS DIN931	4
	6	95171000	NUT M10 HEX SS LOCK DIN 985	4
	7	95171200	NUT M12 HEX SS LOCK DIN 985	4
	8	95180010	WASHER M10 FLAT SS DIN125A	4

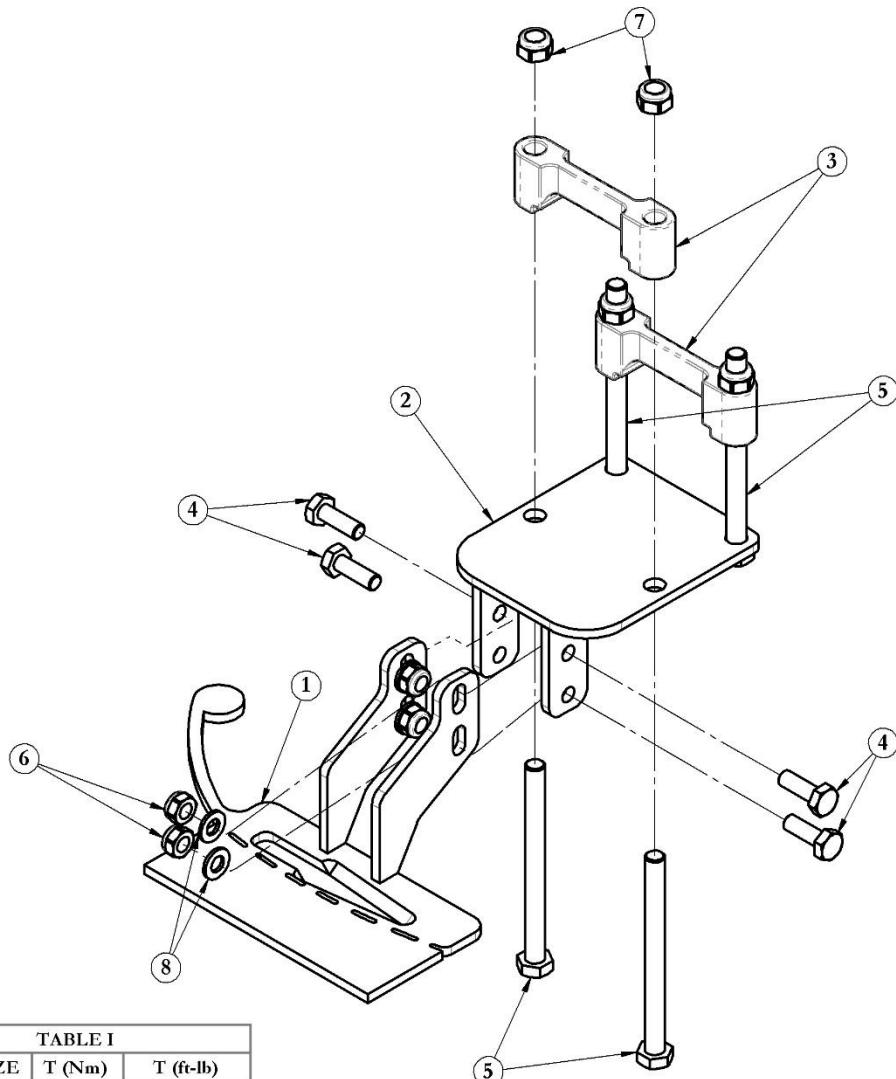


TABLE I		
BOLT SIZE	T (Nm)	T (ft-lb)
M6	11	8
M8	27	20
M10	56	41
M12	96	71
M16	237	175
M20	479	353
M24	458	338

1. GREASE ALL FASTENERS USING ANTI-SEIZE LUBRICANT PRIOR TO ASSEMBLY.
TORMQUE ALL FASTENERS WITHIN $\pm 10\%$ OF THE VALUE LISTED IN TABLE 1.



ASSY VEE BLADE CCW 16 (2796504003)				
FOR CUSTOMER USE	ITEM	PART No	DESCRIPTION	QTY
	1	2796504205	WELD, V BLADE CCW 16	1
	2	2796503000	WELD, MOUNTING BRKT	1
	3	28814812	CLAMP 80mm TUBE	2
	4	95161028	SCR M10x30 HEX CAP SS DIN933	4
	5	95161214	SCR M12x140 HEX CAP SS DIN931	4
	6	95171000	NUT M10 HEX SS LOCK DIN 985	4
	7	95171200	NUT M12 HEX SS LOCK DIN 985	4
	8	95180010	WASHER M10 FLAT SS DIN125A	4

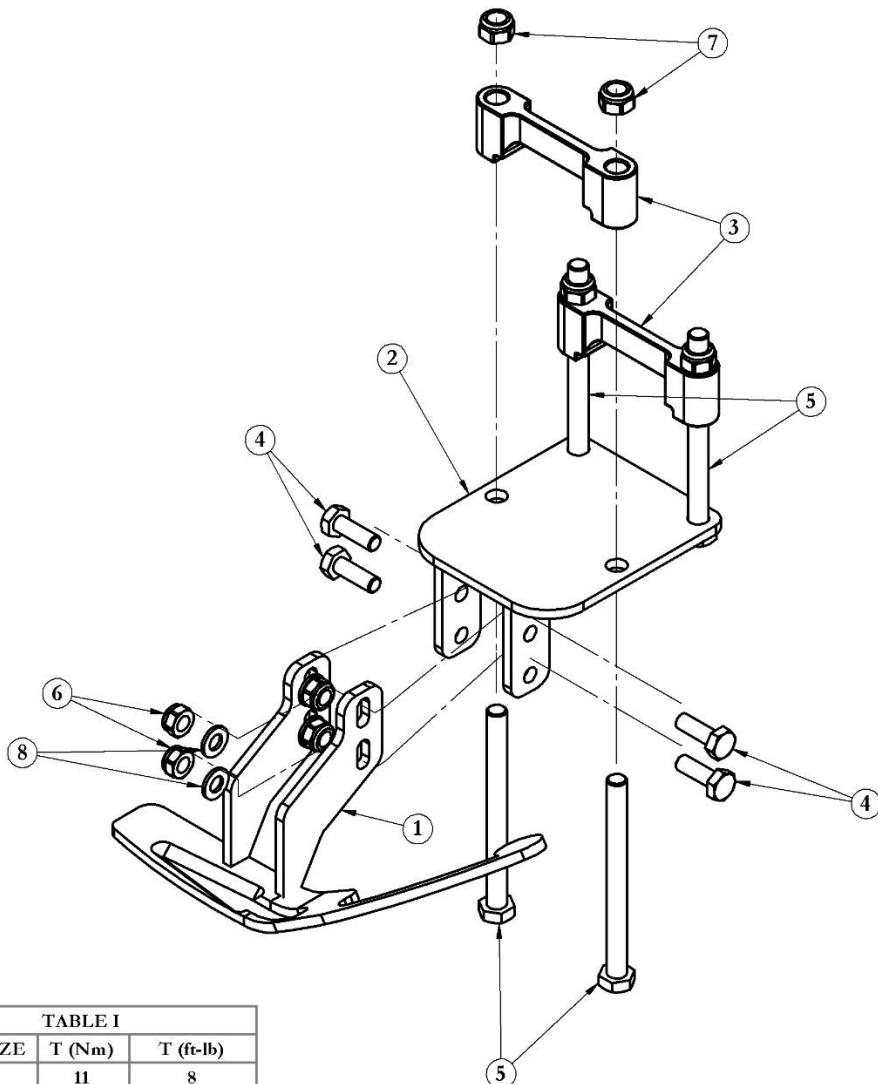
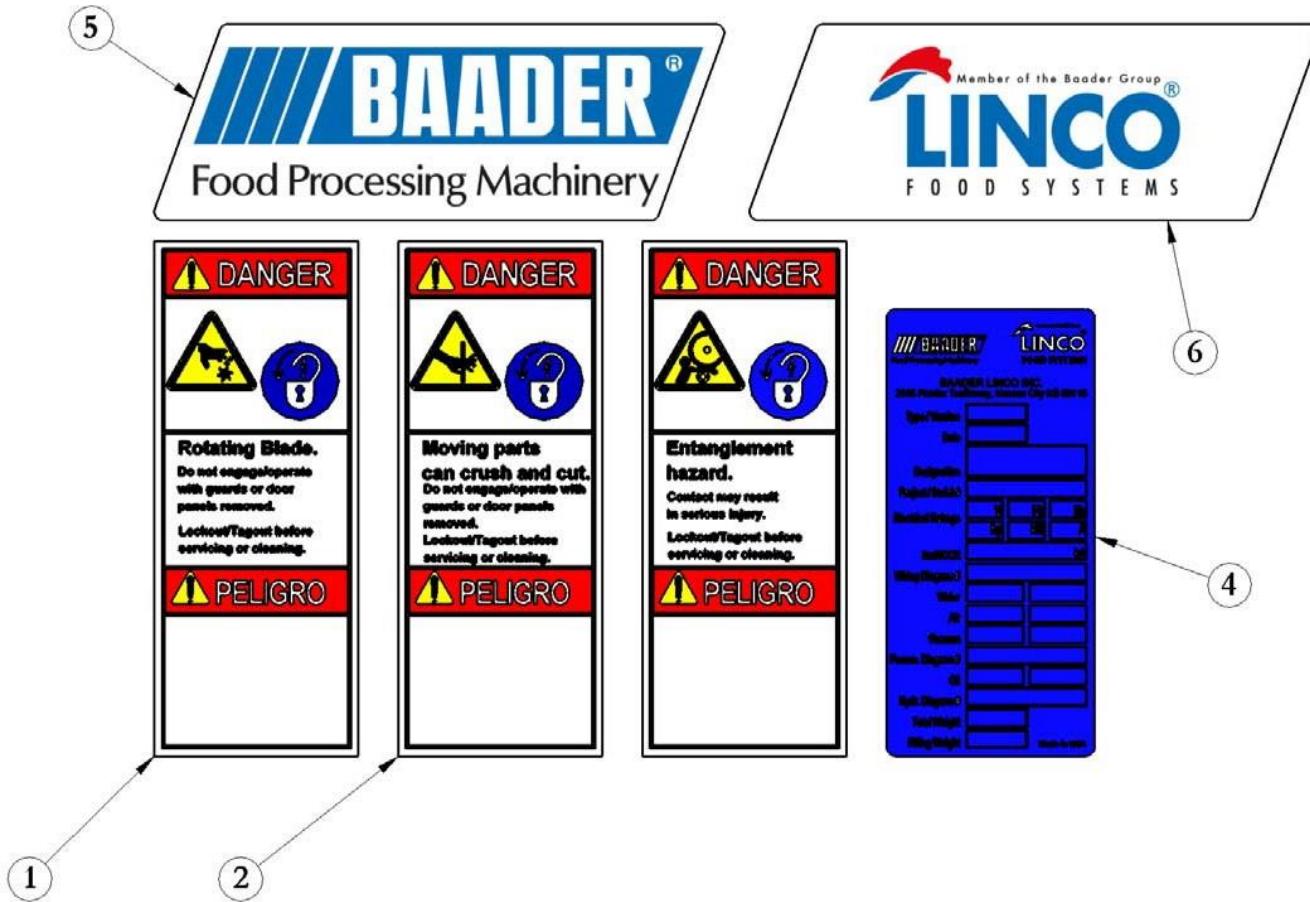


TABLE I		
BOLT SIZE	T (Nm)	T (ft-lb)
M6	11	8
M8	27	20
M10	56	41
M12	96	71
M16	237	175
M20	479	353
M24	458	338

1. GREASE ALL FASTENERS USING ANTI-SEIZE LUBRICANT PRIOR TO ASSEMBLY.
TORQUE ALL FASTENERS WITHIN $\pm 10\%$ OF THE VALUE LISTED IN TABLE 1.

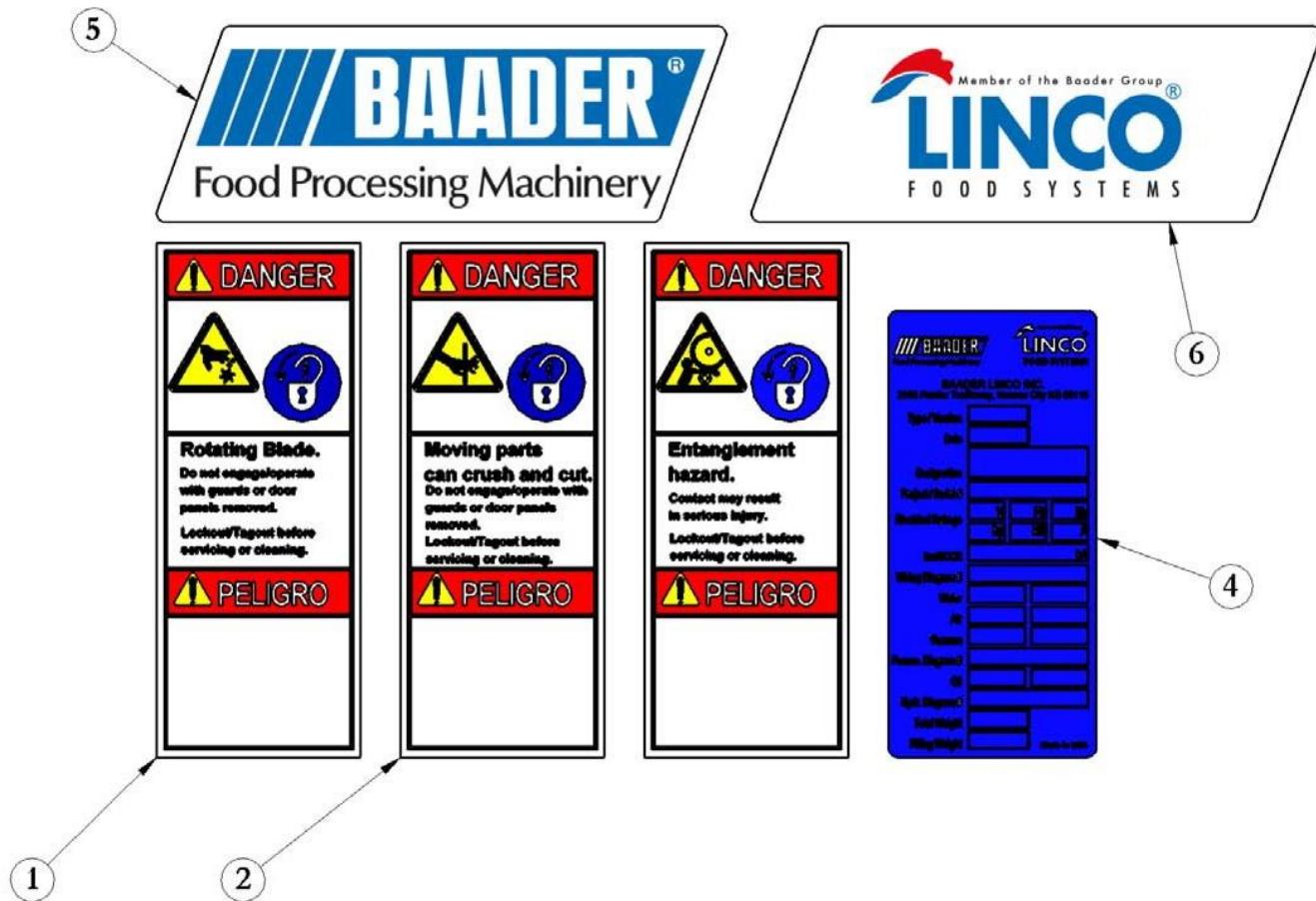


KIT, LABEL 1279 SPANISH				
For Customer Use	Pos.	Part No.	Description	Qty.
	1	93881601	LABEL, ROTATING BLADE S	2
	2	93881602	LABEL, MOVING PARTS S	2
	3	93881603	LABEL, ENTANGLEMENT S	2
	4	93880749	SERIAL PLATE, GENERIC	1
	5	93880774	LABEL, BAADER	2
	6	93880775	LABEL, LINCO	2



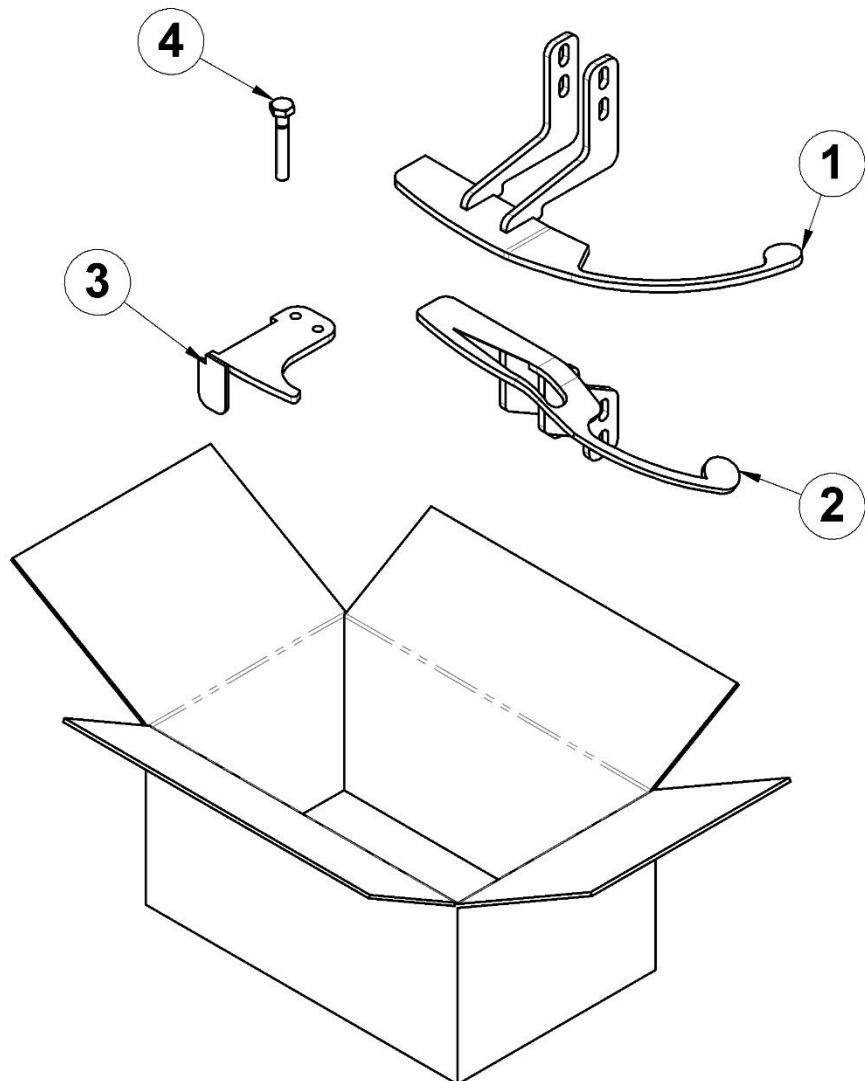


KIT, LABEL 1279 FRENCH				
For Customer Use	Pos.	Part No.	Description	Qty.
	1	93881601	LABEL, ROTATING BLADE S	2
	2	93881602	LABEL, MOVING PARTS S	2
	3	93881603	LABEL, ENTANGLEMENT S	2
	4	93880749	SERIAL PLATE, GENERIC	1
	5	93880774	LABEL, BAADER	2
	6	93880775	LABEL, LINCO	2





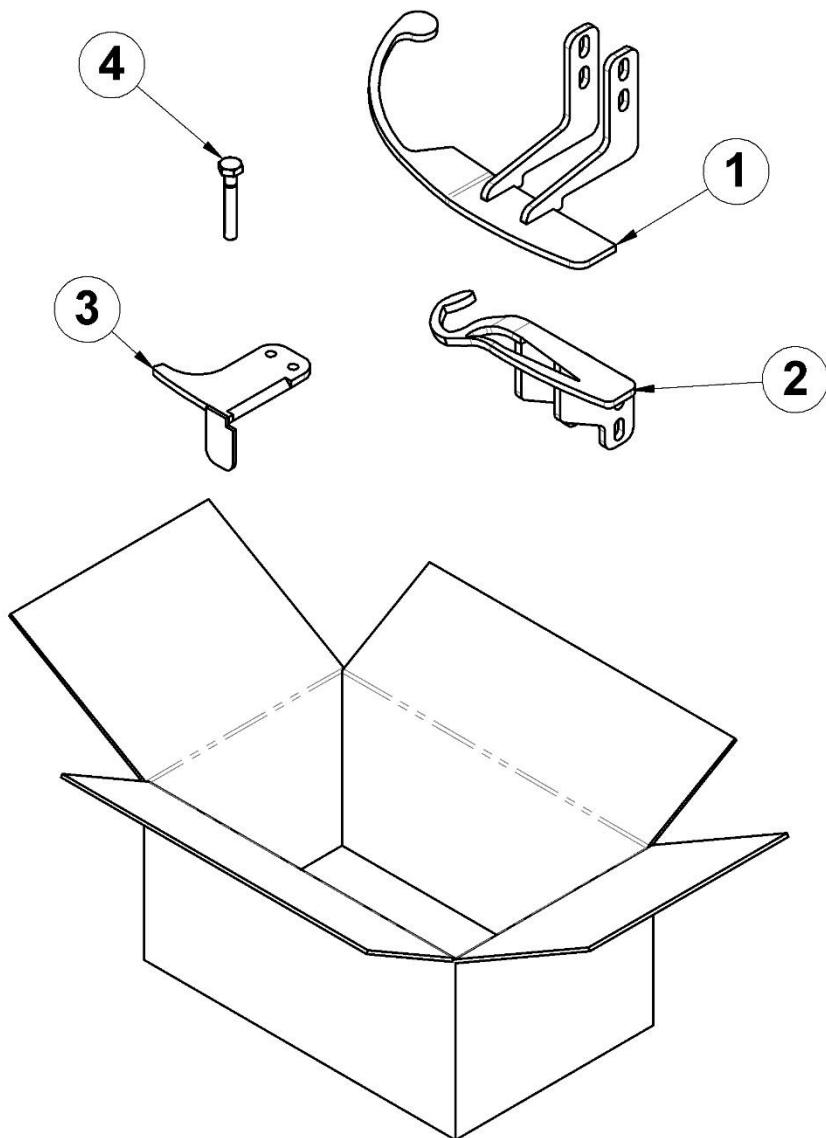
SPARE PART KIT CW(2791700000)				
FOR CUSTOMER USE	ITEM	PART No	DESCRIPTION	QTY
	1	2796501000	WELD, TAIL PRESS CW	1
	2	2796504100	WELD, VEE BLADE CW	1
	3	2796600500	WELDT, POSITIONER,CW	1
	4	0099998	SHEAR BOLT	1





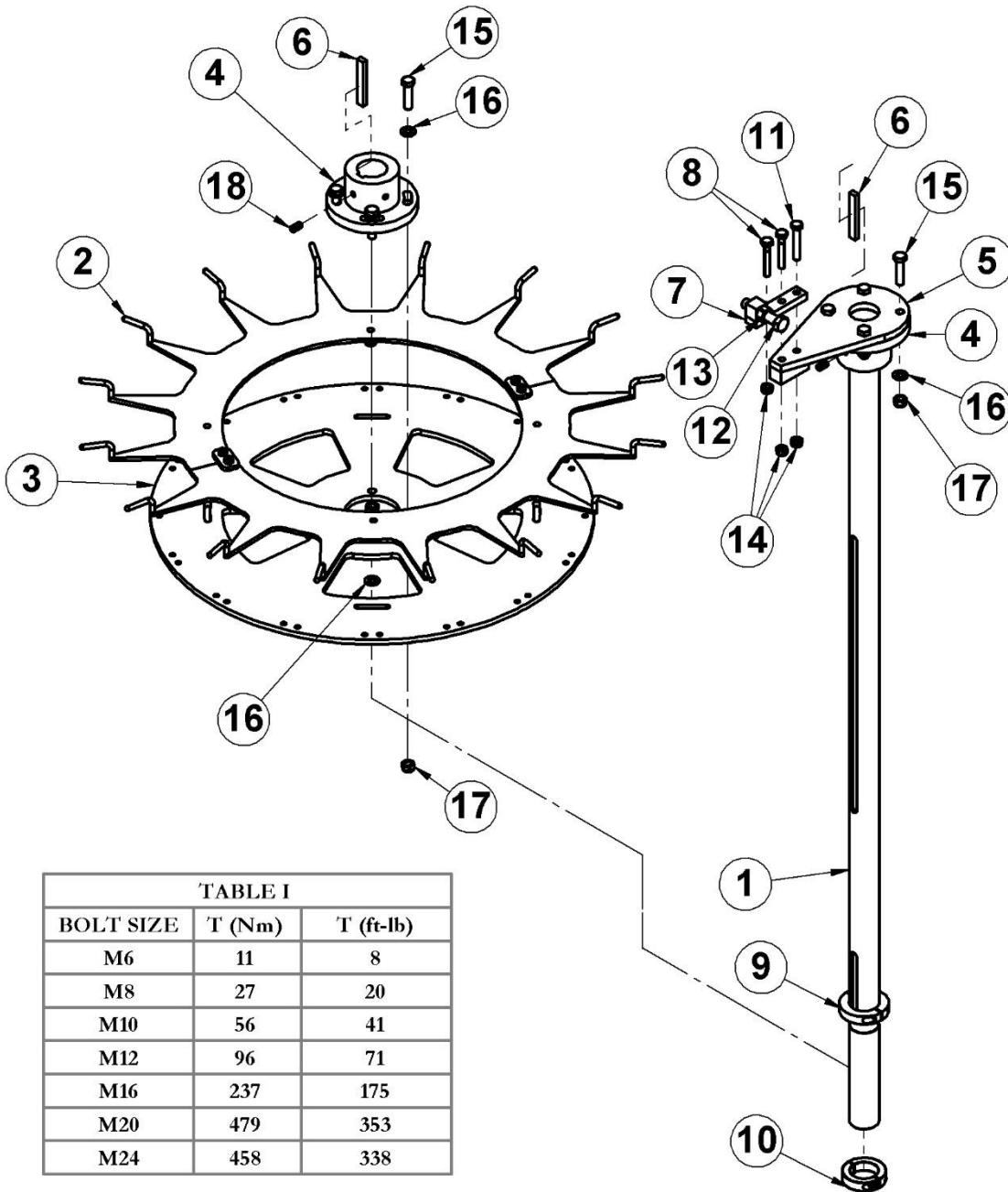
SPARE PART KIT CCW (2791700010)

FOR CUSTOMER USE	ITEM	PART No	DESCRIPTION	QTY
	1	2796502000	WELD, TAIL PRESS CCW	1
	2	2796504101	WELD, VEE BLADE CCW	1
	3	2796600510	WELD, POSITIONER CCW	1
	4	0099998	SHEAR BOLT	1





BARREL ASSEMBLY 6IN



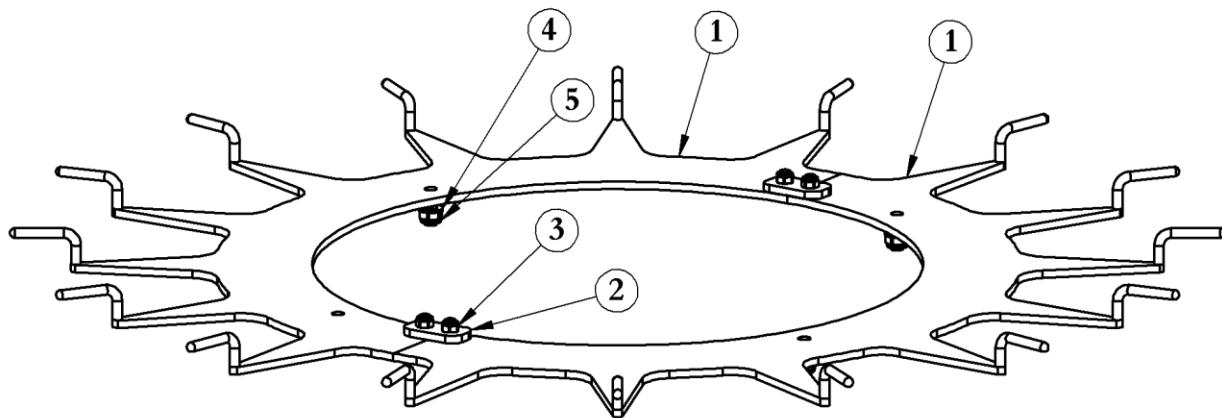
1. GREASE ALL FASTENERS USING ANTI-SEIZE LUBRICANT PRIOR TO ASSEMBLY.
TORQUE ALL FASTENERS WITHIN $\pm 10\%$ OF THE VALUE LISTED IN TABLE 1.



BARREL ASSEMBLY 6IN				
For Customer Use	Pos.	Part No.	Description	Qty
	1	2796600100	SHAFT	1
	2	2796600600	ASSY, ADJ RING	1
	3	2796600200	FLAT, BOTTOM PLATE, 16/6"	1
	4	2796600300	HUB	2
	5	2796600400	WELD, SHEAR PLT	1
	6	0093957	KEY 14 X 9 X 90	2
	7	0095792	SHEAR PIN MOUNT WELD'T	1
	8	0099998	SHEAR BOLT	2
	9	93860630	SPLIT CLR 2 ID X 3 1/4 OD X 5/8	1
	10	93860607	2-PC COLLAR	1
	11	95161680	SCR M8x50 HEX CAP SS	1
	12	95161680	SCR M16x80 HEX CAP SS	1
	13	95170016	NUT M16 HEX SS	1
	14	95171000	NUT M10 HEX SS LOCK	3
	15	95161250	SCR M12x50 HEX CAP SS	8
	16	95180012	WASHER M12 FLAT SS	12
	17	95171200	NUT M12 HEX SS LOCK	8
	18	95191020	SET SCR M10x20 CUP PT SS	4



ADJUSTMENT RING ASSEMBLY 6IN				
For Customer Use	Pos.	Part No.	Description	Qty
	1	2796600610	WELD, ADJ RING HALF	2
	2	2796600640	BAR, RING JOINT	2
	3	95170800	NUT M8 HEX SS LOCK	4
	4	95180010	WASHER M10 FLAT SS	4
	5	95171000	NUT M10 HEX SS LOCK	4





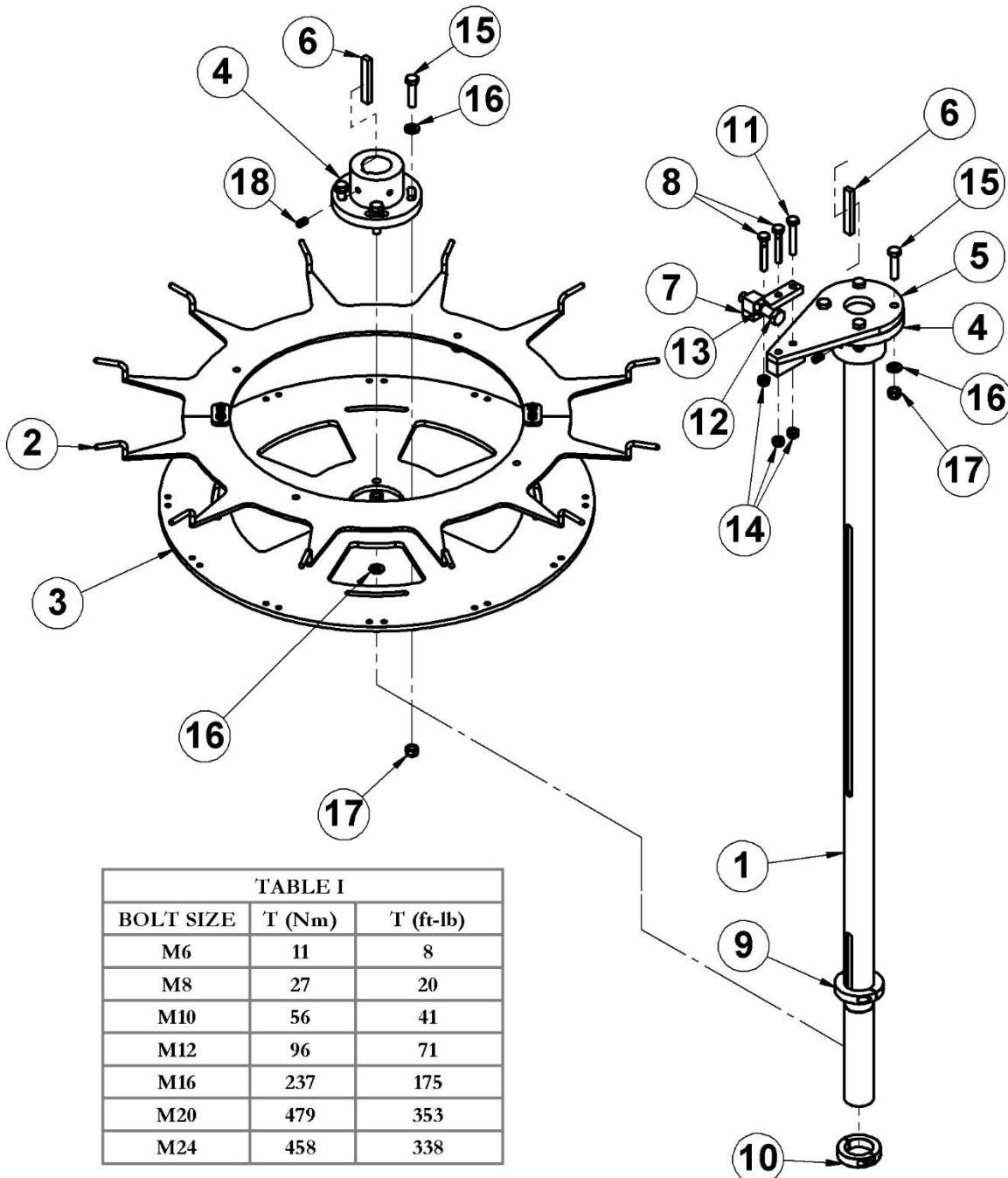
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BARREL ASSEMBLY 8IN



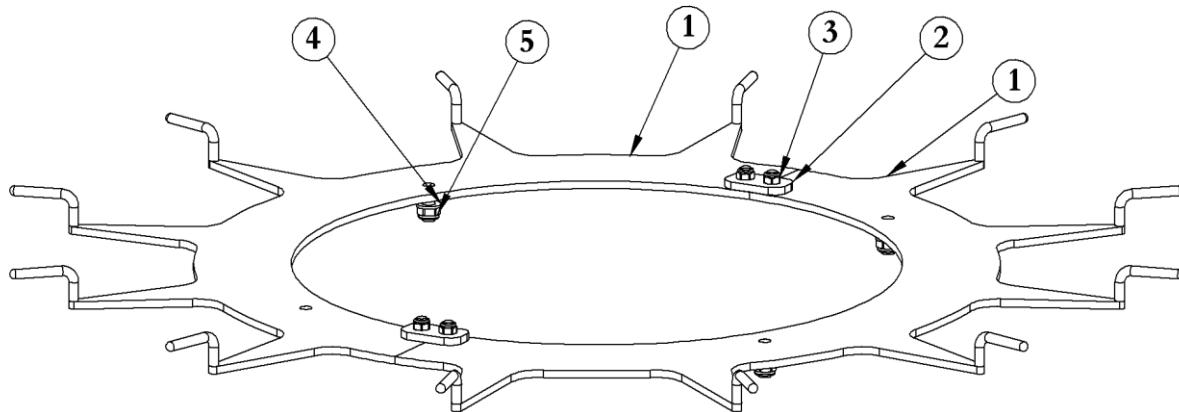
1. GREASE ALL FASTENERS USING ANTI-SEIZE LUBRICANT PRIOR TO ASSEMBLY.
TORQUE ALL FASTENERS WITHIN $\pm 10\%$ OF THE VALUE LISTED IN TABLE 1.



BARREL ASSEMBLY 8IN				
For Customer Use	Pos.	Part No.	Description	Qty
	1	2796600100	SHAFT	1
	2	2796600608	ASSY, ADJ RING 8IN	1
	3	2796600208	BOTTOM PLATE, 12/8"	1
	4	2796600300	HUB	2
	5	2796600400	WELD, SHEAR PLT	1
	6	0093957	KEY 14 X 9 X 90	2
	7	0095792	SHEAR PIN MOUNT WELD'T	1
	8	0099998	SHEAR BOLT	2
	9	93860630	SPLIT COLLAR 2 ID X 3 1/4 OD	1
	10	93860607	2-PC COLLAR #2C-187-S	1
	11	95161066	SCR M10x65 HEX CAP SS	1
	12	95161680	SCR M16x80 HEX CAP SS	1
	13	95170016	NUT M16 HEX SS	1
	14	95171000	NUT M10 HEX SS LOCK	3
	15	95161250	SCR M12x50 HEX CAP SS	8
	16	95180012	WASHER M12 FLAT SS	12
	17	95171200	NUT M12 HEX SS LOCK	8
	18	95191020	SET SCR M10x20 CUP PT SS	4

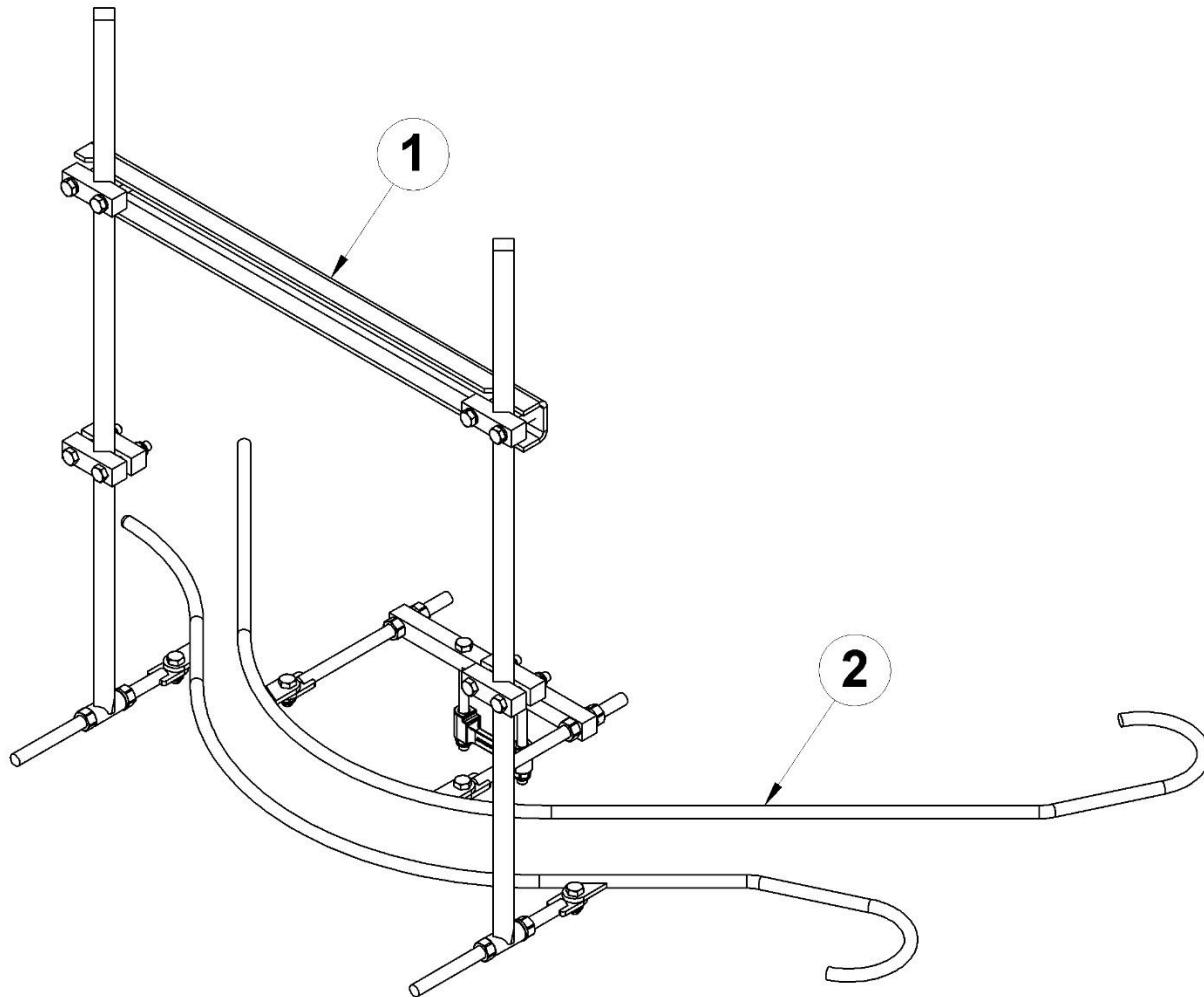


ADJUSTMENT RING ASSEMBLY 8IN				
For Customer Use	Pos.	Part No.	Description	Qty
	1	2796600618	WELD, ADJ RING HALF 8IN	2
	2	2796600640	BAR, RING JOINT	2
	3	95170800	NUT M8 HEX SS LOCK	4
	4	95180010	WASHER M10 FLAT SS	4
	5	95171000	NUT M10 HEX SS LOCK	4



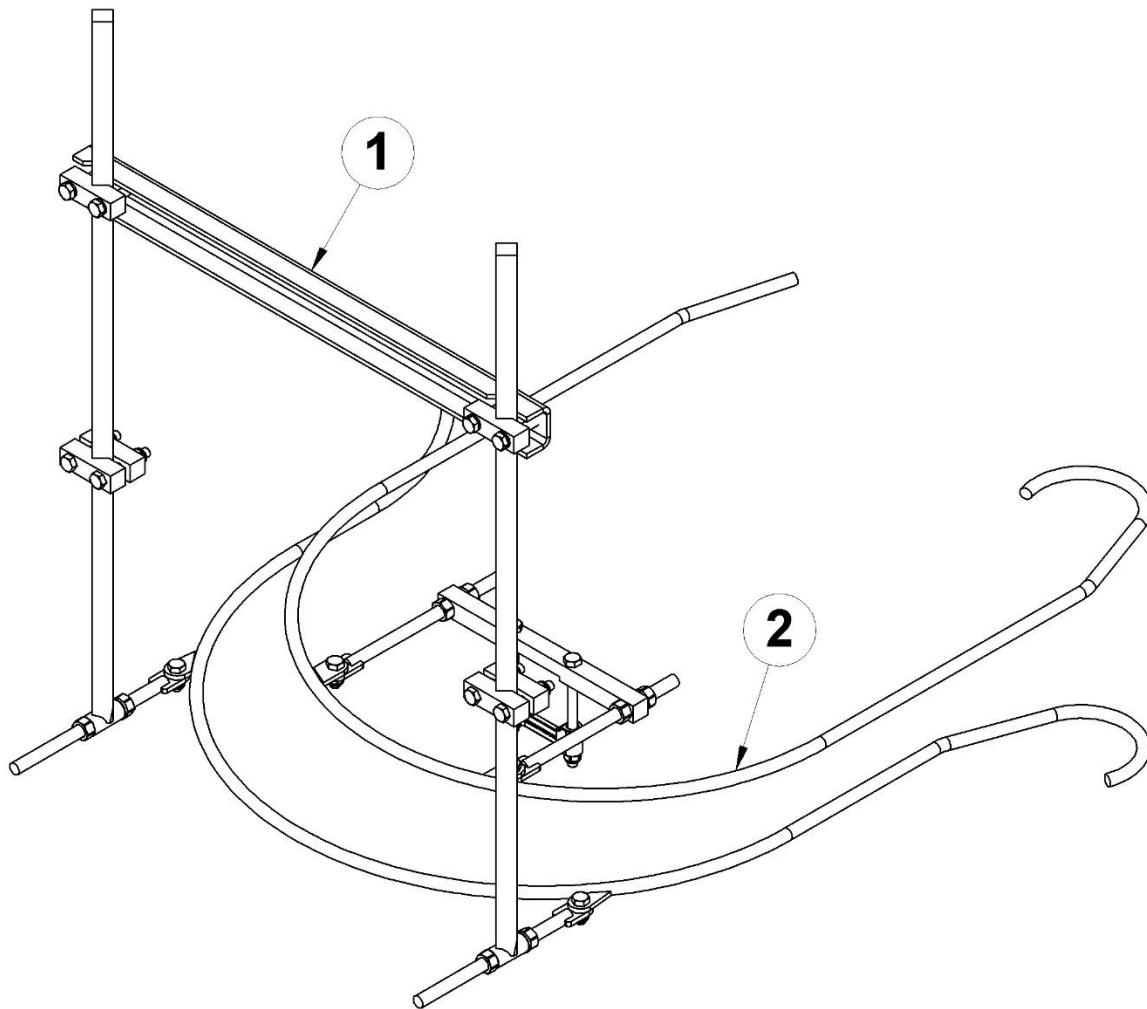


ASSY GUIDE BAR 90 DEG (2796750130)				
FOR CUSTOMER USE	ITEM	PART No	DESCRIPTION	QTY
	1	2796750110	ASSY, OUTER GUIDE BAR	1
	2	2796750100	ASSY, INNER GUIDE BAR	1



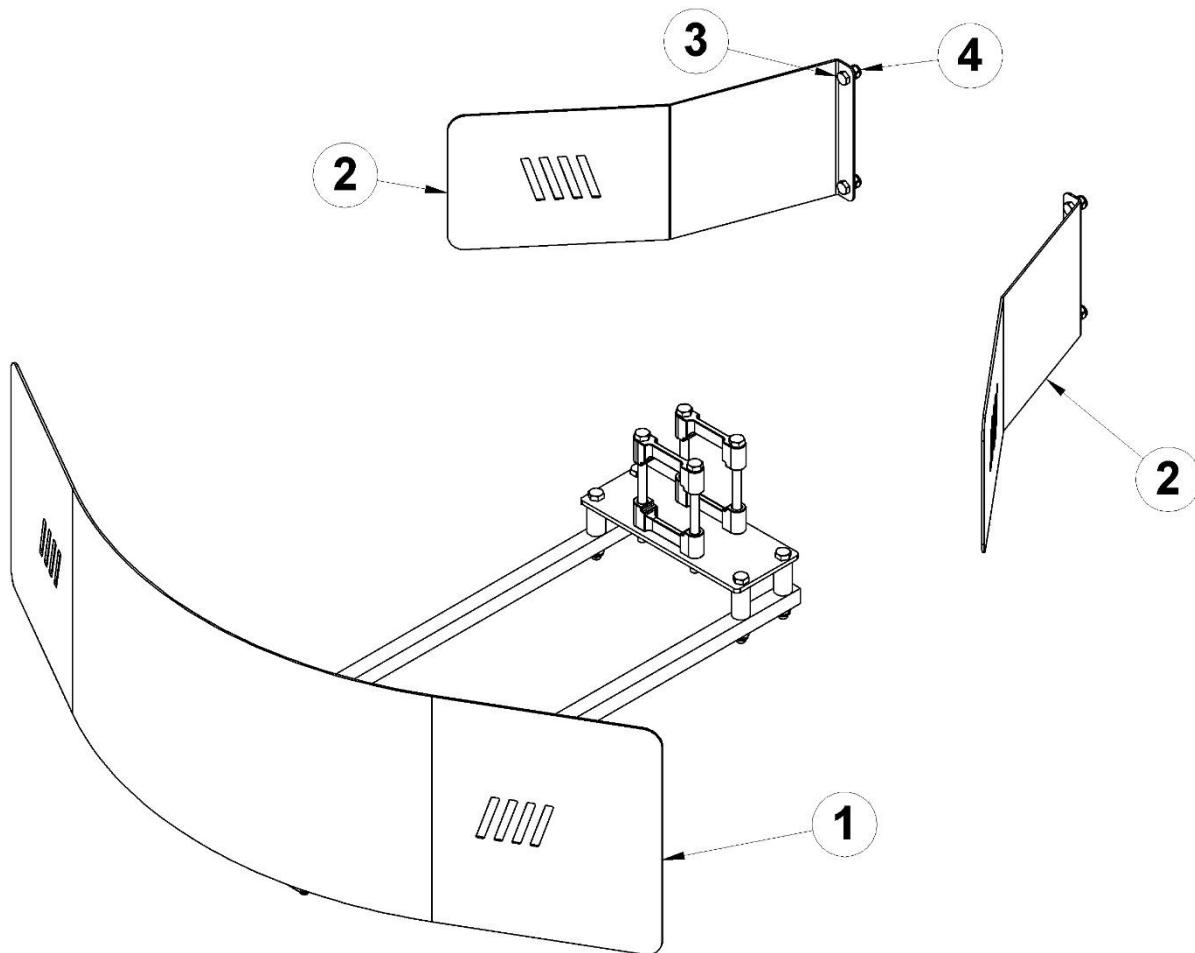


ASSY GUIDE BAR 180 DEG (2796750135)				
FOR CUSTOMER USE	ITEM	PART No	DESCRIPTION	QTY
	1	2796750111	ASSY, OUTER GB, 180 DEG	1
	2	2796750105	ASSY, INNER GUIDE BAR 180	1



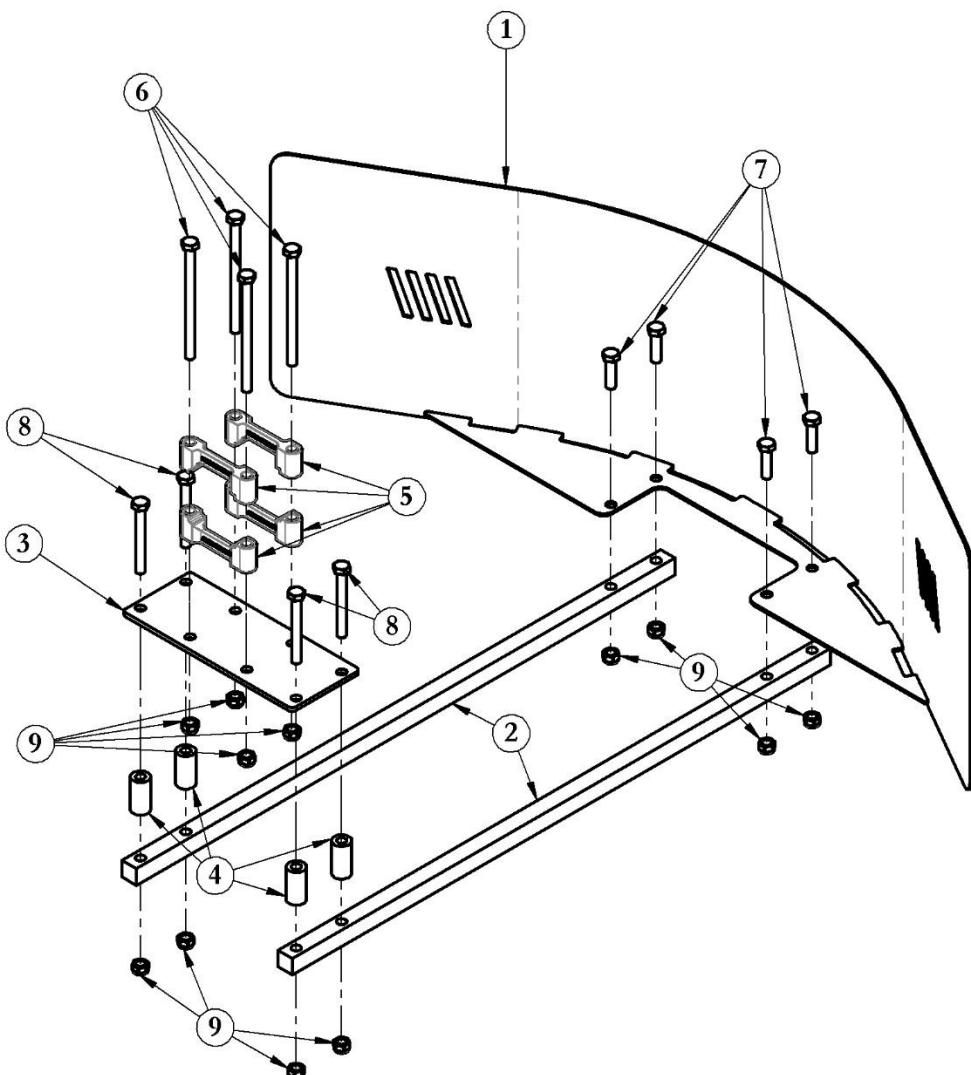


ASSY SHIELD 90 DEGREE (2796403400)				
FOR CUSTOMER USE	ITEM	PART No	DESCRIPTION	QTY
	1	2796403100	ASSY, FRONT SHIELD	1
	2	2796403304	SIDE GUARD	2
	3	95161025	SCR M10x25 HEX CAP SS DIN933	4
	4	95171000	NUT M10 HEX SS LOCK DIN 985	4



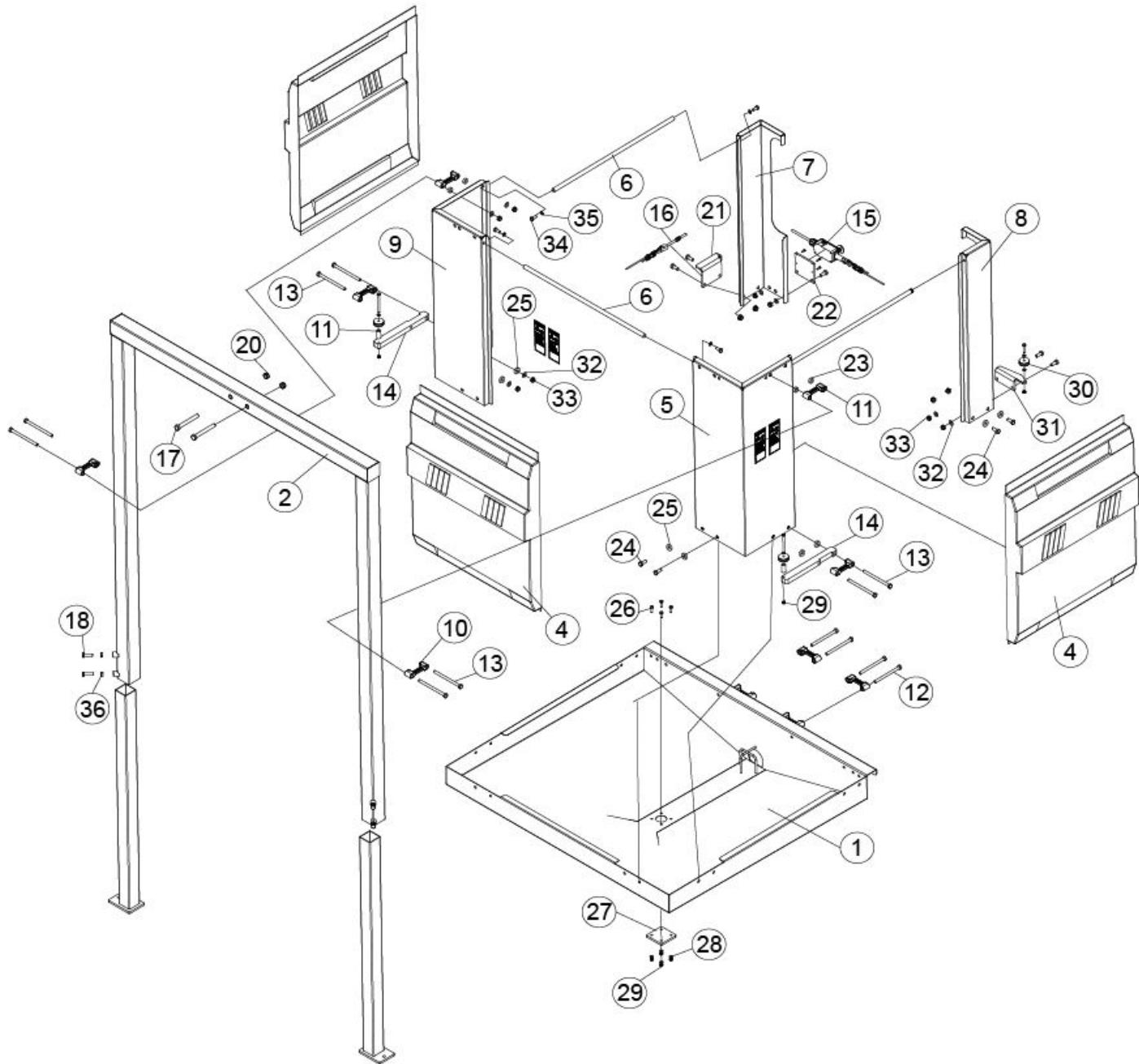


ASSY FRONT SHIELD (2796403100)				
FOR CUSTOMER USE	ITEM	PART No	DESCRIPTION	QTY
	1	2796403110	WELD, FRONT SHIELD	1
	2	2796403200	SUPPORT BAR	2
	3	2796403210	PLATE	1
	4	2796403220	SPACER 50MM	4
	5	28814812	CLAMP 80mm TUBE	4
	6	95161272	SCR M12x170 HEX CAP SS DIN931	4
	7	95161245	SCR M12x45 HEX CAP SS DIN931	4
	8	95161200	SCR M12x100 HEX CAP SS DIN931	4
	9	95171200	NUT M12 HEX SS LOCK DIN 985	12





FRONT SHIELD ASSEMBLY

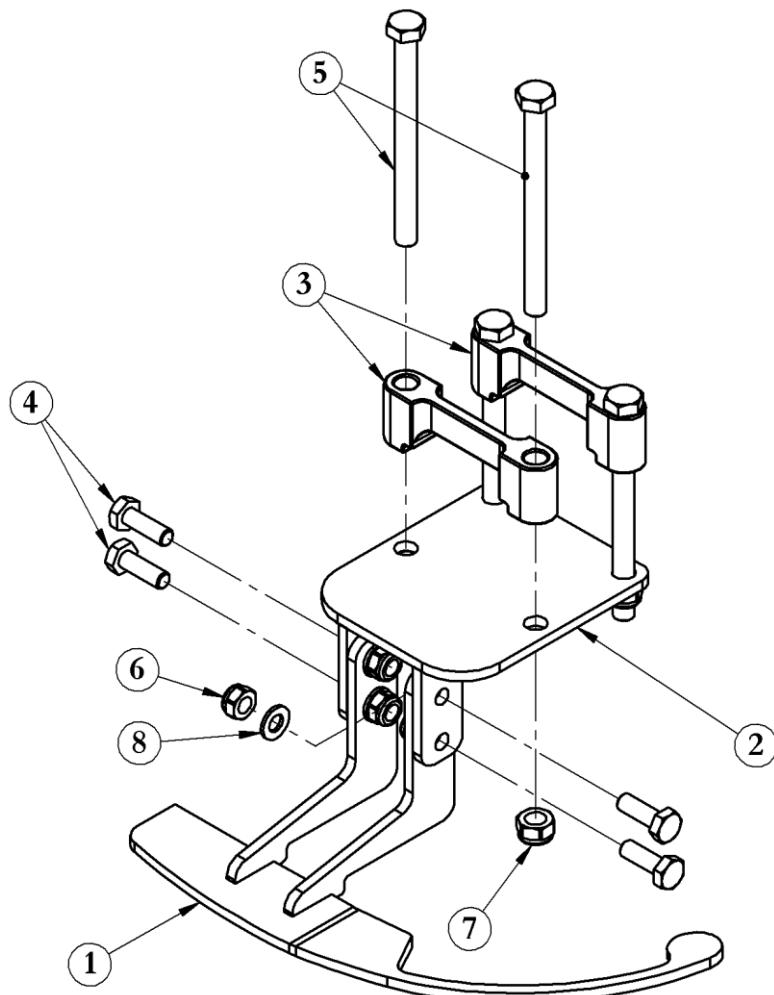




FRONT SHIELD				
For Customer	Pos.	Part No.	Description	Qty
	1	28811611	PANEL WELD 16HD	1
	2	2881381101	WELD LEG 16HD PAN	1
	3	2880400320	ADJUSTING LEG	2
	4	28816810	FRAME PANEL 16	3
	5	28812001	FRONT PANEL 16/20 HD	1
	6	28814102	SUPPORT ROD 16 HD	1
	7	28811904	BACK PANEL LH 16/20 HD	1
	8	28811905	BACK PANEL RH 16/20 HD	1
	9	28812001	FRONT PANEL 16/20 HD	1
	10	28814812	CLAMP 80MM TUBE	10
	11	2880400534	SPACER PULLEY FRAME MK 4.2	2
	12	95161216	SCR,M12x160 HEX,HD,CAP	4
	13	95161272	SCR,M12x170 HEX,HD,CAP	8
	14	28875003	PULLEY BRACKET	2
	15	2880410102	KIT EMERGENCY SWITCH	1
	16	95010005	EYE BOLT 3/8 X 5" LG SS	1
	17	95161585	SCREW M16 X 130 SS	2
	18	95161240	SCR,M12x40 HEX,HD,CAP	4
	19	95160899	SCR,M8x100 HEX,HD,CAP	2
	20	95171600	NUT M16 HEX SS DIN 985	2
	21	2880400538	TENSIONING PLATE FRAME MK 4.2	1
	22	2880400540	SWITCH PLATE FRAME MK 4.2	1
	23	28814510	PACER UPPER PAN TOP PANELS FRAME MK 4	4
	24	95161231	SCR M12 X 30F HEX CAP DIN933	12
	25	28814500	SPACER PAN PANELS FRAME MK 4.1	10
	26	95160825	SCR,M8x25 HEX,HD,CAP	4
	27	28813230	BEARING PLATE PAN FRAME MK 4.1	1
	28	95180008	WASHER,FLAT,M8,	10
	29	95170800	NUT,M8 HEX SS LOCK	3
	30	990017029953	PULLEY	3
	31	2880400535	PULLEY PLATE FLAT FRAME MK 4.2	1
	32	95180012	WASHER,FLAT,M12 DIN 125A	20
	33	95171200	NUT,M12 HEX LOCK	28
	34	95161025	SCR,M10x25 HEX,HD,CAP	6
	35	95181000	WASHER,LOCK,M10	6
	36	95170012	NUT,M12 HEX SS DIN 934	4

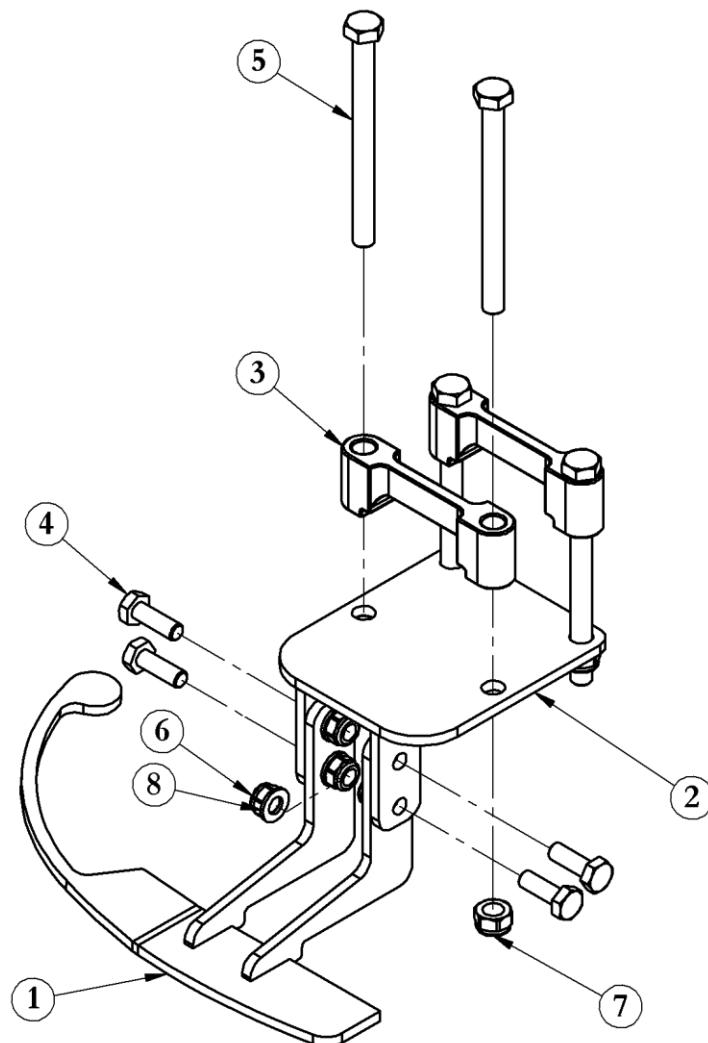


CW TAIL PRESS ASSEMBLY				
For Customer Use	Pos.	Part No.	Description	Qty
	1	2796501000	WELD, TAIL PRESS CW	1
	2	2796503000	WELD, MOUNTING BRKT	1
	3	28814812	CLAMP 80mm TUBE	2
	4	95161028	SCR M10x30 HEX CAP SS	4
	5	95161214	SCR M12x140 HEX CAP SS	4
	6	95171000	NUT M10 HEX SS LOCK	4
	7	95171200	NUT M12 HEX SS LOCK	4
	8	95180010	WASHER M10 FLAT SS	4





CCW TAIL PRESS ASSEMBLY				
For Customer Use	Pos.	Part No.	Description	Qty
	1	2796502000	WELD, TAIL PRESS CCW	1
	2	2796503000	WELD, MOUNTING BRKT	1
	3	28814812	CLAMP 80mm TUBE	2
	4	95161028	SCR M10x30 HEX CAP SS	4
	5	95161214	SCR M12x140 HEX CAP SS	4
	6	95171000	NUT M10 HEX SS LOCK	4
	7	95171200	NUT M12 HEX SS LOCK	4
	8	95180010	WASHER M10 FLAT SS	4







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