



20 – 40 – 50 – 70

125 – 200 – 300 L

**FORK TYPE DOUGH KNEADER
MACHINE**

MODEL: PET 20-40-50-70-125-200-300

IBT 22-VE/32-VE/42-VE/64-VE

User manual - Instructions

EN

“CE” Declarations of Conformity

MANUFACTURER'S DATA

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TECHNICAL CHARACTERISTICS

Type	Model	V	A	Hz	Phases	kW	Weight
PET 20		380-415	10	50/60	3~	0,37 kW	70
PET 40		380-415	11,2	50/60	3~	0,45 kW	95
PET 50		380-415	11,2	50/60	3~	0,75 kW	140
PET 50-32		380-415	11,2	50/60	3~	0,75-1,5 kW	150
PET 70		380-415	15,4	50/60	3~	1,5 kW	200
PET 70-32		380-415	23,8	50/60	3~	1,1-2,2 kW	250
PET 125		380-415	25	50/60	3~	1,5 kW	240
PET 125-32		380-415	32	50/60	3~	1,5-2,5 kW	250
PET 200-32		380-415		50/60	3~	2,2-3,2 kW	400
PET 300-32		380-415		50/60	3~	3,2-5,0 kW	460

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1 Warning

Read this instruction manual before switching the machine on. Keep this instruction book together with the appliance for future consultation.

These warnings were drafted for your safety and for that of others. Please read them carefully before installing or using the appliance.

The appliance is intended for professional use and must be utilized by qualified personnel trained to use it.

Any modification which may be necessary on the electrical system to enable installation of the appliance, must be carried out solely by competent personnel.

It is dangerous to modify or attempt to modify the characteristics of this appliance. Starting up. This unit must be grounded for your protection to avoid the risk of electrical discharges. It should be connected directly to the ground terminal of the control cabinet. The ground cable must not be cut or disconnected from the machine.

The introduction of an object or foreign body other than that necessary in the manufacture of the dough is totally forbidden.

Before doing any maintenance or cleaning jobs, disconnect the appliance from the electrical mains and allow it to cool.

The sound pressure level emitted by the machine is lower than 70 dB.

NOTE: The manufacturer will not be held responsible for the following:

- Incorrect installation of the machine
- Use of non-original spare parts
- Electrical supply problems
- Non authorized alterations
- Lack of daily maintenance
- Improper and/or incorrect use of the machine
- Non-compliant use according to current regulations in the country where the machine will be installed.

2 Safety

2.1 Safety Regulations

It is forbidden to tamper with the safety guards and other safety devices of the machine. If any of the safety features of the machine are damaged, they must be immediately repaired and remounted in the same way.

The safety guard or safety devices must not be removed from the machine except for cleaning or maintenance. The safety guard and safety devices must be replaced in their original position as soon as the reasons for removing them have been dealt with.

Before commencing cleaning or maintenance of the machine, ensure that the power has been disconnected and the plug has been removed.

In the event of machine maintenance, cleaning or repairs ensure that the necessary precautions are taken to avoid that any other person starts the machine or any of its parts. Inform and advise all workers of the risks in the workplace.

Compliance with the legislation in force concerning safety regulations in the workplace.

2.2 Safety Advice

Read the following instruction carefully before using the appliance for the first time.

This appliance is not intended for use by persons (including children) with reduced physical, sensory, or mental capabilities or lack of experience and knowledge, unless they have been given supervision or instruction concerning use of the appliance by a person responsible for their safety.

Children should be supervised to ensure that they do not play with the appliance.

The appliance may only be connected to a power supply whose voltage and frequency comply with the specifications on the rating plate!

Never use or pick up the appliance if;

- The supply cord is damaged,
- The housing is damaged.

If the appliance or the supply cord is damaged, it must be replaced by the manufacturer, its service agent or similarly qualified person, to avoid hazard.

Always disconnect the appliance from the supply if it is left unattended and before assembling, disassembling, or cleaning.

Never release the accessories while the appliance is running. Avoid contact with moving parts. Contact could result in injury!

Do not immerse the appliance in water or any other liquid.

Do not use the appliance to stir paint.

This appliance is intended for kitchen use only. The manufacturer cannot accept any liability for possible damage caused by improper or incorrect use.

Never switch on the appliance until the working attachments are in the mixing bowl with the ingredients to be processed.

Always wait until the attachments stop before you remove the bowl.

ATTENTION!

Machine storage: -25°C to +50 °C

Ambient temperature during operation: +4 °C to +40 °C.

This machine is for professional use and must be used by staff trained to use, clean, and maintain it, in terms of reliability and safety.

Use the machine in adequately lit premises (See applicable technical standard for the country of use. In Europe, refer to standard EN 12464-1)

When handling the machine, always check that the parts taken hold of are not mobile elements: risk of dropping and injury to the lower limbs.

The machine is not designed for use in explosive atmospheres.

2.3 Safety Guards

The most dangerous parts of the machine are the tools that work the mixture in the inner part of the bowl. Access to the bowl when tools are moving is prevented by a moving guard equipped with a safety micro switch; on lifting to open it, the safety switch that stops the tool is activated, when closing it, the tool does not start moving again.

Two other safety switches ensure that the tool cannot function if the bowl is not correctly fitted in the working position of the machine, at the highest point.

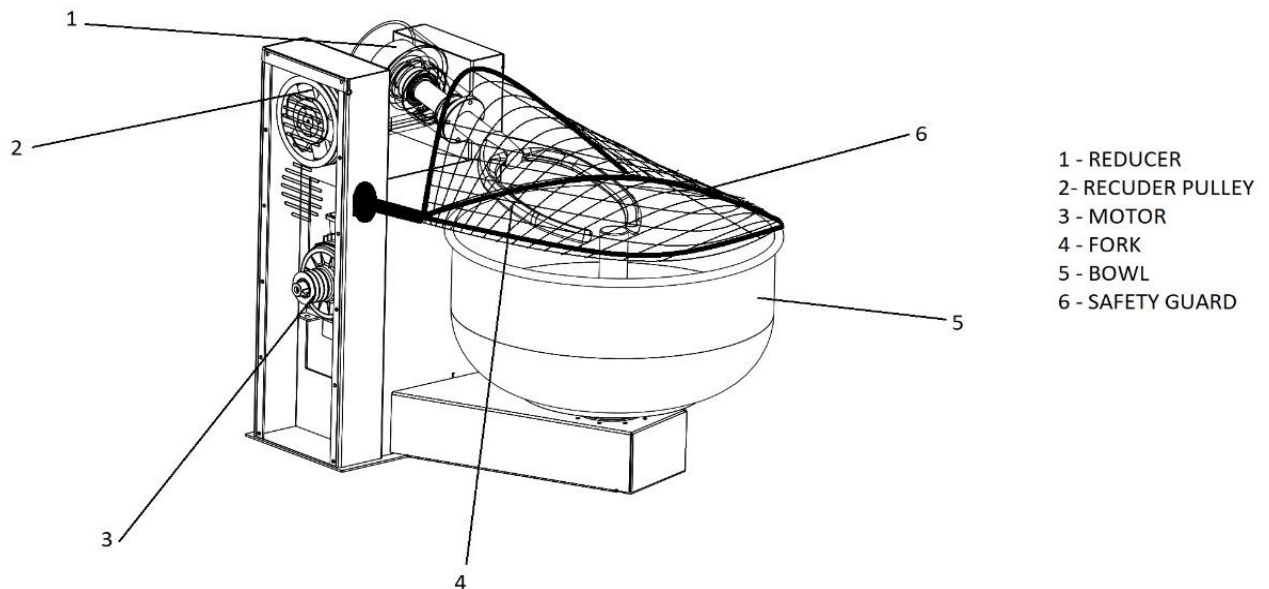
3 General Characteristics

3.1 Description of Machine

The mixer, kneading machine, eggbeater is excellent for small and large production in the confectionery, food, chemical and cosmetic industries.

The machine is equipped with a speed variator, which allows to select the tool speed by means of a special regulator on the control panel. Speed variation is gradual and continuous so that the appropriate speed can be selected for each mix and for each step of the production without sudden speed changes or machine stoppages.

The machine is manufactured according to current CE standards.



Main Parts of machines;

3.2 Machine Use

3.2.1 Correct Use

Machine must be operated by personnel specialized in pastry production. Depending on the tool and rotating speed chosen; different mixes can be made with the machine.

Tool use is shown in the table below;

TOOL	SPEED			USE	EXAMPLES
	IBT 22				
Wire whisk	4 to 10	4 to 10	30 to 80	For all liquid products that need to incorporate air during the mixing	Soft cake, meringue, whipped cream
Paddle	1 to 8	1 to 8	20 to 80	To mix all products of a medium density	Cream puffs, almond pastes
Kneading tool	1 to 3	1 to 3	10 to 40	For all hard dough	Puff pastry, soft pastry, pizza.

The machine has been designed to mix a variety of products of different consistencies, therefore it is not always possible to make use of the whole capacity of the bowl.

We recommend weighing the correct quantity of product to mix, taking into consideration the consistency of the final product.

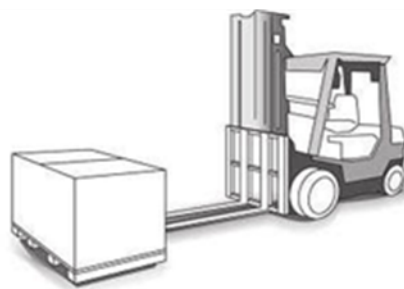
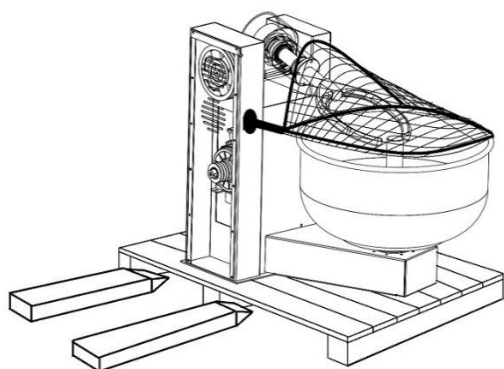
3.2.2 Incorrect Use

The machine has been designed and manufactured for the uses and the product types described in before paragraph Any other use may damage the machine and may cause hazardous situations for the worker for which the manufacturer will not be held responsible.

The machine must not be used in ATEX environments.

4 Preassembly Instruction

4.1 Storage and Transport



- Your machine has been delivered to you in a way that is packaged on a pallet. The transport of the machine must be done as shown in the picture above, another way of transport can cause damages on your machine.
- While the goods are transported, it should not be left suspended (hang in the air), and transport should be done with suitable equipment.
- Sizes and weights of the machines are given in the Technical Specifications section.
- Blanks, holes, arms, and parts located on the machines should not be used for transport. Transport way except for the schema can cause damages to machine.
- To prevent any work accidents while transporting the machine, strictly obey the rules of occupational health and safety. Do not move it without taking necessary security precautions.
- Responsible staff in transport must use safety equipment such as hard hat (helmet), gloves, steel toe shoes.
- By considering weight of the machine, appropriate equipment must be used for the transport. Before moving, the weight of the machine, external dimensions, lifting points and center of gravity must be carefully checked.
- Before moving machinery, the dimensions of the door or partition should be checked whether it is appropriate
- Operations such as acceleration and braking while lifting and handling the machine must not be done in a manner harmful to employees.
- Machine should not be lifted and moved except for the above schema.
- Check the packaging and the product if it is damaged during shipping. If there has been any damage during transport, report to shipping company, insurance company and Salva.
- Certainly, take photo various angles of the damaged machine. It is necessary for the authority to define problem.
- Take out by checking packaged machine and if there is related equipment. Check the bill of consignment if the materials are sent full. Please inform Salva for any missing material.
- Packaging must be opened by authorized personnel who knows the product.
- Never put the load on the machine.

4.2 Conditions of Use

For free standing equipment, the floor strength must withstand 250 kg. Likewise for maintenance operations, a space of 350 mm must be left behind the mixer.

The machine has been designed to be installed in enclosed areas with a temperature that varies from +10 to +40 degrees Celsius. It has not been designed to be installed outdoors.

After positioning the machine in the selected place, which must be as level as possible, regulate the stabilizers inside the front cylindrical hard until they meet the floor.

5 Electrical Connection

ATTENTION!

Connection to the electrical power supply must be done according to proper professional practice by a qualified and authorized person (see current standards and legislation in the country of installation).


If an adapter is used on the socket, a check must be made that the electrical characteristics of this adapter are not lower than those of the machine.
 Do not use multiple plugs.
 The AC power supply to the machine must comply with the following conditions- Maximum voltage variation: $\pm 5\%$
 - Maximum frequency variation: $\pm 1\%$ on a continuous basis, $\pm 2\%$ over short periods

ATTENTION: the electrical installation must comply (for design, creation, and maintenance) with the legal and standard requirements in the country where used.

Check that the electric mains voltage, the value shown on the specification plate and the label on the power cable are the same.
 - The machine's electrical power supply must be protected against voltage surges (short-circuits and excess voltages) by using fuses or thermal relays of the appropriate gauge relative to the place of installation and machine specifications.

ATTENTION: Concerning protection against indirect contact (depending on the type of power supply provided and connection of the exposed conductive parts to the equipotential protection circuit), refer to point 6.3.3 of EN 60204-1 (IEC 60204-1) with the use of protection devices for automatic shut-off of power in the event of an insulation fault with a TN or TT, system, or for the IT system, with the use of a permanent insulation or differentials controller for automatic shut-off. The requirements of IEC 60364-4-41, 413.1 must apply for this protection.

ATTENTION: Failure to comply with these instructions means the customer runs the risk of machine failure and/or accidents due to direct or indirect contacts.



ATTENTION!

Cut and lock the electricity before making electricity connection.

Connect circuit breaker plug for each machine.

Do not operate the machine without residual current relay and earthing.

Check the apparatus for turning arrow directions which shown on bowl.

Must be earthed using the green and yellow wire.

Check that the electric mains voltage, the value shown on the specification plate and the label on the power cable are the same.

	Supply Voltage	Electrical Power Max.
PET 20	380 V / 3P / 50 Hz	0,37 kW
PET 40	380 V / 3P / 50 Hz	0,45 kW
PET 50	380 V / 3P / 50 Hz	0,75 kW
PET 50-32	380 V / 3P / 50 Hz	0,75-1,5 kW
PET 70	380 V / 3P / 50 Hz	1,5 kW
PET 70-32	380 V / 3P / 50 Hz	1,1-2,2 kW
PET 125	380 V / 3P / 50 Hz	1,5 kW
PET 125-32	380 V / 3P / 50 Hz	1,5-2,5 kW

PET 200-32	380 V / 3P / 50 Hz	2,2-3,2 kW
PET 300-32	380 V / 3P / 50 Hz	3,5-5,5 kW

6 Use and Safety

ATTENTION!

Clean the machine properly prior to its first use.

Uncontrolled closure of the lid or ram press involves a risk of crushing the fingers.

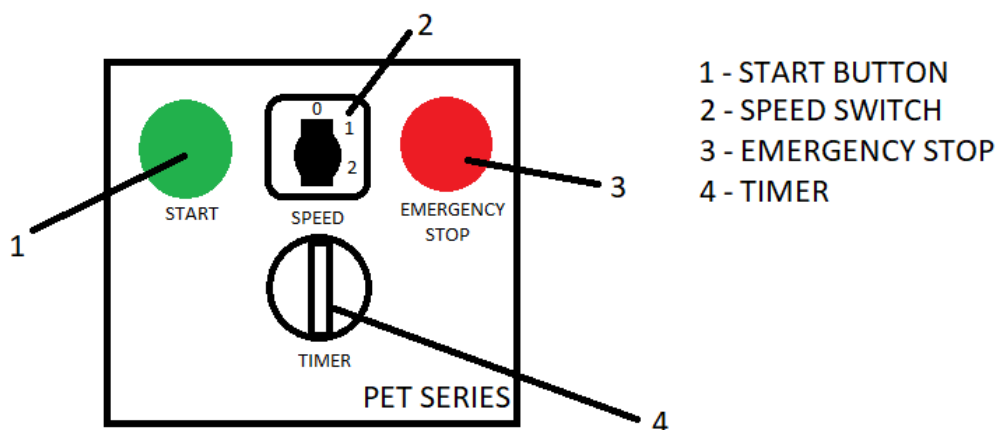
Never put a hand in the work area while the machine is in operation, risk of injury. It is strictly forbidden to put the safety systems out of action or modify them: Risk of permanent injury!!!!

Check that the safety devices correctly operate each time before using (see section about «safety system checks»).

Never put a hand, a hard or frozen object in the appliance.

For health and safety reasons, always use a strong washable or disposable head covering that covers the hair completely.

6.1 Operation - Safety



- Start (Green Button): Provides to start operation of the machine.
- Time Relay (Timer) : Provides to operate the machine in set time, and stops automatically at the end of the cycle. (Included some type of model)
- Emergency Stop (Red Mushroom Button): Stops operation, Turn the button and re-operate.
- Protector Switch: Provides not to operate if protector is not closed. It is designed for the safety of operator.
- Bowl Switch: Provides non-operation if the bowl is not in operation position.
- 1.Speed (Green Button): Provides the machine to begin mixing in low speed.
- 2.Speed (Green Button): Provides the machine to start rotating in high speed.

In this part, all information and instruction have been given to operate the machine. Operator must know these instructions before using it.

The safety of the user is guaranteed by:

The motor stops when the safety guard is opened.

The design of the guard that allows products to be added perfectly safely during operation.

The motor stops when the cradle is lowered. It will not start again when the START switch is pressed.

The need to press the START button after the machine has been stopped.

Protection against current and power surges, drops in power and the motor overheating.

Compliance with the instructions given in this manual for using, cleaning and maintaining the machine.

You have to look the apparatus speeds for speed setting from table or selection sticker.

- When the operator opens the bowl protector or if you move the bowl to lower position the machine will be stopped. operator must press the button for start to operation again.
- The operator must look the apparatus speeds for speed setting from table.

6.2 Daily Operation

- Control the machine if it is clean, if not clean it properly.
- Close the circuit breaker.
- Load according to function of the work and the capacity of the machine.
- Put the dust mask on while loading flour into the bowl.
- While loading flour, prevent dispersion of the flour by putting little distance between flour bag and bowl.
- Install all the protectors its place and close it.

ATTENTION!

Do not disable the protectors designed for operation safety.

Do not move the machine during operation.

Do not put anything on the machine during operation.

Do not touch moving parts of the machine during operation.

Clean the machine when operation is completed.

6.3 Maximum Capacities

- The beater's working capacity depends upon:

- The tool used.
- The nature, quantity and density of the mass to be worked.
- The optimum speed for quality results.
- Too large a quantity is always detrimental to the quality of the work and the life of the mechanical parts of the beater and may result in the motor overheating and abrupt stoppage

Maximum recommended quantities:

MODEL	BOWL VOLUME	MAX. FLOUR CAPACITY	MAX. POURING CAPACITY	MAX. DOUGH QUANTITY	MEAT QUANTITY
PET 20	20 L	9 kg	5 kg	14 kg	15 kg
PET 40	40 L	15 kg	7,5 kg	22,5 kg	25 kg
PET 50	50 L	17 kg	10 kg	27 kg	33 kg
PET 70	70 L	25 kg	15 kg	40 kg	47 kg
PET 125	125 L	50 kg	25 kg	75 kg	84 kg
PET 200	200 L	70 kg	40 kg	110 kg	134 kg
PET 300	300 L	105 kg	60 kg	165 kg	200 kg

7 Cleaning and Hygiene

7.1 Between Two Sessions

- Using hot water and detergent/disinfectant or degreaser (if working with greasy products), immerse and wash the inside of the bowl and the tool in the sink, then rinse in clean water and dry.

-Clean the planetary gear housing, the tool holder spindle and the safety guard with a damp sponge and a detergent disinfectant product, then rinse in clean water.

Note: Use cleaning products that are compatible with the aluminum and stainless steel parts.

Do not use hard material for cleaning the machine, otherwise your machine will be scratched and will lose its hygienic features.

7.2 After Use

- Disconnect the machine.

- Clean the bowl and tools with detergent/disinfectant or degreaser in a sink, then rinse in clean water and dry. Only the bowl may be cleaned in a dishwasher.

- Clean the planetary housing, tool holder shaft, the safety guard and the cradle, paying attention to the bowl handles and where necessary the outside of the beater using a damp sponge and a disinfectant/detergent product, then rinse.

- Check that the different parts have been cleaned correctly.

- Check that the products used for cleaning are compatible with the machine part materials
- Do not use abrasive detergents as these could scratch the surfaces.
- To clean the accessory appliances, check with the instruction sheet for each accessory.
 - On a regular basis: (at least once a month)
- Remove dust from the ventilation slots at the back of the machine (cause of overheating).
- Wipe and lightly lubricate the raising and lowering pins with Vaseline.
- Oil the tool-holder shaft (food quality oil or grease).

STRAY FLOUR PARTICLES

To reduce the emission of stray flour particles while loading the bowl, it is recommended as follows.

- Empty the flour bag or the container containing the flour without shaking it.
- Pour in the water before putting the flour in if that is possible.
- Always start at slow speed during the water/flour mixing.
- Do not shake an empty flour bag. Roll it with care.

Keeping to these simple rules will contribute to reducing the emission of flour dust and consequently reducing the risks of allergy linked to that dust.

8 Fault Finding

BREAKDOWN	REASON	SOLUTION
Machine doesn't work.	Energy does not come to machine.	Check the supply voltage.
	Supply fuse blown.	Check the fuse.
	Engine heat blown.	Wait thermal cool, and switch on
	Circuit breaker is open.	Close circuit breaker.
Engine working noise is coming, but it is not suitable	One of the feeding phases is missing.	Check phase one by one.
	Drive belts are missing or loose	Check the belt tension.
	There is a congestion in the mechanical movement	Turn off energy! and check manually whisk-dough hook-beater. Inform technical service if there is congestion.
Machine receives energy but the machine is not activated.	Engine heat is blown	Wait for thermal cooling and switch on.
	Safety Switches are not active.	Make sure that the bowl is above and protective closed.
	Switch mechanical adjustment damaged or broken.	Contact with technical service.
	Defective part in the control circuit (contactor-thermal-Button-etc ..)	Contact with technical service.

9 Maintenance

This section describes the regular maintenance work to be done. When these maintenances are carried out:

- The machine performs the mixing efficiently.
- Food products prepared by the machine becomes suitable to human health.
- The machine will be long-lasting.
- Minimum time lose due to malfunction
- Prevents small malfunctions before being grave.

9.1 Checking the Safety Elements

The safety elements must be checked frequently to ensure that they operate correctly. The motor should stop when the safety guard is opened. If one of these two functions is not implemented:


- Do not use the machine.
- Have it adjusted by your local dealer's service department.

ADDRESS FOR SERVICE REQUIREMENTS

We advise you first to contact the dealer who sold you the machine.

For any information or orders for spare parts, specify the type of machine, its serial number and the electrical specifications.

The manufacturer reserves the right to modify and make improvements to the products without giving prior warning.

Dealer's stamp 

Date of purchase:

9.2 Electrical Components

- Check the condition of the power cable and the electrical components regularly.
- **Wire color Identification:**
 - Earth : (B/C) yellow/green
 - Neutral : (N) blue
 - Phase : (L) brown
 - Power circuit : black
 - Control circuit: red

10 Compliance with Regulations

The machine has been designed and manufactured in compliance with:

2014/30/EU

2014/35/EU

2006/42/EC

EN ISO 12100: 2010

EN ISO 13854:2019

EN ISO 13857: 2019

EN 60204-1:2018

EN ISO 14120: 2015

EN 1672-2:2020

EN 454:2014

REGULATION (EC) No 1935/2004

- **European Standards:**

EN 454 Beater Mixers. Safety and hygiene regulations.

This compliance is certified by:

- The CE compliance mark attached to the machine.
- The relative CE compliance declaration associated with the warranty,
- This instruction manual, which must be given to the operator.

Protection indices as per the EN 60529-2000 standard:

- IP54 electrical controls.
- IP32 overall machine.

Integral safety:

- The machine has been designed and manufactured in compliance with the relevant regulations and standards referred to above.
- Before using the machine, the operator must be trained in its use and informed of any possible residual risks.

Food hygiene:

The machine is made from materials that comply with the following regulations and standards:

- Standard EN 60204-1: cast aluminum alloy objects in contact with foodstuffs.

The surfaces of the food area are smooth and easy to clean. Use detergents that are approved for food hygiene and observe the instructions for their use.

11 Caution

In the event of danger to the user or the machine, you must use the **STOP** button.

Before any operation on the machine, remove the plug from the socket or turn off the switch at the connection point.

There may be certain risks:

- The blades are very sharp and may cause serious cuts even if the machine is idle.
- The replacement of the blades must be done by an approved agent only.
- All the blades must be present to avoid fingers getting caught in the mechanism when removing bread.
- After a few days of operations, get a qualified professional to control the tension of the blades by a qualified person.
- Earthing is imperative.

12 Guarantee

Our products are guaranteed against every failure or manufacturing defect, within a correct use of them. The guarantee does NOT apply to the substitutions and mending appearing from:

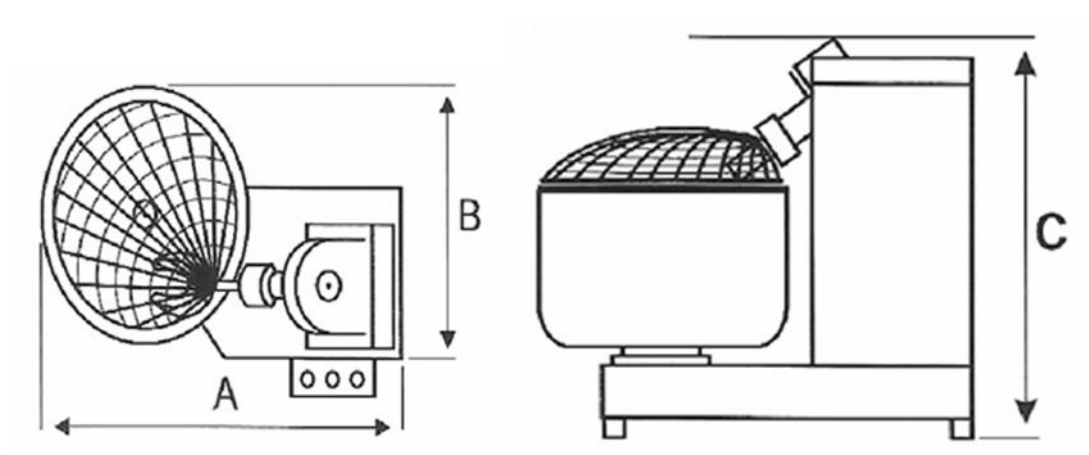
- Abnormal use of the machine
- Deterioration or accidents due to negligence.
- Lack of maintenance.
- External agents such as power supply voltage fluctuations or atmospheric elements such as storms or floods, or any other of similar origin. The guarantee is limited to replacing and repairing parts which have failed as a consequence of manufacturer defects, without covering the corresponding labor and call-out costs (except in Spain, where these costs are included).

The following materials are excluded from the aforementioned warranty: glass, light bulbs, gaskets, fabrics, ceramic tiles, refrigerant gas, oil changes, hinges and other parts that are subject to wear and tear.

Guarantee conditions

The materials must be installed, used and maintained in line with the conditions set out in this “Instructions Manual”. Any problems which require the intervention of an engineer must be carried out by the Official After-Sales Service of SALVA INDUSTRIAL S.L.U. or by one of our authorized distributors. Changing any part during the warranty period does not imply an extension of the warranty beyond the initially agreed period. In this case, only the warranty for the replaced part or piece will be extended by 6 months. Failure to meet these conditions implies the automatic invalidation of the guarantee. SALVA INDUSTRIAL, in its continual search to improve its products, reserves the right to make amendments without prior notice.

13 LOADING DIMENSIONS AND TECHNICAL SPECIFICATIONS

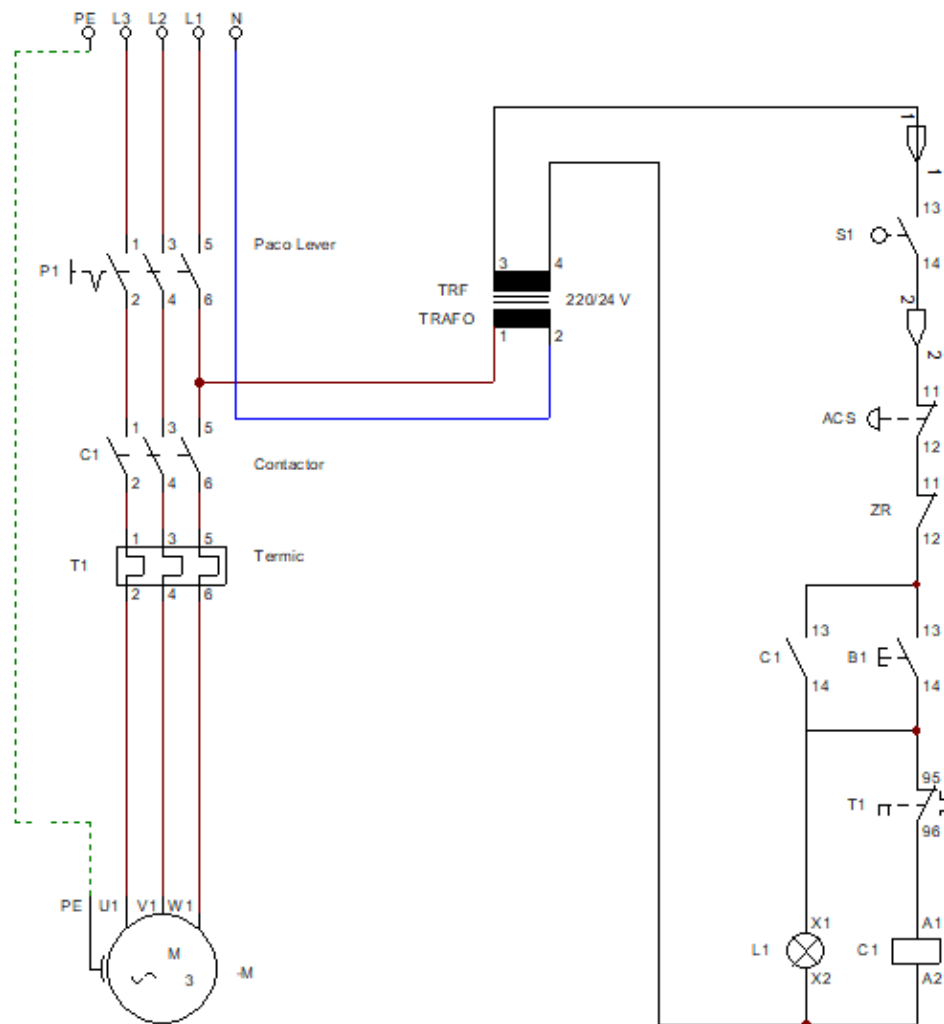


MODEL	BOWL VOLUME LT	MOTOR (KW)	DIMENSIONS (CM)	WEIGHT (KG)
PET 20	20	0,37	55 x 55 x 55	50 kg
PET 40	40	0,55	65 x 85 x 95	65 kg
PET 50	50	0,75	65 x 85 x 95	100 kg
PET 70	70	1,1	65 x 90 x 95	120 kg

PET 125	125	1,5-2,5	120 x 80 x 95	150 kg
PET 200	200	2,2-3,2	130 x 90 x 105	170 kg
PET 300	300	3,2-5,0	135 x 110 x 125	250 kg

14 Electrical Scheme

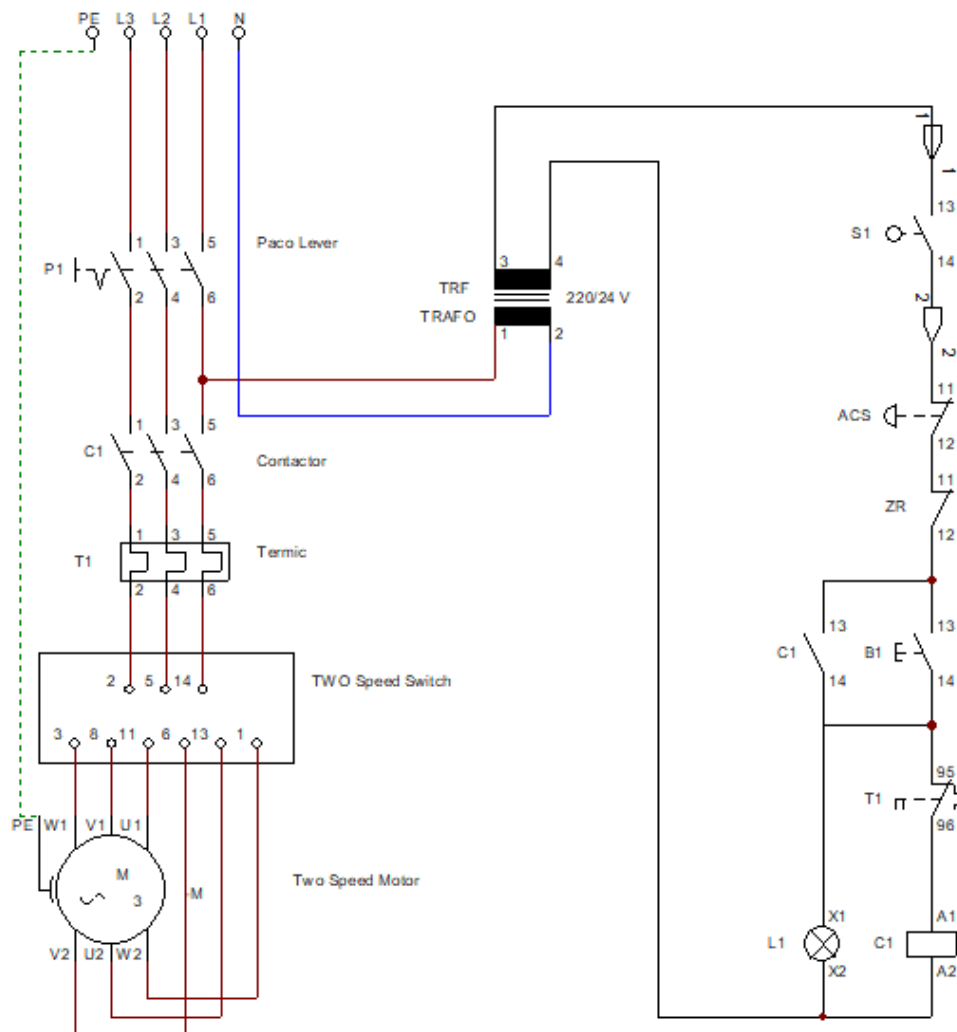
14.1 ELECTRICAL SCHEME PET 20-40-50-70-125



C1	Contactor
T1	Termic
M1	Motor
TRF	Transformer
S1	Safety Guard Switch

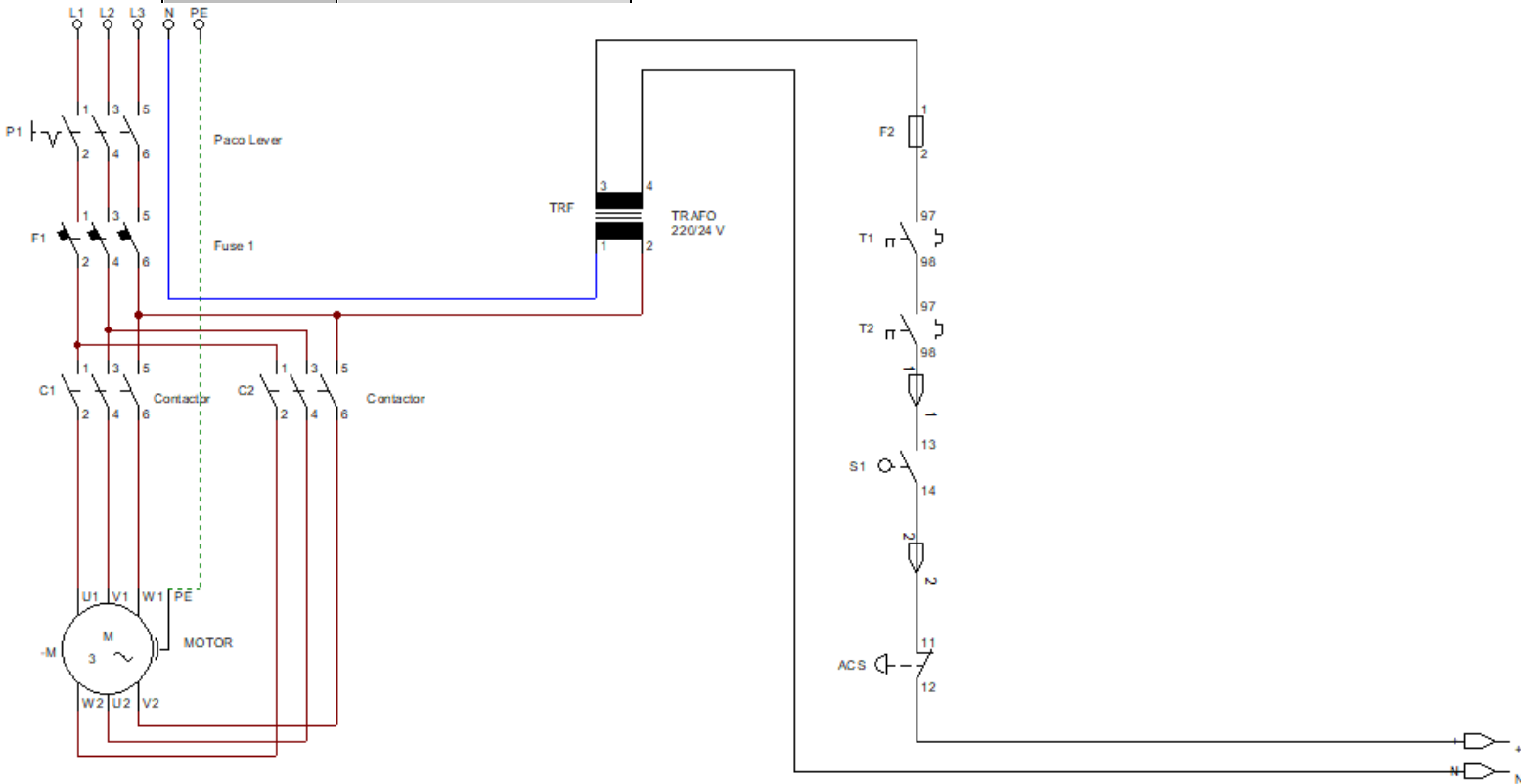
ACS	Emergency stop
B1	Start Button
L1	Lamb
ZR	Mechanic Timer

14.2 ELECTRICAL SCHEME PET 20-32 / 40-32 / 50-32 / 70-32 / 125-32



C1	Contactor
T1	Termic

14.3 ELECTRICAL SCHEME PET 125-200-

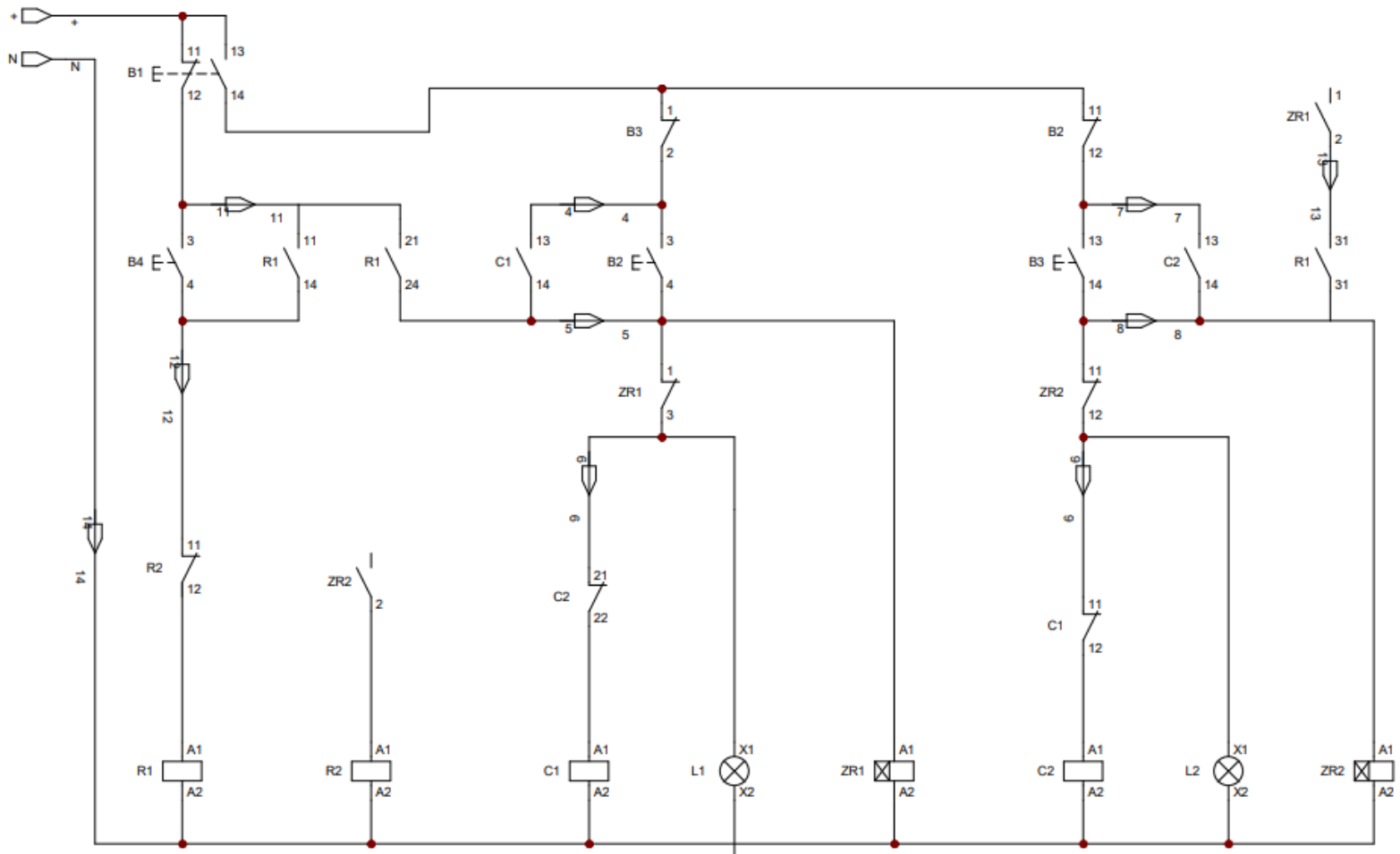


300

KM1A	Contactor
KM1B	Contactor
P1	Paco Lever
M	Motor
C1	Contactor
C2	Contactor
F1	Fuse
F2	Fuse
T1	Termic
T2	Termic
S1	Safety Guard Switch

ACS	Emergency Stop
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14.4 ELECTRICAL SCHEME PET 125-32 200-32 300-32



C1	1 st Speed Contactor
R1	Auto Start Relay
R2	Finish Relay
C2	2 nd Speed Contactor
L1	1 st Speed Lamb
L2	2 nd Speed Lamb

15 Spare Part list

B1	Auto-Manuel Switch
B2	1 st Speed Start Button
B3	2 nd Speed Start Button
B4	Auto Start Button
ZR1	1 st Speed Timer
ZR2	2 nd Speed Timer

