

The Moline Starwheel Chunker



Designed to deliver uniform dough chunks to a dough former for consistent and controlled operation.

- *Electronically synchronized to the dough former for uniform and consistent dough delivery.*
- *Increases dough sheet uniformity and product weight control.*
- *Simple design provides efficient sanitation.*



**Star Wheel Paddles
Inside Hopper**



**Chunker and
Dough Former**

The Moline starwheel chunker is designed to deliver uniformly measured dough pieces, or chunks, to a dough former or extruder installed below the chunker hopper.

From a mixer, dough is delivered to the chunker hopper where chunks are formed by "starwheel" paddles rotating 120° per cycle. The chunks are released to the dough former below at the desired interval. Electronic dough sensors, mounted on the sides of the chunker frame, detect dough level in the dough former hopper and signal when the next

dough chunk should be released from the chunker. The starwheels are driven by a drive motor and gear reducer.

The starwheel chunker is electronically synchronized with the Moline dough former to automatically maintain a constant level of dough in the hopper. This provides a consistent dough sheet to the sheeting line and greatly improves product uniformity and weight control.



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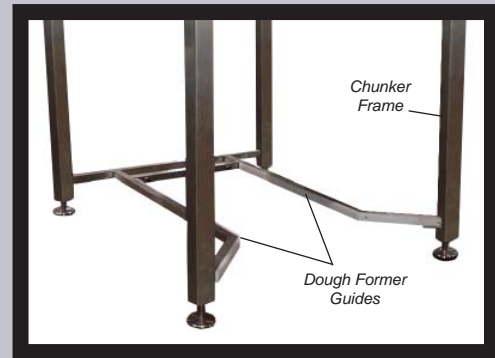
Features

- **Construction:**
Heavy-gauge stainless steel with precision-machined components. Chunker hopper interior can be specially coated for optimum dough release.
- **Control Functions:**
Activation and speeds are easily accessed through the production system's operator interface. Electronic dough sensors mounted on the chunker frame (see photo at right) detect dough levels in the extruder hopper and signal dough release.
- **Drive System:**
Standard: direct drive with motor, gear reducer and drive gears.
- **Electrical System:**
Standard Electrical Requirements: 480 Volt / 60 Hertz / 3 Phase (other options are available).

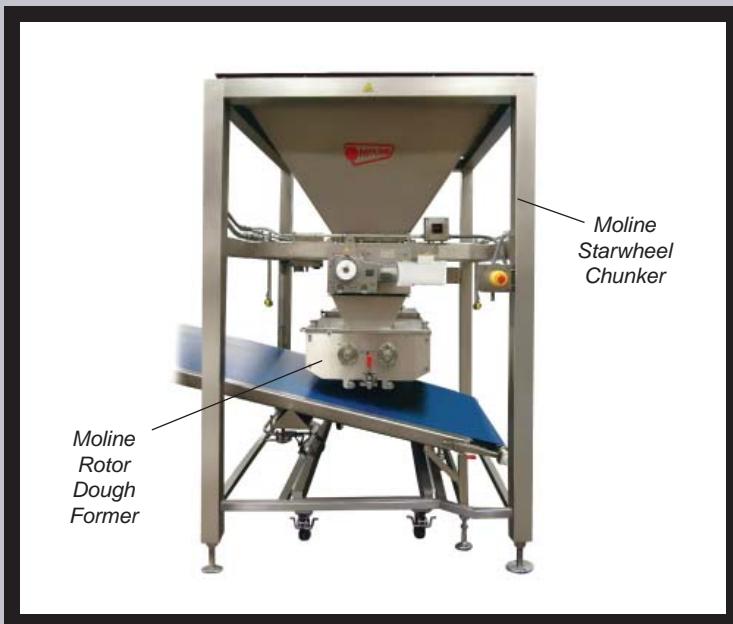
In-position switch between starwheel chunker frame and dough former frame ensure correct positioning for optimum operation.



Dough Sensors on Chunker Frame



Optional Dough Former Guides on Chunker Frame



Starwheel Chunker with Low Stress Rotor Dough Former

Using a Dough Former

The chunker is typically used with a Moline low stress dough former. The two units provide synchronized delivery of portioned dough chunks to maintain a constant level in the dough former hopper. This system provides a continuous and consistent dough sheet which greatly improves weight control of the final product.

The portable dough former is easily moved into position beneath the chunker. Optional guide brackets can be installed (see photo above) to make the process simple even in confined or low-visibility areas.

The chunker and dough former are electronically interlocked to ensure correct positioning for optimum operation.