



## **Model PM18**

### **Owner's Manual**

Revised October 2019



**Patty-O-Matic Inc.**

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**MADE IN USA**



**NSF/ANSI 8  
E475191**

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Thank you and congratulations on the purchase of your new Model PM18 Patty Molding Machine from Patty-O-Matic, Inc! The Model PM18 will form, interleave paper between, and stack patties. This machine is designed for easy operation and cleaning. Please become familiar with this manual and your machine will give you many years of service.

The Model PM18 is shipped to you in at least three cartons which contain the patty machine, feed tray, mold plate guard, spare parts box, receiving table, riser platform, and the manual. If you purchased your machine with any other accessories, such as a mobile table or patty paper, these items may be in a separate carton.

Your machine is equipped with two interlocks. One is located on the front of the machine and one is located on the top of the machine. The Mold Plate Guard must be installed on the machine to engage the interlock on the front of the machine and the Feed Tray including the guard must be installed on top of the Hopper to engage the interlock on top of the machine.

### **Installing Machine onto Riser Platform**

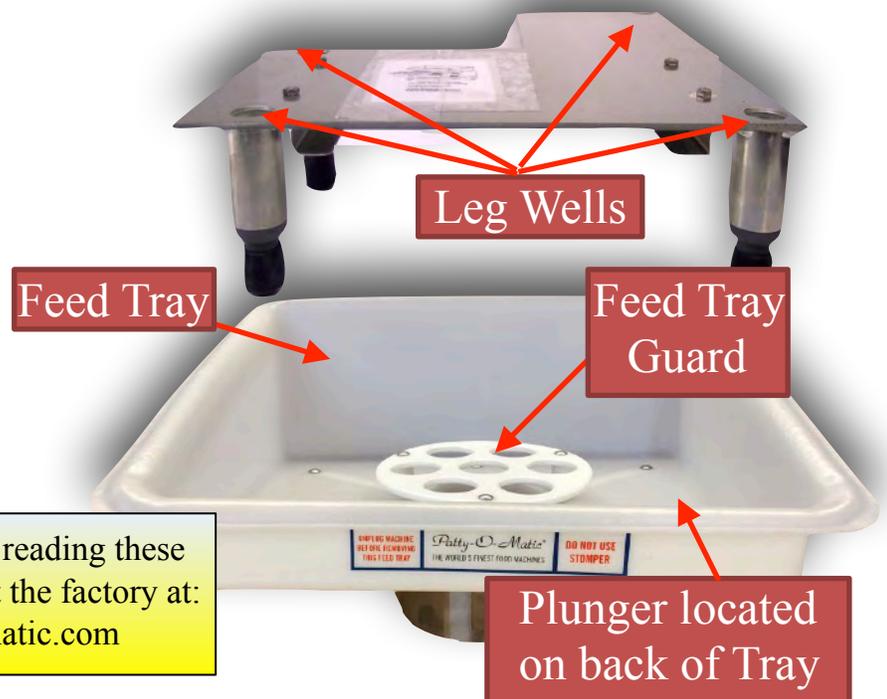
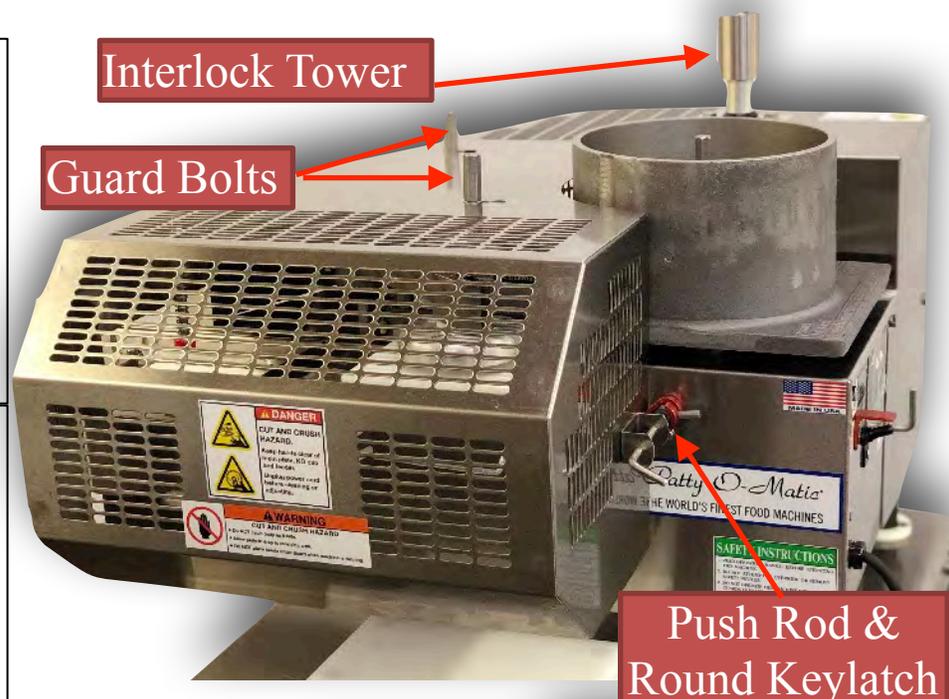
Place machine on the riser platform making sure the 4 legs of the machine go into the 4 leg wells on the Riser Platform. The Picture shown shows the front view of the Riser Platform.

### **Installing the Mold Plate Guard**

Loosen Guard Bolts on the Hopper and the rear post. Place Mold Plate Guard under the washers located under the bolt heads. Tighten bolts using the provided Speed Driver. To activate the interlock, slide push rod into the plunger, inside the keylatch, and turn rod to the right. This will lock the push rod in place and activate the interlock.

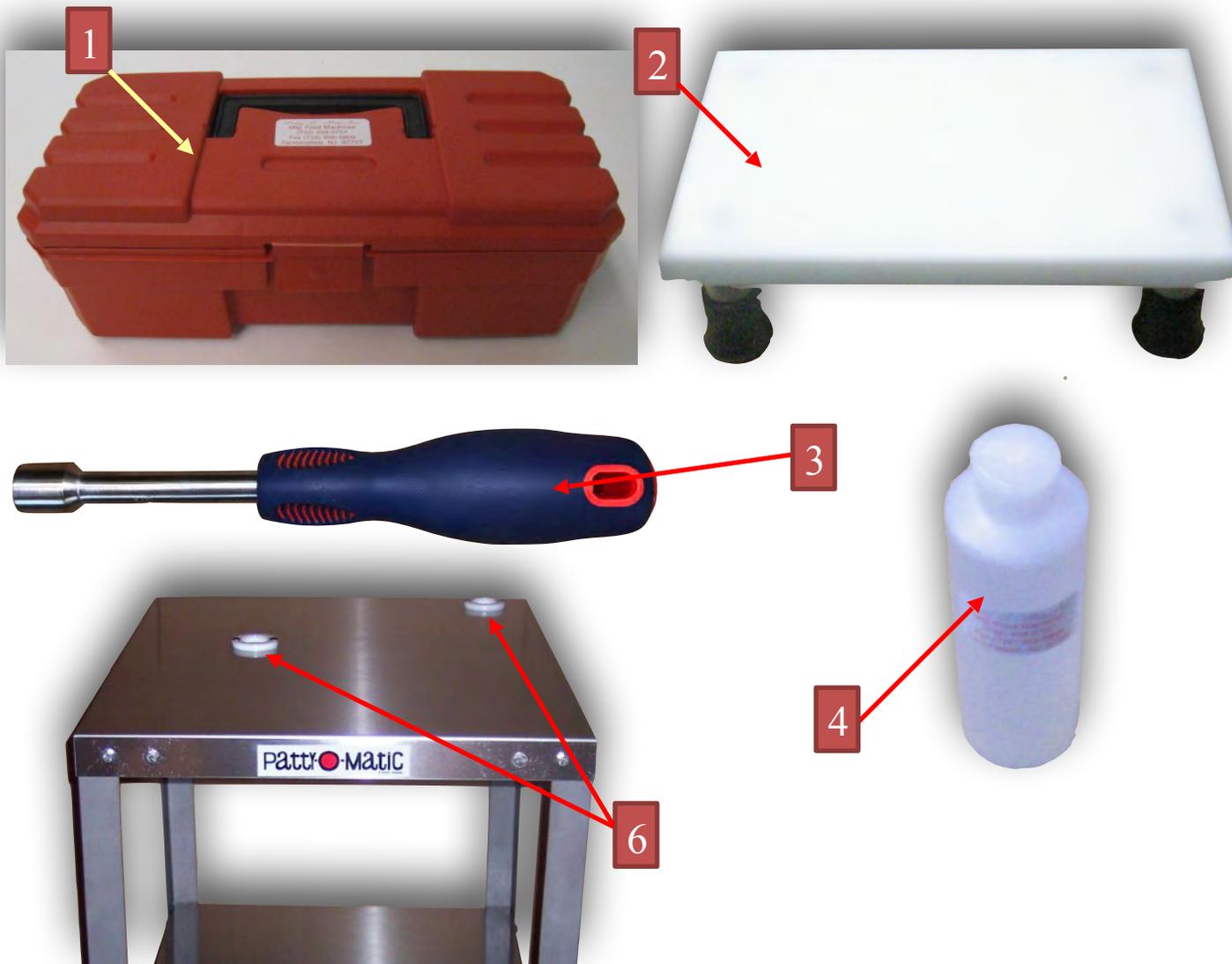
### **Installing the Feed Tray**

Place stainless steel tube of Feed Tray over the Hopper. Make sure the Switch Plunger on the bottom of Feed Tray depresses the Tower Stem inside the Tower Sleeve.



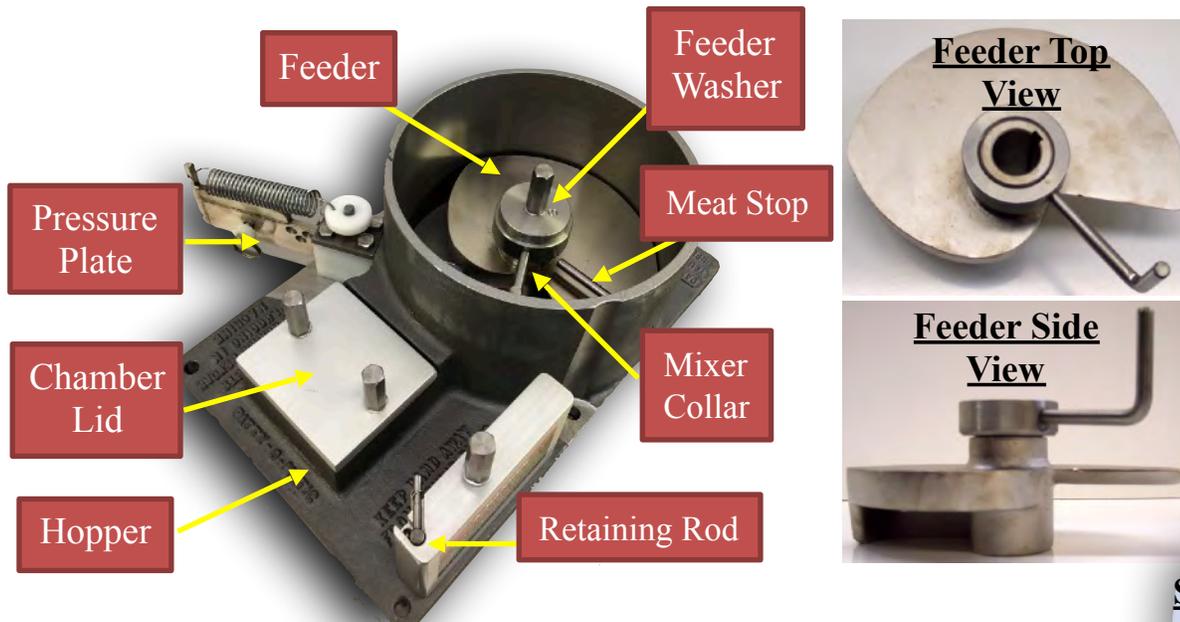
If you have any questions or concerns after reading these instructions, please do not hesitate to contact the factory at:  
732-938-2757 or [info@pattyomatic.com](mailto:info@pattyomatic.com)

## Accessories Equipped with the Model PM18



<u>Item#</u>	<u>Description</u>	<u>Part #</u>
1	Spare Parts Box	655
↙	Holds Spare Parts, Patty Paper Sample, Machine Lubricant, Speed Driver, and Locator Rings c/w instructions	
2	Receiving Table	609-6
3	Speed Driver	544
4	8 Ounce Bottle of Machine Lubricant and Cleaner	600
5	Gallon of Machine Lubricant(Separate Order Only)	600A
6	Machine Locator Rings	610-2

**Please become familiar with some of the parts of your machine prior to operation**



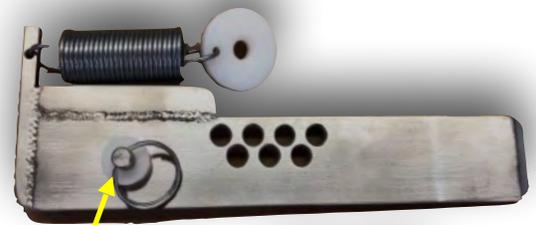
**Mold Plate Assembly Side View**



**Mold Plate Assembly Underside View**

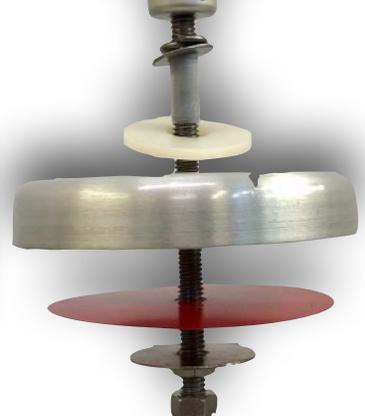


**Ring Pin Pressure Plate**



**Ring Pin**

**Knock Out Cup Assembly**  
Refer to Page 12



**Feed Tray Guard**

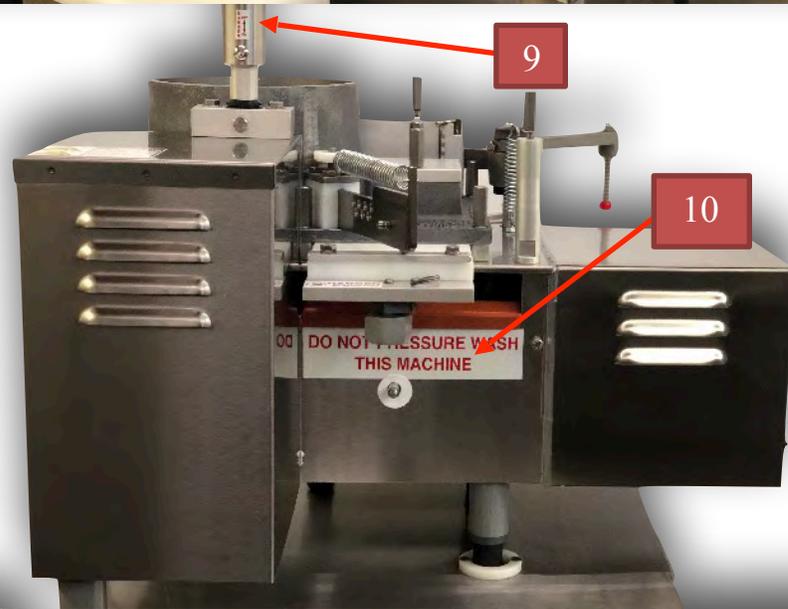
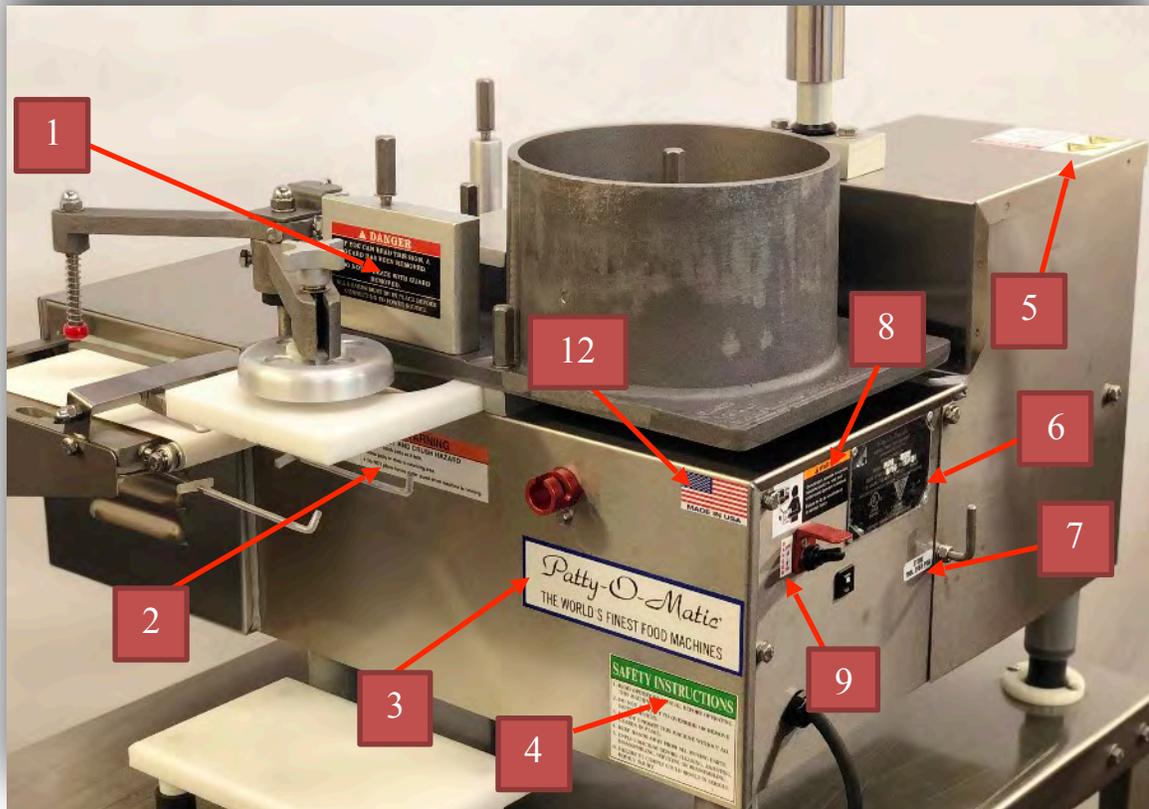


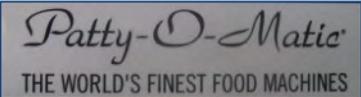
**Mold Plate Guard**



Feed Tray Guard and Mold Plate Guard are installed for your safety. Do not tamper with them in any way!

## Proper Label Location for a Model 330A



<u>Item #</u>	<u>Description</u>	<u>Part#</u>
1.	Danger Label 3	 514-09a
2.	Warning Orange	 514-02
3.	Patty-O-Matic	 514-08
4.	Safety instructions	 514-06
5.	Danger Label 2	 514-00
6.	Serial Tag For UL Machines	 514-15UL
7.	Store Tool	 514-14
8.	Warning Manual	 514-01
9.	Danger on/off	 514-05
10.	Do Not Pressure Wash	 514-04
11.	Unplug Machine	 514-07
12.	Made in USA	 514-19

### Proper Procedure for Operating a PM18

When the Model PM18 is fully assembled with all guards secured in their proper place, put product to be molded in the Feed Tray. Push the product through the holes in the Feed Tray Guard, or under the Feed Tray guard and into the Hopper. **DO NOT PUT HANDS OR FINGERS, OR FOREIGN OBJECTS, SUCH AS STOMPERS OR PLUNGERS INTO THE HOPPER. THERE ARE NO STOMPERS OR PLUNGERS NECESSARY WHEN USING THIS UNIT, THEREFORE NONE ARE SUPPLIED.** After you allow product to drop into the Hopper turn the machine on by moving the On/Off switch down towards the on position. The machine may need to cycle a few times to prime the machine with product. As patties are being formed continue to push product through the holes and under the Feed Tray Guard. Patty paper may be added to the machine as needed. The machine can hold up to 1 inch of paper at a time, but no more.

As the Mold Plate moves back and forth to form patties, a thin coating of product may accumulate over its surface. This coating may also accumulate on the edges of the Knock Out Cup or on the front of the Hopper and Spacer Plate. This accumulation does occur on all molding machines. It is nothing to be concerned with. There are certain machine settings that may lessen this accumulation.

### Setting the Ring Pin Pressure Plate for your Patty Size

The Purpose of the Pressure Plate is to entrap the amount of product necessary to form your size patty. This part is also used in controlling the firmness of your patty. With the Pressure Plate set correctly you will in turn have:

- less leakage, oozing, and coating of parts
- less over working of your product
- and less strain on your machine.

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If your patty weight is 8 ounces, keep the ring pin in the storage hole as described in the picture. This will allow the Pressure Plate to move all the way into the Hopper and stop on the welded stop, which traps the most product and is the maximum volume setting.

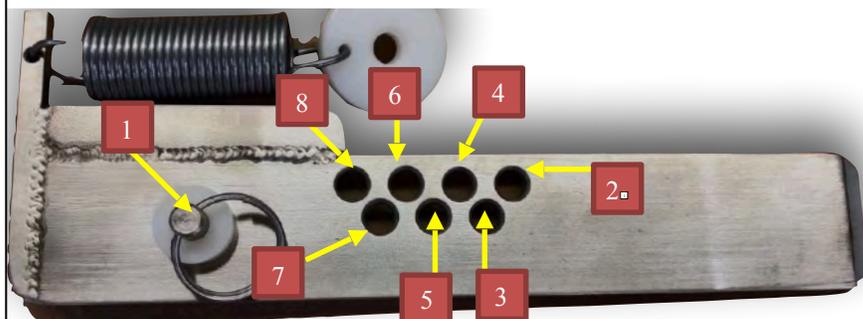
If your mold cavity is for 4 ounces, remove the ring pin from the storage hole and place it in the 4 ounce hole.

If your mold cavity is for 6 ounces, place the ring pin in the 6 ounce hole.

If you would like to have a tightly packed patty, move the ring pin to a higher than recommended setting for that particular weight.

THESE ARE ONLY RECOMMENDED SETTINGS. A VARIETY OF CIRCUMSTANCES MAY CALL FOR YOU TO INSERT THE RING PIN IN A DIFFERENT LOCATION.

- |   |
|---|
| <p>1 - Ring Pin in storage hole<br/> 2 - 2 ounce hole<br/> 3 - 3 ounce hole<br/> 4 - 4 ounce hole<br/> 5 - 5 ounce hole<br/> 6 - 6 ounce hole<br/> 7 - 7 ounce hole</p> |
|---|



## Changing Your Machine's Mold Plate

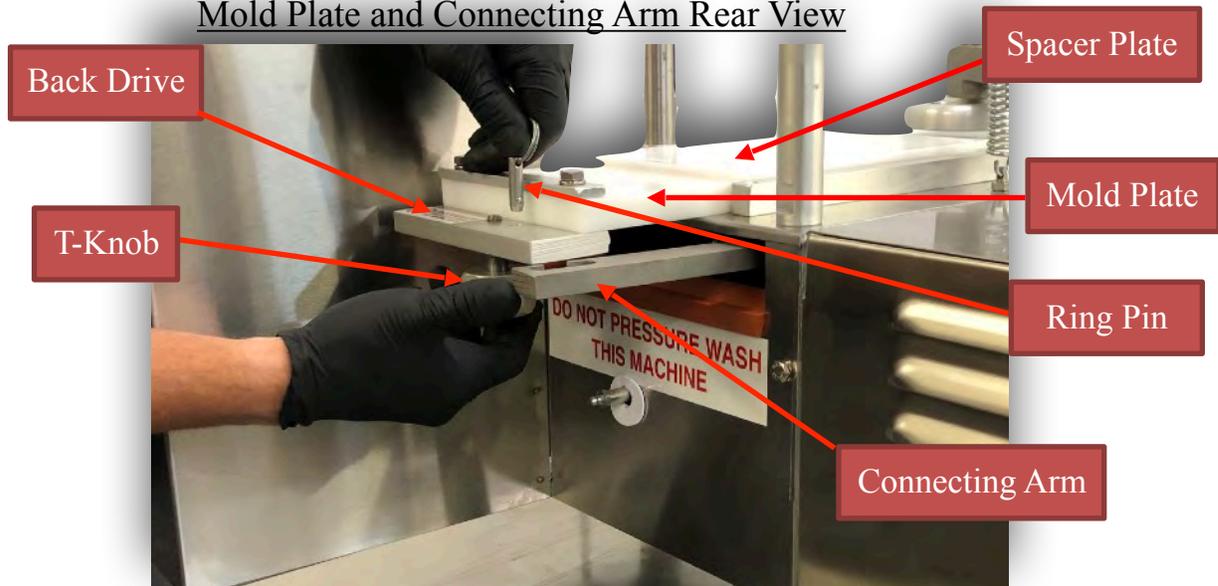
**Always disconnect the machine from its power source  
before attempting to change or clean any of the machines component parts.**

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If the Mold plate is all the way into the machine, remove the T-Knob from the Back Drive by lifting the ring pin and unthreading the knob. Pull the Mold Plate out from the back of the machine. If the Mold Plate is slightly out of the machine and you prefer to remove it without removing the T-Knob, simply pull the ring pin out and unhook the Connecting Arm from the T-Knob. Then slide the Mold Plate from the back of the machine.

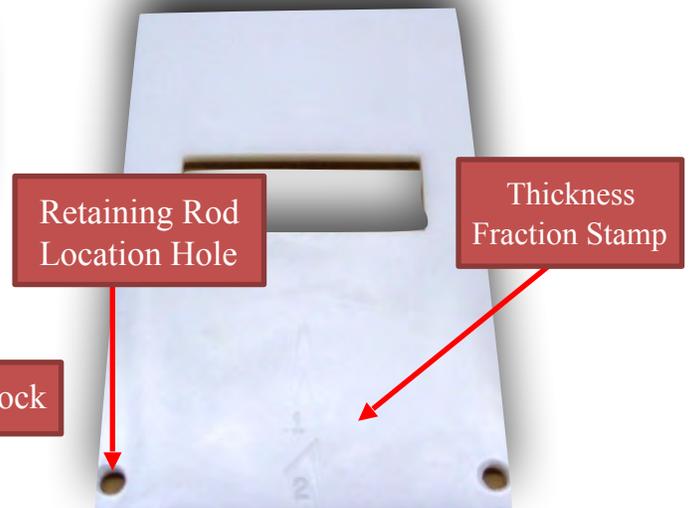
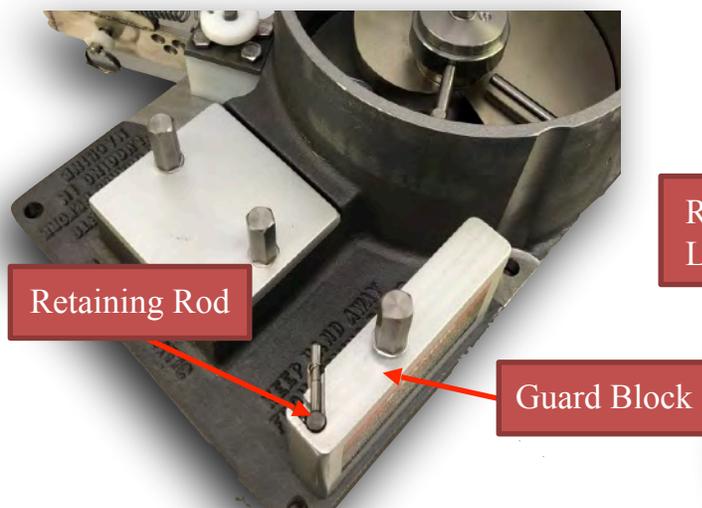
When changing the Mold Plate always use the corresponding Spacer Plate and Knock Out Cup. The thickness fraction stamped on the Spacer Plate should match the fraction stamped on the front right corner of the Mold Plate. For example: if your Mold Plate is stamped "4F 1/2" then the Spacer Plate should be stamped "1/2". The Spacer Plate is held in place by the Retaining Rod. The Retaining Rod is secured by a spring into the Guard Block. Lift the Retaining Rod up and to the side so it does not protrude into the Spacer Plate. There is no need to remove the Retaining Rod from the Guard Block. After putting the new Mold Plate and corresponding Spacer Plate into the machine, lift the Retaining Rod and let it go into the hole located on the front of the Spacer Plate. Make Sure that the Spacer Plate is in the locked position. Failure to do so may cause the Spacer Plate to move with the Mold Plate, and could damage the machine.

### Mold Plate and Connecting Arm Rear View



Hopper Front View

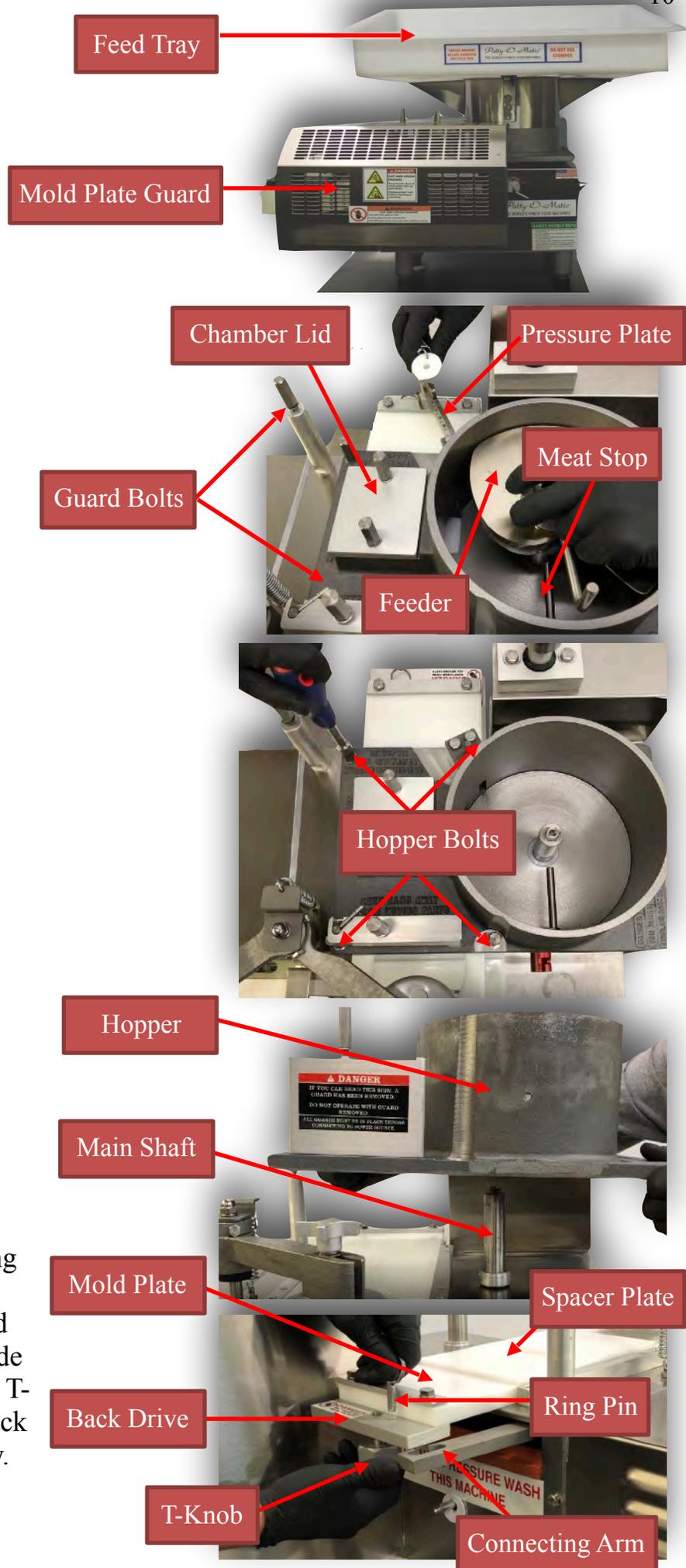
Spacer Plate Top View



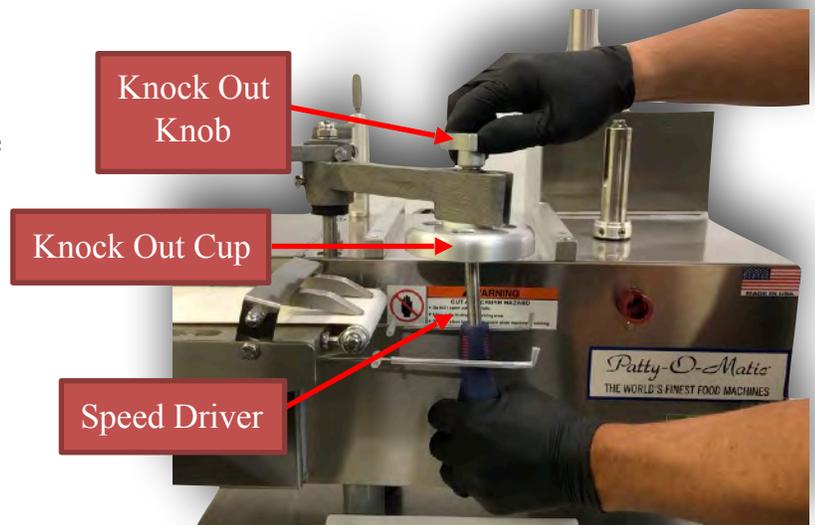
## Proper Disassembly for Cleaning your Model PM18

**Always Unplug Machine from its  
Electrical Source Before Cleaning**

- Remove Feed Tray by lifting it off the Hopper, and Mold Plate Guard by loosening the Guard Bolts, and unlatching the push rod.
- Remove the Pressure Plate by detaching the spring and sliding the plate from inside the Hopper. Slide Retractable Meat Stop out of the Hopper until it stops. Remove Feeder by loosening the bolt with the tool provided. Twist the Feeder and lift it off the Main Shaft.
- Remove the four Hopper Bolts using the provided speed driver. The two bolts on the Chamber Lid may be removed for additional cleaning.
- Remove the Hopper by lifting it off the Main Shaft of the machine..
- After the Hopper is removed from the machine, remove Spacer Plate from the top of the Mold Plate. \*Note--Occasionally the Spacer Plate sticks to the bottom of the Hopper. 3/4" Molds do not use a spacer plate. Retaining Rod should be left in storage position when using a 3/4" mold.
- Remove the Mold Plate by pulling the ring pin and disengaging the Connecting Arm from the T-Knob. This will allow the Mold Plate to be removed from between the Guide Rails and removed from the machine. The T-Knob may also be un-screwed from the Back Drive as an alternate means of disassembly.



- Remove the Knock Out Cup by loosening the Knock Out Knob while holding the other end of the bolt with the Speed Driver provided with the machine.
- All of the parts that were removed from the machine can now be washed and sanitized thoroughly. USDA recommends the sanitizing solution should be 50 parts per million but no more than 200 parts per million. The machine itself should be cleaned and sanitized by hand. After all the parts are cleaned, sanitized and dry they should be coated in mineral oil as an extra protectant.



**DO NOT HOSE DOWN OR PRESSURE WASH THIS MACHINE!**

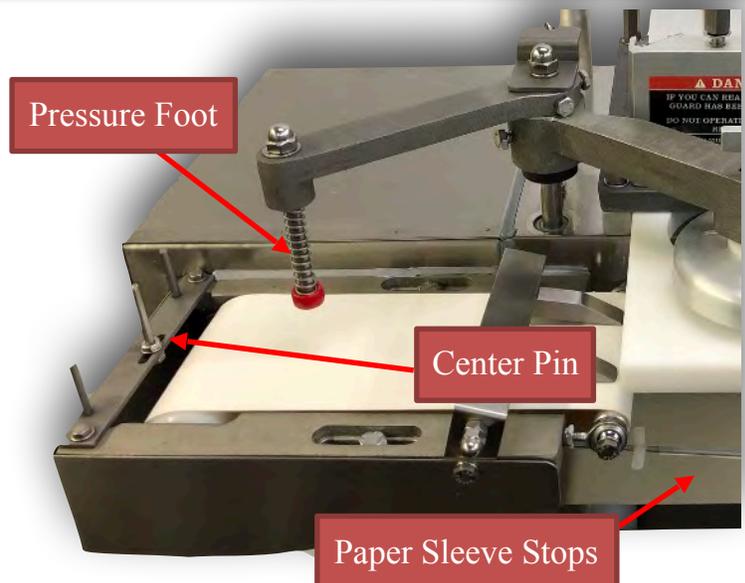
\*To Re-Assemble the Machine reverse the above procedure. Hopper bolts should only be hand tightened with the speed driver provided.

\*The Knock Out Cup Should be installed on the Machine before the Feed Tray and Mold Plate Guard, but after all other parts are in place. The Mold Plate should be all the way forward and the Knock Out Arm should be in the down position for the cup to align with the Mold Plate properly.

### Installing Patty Paper on Interleaver

-Place a stack of paper no thicker than 1 inch under the pressure foot. Slide the hole in the paper over the center pin.

\*Placing more than 1 inch of paper may cause improper paper feeding.



Paper Sleeves Stops should be adjusted for different size patty paper

Shown without guard for better visual

**Patty-O-Matic Inc. offers the highest quality patty paper, machine lubricant, and machine grease. Please contact the factory for information on these products.**

732-938-5244

[www.pattyomatic.com](http://www.pattyomatic.com)

[info@pattyomatic.com](mailto:info@pattyomatic.com)

## Points of Daily Lubrication For Your Model PM18:

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**Always Unplug Machine and use Food Approved Oil and Grease!**

The Following Parts should be lubricated daily

- Pressure Foot should be lifted up and oiled. Hold the Acorn Nut and lift up. Place a few drops of oil on the Pressure Foot shaft.

- Knock Out Shaft should be oiled when the Knock Out Arm is in the up position. The picture shown displays the Arm in the up position.

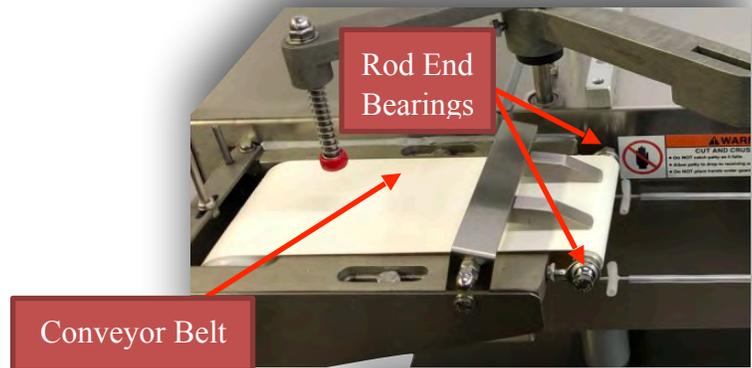
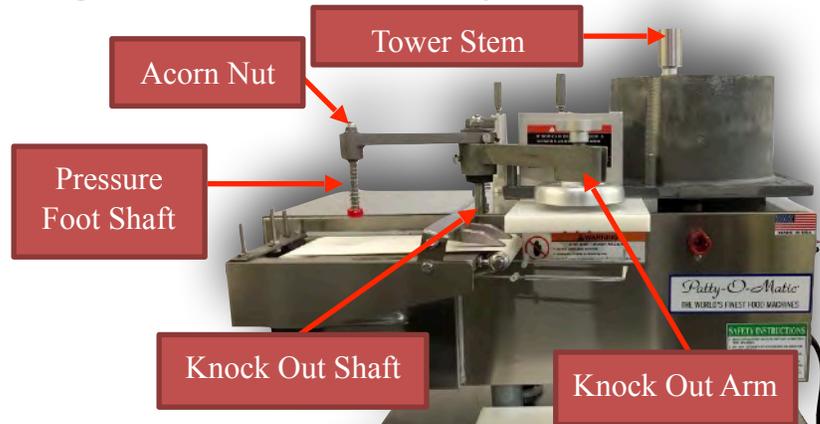
- Tower Stem should be oiled when the Feed Tray is removed as shown.

- Rod End Bearings should be oiled with a few drops of oil. There are two Rod End Bearings to be oiled. Do not allow oil to drip onto the Conveyor Belt.

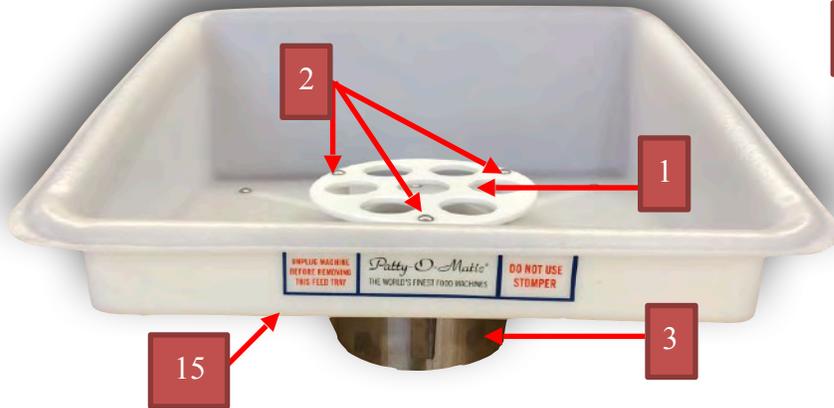
- Main Shaft should be oiled when the machine is disassembled as shown in this picture. Be sure to oil under the collar by the machine cabinet.

- The inside of the machine can be greased through the Rear Inspection Opening. By spraying lithium grease here, you can lubricate all internal moving components.

- The Grease Fitting in the back of the machine should be greased once every two weeks. 3 to 4 shots of grease are recommended.



## Poly Coved Feed Tray

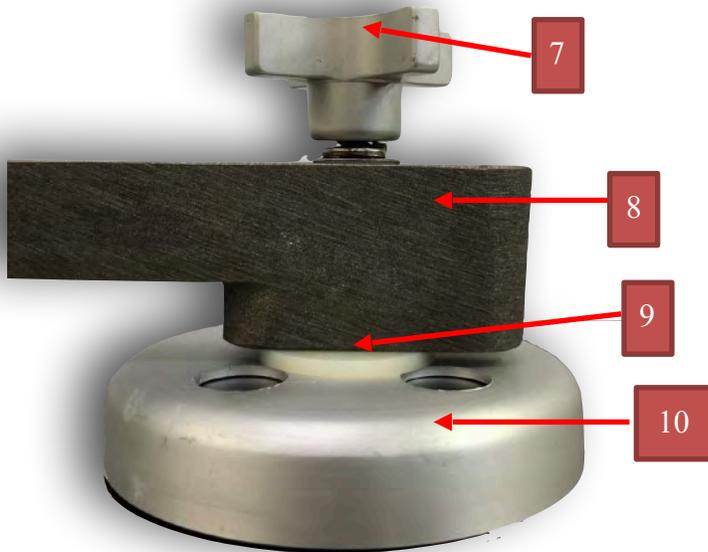


## Mold Plate Guard

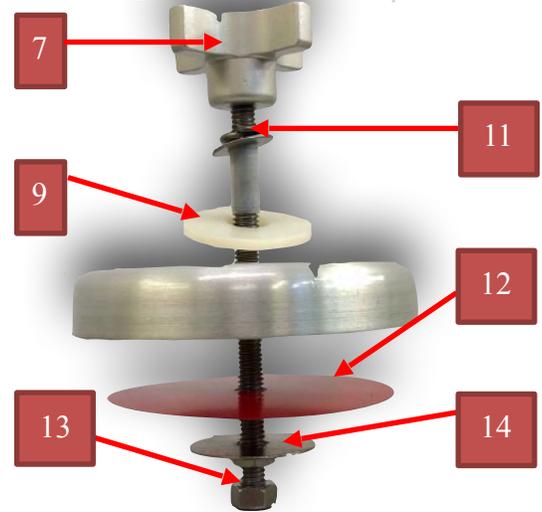
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## Knock Out Cup Assembly



## Knock Out Cup Assembly Exploded View

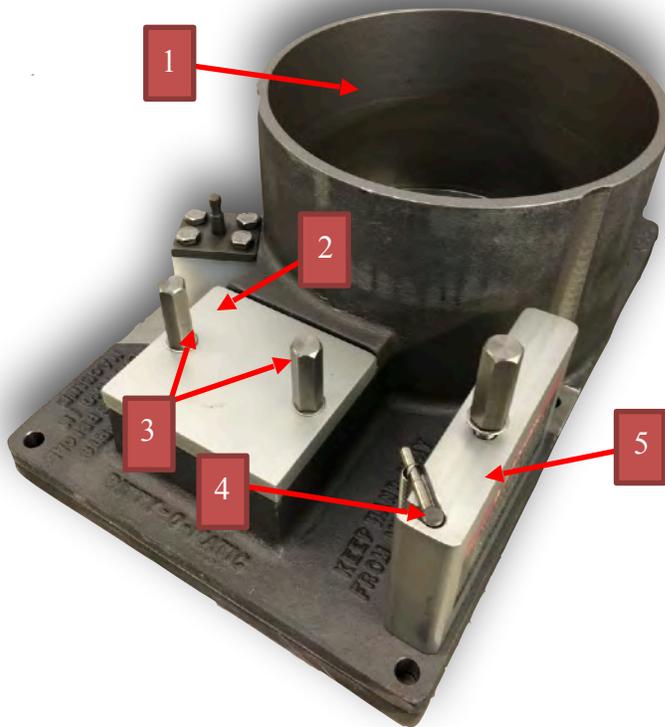


-Knock Out Cup Assembly is Part #PM18-571

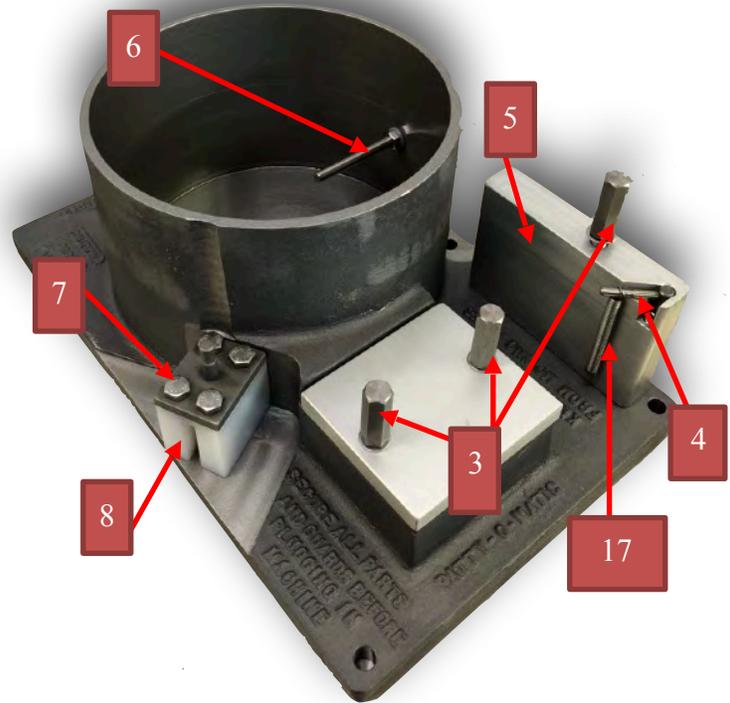
-Knock Out Cup Hardware **Only** is Part #PM18-571-H1

Item#	Description	Part #
1	Feed Tray Guard Assembly	543
2	Feed Tray Guard Hardware	541-B
3	Stainless Steel Flange Support	554
4	Mold Plate Guard Assembly	PM18-550SC
5	Push Rod Collar	553-1B
6	Push Rod	553-5
5&6	Push Rod and Collar Assembly	553
7	Knock Out Knob	PM18-571-7
8	Knock Out Arm (partial view)	502B
9	Knock Out Cup Plastic Washer	571-6
10	Round Knock Out Cup(Specify Size)	571-1
11	Knock Out Cup Flat Washer and Lock Washer	571-8
12	Knock Out Air Valve (shown in red for visual affect)	571-4
13	Knock Out Cup Bolt	571-9
14	Knock Out Cup Fender Washer	571-10
15	Feed Tray Tower Plunger and Bolt(Located on the bottom of the feed tray)	620-17

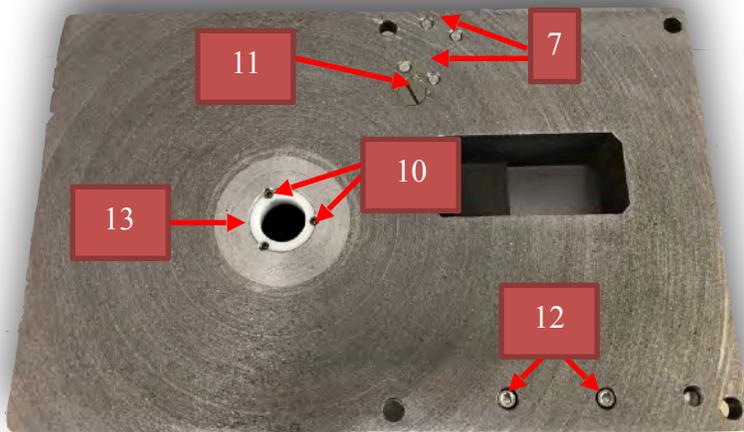
## Hopper Front View



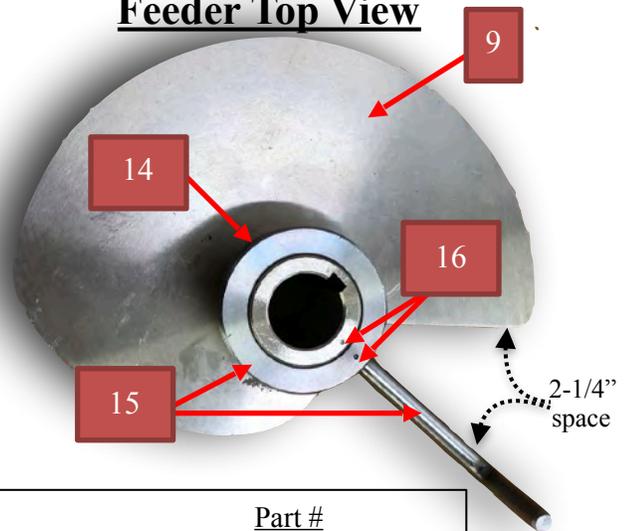
## Hopper Rear View 14



## Hopper Bottom View

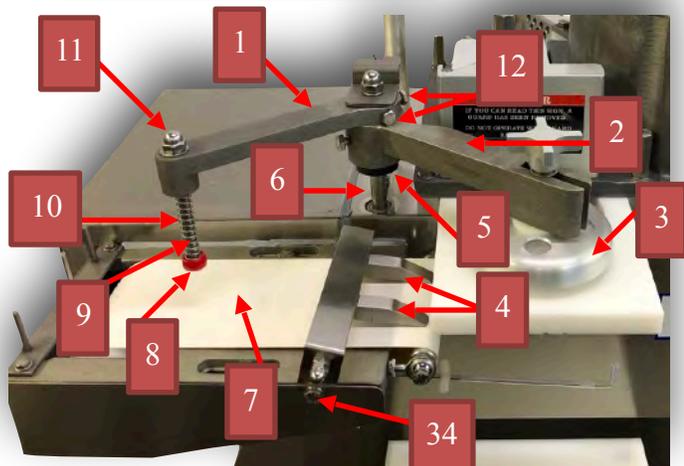


## Feeder Top View

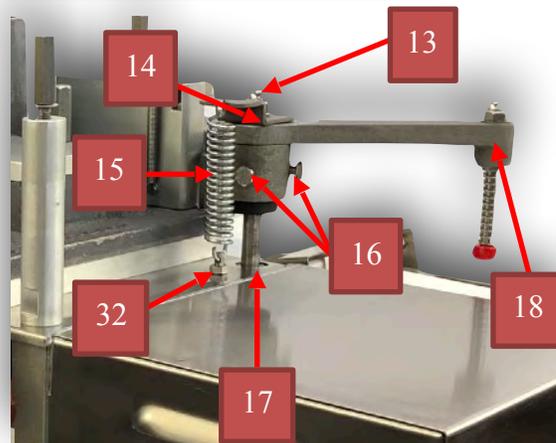


<u>Item#</u>	<u>Description</u>	<u>Part #</u>
1	Hopper Casting	PM18-545
2	Chamber Lid	545-A
3	Hex Hold Down Bolt (also used as Hopper hold down)	556B
4	Retaining Rod	PM18-551-1C
5	Guard Block	PM18-551-C
6	Meat Stop c/w Washer	555
7	Pressure Plate Block Hardware	548-CR
8	Pressure Plate Block	547-YR
9	Feeder	557
10	Hopper Nylon Bushing Set Screw(3 Required)	604
11	Hopper Threaded Plug	607
12	Guard Block Mounting Screws	PM18-551-C1
13	Hopper Nylon Bushing c/w set screws	603
14	Mixer Collar Set Screw	559
15	Mixer Collar	558
16	Witness Marks (one on Feeder and Mixer Collar for location)	N/A
17	Retaining Rod Spring	551-1A

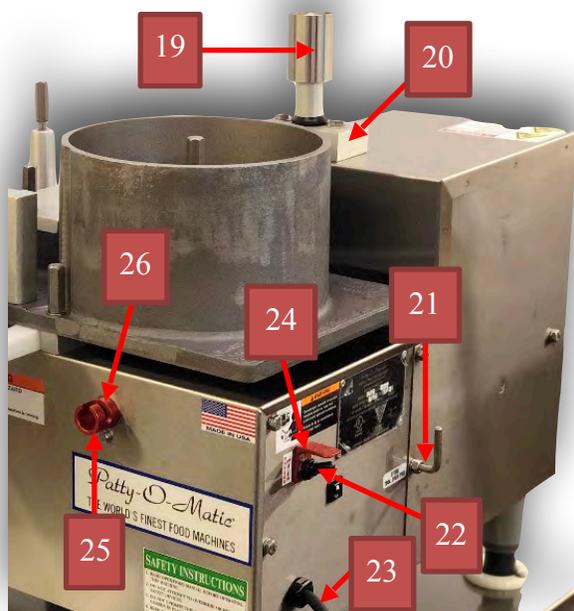
### Machine Front View



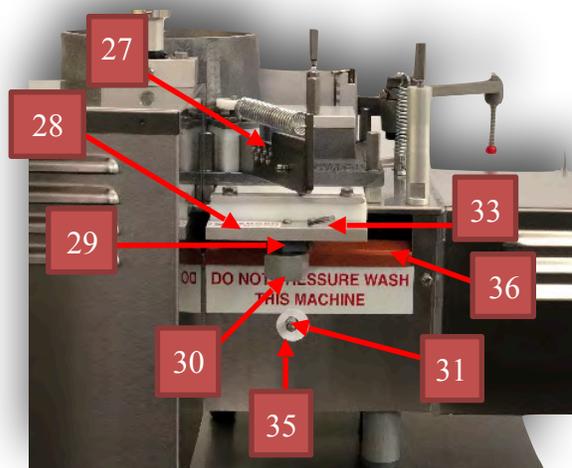
### Machine Left Side View



### Machine Right Side View



### Machine Rear View

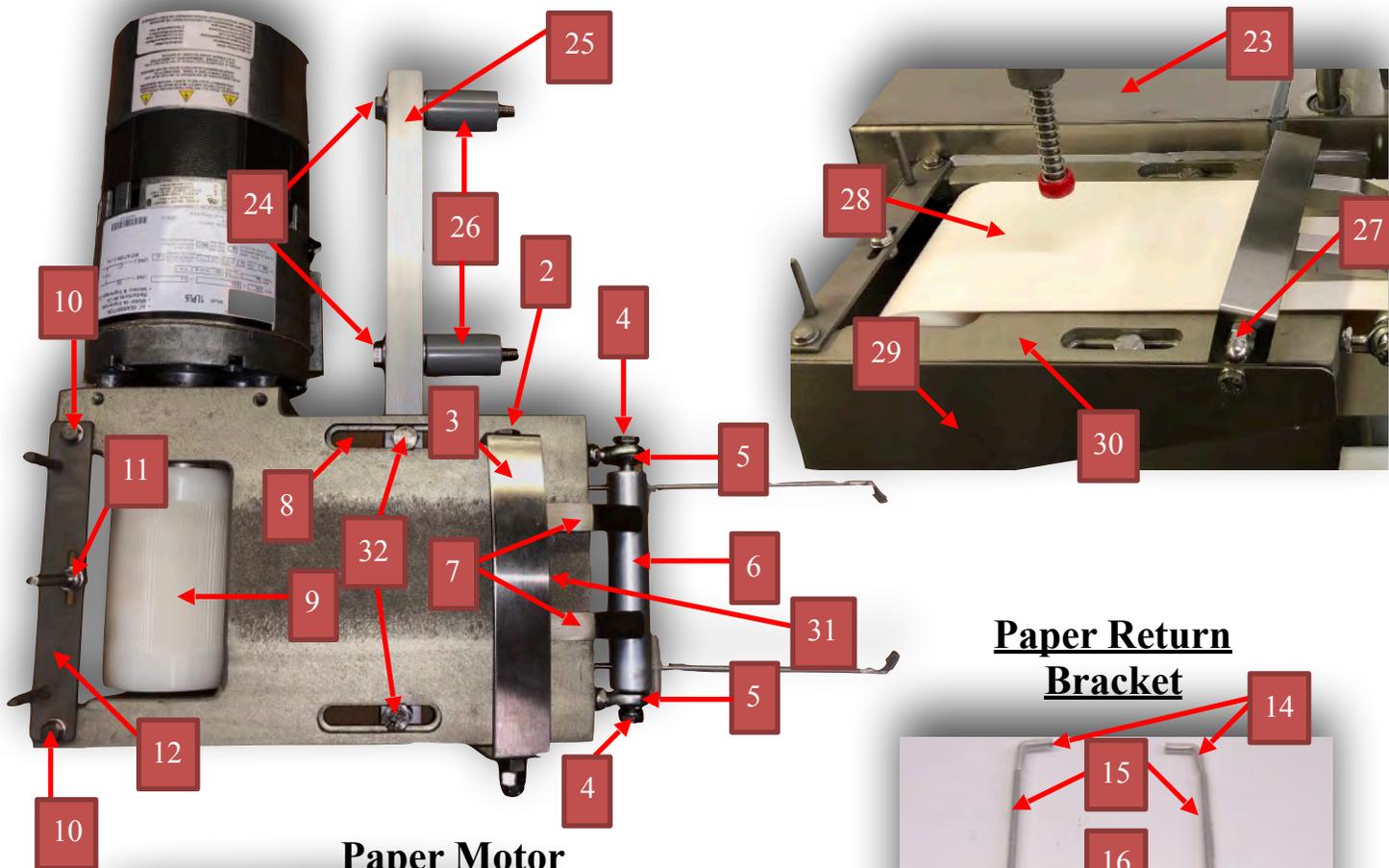


Item #	Description	Part #
1	Paper Interleaver Arm and Bolts	PM18-505
2	Knock Out Arm and Bolts	502B
3	Knock Out Cup	571-1
4	Paper Weight	532
5	Knock Out Bumper	PM18-504
6	Knock Out Shaft	PM18-449
7	Conveyor Belt	534
8	Pressure Bolt Tip	506D
9	Pressure Bolt	PM18-506
10	Pressure Foot Spring	508
11	Pressure Foot Hardware	PM18-506B
12	Paper Interleaver Arm Bolt(2)	PM18-505-1
13	Knock Out Shaft Acorn Nut	503
14	Knock Out Spring Tab	PM18-498C
15	Knock Out Spring	PM18-490
16	Knock Out Arm Bolt(2)	502-1
17	Knock Out Shaft Bushing (white bushing pressed into Machine Frame)	462
18	Paper Interleaver Arm Bushing (white bushing)	505-1B

Item#	Description	Part#
19	Feed Tray Tower Sleeve	620-16
20	Feed Tray Tower Block	620-6
21	Tool Holder	601
22	On/Off Switch	500
23	Power Cord	115-01
24	On/Off Switch Guard	501
25	Round Key Latch Assembly	PM18-553-R
26	Plunger Switch(Located inside machine)	608-1B
27	Ring Pin Pressure Plate	546-3
28	Mold Plate Back Drive	564
29	Connecting Arm	455
30	T-Knob	567
31	Grease Fitting	701
32	Knock Out Spring Threaded Holder	490E
33	Ring Pin	546C
34	Weight Shaft Support Hardware	530
35	Grease Fitting Gasket	PM18-701-G
36	Connecting Arm Wiper	PM18-455W

Many parts are also sold as assemblies. Please contact the factory for further information:  
Toll Free in the U.S.A. 877-938-5244  
Outside the U.S.A. 732-938-2757

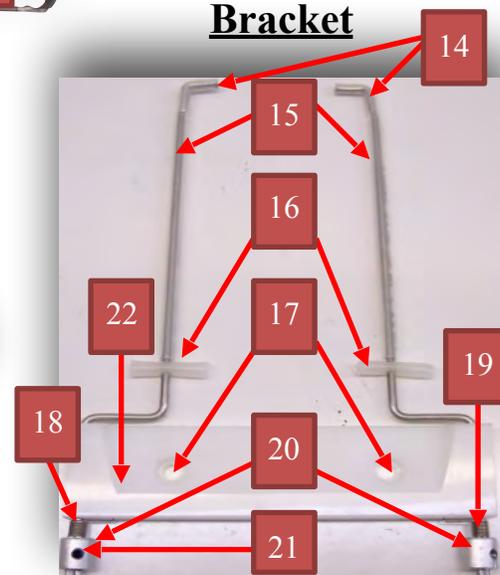
### Paper Interleaver Top View



### Paper Motor



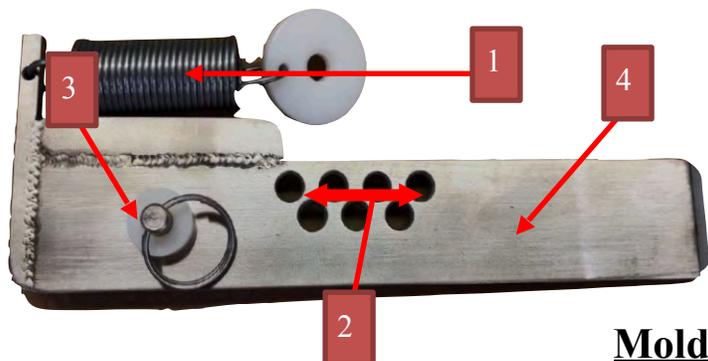
### Paper Return Bracket



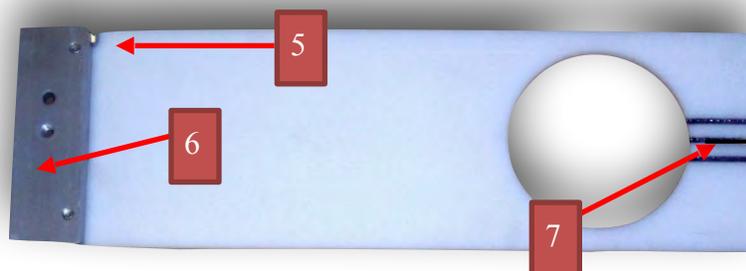
Item #	Description	Part #
1	Paper Interleaver Motor c/w Extension Shaft	516
2	Weight Shaft	527
3	Weight Shaft Support	529
4	Rod End Hardware	523
5	Rod End Bearing (2 required)	522
6	Paper Interleaver Front Pulley	521
7	Paper Weight (2 required)	532
8	Interleaver Adjustment Slots	N/A
9	Paper Interleaver Back Pulley	520
10	Pin Holder Bolt and Nuts (2 required)	526
11	Paper Pin, Nuts, and Washers	525
12	Paper Pin Assembly	524-A
13	Motor Extension Shaft and Screws	517
14	Paper Sleeve Stop	248A
15	Stainless Steel Paper Pivot Rod(2)	247
16	Paper Stop	248
17	2 Return Bracket Mounting Screws	249
18	Left Return Spring	246L
19	Right Return Spring	246R

Item#	Description	Part#
20	Spring Adjusting Collar w/ set screw	244
21	Set Screw (one in each collar)	245
22	Pivot Rod Support Bracket	243
23	Paper Motor Cover c/w Hardware	PM18-537
24	Interleaver Support Hardware	499
25	Interleaves Support Bar	PM18-497
26	Interleaver Support Bar Spacers	PM18-498
27	Weight Shaft Hardware	528
28	Conveyor Belt	534
29	Conveyor Belt Guard	PM18-536
30	Paper Interleaver Casting Frame	519
31	Weight Shaft Spacers (Not Shown)	531
32	Interleaver to Support Bar Hardware	PM18-539-1

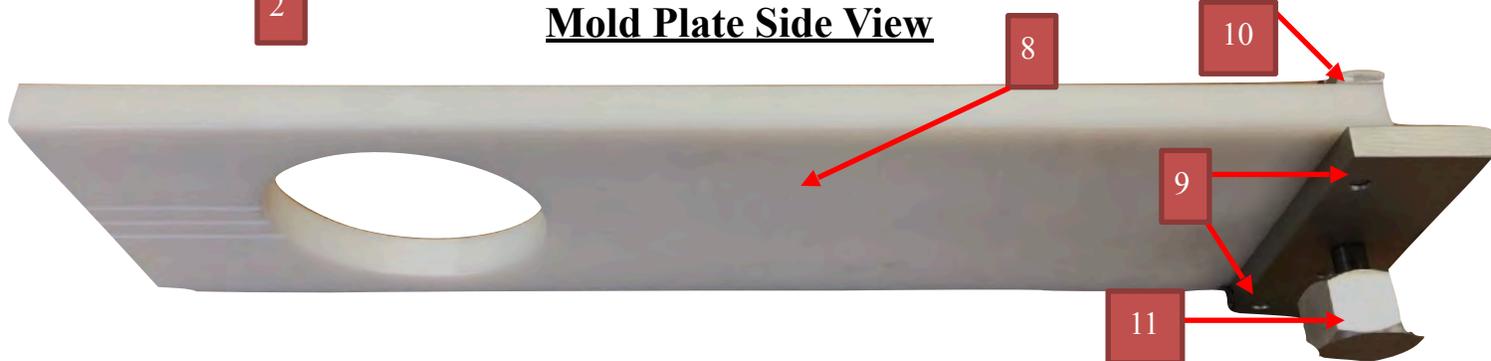
**Ring Pin Pressure Plate**



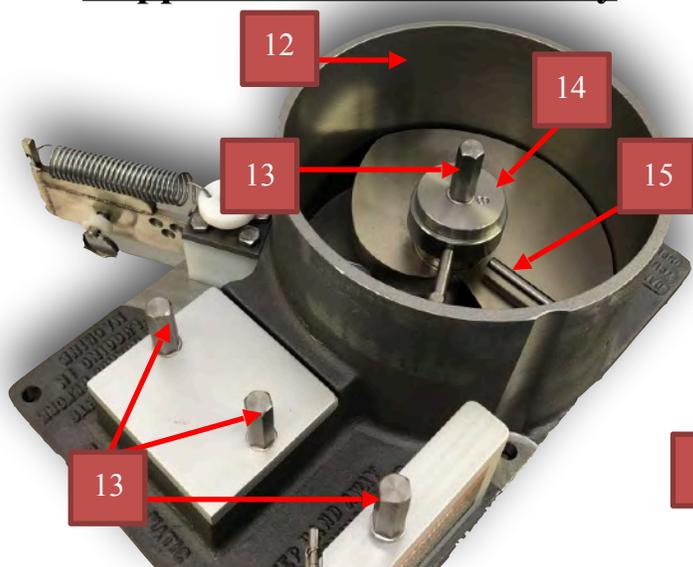
**Mold Plate Bottom View**



**Mold Plate Side View**

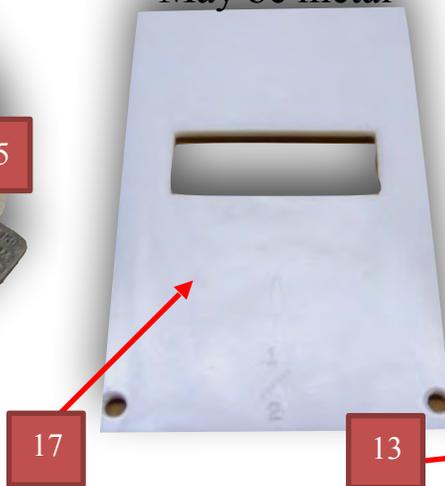


**Hopper and Feeder Assembly**

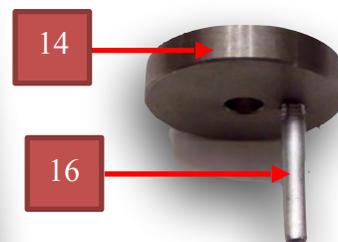


**Spacer Plate**

May be metal



**Feeder Washer & Shear Pin**



**Hold Down Bolt**



<u>Item #</u>	<u>Description</u>	<u>Part #</u>
1	Pressure Plate Spring and collar	549
2	Ring Pin Adjustment Holes	N/A
3	Ring Pin (shown in the storage hole)	546C
4	Ring Pin Pressure Plate	546-3
5	Back Drive Stop Bolt	565
6	Mold Plate Back Drive	564
7	Air Grooves (colored for visual)	N/A
8	Round Mold Plate	563-1
9	Set of Back Drive Hardware	568A
10	Back Drive Clamp	568

<u>Item #</u>	<u>Description</u>	<u>Part #</u>
11	T-Knob	567
12	Hopper Casting	PM18-545
13	Hold Down Bolt	556B
14	Feeder Washer	560
15	Meat Stop c/w washer	555
16	Shear Pin	562
17	Spacer Plate (Specify Size)	569

**Part # PM18-563 - Mold Plate Assembly**  
 -Includes Round Mold Plate,  
 Back Drive Assembly and  
 Knock Out Cup Assembly  
*Other Shapes Available*

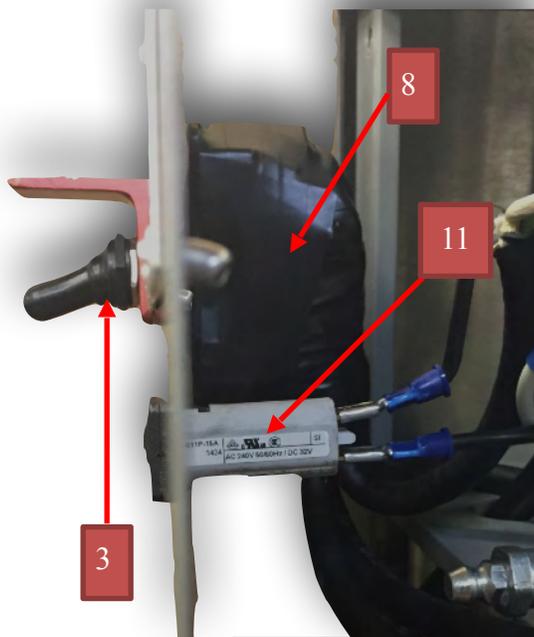
**Machine Switches Front View**



**Guard Switch Interior View**



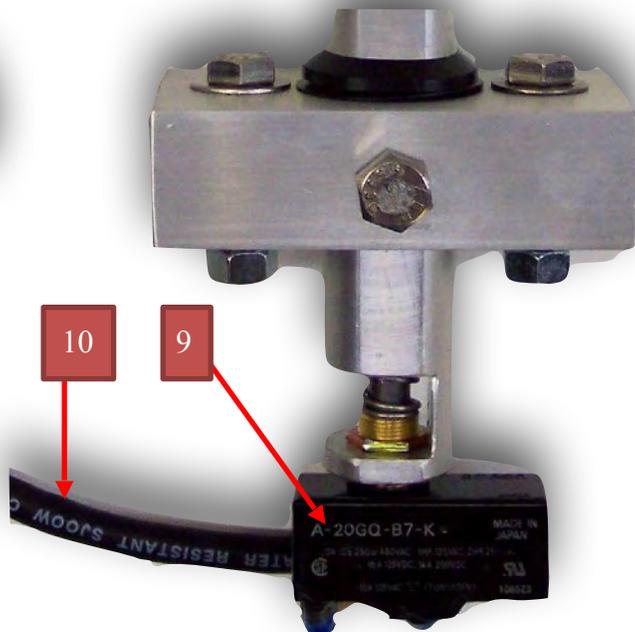
**On/Off Switch Interior View**



**Tower Switch Interior View**



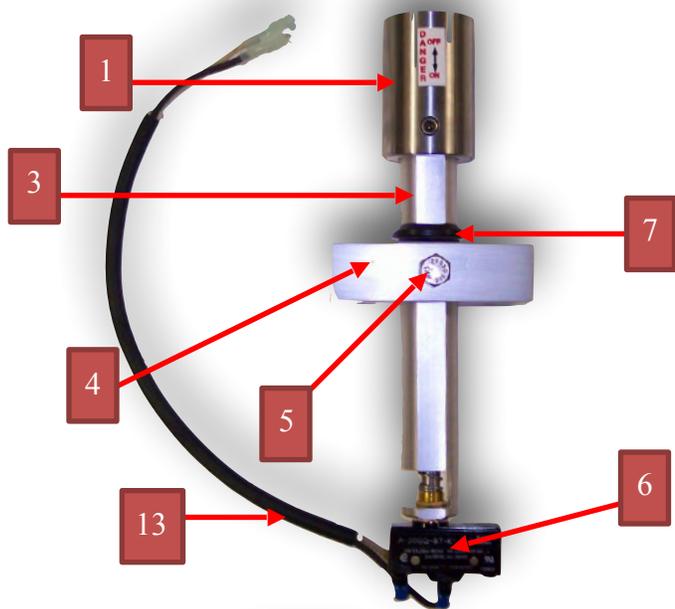
3



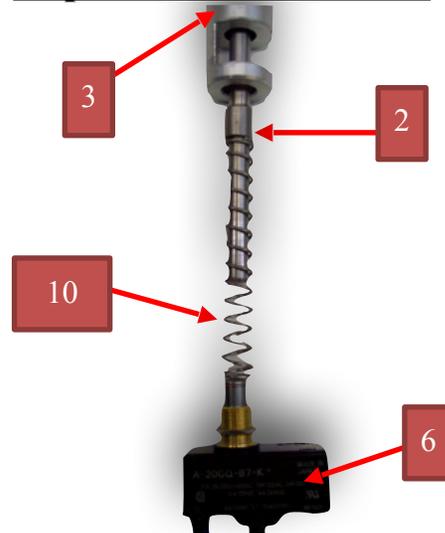
<u>Item#</u>	<u>Description</u>	<u>Part</u>
1	Round Key Latch	609-A1
2	On/Off Switch Guard	501
3	On/Off Switch Boot	500B
4	Power Cord	115-01
5	Wire Grommet	487
6	Guard Switch	608-1B
7	Guard Switch Wire	608-1D
8	On/Off Switch (insulated in electrical tape)	500
9	Tower Switch	620-10B
10	Tower Switch Wire	620-10A
11	15 AMP Circuit Breaker	115-15

**Part # 608-5A – Includes Guard Switch and Wire      Part # 620-10 – Includes Tower Switch and Wire**

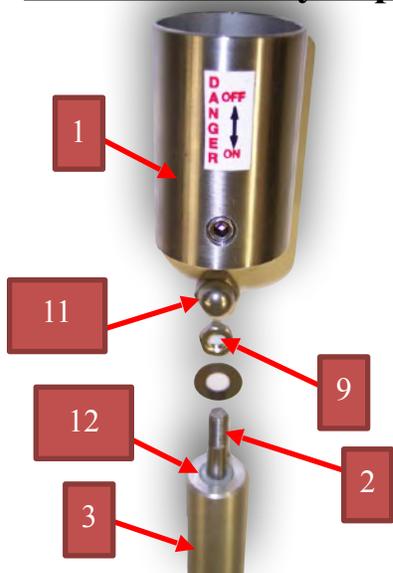
**Tower Assembly w/ Tower Block**



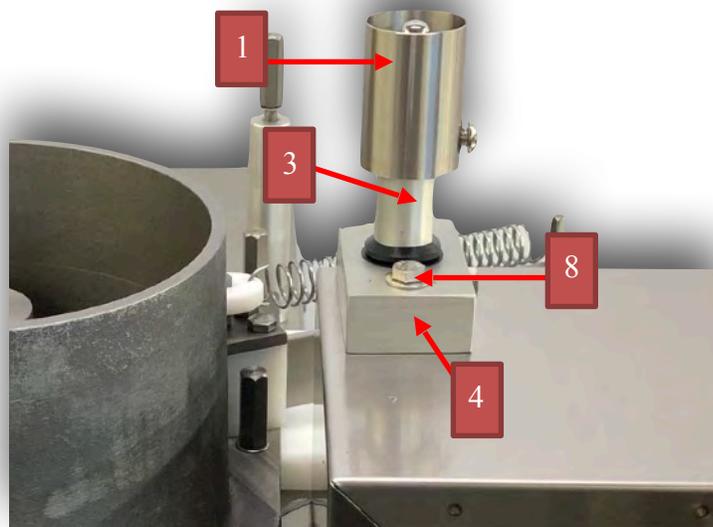
**Tower Assembly Exploded Bottom View**



**Tower Assembly Top View**

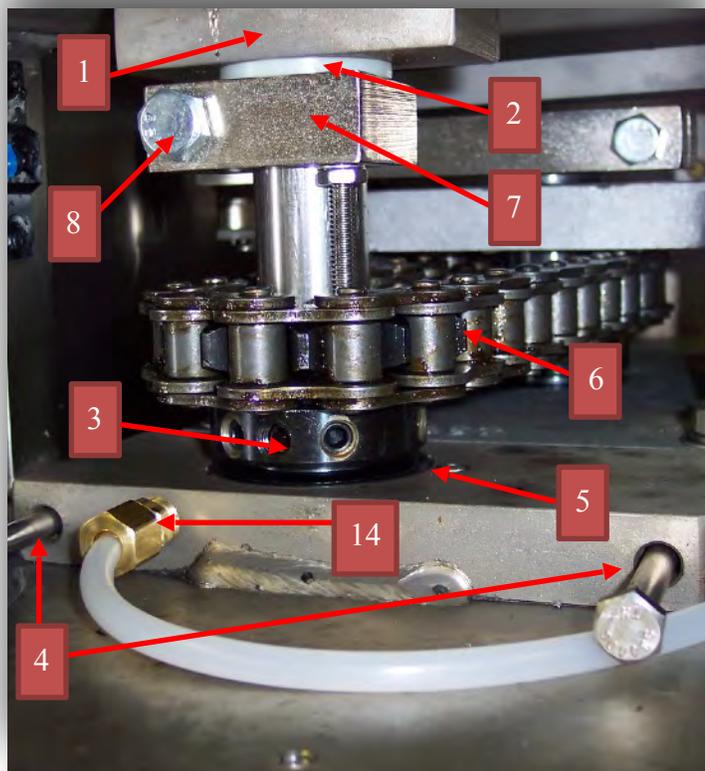


**Tower Assembly Machine View**

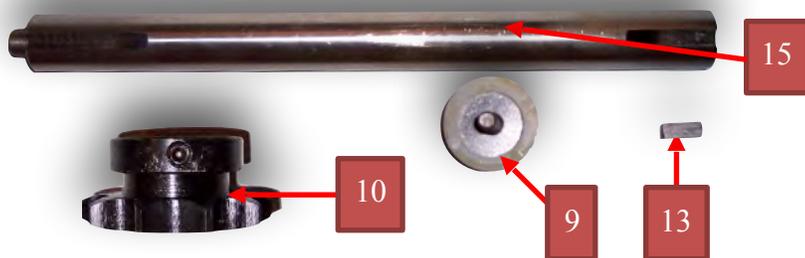
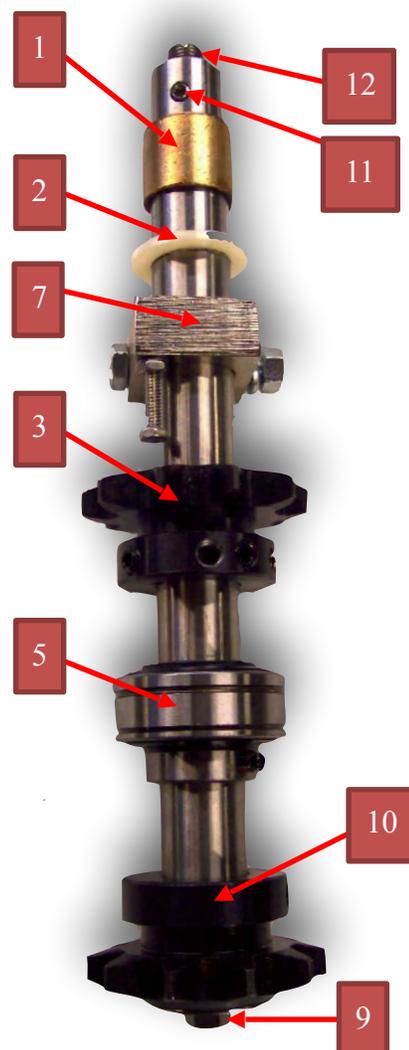


<u>Item#</u>	<u>Description</u>	<u>Part #</u>
1	Tower Sleeve	620-16
2	Tower Stem	620-3
3	Tower Tube	620-5
4	Tower Block	620-6
5	Tower Locator Lock Bolt	620-7
6	Tower Switch	620-10B
7	Rubber Seal	464S
8	Tower Block Hardware	620-8
9	Tower Jam Nut	620-06
10	Tower Spring	620-9
11	Tower Acorn Nut	620-15
12	Tower Bushing	620-4
13	Tower Switch Wire	620-10A

## Main Shaft Assembly Interior View

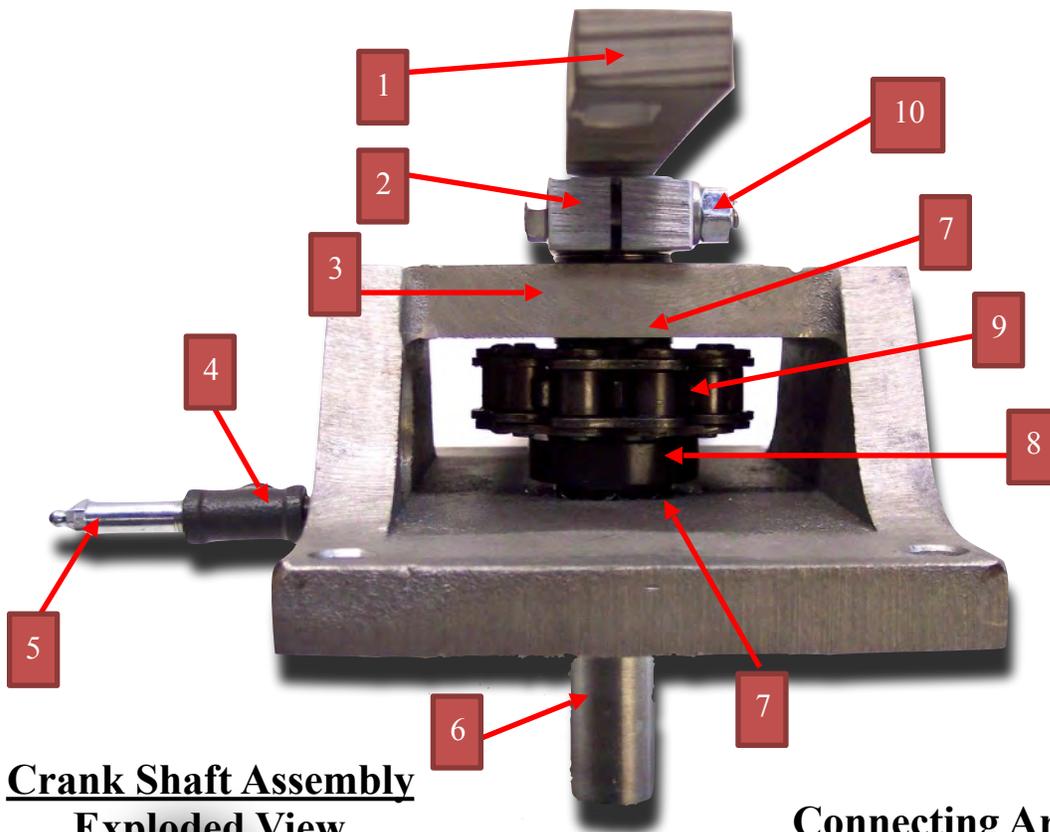


## Main Shaft Exploded View

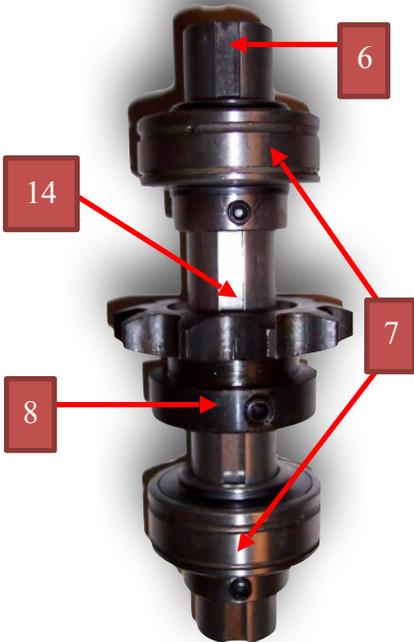


<u>Item#</u>	<u>Description</u>	<u>Part#</u>
1	Main Shaft Bushing (pressed into Machine Frame)	470
2	Main Shaft Thrust Washer	469-1
3	Timing Sprocket	465T
4	Chain Tension Adjuster Bolt	463
5	Main Shaft Bearing (pressed into Machine Frame)	464A
6	Timing Chain and Link	471
7	Main Shaft Clamp	467
8	Main Shaft Clamp Hardware	468
9	Main Shaft Fender Washer and Hardware	240-1
10	Main Shaft Driven Sprocket(Specify Amount of Teeth)	240
11	Main Shaft Threaded Insert Set Screw	464-2
12	Main Shaft Threaded Insert c/w Set Screw and Locking Nut	464-1
13	Main Shaft Sprocket Key	241
14	Grease Line System(Not completely shown)	704
15	Main Shaft C/W Insert and Set Screw	464

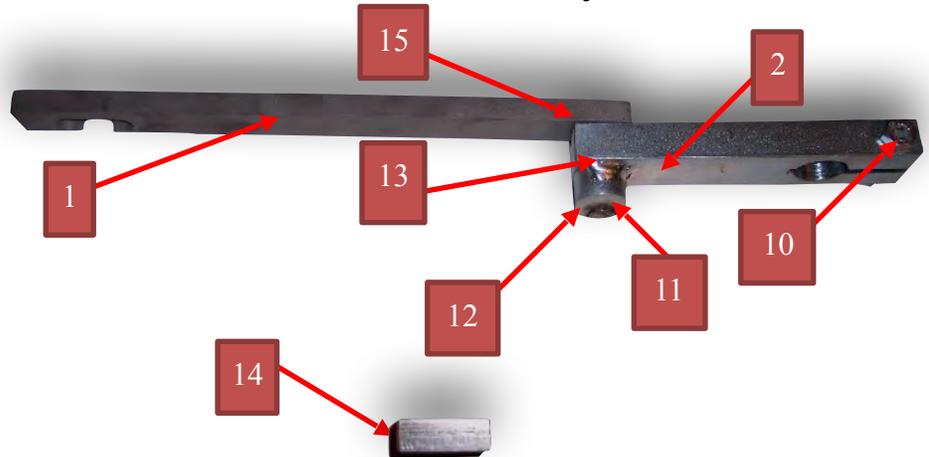
# Crank Housing Assembly Side View



## Crank Shaft Assembly Exploded View



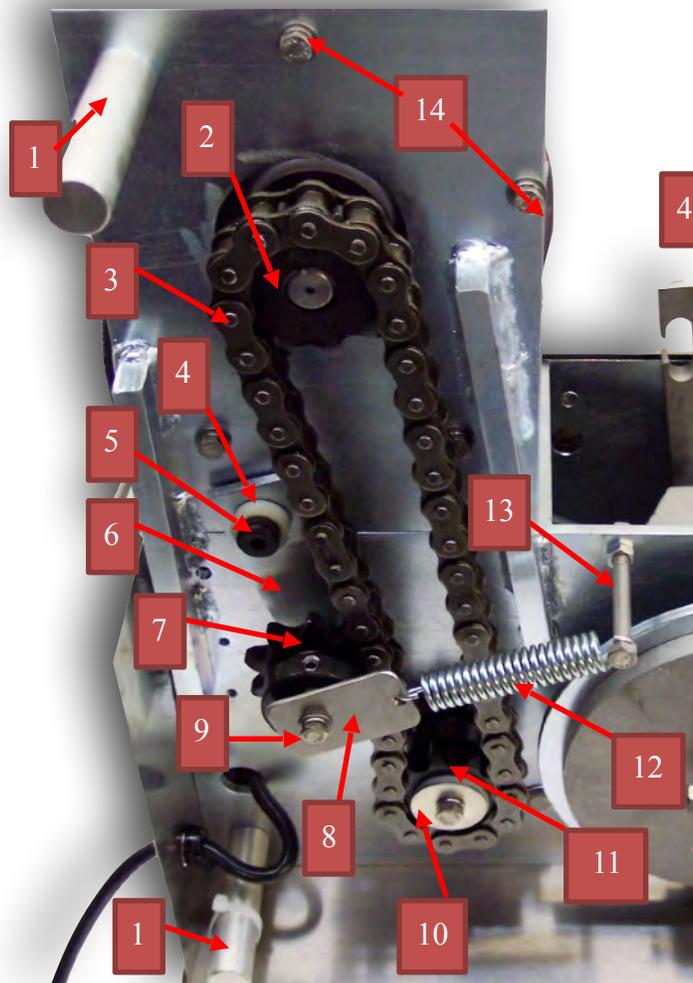
## Connecting Arm Assembly



Item #	Description	Part #
1	Connecting Arm	455
2	Crank Arm	452
3	Crank Shaft Housing Casting	457
4	Grease Line T Fitting	703
5	External Grease Fitting	701
6	Crank Shaft	456
7	Crank Housing Bearing(2)(pressed into Crank Housing)	457A

**Part # 459 – Crank Housing Hardware**

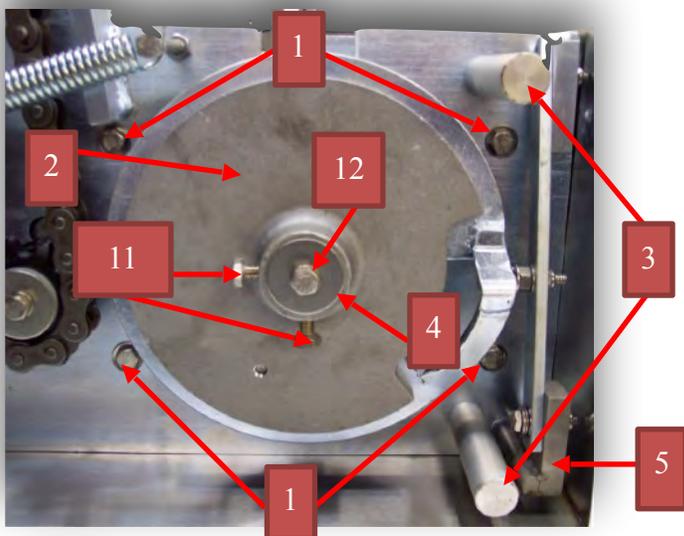
Item #	Description	Part #
8	Crank Shaft Sprocket	460
9	Timing Chain and Link	471
10	Crank Arm Hardware	453
11	Connecting Arm Thrust Washer	456B
12	Connecting Arm Cotter Pin	455A
13	Connecting Arm Bushing (white poly bushing pressed into the Connecting Arm not shown)(2)	455-1
14	Sprocket Key	461
15	Connecting Arm Spring Washer (Between the Connecting and Crank Arm)	455C

Motor to Main Shaft Bottom ViewIdler Arm Assembly Parts

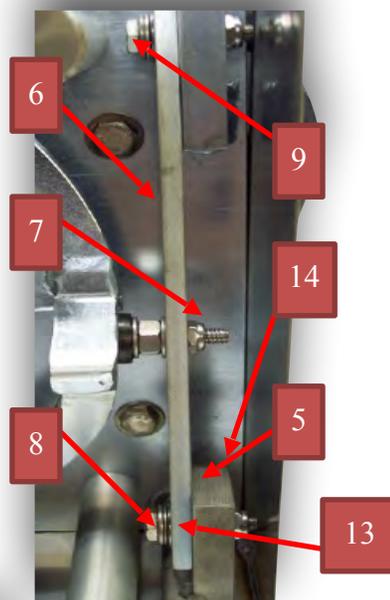
<u>Item#</u>	<u>Description</u>	<u>Part #</u>
1	Machine Legs (set of 4)(Only 2 shown)	446
2	Motor Drive Sprocket(Specify Teeth)	236
3	Motor to Main Shaft Chain and Link	239
4	Idler Arm Shoulder Bolt Hardware	229B
5	Idler Arm Shoulder Bolt	229A
6	Idler Arm	230-A
7	Idler Arm Sprocket and Bushing Assembly	232
8	Idler Arm Spring Tab	231A
9	Idler Arm Spring Tab Hardware	231B
10	Main Shaft Fender Washer and Hardware	240-1
11	Main Shaft Driven Sprocket(Specify Teeth)	240
12	Idler Arm Spring	231
13	Idler Arm Spring Bolt and Hardware	235
14	Gear Head Motor Mounting Hardware(set of 5)	284B
15	Idler Arm Sprocket Bushing(Set of 2)	234

**Part # 229 – Idler Arm Assembly - Includes spring, tab, arm, and all hardware**

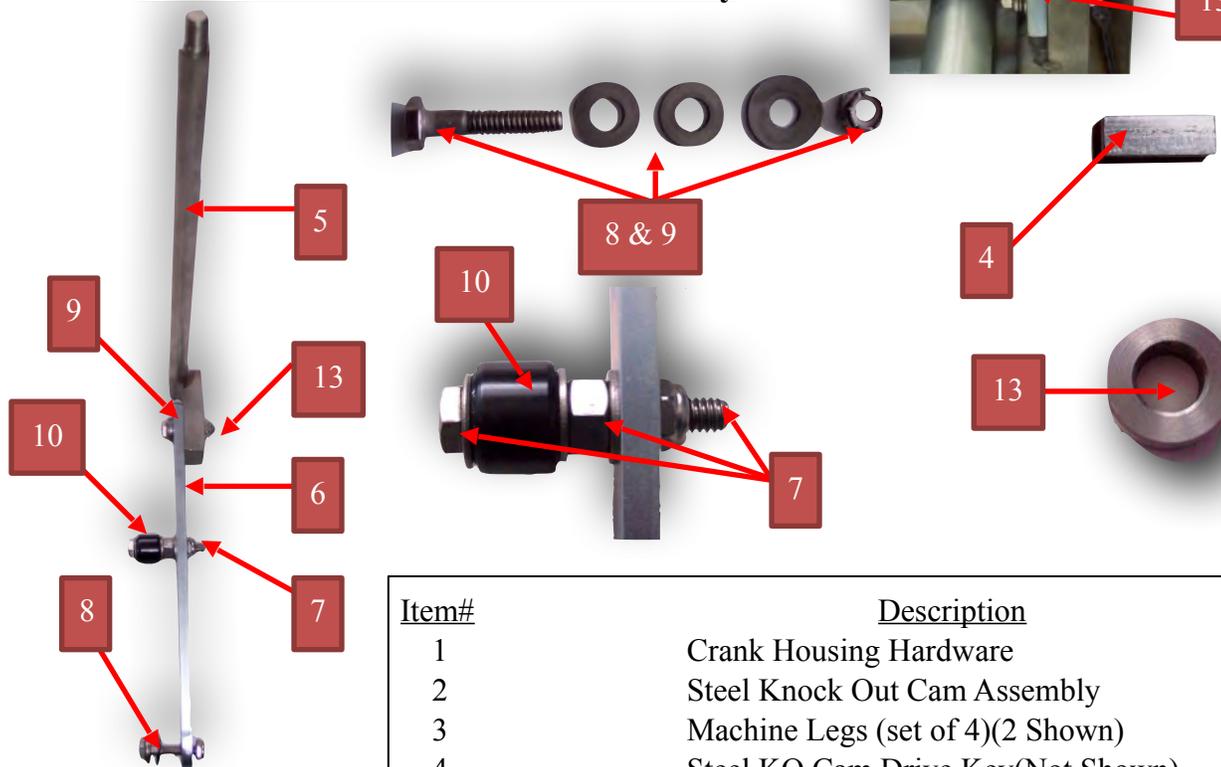
**Knock Out Cam Bottom View**



**Knock Out Lever Assembly**



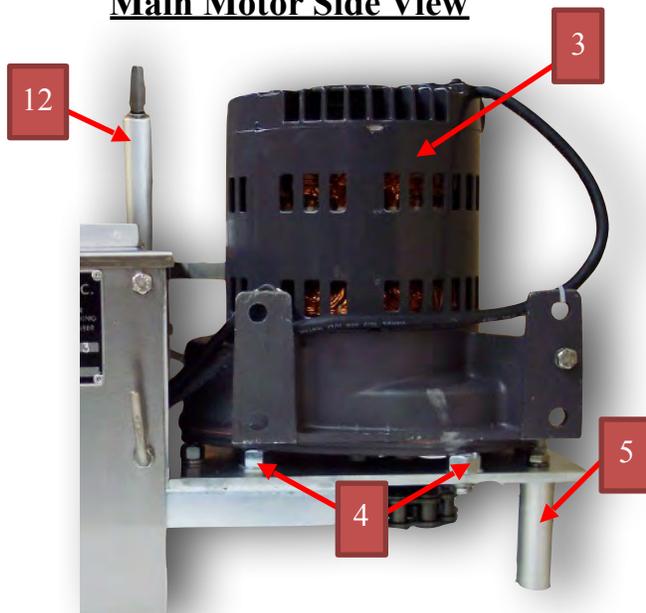
**Knock Out Shaft and Lever Assembly**



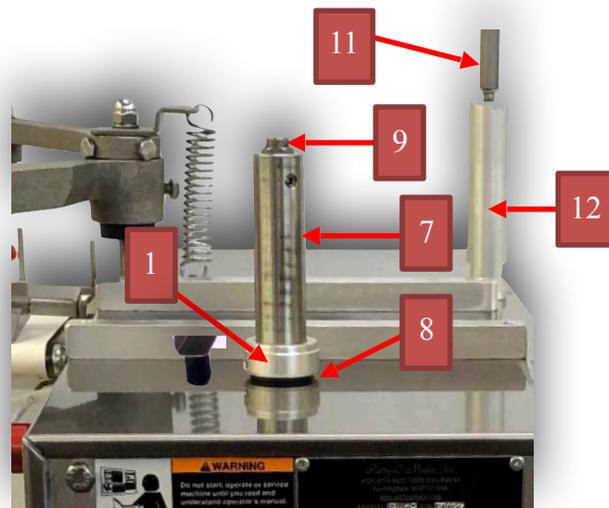
**Part # 450X**  
**Knock Out Lever**  
**Assembly**  
 -Includes Lever,  
 Bushing, Cam  
 Bearing, and all  
 Hardware

Item#	Description	Part #
1	Crank Housing Hardware	459
2	Steel Knock Out Cam Assembly	472-S
3	Machine Legs (set of 4)(2 Shown)	446
4	Steel KO Cam Drive Key(Not Shown)	477-1
5	Knock Out Shaft	PM18-449
6	Knock Out Lever	450
7	Cam Follower Bearing Hardware	475
8	Knock Out Lever Hardware	451
9	Knock Out Lever Bushing Hardware	450B
10	Cam Follower Bearing	474
11	Steel Knock Out Cam Bolts(2)	472-S1
12	Steel KO Cam Keeper Bolt and Hardware	472-S2
13	Knock Out Lever Bushing(sits inside Knock Out Lever)	450A

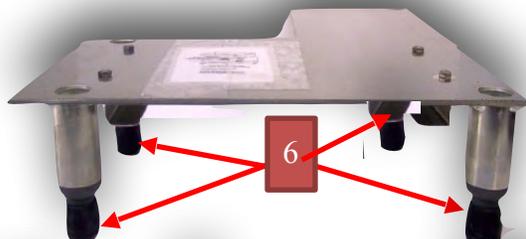
**Main Motor Side View**



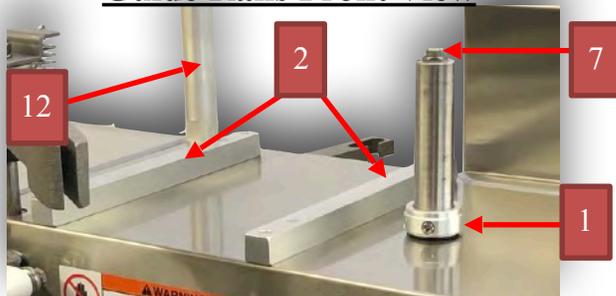
**Main Shaft Machine View**



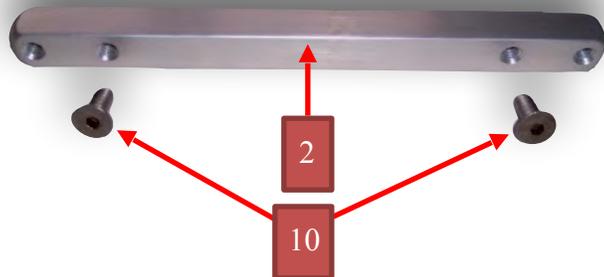
**Riser Platform**



**Guide Rails Front View**



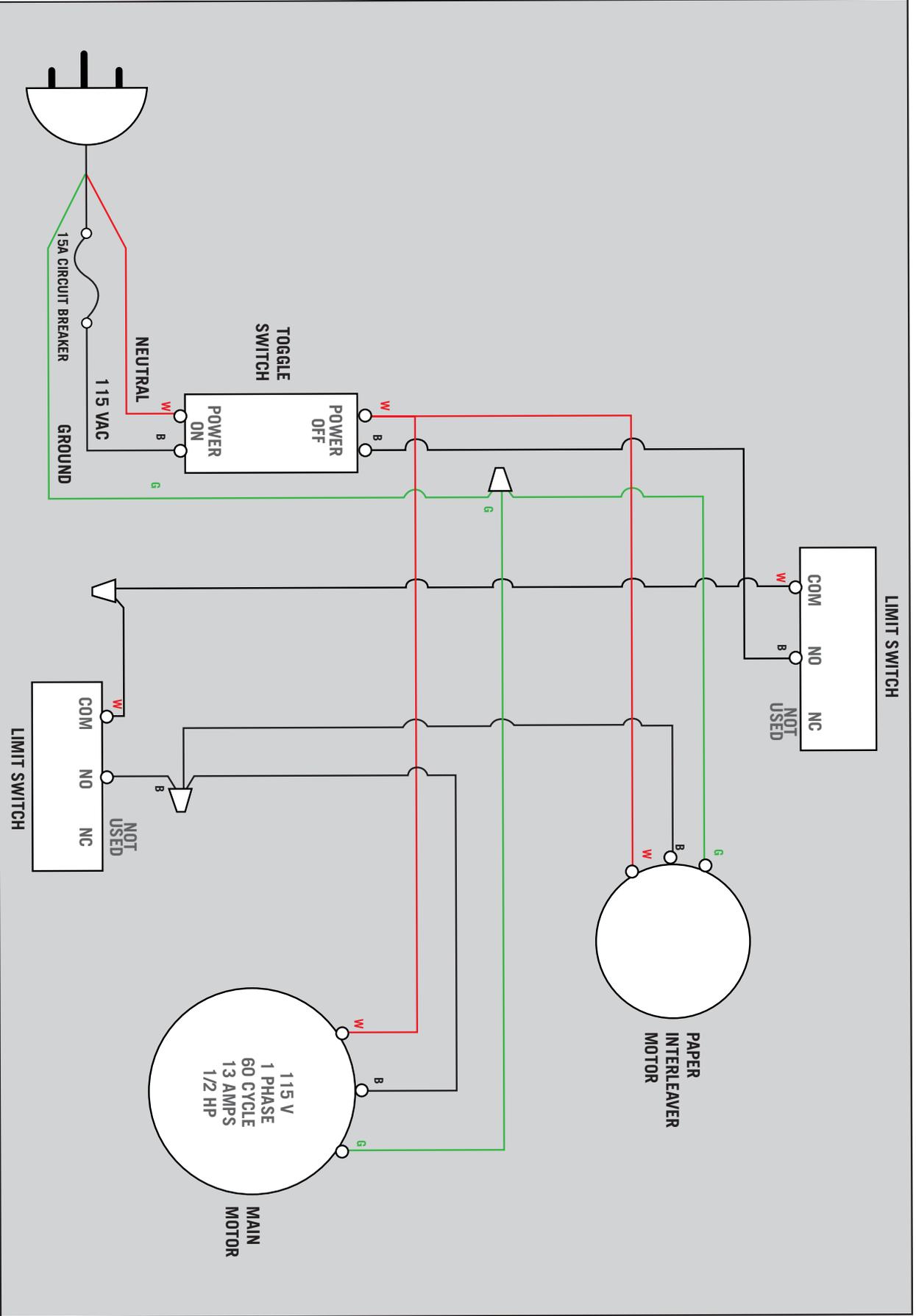
**Mold Plate Guide Rail**



Please call factory for instructions on installing new Mold Plate Guide Rails  
Toll Free in the U.S.A. 877-938-5244  
Outside the U.S.A. 732-938-2757

<u>Item#</u>	<u>Description</u>	<u>Part #</u>
1	Hopper Bushing Set Collar w/ screws and o-ring	603C
2	Mold Plate Guide Rail (2 Required)	494
3	Gear Head Motor	PM18-284
4	Motor Spacer(5 Required)(2 Shown)	284A
5	Machine Legs (set of 4)(1 Shown)	446
6	Rubber Feet (set of 4)	448
7	Main Shaft C/W Insert and Set Screw	464
8	Hopper Bushing Set Collar O-Ring	603E
9	Main Shaft Insert	464-1
10	Mold Plate Guide Rail Bolts (set of 2 bolts)	495
11	Hold Down Bolt	556B
12	Mold Plate Guard Rear Post Assembly	PM18-551-D

WIRING DIAGRAM



**KEY: W = WHITE/NEUTRAL    B-BLACK/115 VAC    G = GREEN/GROUND**

## Warranty Information

This appliance is guaranteed to original purchaser to be free from defects in materials and workmanship.

Warranty shall be limited to repairing or exchanging any part that shows evidence of defect within One Year of the original date of purchase.

In the event of the return due to defect in material or workmanship, within the warranty period, please return in original packing case or equivalent.

Our expert factory authorized repair service is provided, and recommended for all repairs, within and beyond the warranty period.

Warranty shall not apply if appliance has been plugged into any current other than that specified; or has been tampered with or altered in any way.

Warranty does not cover parts that wear out from use or parts that are damaged or broken in use; or service claims arising due to failure to follow operating instructions.

This warranty is in lieu of all other warranties, expressed or implied. No representative or other person is authorized or permitted to make any guarantee or to assume for us any liability not strictly in accordance with the foregoing.

If you should have any further questions or require assistance with anything please do not hesitate to call the factory. We recommend that you are near the machine when you call. Please provide us with the age, serial number, model number, and mold plate size when you call.



[www.PattyOMatic.com](http://www.PattyOMatic.com)

Toll Free 877-938-5244

**Patty-O-Matic Inc. Model PM18**

**Serial Number** \_\_\_\_\_

**Date Purchased** \_\_\_\_\_

**Purchased From What Dealer** \_\_\_\_\_

**Dealer Address and Phone Number** \_\_\_\_\_

\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_

**Maintenance Performed on Machine** \_\_\_\_\_

\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_

**Owner's Notes** \_\_\_\_\_

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