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AL.MA. 250 double-sheet ravioli and varenyky line

AL.MA. Srl (Italy) · output up to 300 kg/h · double-sheet dough products

Purpose

A line for producing ravioli, varenyky and dumplings from two dough sheets in a range of shapes. It is designed to work with fillings of any consistency, including delicate fillings containing pieces — meat, cheese or vegetable: the filling is fed continuously by a lobe pump and keeps its structure. This is the entry level in the double-sheet range — more compact than the RSA540 line and intended for smaller volumes.

Line composition

- 1. IMP540-80R dough mixer — tilting, discharges the dough directly into the sheeter
- 2. CA250FD or CA250FDA sheeter — produces two dough sheets 250 mm wide
- 3. RSA250N forming machine — forms the product from two dough sheets with an interchangeable die
- 4. PLA100 lobe pump — continuous filling supply to the forming machine

The dough mixer is used as a separate machine: the sheeter is fitted with a receiving hopper designed to accept dough discharged from it. All parts in contact with dough and filling are made of stainless steel and other non-toxic materials suitable for the food industry. The equipment complies with current CE standards.

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1. IMP540-80R dough mixer

A tilting dough mixer for preparing the dough and discharging it directly into the sheeter.



AL.MA. IMP540-80R dough mixer

- bowl entirely of AISI 304 stainless steel, shaft with inclined profiled blades for even dough distribution;
- discharge by tilting with vertical lift along two AISI 304 stainless steel rack-and-pinion guides;
- independent drive, control panel on the machine, safety devices;
- noise level at the operator’s position LAeq = 68.0 dB (A).

Parameter	Value
Bowl capacity (semolina + moisture)	80 kg
Mixing time	10–15 minutes
Depth	1300 mm
Height, width	to be confirmed at order
Weight	585 kg
Installed power	6 kW

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2. CA250FD / CA250FDA sheeter

An automatic machine producing a double-laminated dough sheet: it prepares two 250 mm sheets from which the forming machine shapes the product.



AL.MA. CA250FD sheeter — photo by the manufacturer AL.MA. Srl

- loading hopper with stainless steel shafts and blades;
- stainless steel sheeting group — gramola unit and laminating cylinders;
- construction entirely of stainless steel, round-tube frame;
- belt conveyor made of material certified for food products;
- control panel and electrical cabinet with safety devices to CE standards.

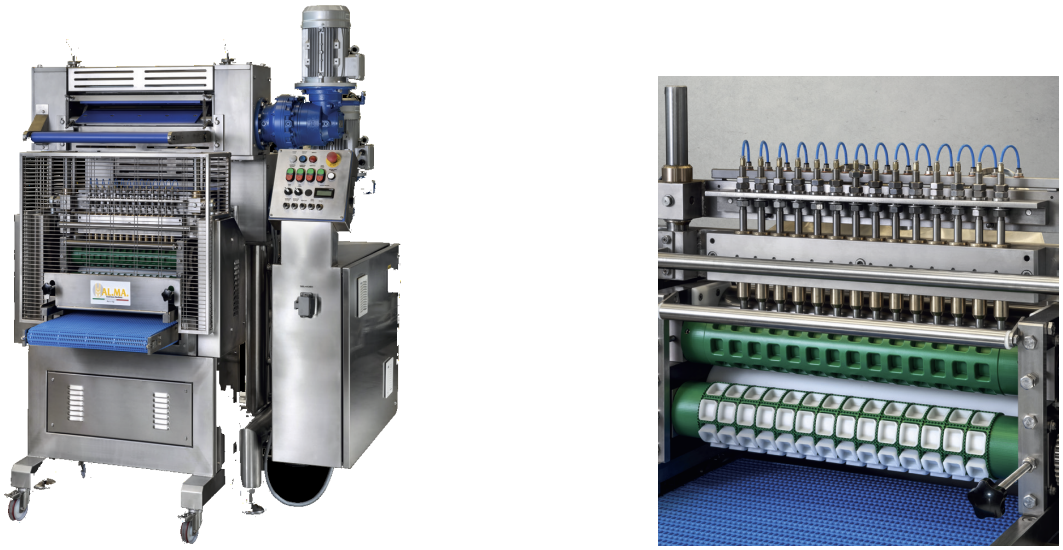
Parameter	Value
Output	300 kg/h
Dough sheet width	2 × 250 mm
Height	1880 mm
Width	1630 mm
Depth	1840 mm
Weight	1900 kg
Installed power	10 kW

The FDA version has the same dimensions, weight, power and output but additionally features a tilting hopper with folding side walls and a new step-by-step gramola rotation system for full sanitary cleaning.

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3. RSA250N forming machine

A machine for producing ravioli from two dough sheets in a range of shapes. For continuous operation it works together with a lobe pump feeding the filling.



AL.MA. RSA250N forming machine and the die fitted on it — photos by the manufacturer AL.MA. Srl

• construction entirely of stainless steel;

• two separate stainless steel sheeting groups with adjustable thickness, controlled by an automatic motovariator;

• quick and simple die change;

• adjustment of the filling quantity inside the product according to the shape;

• belt conveyor made of food-grade certified material;

• functions controlled by independent motovariators; control panel and electrical cabinet with safety devices to CE standards;

• wheels for moving the machine.

Parameter	Value
Output	up to 300 kg/h
Dough sheet width	250 mm
Height	1690 mm
Width	1090 mm
Depth	1590 mm
Weight	1055 kg
Installed power	4.5 kW
Die	one included with the machine, shape chosen by the customer

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4. PLA100 lobe pump

A lobe pump for continuous filling supply to the forming machine. It handles meat, cheese and vegetable fillings, including those containing pieces: the filling comes out dense and unchanged in character.





AL.MA. PLA100 lobe pump and its lobes — photos by the manufacturer AL.MA. Srl

- tilting cover with a safety grid;
- rotor and lobes are easily dismantled for sanitary cleaning;
- machine entirely of stainless steel;
- supplied in two versions — PLA100-A and PLA100-B.

Parameter	Value
Height	1685 mm
Width	760 mm (PLA100-B — 756 mm)
Depth	720 mm (PLA100-B — 713 mm)
Weight	200 kg
Installed power	1.5 kW

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General specifications

Parameter	Value
Line output	up to 300 kg/h
Dough sheet width	250 mm (sheeter 2 × 250 mm)
Line composition	IMP540-80R dough mixer + CA250FD/FDA sheeter + RSA250N forming machine + PLA100 lobe pump
Total installed power	22 kW
Power supply	380 V / 3 ph + N + E / 50 Hz
Materials	stainless steel, food-grade certified belts
Conformity	CE standards

Calculating the output: cycles per minute × products per cycle × weight of one product × 60. On average the forming machine runs at about 90 cycles per minute (up to 110). The number of products per cycle is set by the die, so the output depends on the chosen shape and product weight. The figures given are indicative.

Supply and service

DDP delivery to the customer’s warehouse anywhere in Ukraine, positioning at the customer’s production site, commissioning, staff training, warranty and post-warranty service, dies and spare parts. The exact line configuration and product shapes are selected to order.

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Appendix. Catalogue of double-sheet dough product shapes

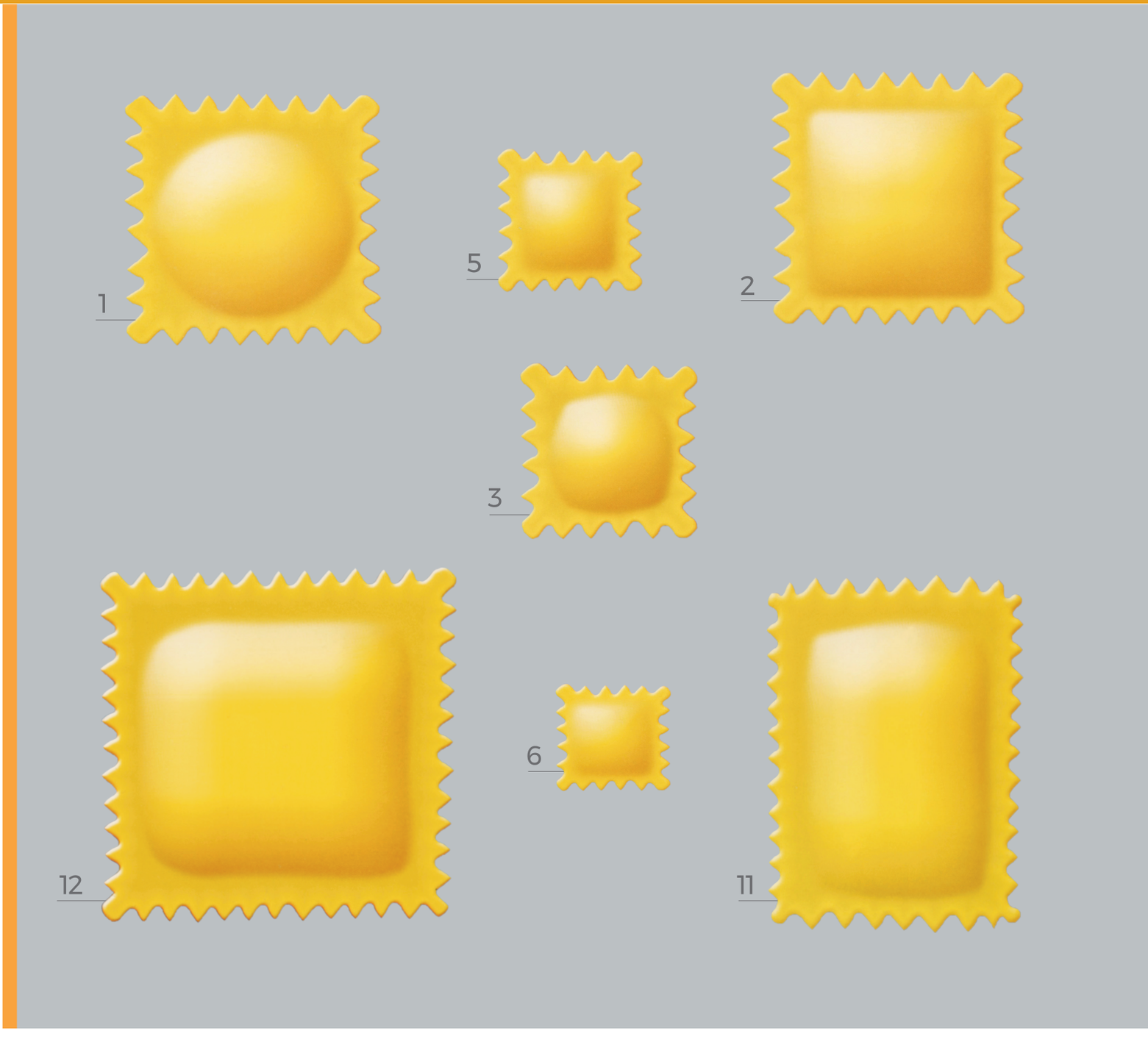
AL.MA. Srl catalogue · die formats for the RSA250N

The forming machine with interchangeable dies produces double-sheet dough products: square and rectangular ravioli, round ones (including classic dumplings), half-moons (varenyky) and figured shapes. One die is included with the machine and the shape is chosen by the customer; additional dies, including custom shapes, are made to order.

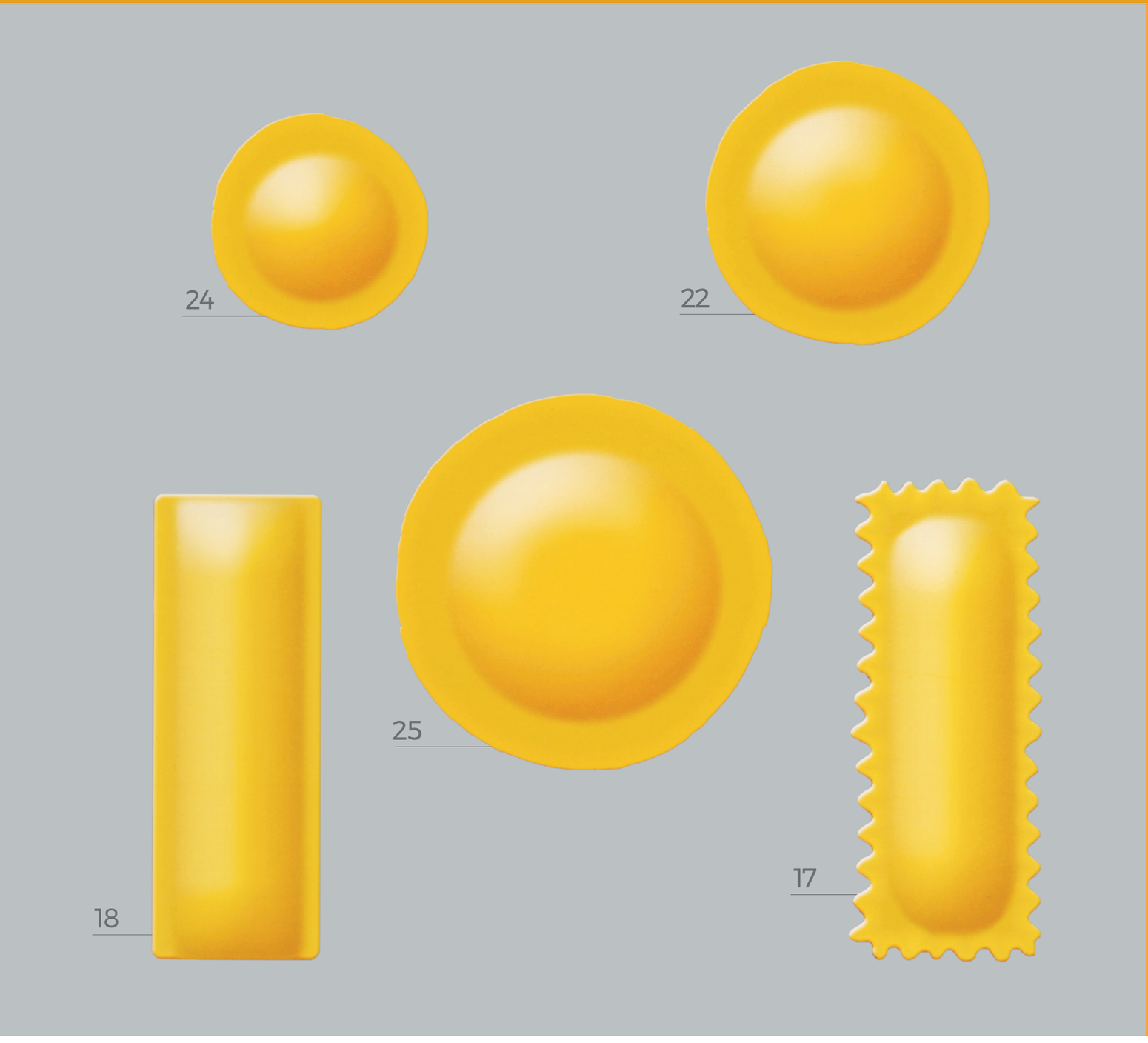
Weight, dimensions and output are indicative and may vary with the dough sheet thickness and the dough-to-filling ratio.

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FORMATO *FORMAT*	PESO gr *WEIGHT gr*
1	13
2	14
3	7
5	3,5
6	2,5
11	17
12	*21*



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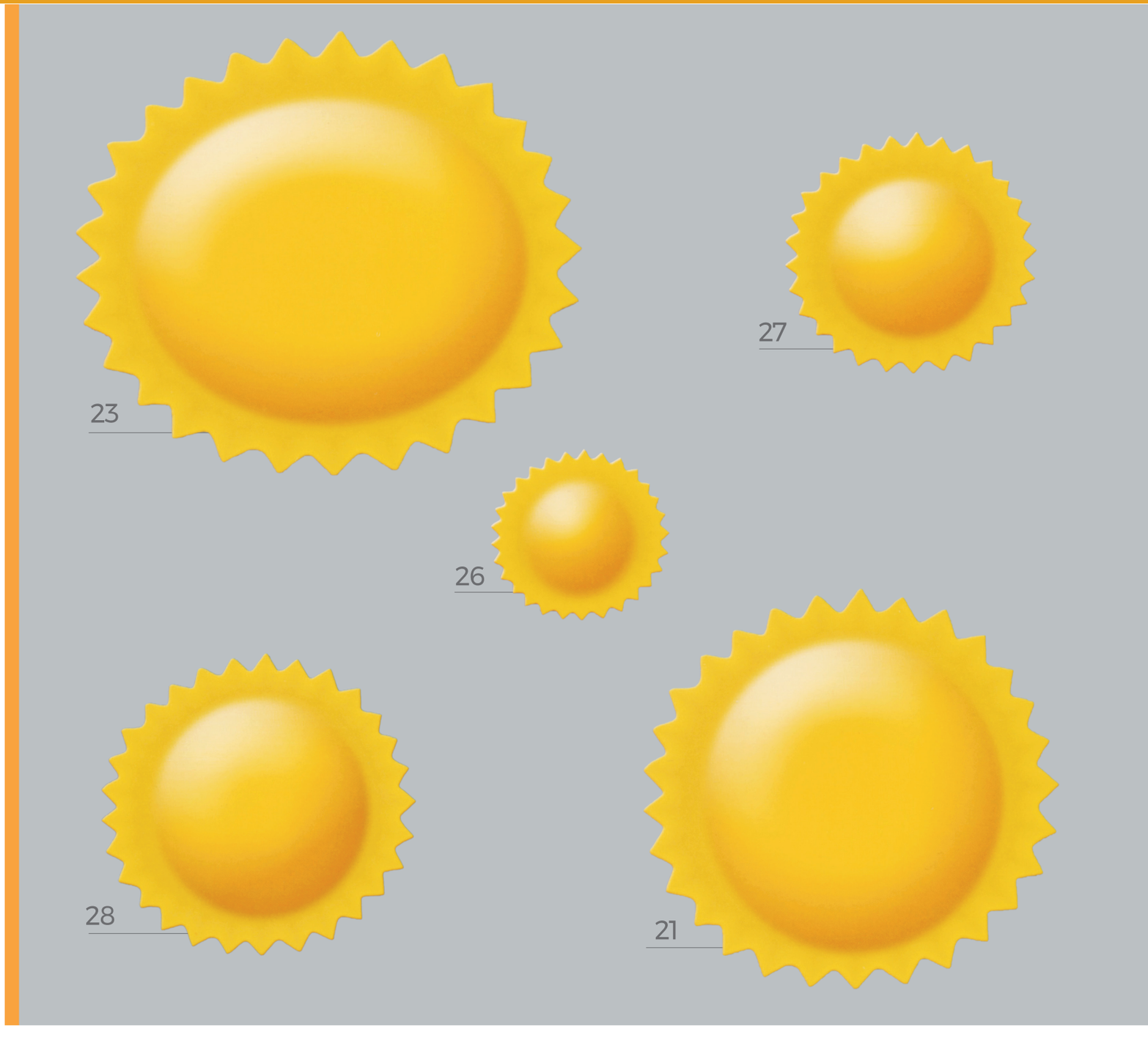
FORMATO *FORMAT*	PESO gr *WEIGHT gr*
17	16
18	16
22	46
24	8
25	28

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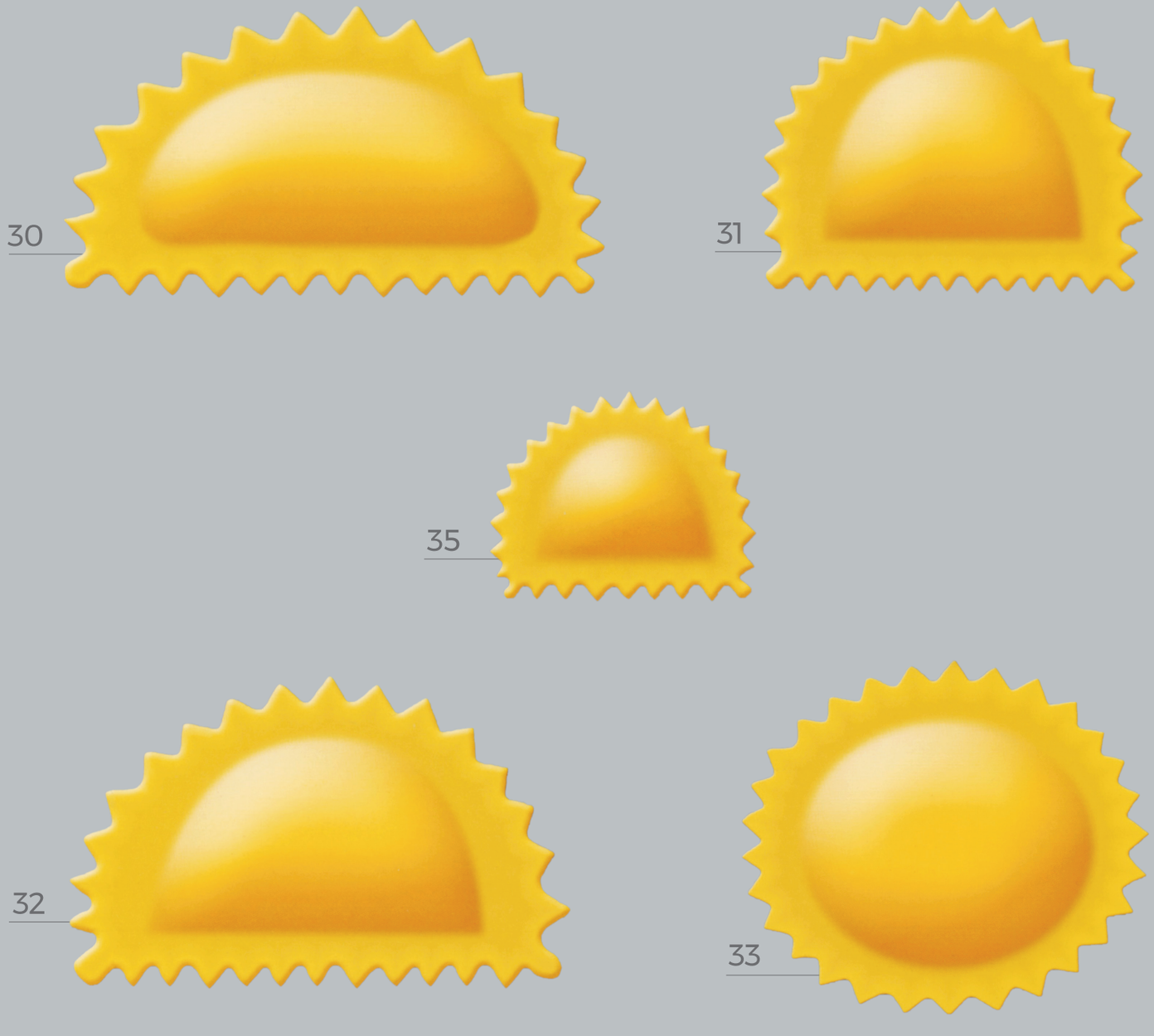
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FORMATO *FORMAT*	PESO gr *WEIGHT gr*
21	32
23	50
26	5
27	12
28	18



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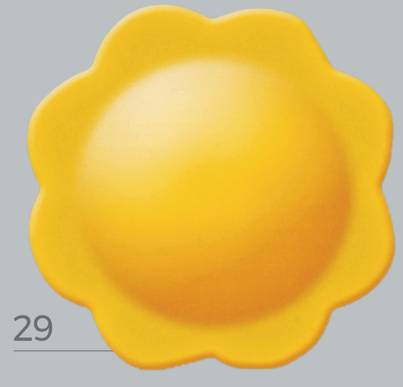
FORMATO *FORMAT*	PESO gr *WEIGHT gr*
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31	20
32	25
33	23
35	8

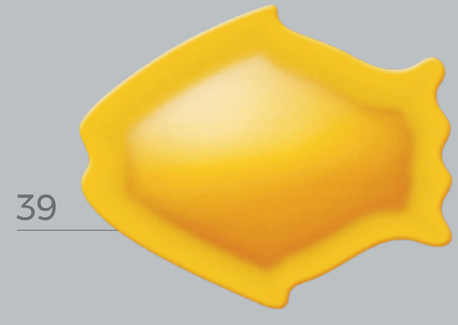
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FORMATO *FORMAT*	PESO gr *WEIGHT gr*
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29	16
39	12
40	14

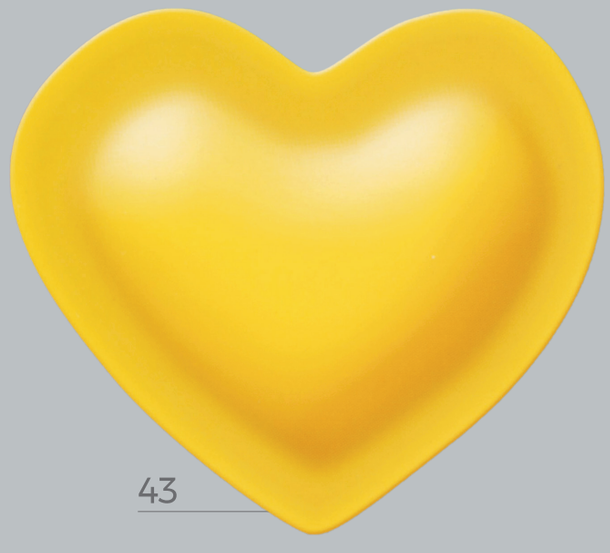

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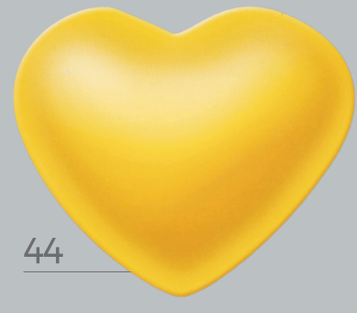

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43


44


48


50

FORMATO *FORMAT*	PESO gr *WEIGHT gr*
43	30
44	12
48	13
50	14

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