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AL.MA. RSA540 double-sheet ravioli and varenyky line

AL.MA. Srl (Italy) · output up to 700 kg/h · double-sheet dough products

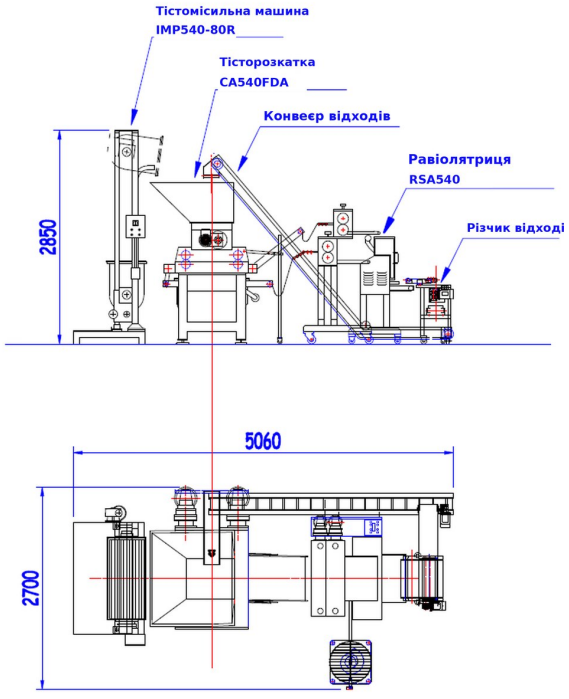
Purpose

An industrial 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. Unused dough sheet is cut up and returned to the sheeter, so the line runs with virtually no scrap loss.

Line composition

- 1. IMP540-80R dough mixer
- 2. CA540FDA sheeter
- 3. RSA540 forming machine
- 4. PLA100-A lobe pump
- 5. Scrap cutter
- 6. Scrap return system

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.



Line layout. The markings on the drawing match the line composition above.

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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. CA540FDA sheeter

An automatic double-sheet sheeter: it prepares two 540 mm sheets from which the forming machine shapes the product.



AL.MA. CA540FDA sheeter

- loading hopper with stainless steel shafts and blades, tilting, with folding side walls;
- sheeting group: gramola unit with stainless steel rollers and stainless steel laminating cylinders;
- step-by-step gramola rotation system for full sanitary cleaning;
- construction entirely of stainless steel with access doors for easy washing, round-tube frame;
- belt conveyor made of food-grade certified material;
- external main drive with inverter, electrical cabinet and CE control panel.

Parameter	Value
Dough sheet width	2 × 540 mm
Height	1880 mm
Width	1950 mm
Length	1880 mm
Weight	2720 kg
Installed power	13 kW



CA540FDA sheeting group

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3. RSA540 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. RSA540 forming machine

• 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;

• vacuum pump application;

• 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 700 kg/h
Dough sheet width	540 mm
Laminator, H×W×D	1980 × 1550 × 1160 mm · 980 kg
Die trolley, H×W×D	160 × 1050 × 700 mm · 395 kg
Installed power	8.5 kW
Die	one included in the supply, shape chosen by the customer

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4. PLA100-A lobe pump

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



AL.MA. PLA100-A lobe pump

- tilting cover with a safety grid;
- screw removable without tools — for easy sanitary cleaning;
- machine entirely of stainless steel.

Parameter	Value
Height	1685 mm
Width	760 mm
Depth	720 mm
Lobe height	110 mm
Weight	200 kg
Installed power	1.5 kW

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5. Scrap cutter

A cutter that cuts up unused dough sheet for continuous return into production.



Scrap cutter for the RSA540

• cutting group with stainless steel rollers, independent variator drive, speed directly proportional to the laminator speed;

• anodised aluminium construction, safety devices;

• scrap collection belt from the forming machine to the return system: stainless steel construction, independent variator drive, food-grade belts, transparent Plexiglas inspection guards.

6. Scrap return system

A belt elevator conveyor loading the CA540FDA sheeter: construction entirely of stainless steel, food-grade belt, independent variator drive. The cut-up sheet is returned for reprocessing together with fresh dough.



Scrap return system

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General specifications

Parameter	Value
Line output	up to 700 kg/h
Dough sheet width	540 mm (sheeter 2 × 540 mm)
Total installed power	29 kW
Power supply	380 V / 3 ph + N + E / 50 Hz
Floor area envelope (L×H×D)	5060 × 2850 × 2700 mm
Materials	stainless steel, food-grade certified belts
Conformity	CE standards

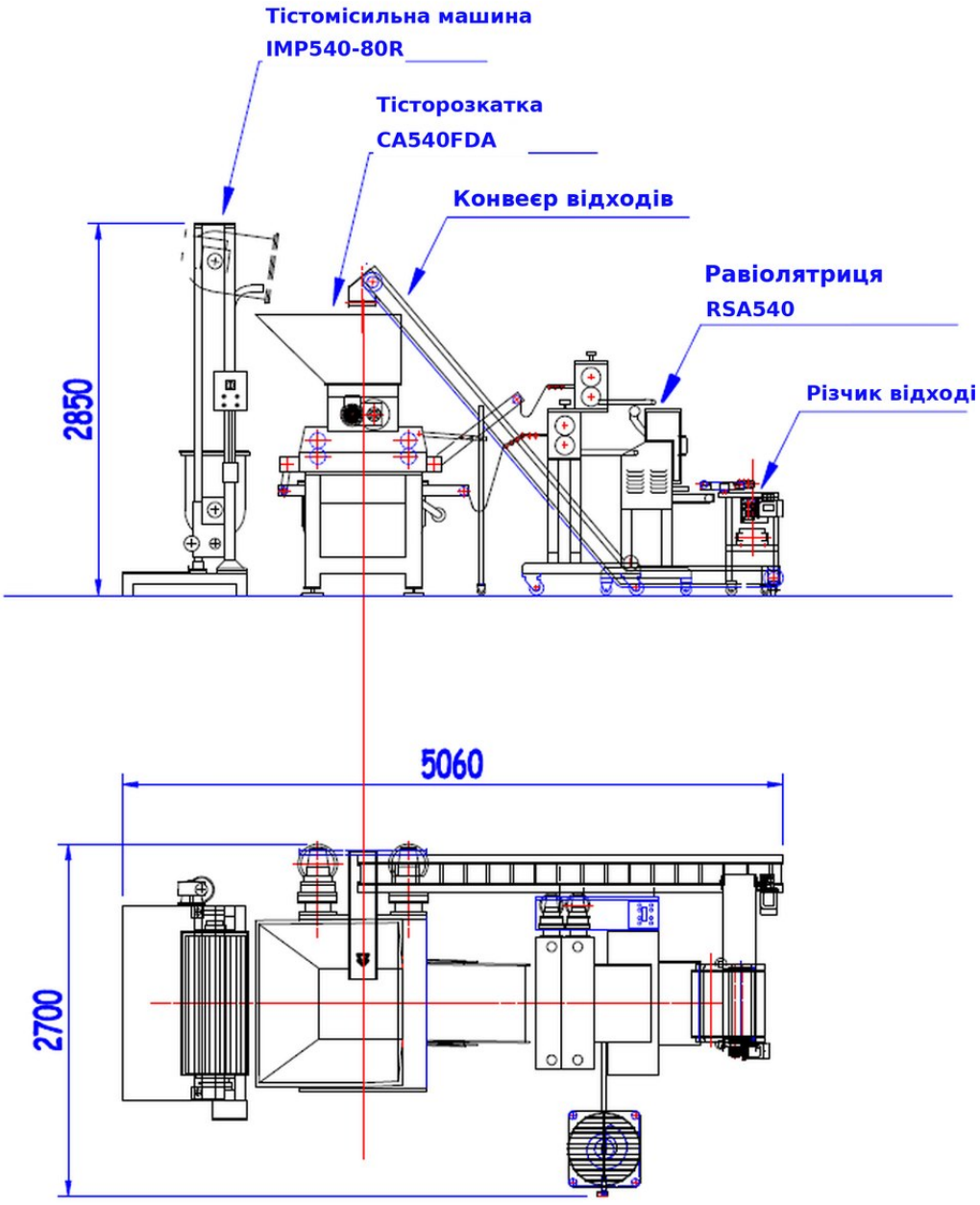
Calculating the output: cycles per minute × products per cycle × weight of one product × 60. On average the forming machine runs at about 90 cycles per minute (up to 110). The number of products per cycle is set by the die, so the output depends on the chosen shape and product weight. The figures given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



Line layout, dimensions in mm

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Appendix. Catalogue of double-sheet dough product shapes

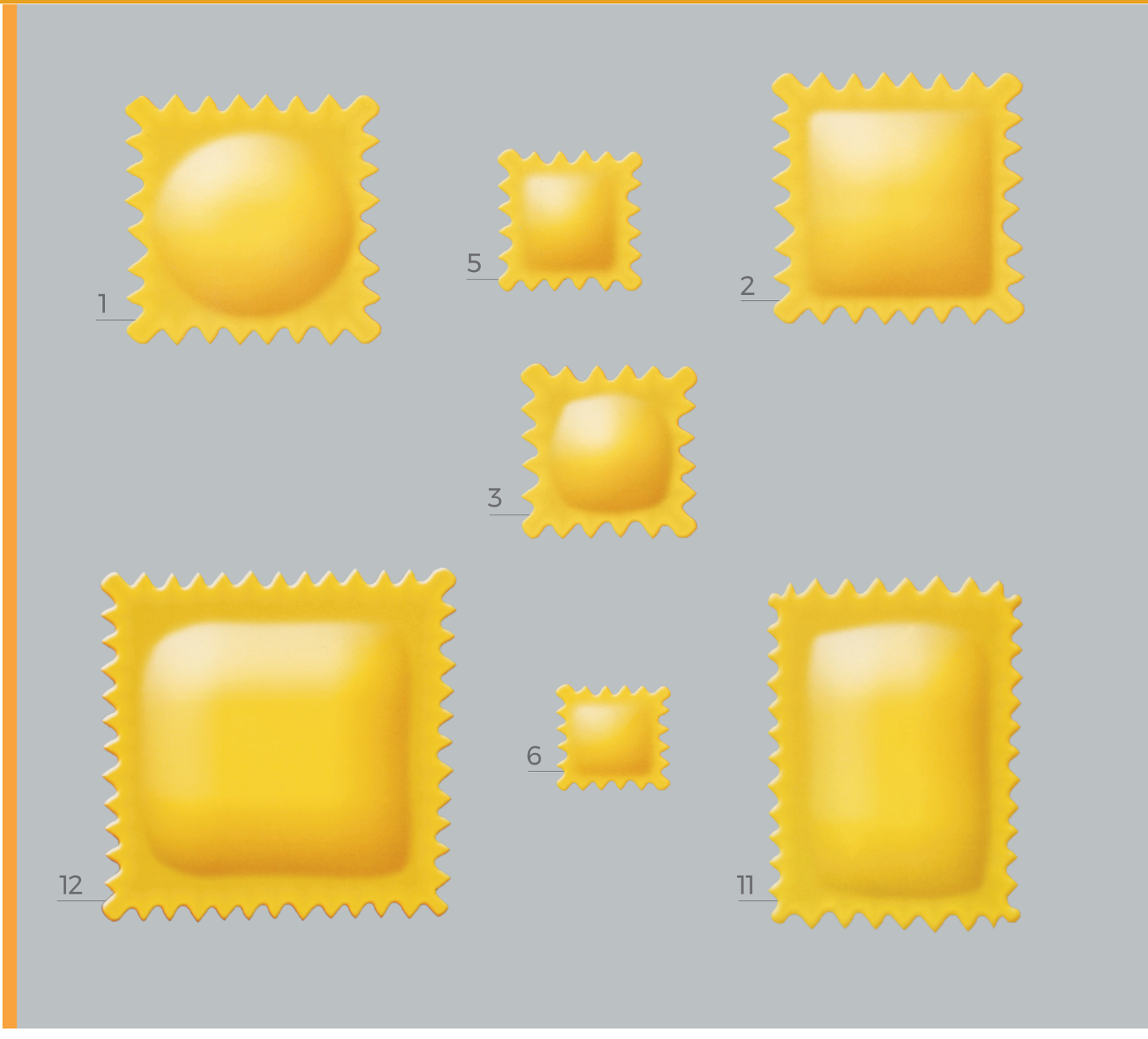
AL.MA. Srl catalogue · die formats for the RSA540

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.

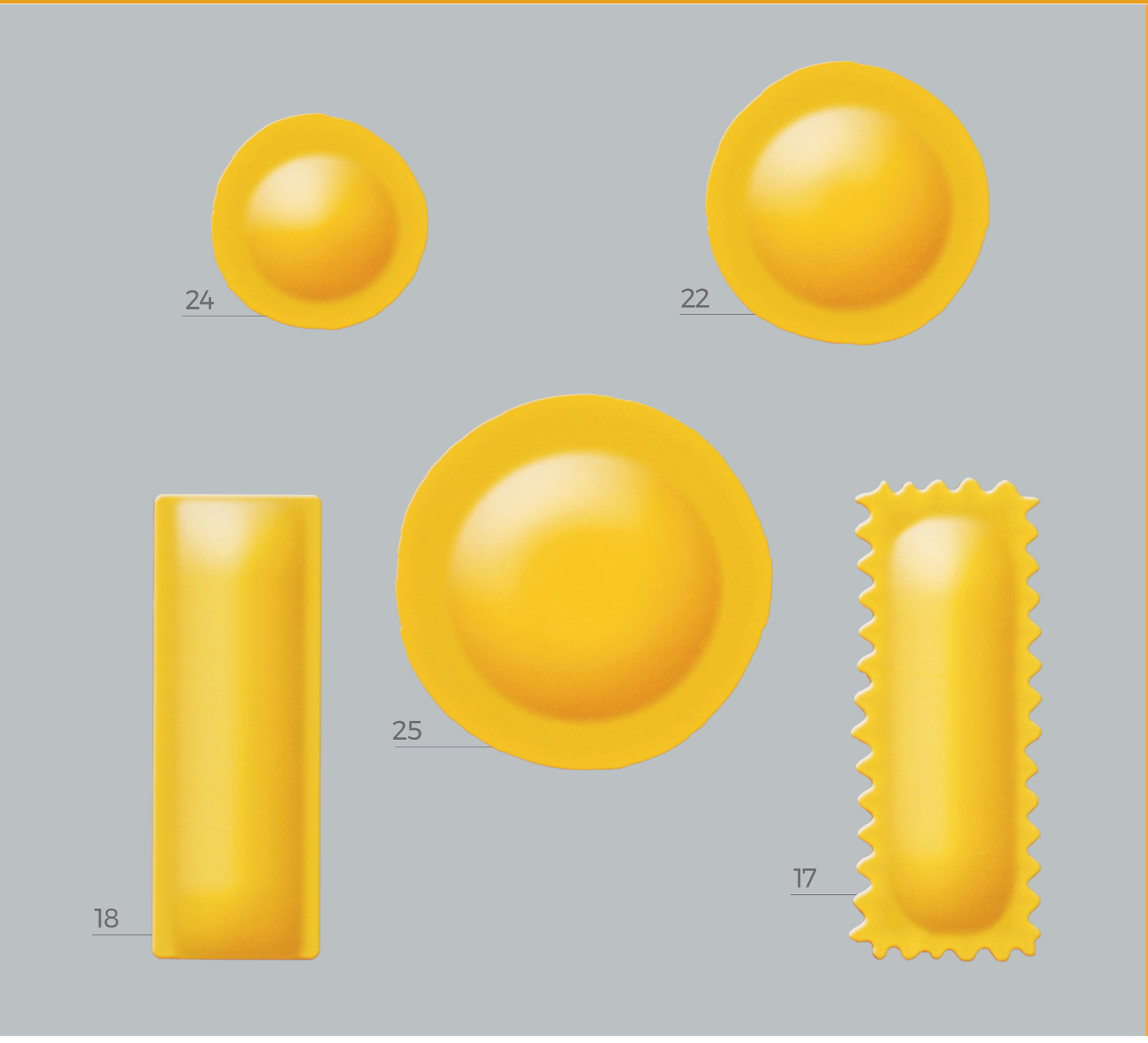
Weight, dimensions and output are indicative and may vary with the dough sheet thickness and the dough-to-filling ratio.

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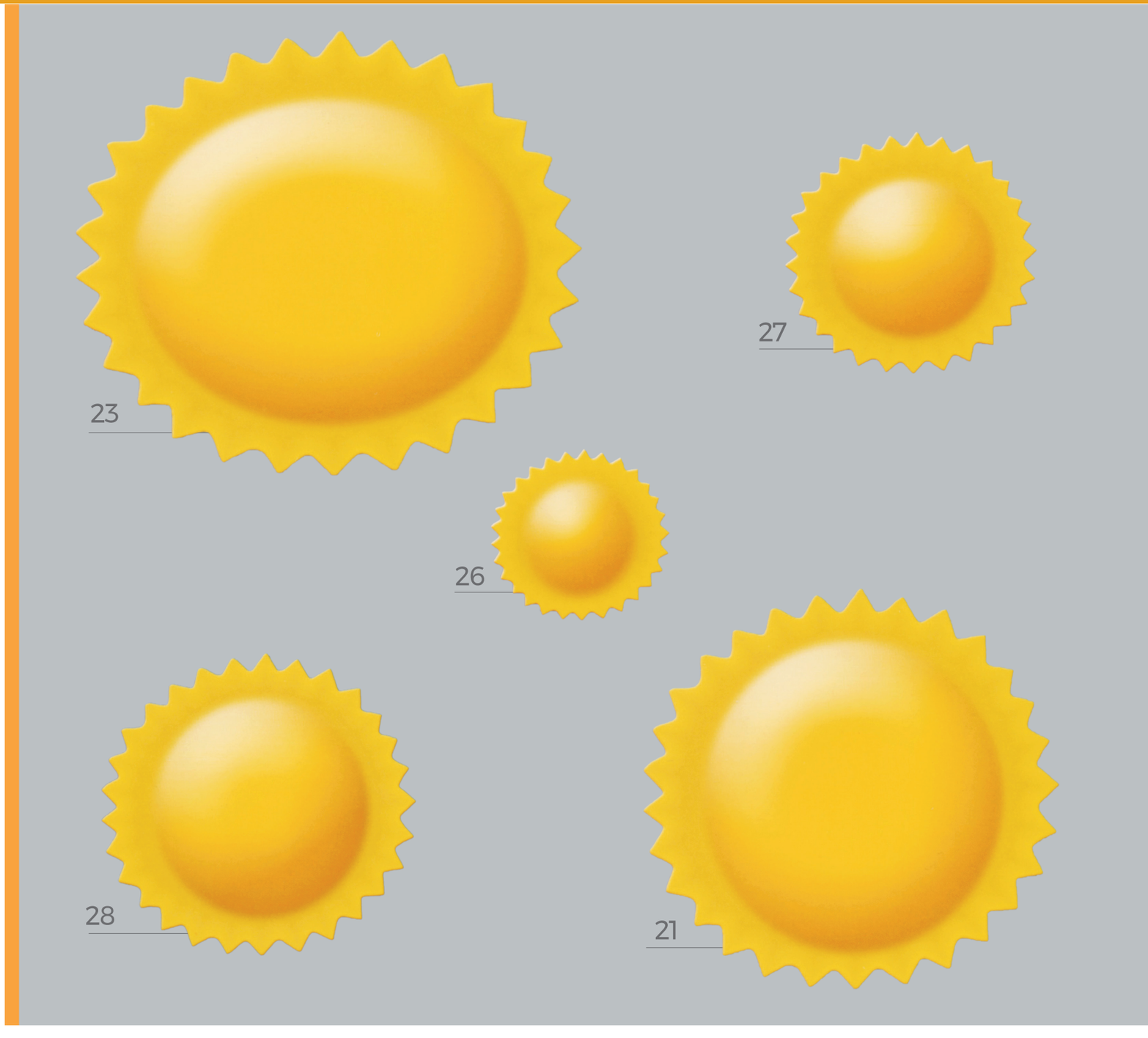
FORMATO *FORMAT*	PESO gr *WEIGHT gr*
17	16
18	16
22	46
24	8
25	28

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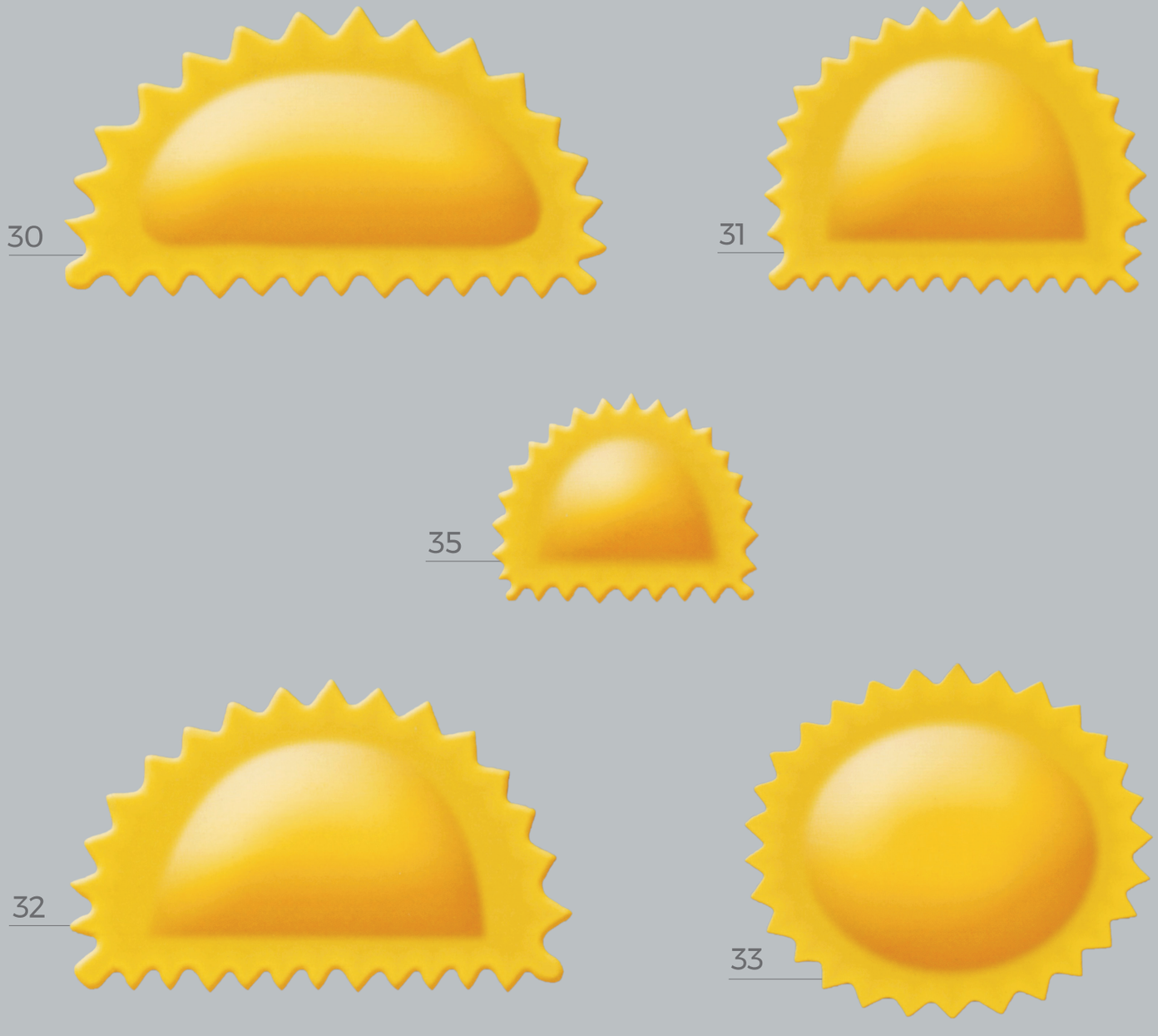
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FORMATO *FORMAT*	PESO gr *WEIGHT gr*
21	32
23	50
26	5
27	12
28	18



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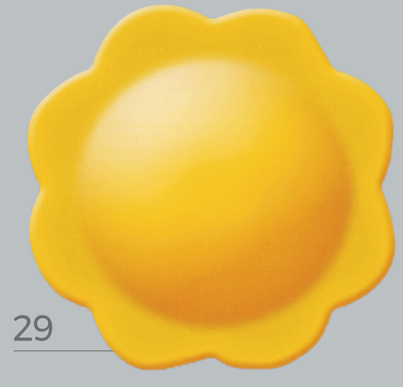
FORMATO *FORMAT*	PESO gr *WEIGHT gr*
30	25
31	20
32	25
33	23
35	8

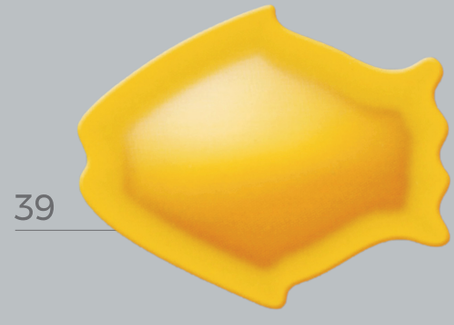
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FORMATO *FORMAT*	PESO gr *WEIGHT gr*
19	13
29	16
39	12
40	14

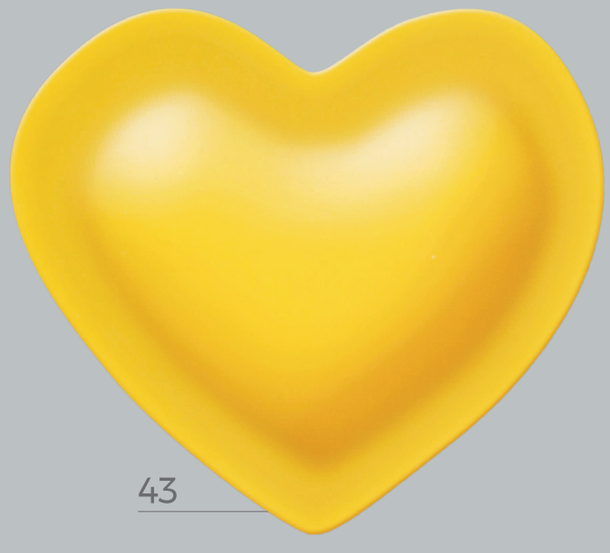

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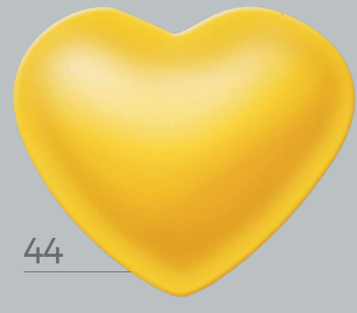

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43


44


48


50

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

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