tel. +38 044 225 93 72 · +38 067 566 0 566
kyuri@ec-cibo.kiev.ua · www.ect.kiev.ua
27 Vadyma Hetmana St., Kyiv, 03056, Ukraine

AL.MA. RSA540 multi-station ravioli and varenyky line with a continuous dough mixer

AL.MA. Srl (Italy) · 4-station configuration · up to 2800 kg/h · double-sheet dough products

Operating principle

The continuous dough mixer prepares dough without interruption and discharges it into the shuttle hopper. The shuttle travels above the line and distributes dough between the stations. Each station consists of a sheeter, a forming machine, a lobe pump for filling supply and a scrap cutter; the stations work in parallel and independently of one another.

A two-tier conveyor runs along the line. Formed products with filling drop onto the upper belt and travel towards the blast freezing tunnel. Trimmings of unused dough sheet, cut up by the scrap cutters, drop onto the lower belt and travel in the opposite direction — to the conveyor returning scrap to the dough mixer. The dough sheet goes back into production, so the line runs with virtually no raw material loss.

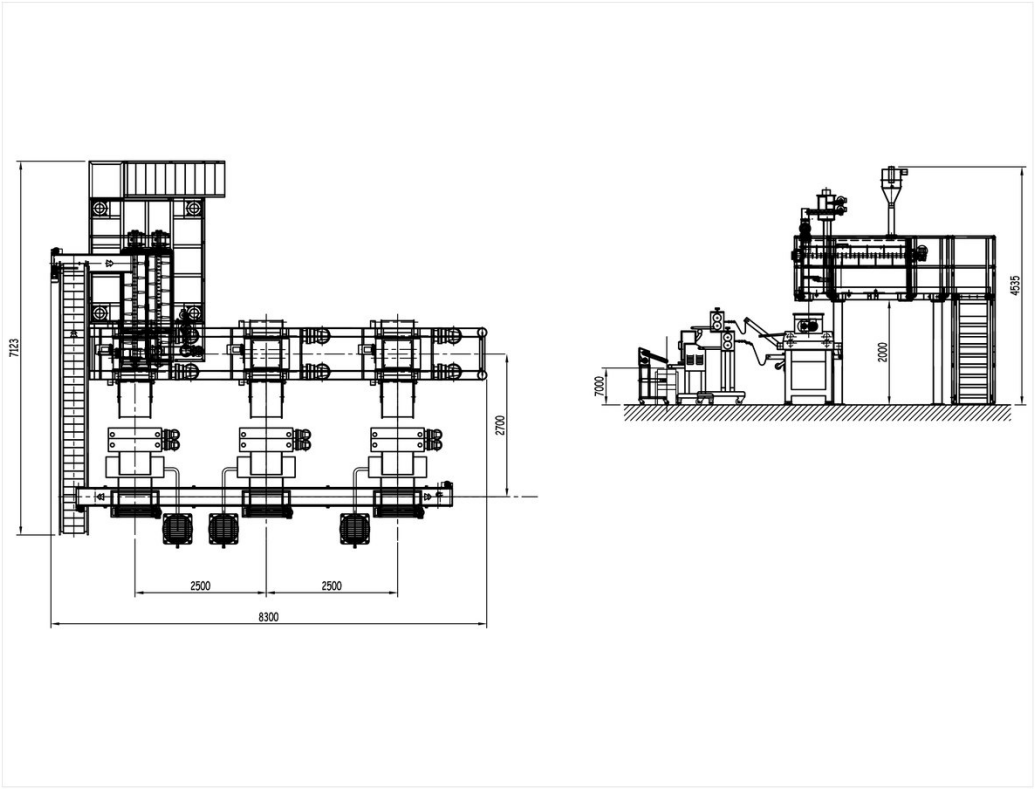
Scaling and maintenance

• the line can have from 3 to 5 stations; output grows in proportion to their number;

• the system can be ordered for the full number of stations while being equipped with machines only in part — for example, four stations with two equipment sets. Unused stations are switched off from the control panel;

• when output needs to grow, machines are purchased and installed on the free stations — the line does not need rebuilding;

• any station can be stopped for scheduled maintenance without stopping the line: the remaining stations keep running.



Line layout example — three-station version, dimensions in mm

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Line composition in the 4-station configuration

Item	Qty
GR.IM.2000 continuous dough mixer with TURBOMIX	1
NAV-4 shuttle dough distribution system for 4 stations	1
CA540FDA double-sheet sheeter	4
RSA540 forming machine with vacuum pump	4
PLA100-A lobe pump for filling supply	4
Scrap cutter for the RSA540	4
Two-tier conveyor, 10 m	1
Scrap return system to the dough mixer	1
Dies	one per forming machine, shape chosen by the customer

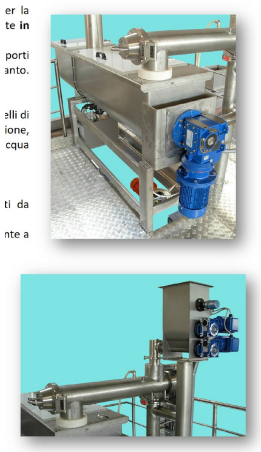
The equipment is made of AISI 304 stainless steel and other non-toxic materials suitable for the food industry and complies with current CE standards. The blast freezing tunnel that receives the finished product is supplied at the customer’s request — see the Blast freezing section.

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GR.IM.2000 continuous dough mixer

A continuous dough preparation unit made entirely of AISI 304 stainless steel. It serves all stations of the line.





GR.IM.2000 continuous dough mixer — photos by the manufacturer AL.MA. Srl

• tubular base frame on four removable supports, access ladder, side guards, chequered anti-slip decking;

• group of mixing bowls in polished stainless steel, PTFE shaft seals with quick removal, drain hole with a plug for washing water;

• AISI 304 stainless steel mixing shafts with independent geared motors; through-type stirrers with a conical seat and adjustable position;

• volumetric doser — continuous screw semolina doser with variable speed under inverter control, transparent feed spout, maximum and minimum level sensors;

• peristaltic pump for liquids with variable speed under inverter control;

• TURBOMIX — rapid pre-mixing system under inverter control, the bladed shaft is removable for sanitary cleaning;

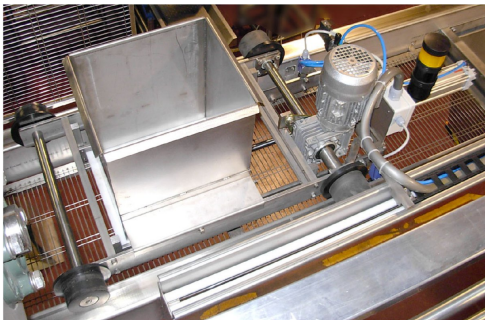
• electropneumatic discharge, safety top cover, stainless steel electrical cabinet to CE standards.

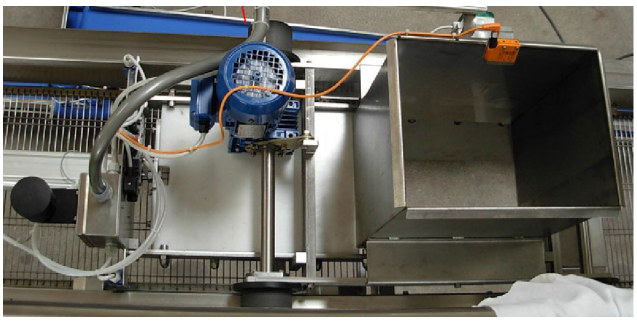
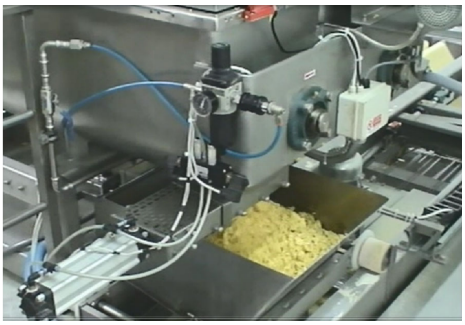
Parameter	Value
Output	up to 2000 kg/h
Flour feed	up to 1600 kg/h
Liquid feed	up to 500 kg/h
Mixing shaft speed	up to 50 rpm
Absorbed electrical power	14 kW

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NAV-4 shuttle dough distribution system

A system for automatic dough distribution between four sheeters. The trolley travels on a rail track above the line and discharges dough at the required station.



NAV-4 shuttle system — photos by the manufacturer AL.MA. Srl

• stainless steel construction, tubular base frame and guides, removable supports;
• hoppers for connection to the machines of the line;
• distribution trolley with a stainless steel product container; containers on quick clamps for washing;
• motorised trolley drive with a motovariator under inverter control;
• electropneumatic product discharge;
• operation is programmed and performed automatically; stainless steel electrical cabinet to CE standards.

Parameter	Value
Number of stations	4
Pitch between discharge stations	2500 mm
Discharge height	2200 mm (to be confirmed at order)

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Station equipment

Each of the four stations has the same equipment: a sheeter, a forming machine, a filling pump and a scrap cutter.

CA540FDA double-sheet sheeter





CA540FDA sheeter and its sheeting group — photos by the manufacturer AL.MA. Srl

Parameter	Value
Dough sheet width	2 × 540 mm
Dimensions, H×W×D	1880 × 1950 × 1880 mm
Weight	2720 kg
Installed power	13 kW

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RSA540 forming machine



RSA540 forming machine — photo by the manufacturer AL.MA. Srl

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 with the machine, shape chosen by the customer

Two independent sheeting groups with adjustable thickness, a calibrating group, quick die change, filling quantity adjustment and a vacuum pump.

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PLA100-A lobe pump



PLA100-A lobe pump

Parameter	Value
Dimensions, H×W×D	1685 × 760 × 720 mm
Lobe height	110 mm
Weight	200 kg
Installed power	1.5 kW

The pump feeds filling continuously and handles meat, cheese and vegetable fillings, including delicate ones containing pieces. Tilting cover with a safety grid, screw removable without tools.

Scrap cutter



Scrap cutter for the RSA540

The cutter cuts up unused dough sheet: cutting group with stainless steel rollers, drive speed proportional to the laminator speed, belt transferring scrap to the lower conveyor tier.

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Two-tier conveyor



Two-tier conveyor — photo by the manufacturer AL.MA. Srl

Parameter	Value
Upper belt	length 10,000 mm · width 300 mm · modular belt · finished product transport
Lower belt	length 10,000 mm · width 300 mm · modular belt · cut-up scrap transport

The tiers run towards each other: the finished product goes to the blast freezing tunnel, the scrap to the return system.

Scrap return system



Scrap return system — photo by the manufacturer AL.MA. Srl

A belt elevator conveyor loading the continuous dough mixer: construction entirely of stainless steel, food-grade belt, independent variator drive.

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General specifications

Parameter	Value
Configuration	4 stations
Line output	up to 2800 kg/h (4 × 700 kg/h)
Dough mixer output	up to 2000 kg/h
Dough sheet width	540 mm (sheeters 2 × 540 mm)
Station pitch	2500 mm
Possible configurations	from 3 to 5 stations; partial equipping with later expansion
Power supply	380 V / 3 ph + N + E / 50 Hz
Materials	AISI 304 stainless steel, food-grade certified belts
Conformity	CE standards

The total installed power of the main equipment in the 4-station configuration is approximately 106 kW (dough mixer, four sheeters, four forming machines and four pumps). The power of the shuttle, conveyors and scrap cutters is confirmed at order.

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 number of stations, the equipment set and product shapes are selected to order.

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Appendix. Catalogue of double-sheet dough product shapes

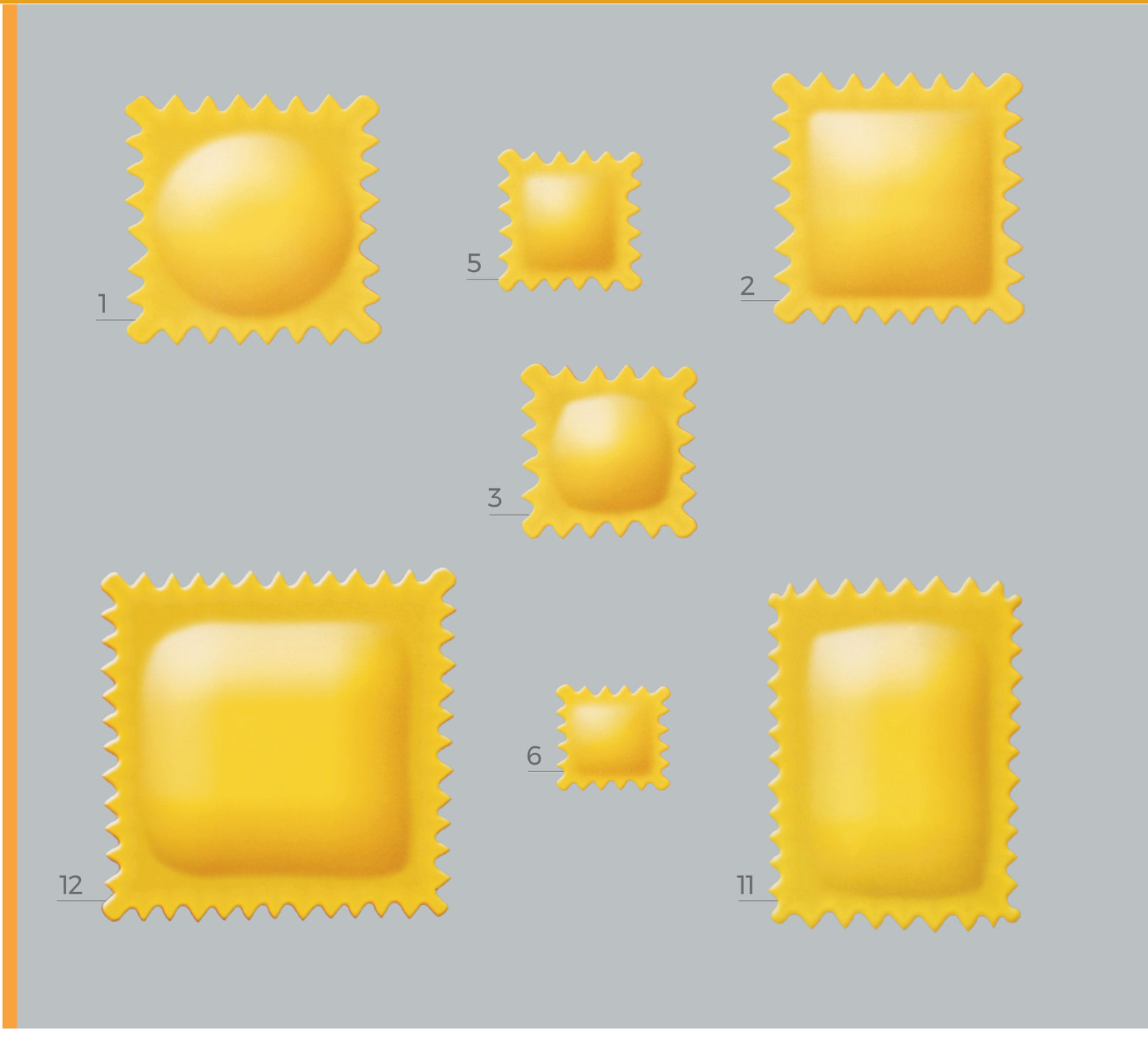
AL.MA. Srl catalogue · die formats for the RSA540

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

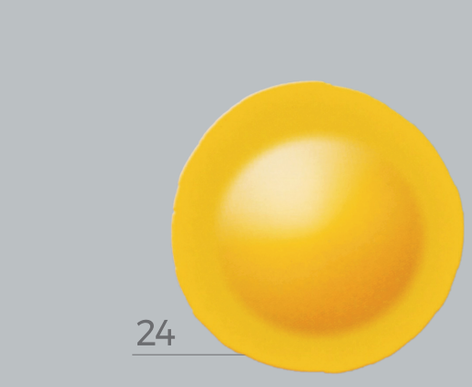
Weight, dimensions and output are indicative and may vary with the dough sheet thickness and the dough-to-filling ratio.

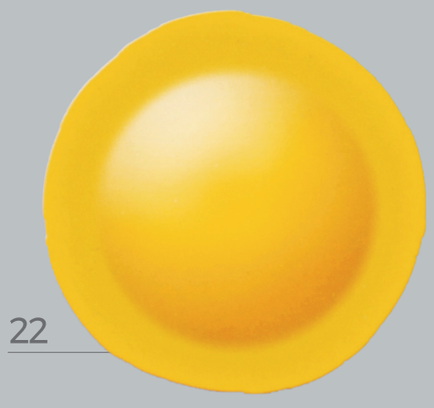
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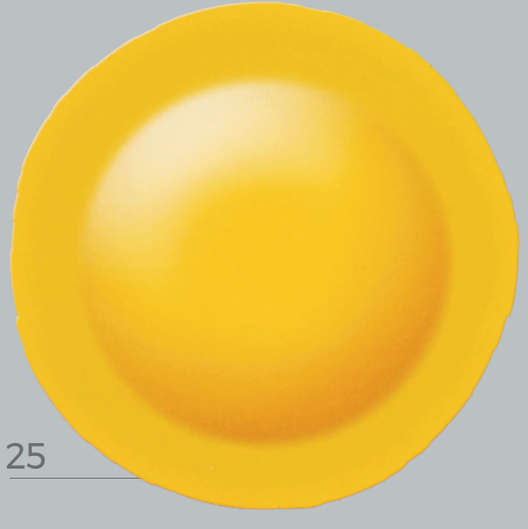
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2	14
3	7
5	3,5
6	2,5
11	17
12	*21*



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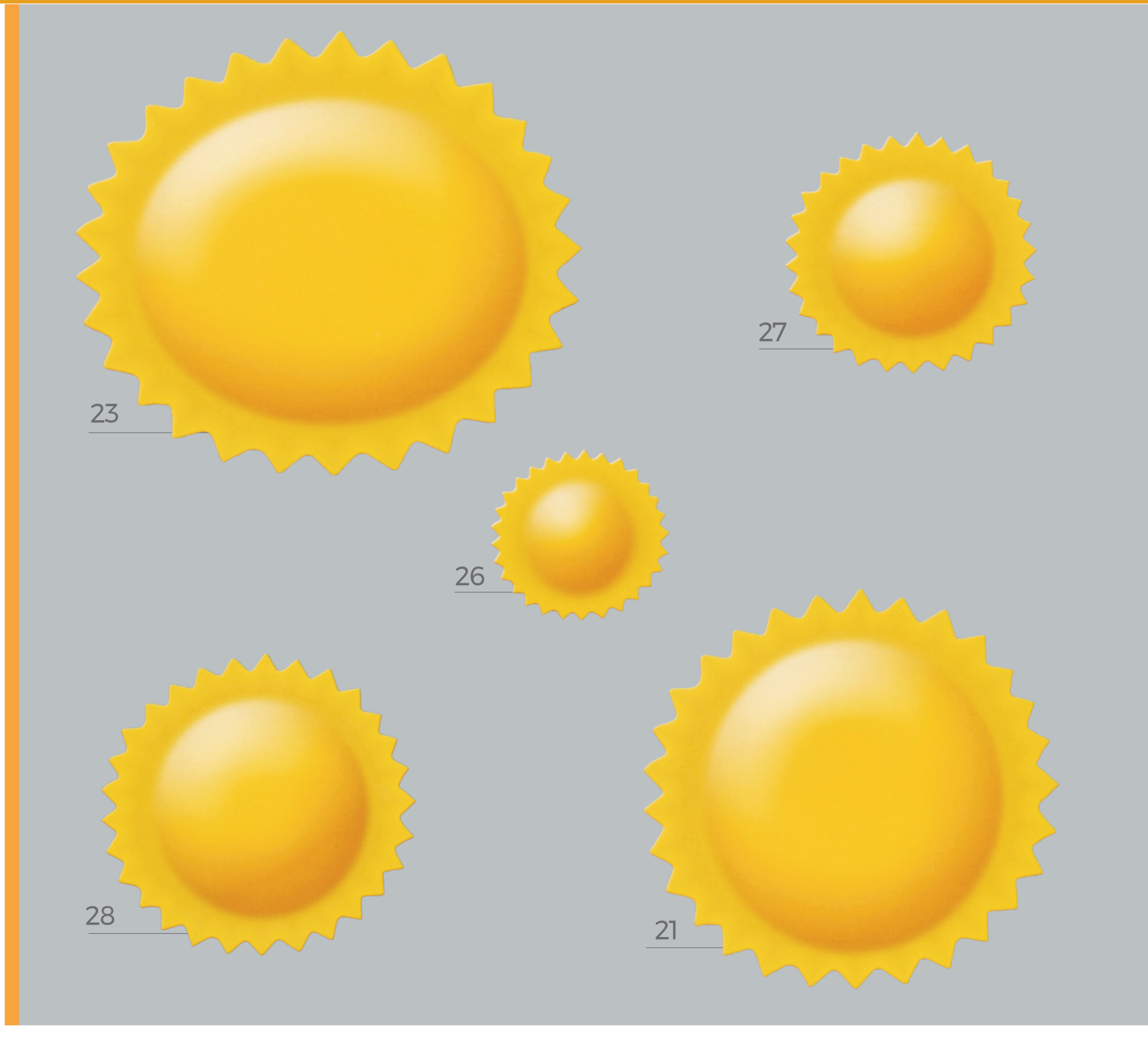
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18	16
22	46
24	8
25	28

REALIZZIAMO STAMPI CON FORMATI PERSONALIZZATI

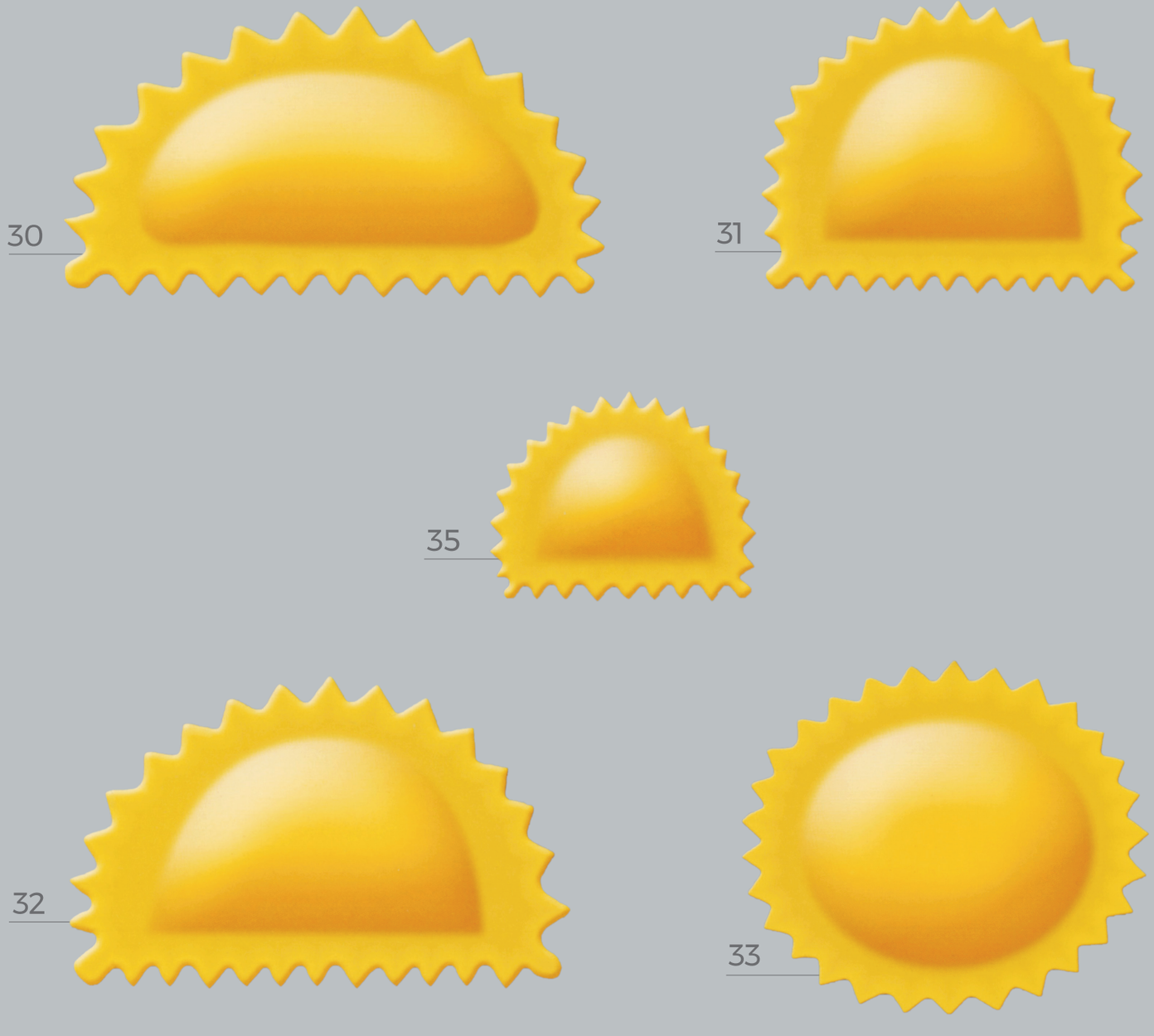
TAYLOR-MADE SHAPES ON REQUEST

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



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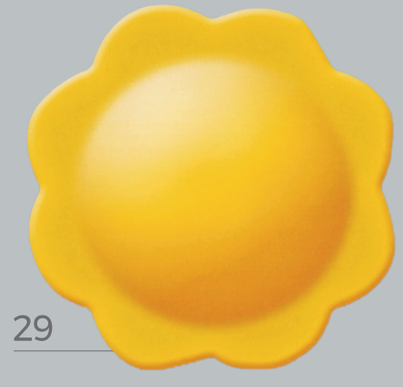
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32	25
33	23
35	8

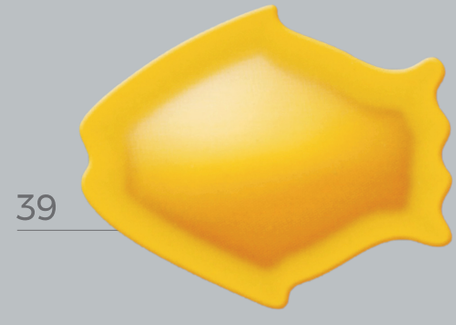
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29	16
39	12
40	14

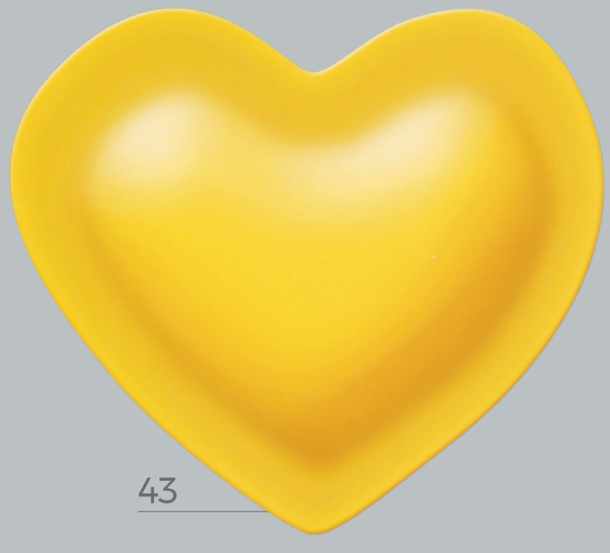

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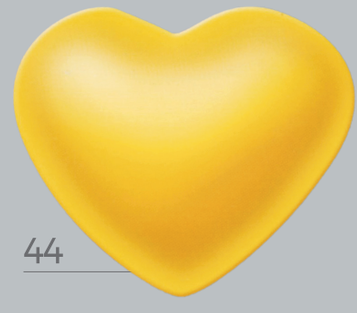

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50

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

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