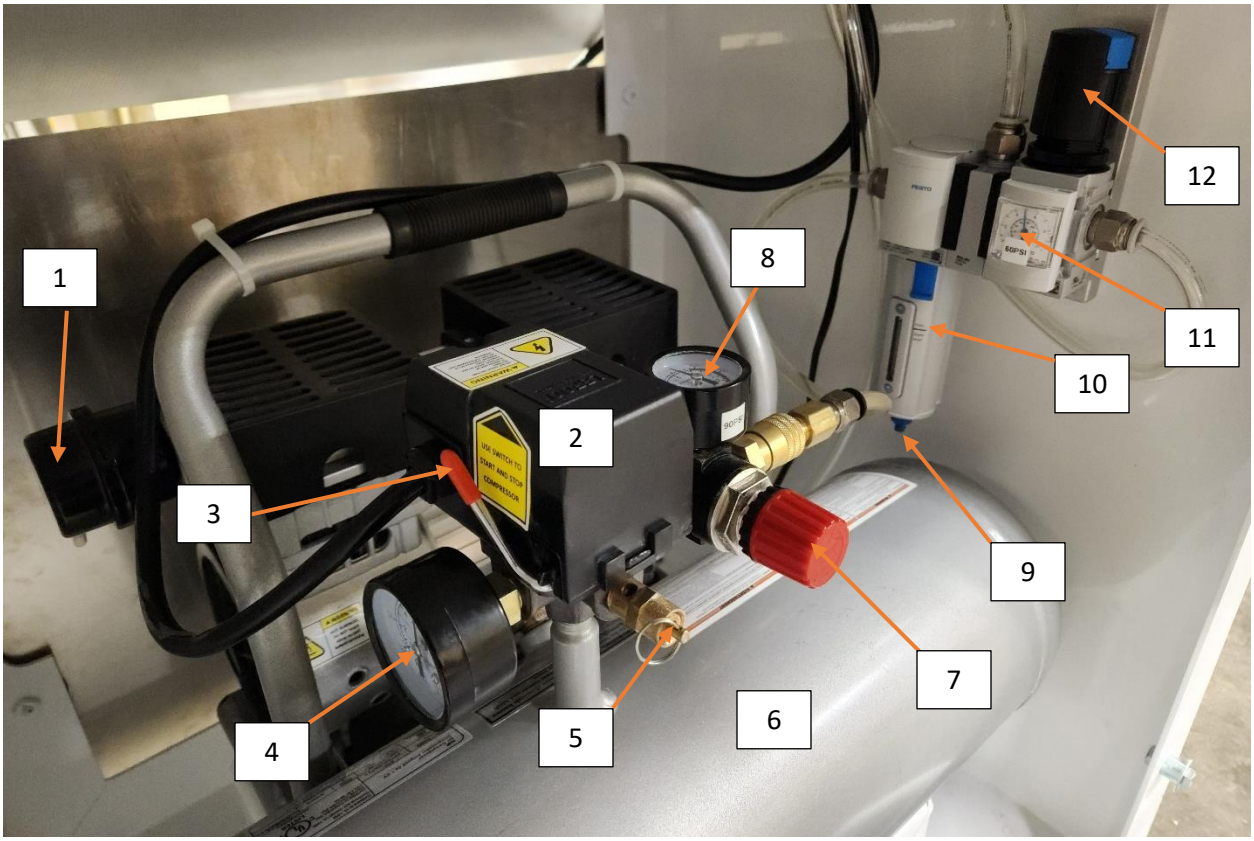
# Compressed Air Devices

The DD104 Dough processor is powered by a single 120 VAC plug. A self-contained air compressor is mounted in the bottom cabinet that runs off of a controlled outlet inside. The cut in pressure is 90 PSI and cut out is 120 PSI, which is measured from the tank pressure.



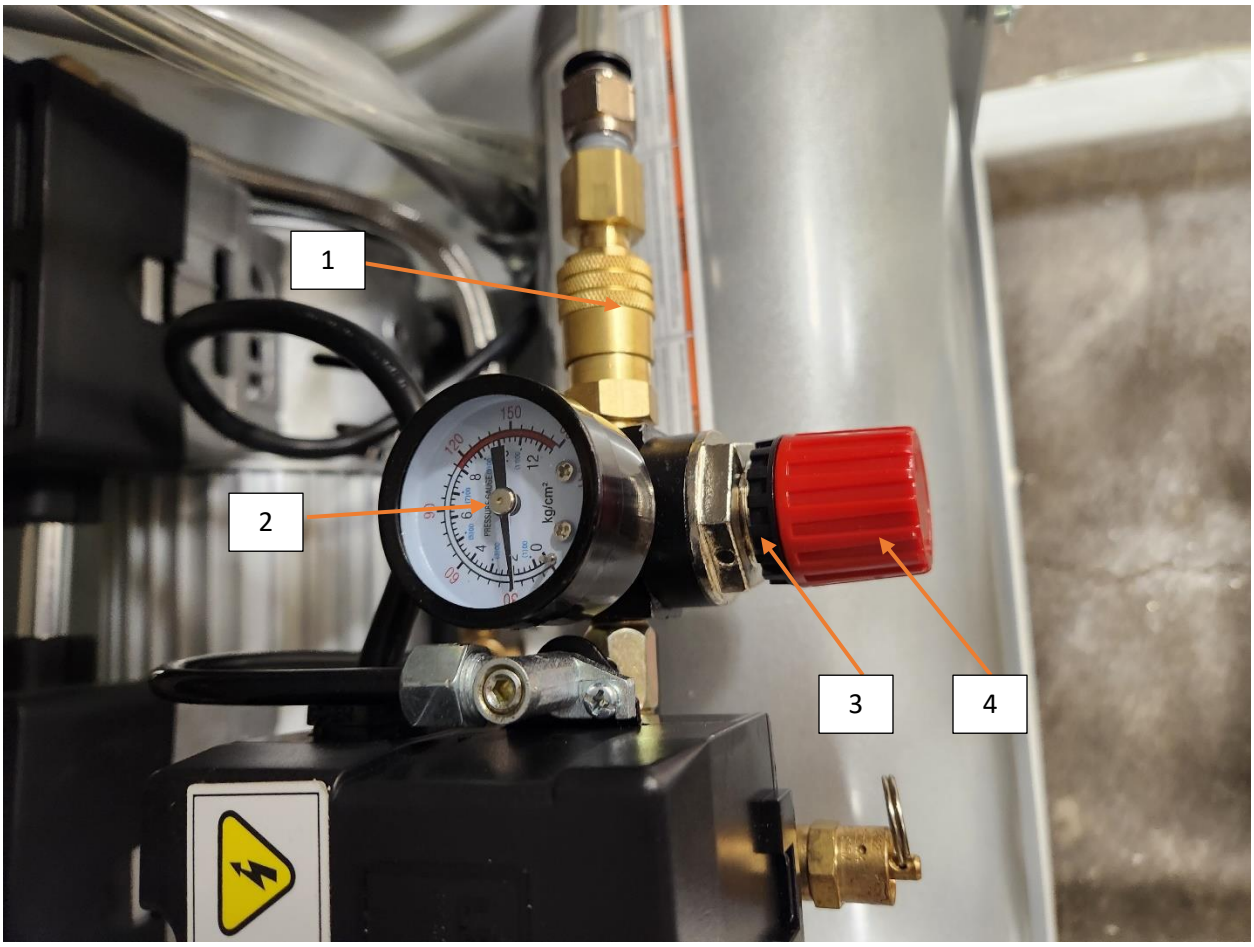

## Air Compressor

1. Intake Filter
2. Pressure Switch
3. Pressure Switch On/Off Lever
4. Tank Pressure Gauge
5. Safe Pressure Relief
6. Compressed Air Tank
7. System Pressure Adjustment Knob
8. System Pressure Gauge

## Air Filter

9. Filter Drain Valve
10. Compressed Air filter
11. Secondary Pressure Gauge
12. 12-Secondary Pressure Adjustment Knob

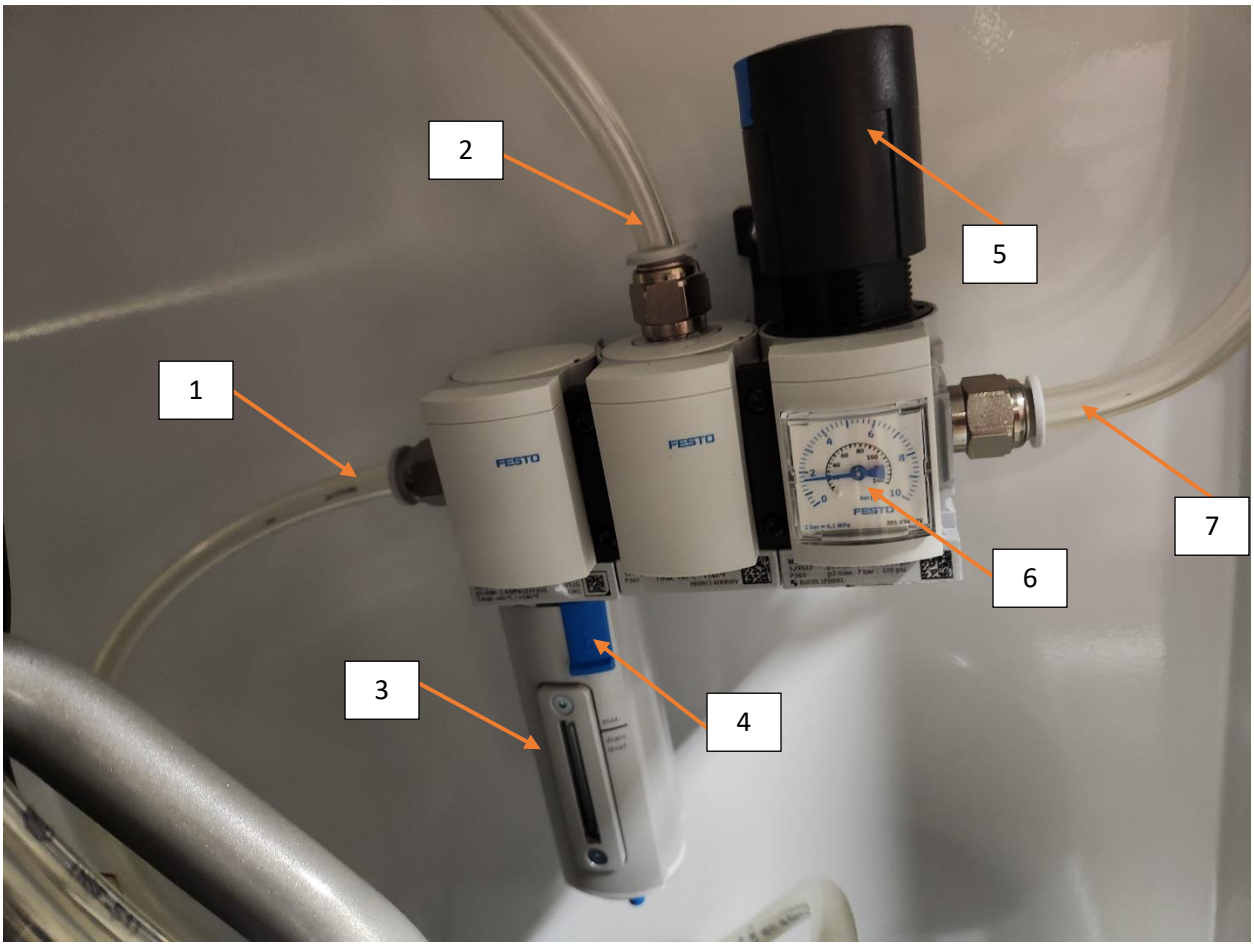
The compressed air from the compressor is metered down to a consistent 90 PSI by the Compressor Regulator. This is the System Pressure, and it feeds into a compressed air filter, and then into the pilot operated blowout valve and secondary pressure regulator for other system controls.




## System Pressure Regulator

1. Quick Disconnect
2. System Pressure Gauge
3. Lock Nut
4. Adjustment Knob

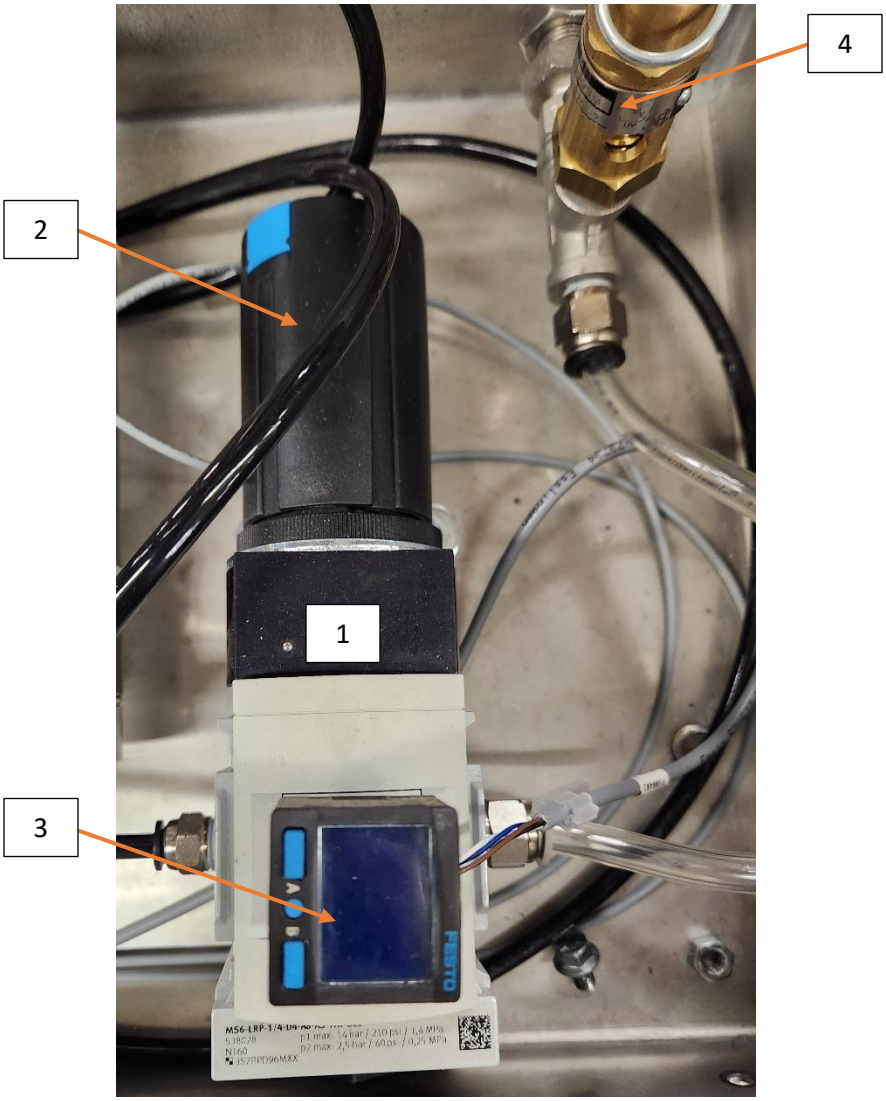
The secondary pressure regulator lowers the air pressure to 60 PSI. This is the pressure the feeds into the valve manifold to operate the air cylinders, piloted valves, hopper via hopper pressure regulator and oil pump on applicable models.




## Secondary Pressure Unit

1. Pressure In Line
2. Blowout Line
3. Compressed Air Filter
4. Release Switch
5. Adjustment Knob
6. Secondary Pressure Gauge
7. Pressure Out Line

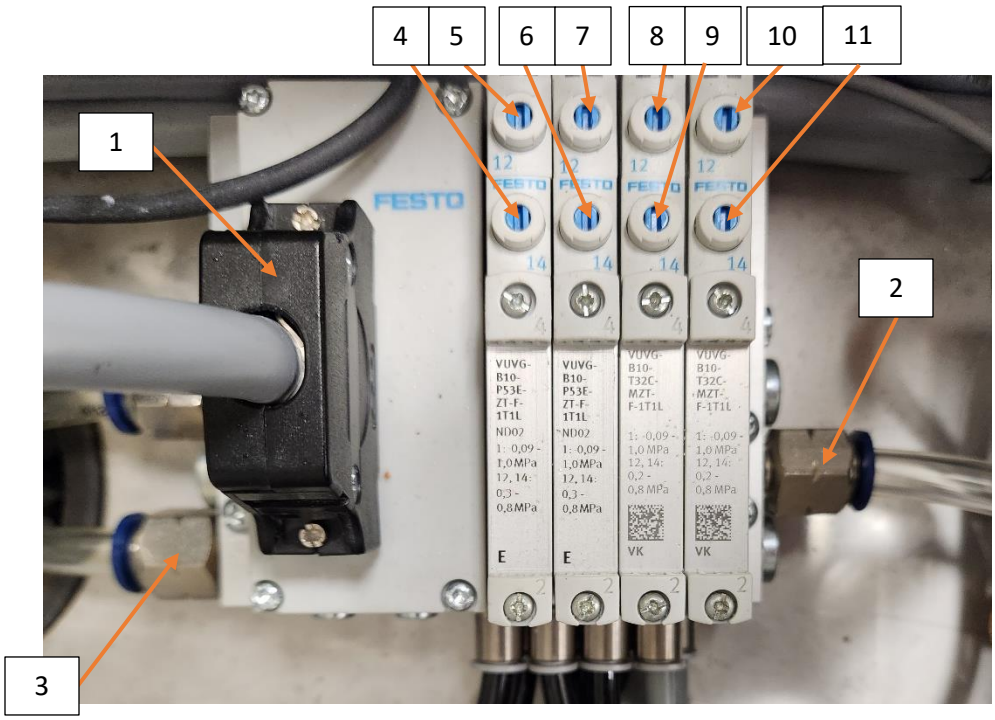
Hopper pressure regulator controls the pressure to the hopper it should be set to 12 PSI. This is also where the pressure feedback for the system is read. Hopper pressure valve must be active to feed pressure to this regulator. The outlet will freely flow out to the lid connection, close the bottom of the hopper with a plug or dough and latch the lid before adjusting regulator. Allow time for the pressure to stabilize when adjusting, if there is an air leak the pressure will not build to the correct level.




## Hopper Pressure Regulator

1. Hopper Pressure Regulator
2. Adjustment Knob
3. Pressure Sensor
4. ASME Safe Pressure Relief

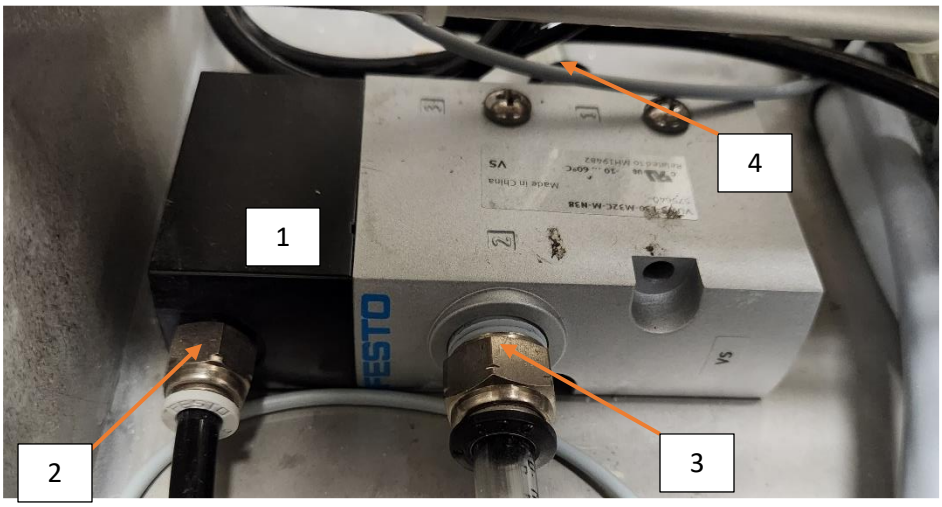
Valve manifold receives signals from the controller and redirects the inlet pressure out of the ports at the bottom of the manifold. The blue buttons on the front face are physical bypass switches. Pressing them will cause the valves to move, redirecting air pressure. This can cause unexpected motion of the equipment, do not operate without proper training, guarding installed and all body parts outside of the equipment. The buttons can be rotated to lock them into the active position.




## Valve Stack

1. Control Cable
2. Inlet
3. Exhaust
4. Block Extend
5. Block Retract
6. Knife Extend
7. Knife Retract
8. Blowout Pilot
9. Hopper Pressure
10. Spare
11. Oil Pump (Optional)

The Blowout Valve uses System Pressure (90 PSI) to eject the doughball from the dough pocket.




## Blowout Valve

1. Piloted Valve
2. Pilot Inlet
3. High Pressure Inlet
4. Outlet