DEPARTMENT OF THE ARMY TECHNICAL MANUAL

FIELD AND DEPOT MAINTENANCE MANUAL
BAKERY PLANT, MOBILE
FSN 7360-221-2418

This copy is a reprint which includes current pages from Changes 2 through 4.

HEADQUARTERS, DEPARTMENT OF THE ARMY
OCTOBER 1961

Change in force: C 2 through C 4

TM 10-7360-201-35
C4

Change
No. 4

HEADQUARTERS
DEPARTMENT OF THE ARMY
WASHINGTON, DC, 14 May 1976

Direct Support, General Support, and Depot Maintenance Manual

BAKERY PLANT, TRAILER MOUNTED, FIELD;
16,000-LB. CAPACITY OUTPUT PER 24-HR; MODELS M-1945,
M-194550, M-1945-53, M-534-68, NSN 7360-00-221-2418

CONSISTING OF:

SIFTER MACHINE, FLOUR; ELECTRIC; AGITATOR-TYPE, 110 V,
AC, 60 HZ; 55-LB PER MINUTE
(ALLIS-CHALMERS MODEL, ARMY MODEL SPE-20) NSN 73200-221-2386
(ARMSTRONG PRODUCTS MODEL 42386) NSN 7320-04

DOUGH MIXING AND MAKEUP OUTFIT; TRAILER MOUNTED
(CENTURY MACHINE MODEL, ARMY MODEL SPV-18) NSN 7320-00-255-7769
(CENTURY MACHINE MODEL TR306, ARMY MODEL SPV4-) NSN 7320-00215256
(BAKER-PERKINS MODEL TM-BP48) NSN 7320880-8745
(CAM INDUSTRIES MODEL M534-1) NSN 73200033415326

CABINET, DOUGH PROOFING; 36-PAN CAPACITY; ELECTRICALLY HEATED;
220 V, AC, 60 HZ
(DRYING SYSTEMS MODEL 1950, ARMY MODEL SPE-23) NSN 7320-00298-1380
(GREEN AND SONS MODEL 1954, ARMY MODEL SPE-30) NSN 7320-0215-5189
(WASHINGTON INDUSTRIAL PRODUCTS, INC. MODEL 8848) NSN 732000815-2682
(CAM INDUSTRIES MODEL C-PB30623) NSN 7320936632
(CAM INDUSTRIES MODEL C-PB30623) NSN 732000-38 4760

BAKERY OVEN, TRAILER MOUNTED; 208 V TO 220 V, AC;. 60 HZ, 3-PHASE
(AMERICAN MACHINERY MODEL, ARMY MODEL SPV-26) NSN 731000-25 8059
(CENTURY MACHINE MODEL MO-311, ARMY MODEL SPV-31) NSN 7310-021260
(CAM INDUSTRIES MODEL 533-235) NSN 731003 540'

TM 107360-201-35, 9 October 1961, is changed as follows:

The title is changed to read as shown above.

Page 3, paragraph 1. Add the following NOTE before subparagraph a.

NOTE

All "Federal Stock Numbers" appearing in this publication should be corrected to the new "National Stock Numbers" before using. This can be done by inserting -O after the Federal stock class. For example, Federal Stock Number 6350-2882735 will be corrected to the following National Stock Number 8350-028-273& Wherever the words "Federal Stock Number" appears correct to read "National Stock Number."

Paragraph 1*a*(2), line 3. Add the following, "and NSN 7: 21M3345336".
Paragraph 1*a*(3), line 3. Add the following, "and NSN 7 2-328476 ".
Paragraph 1*b*, line 4. After TM -43103314, add the following, "and TM 5-4310-25215".
Paragraph 1*c* is rescinded.

Page *35*, appendix 1, paragraph *i.* Add the following:
TM 64310-256215 .....Air Compressor, Johnson Model 110 LAG; NSN 4310-0-631-5693; Air Reciprocating; Electric Driven; 2.7 CFM, 80 PSI.

By Order of the Secretary of the Army:

FRED C. WEYAND
General, United States Army
Chief of Staff

Official:

PAUL T. SMITH
Major General, United States Army
The Adjutant General

Distribution:
To be distributed in accordance with DA Form 12-25A, (qty rqr block No. 103) Direct and General Support maintenance requirements for Baking Equipment.

GPO 908-52I

Change in force: C 2

TM 10-7360-20135
***C 2**

Change
No. 2

HEADQUARTERS
DEPARTMENT OF THE ARMY
WASHINGTON, DC, 24 February 1966

DS, GS, and Depot Maintenance Manual
BAKERY PLANT, TRAILER-MOUNTED, M-1945
(FSN 7360-221-2418)

TM 10-7360-201-35, 9 October 1961, is changed as follows:

Tittle is changed to read as shown above, and in addition, wherever "Bakery Plant, Mobile" appears throughout the manual it is changed to read: Bakery Plant, Trailer-Mounted. Add "(SPV2G and SPV31)" immediately after the title in figures 14 and 15.

1. Scope

a. (Superseded) These instructions are published for the use of personnel responsible for direct and general support and depot maintenance of the M-1945 Trailer-Mounted Bakery Plant (FSN 7360-221-2418). Listed below are the number, name, and Federal stock number of each of the components that comprise the M-1945 trailer-mounted bakery plant.

(1) Three trailer-mounted bakery ovens (FSN 7310-215-5260, FSN 7310-255-8068, and FSN 7310-903-5402). The bakery ovens can be all of one model or any combination of the three models.

(2) One Trailer-Mounted Dough Mixing and Makeup Outfit (FSN 7320-255-7769 and FSN 7320-215-5256). Either model is used.

(3) Three Dough-Proofing Cabinets (FSN 7320-215-5189, FSN 7320-298-1380, and FSN 7320-815-2682). The dough-proofing cabinets can be all of one model or any combination of the three models.

(4) One Electric Flour Sifting Machine (FSN 7320-221-2386).

(5) Two Generator Sets (FSN 6115-376-7006, FSN 6115-312-7865, FSN 6115-635-8143, and FSN 6115-538-8726) and the accessories. The generator sets can be both of one model or any combination of two out of the four models.

c. (Added) The direct reporting by the individual user, of errors, omissions, and recommendations for improving this manual is authorized and encouraged. DA Form 2028 (Recommended Changes to DA Publications) will be used for reporting these improvements. This form will be completed using pencil, pen, or typewriter and forwarded direct to Commanding General, U.S. Army Mobility Equipment Center, ATTN: SMOME-MPD, 4300 Goodfellow Boulevard, St. Louis, Mo., 63120.

d. (Added) Report all equipment improvement recommendations as prescribed by TM 38-750.

2. References

a. (Superseded) The appendix contains a list of current references.

3. Maintenance Forms and Records (Superseded)

The maintenance forms and records which are to be used by the field and depot maintenance personnel in the maintenance of the M-1945 trailer-mounted bakery plant are listed and described in TM 38-750.

37. Temperature Control

a.1. (Added) Removal (M533 Bakery Oven).

(1) Disconnect electrical power to oven unit.

(2) Loosen temperature setting adjusting knob setscrew, and remove the temperature setting adjusting knob (7, fig. 14.1) from temperature control (4).

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*ThIs change supersedes C 1, 26 April 1962.
TAGO 1398A---Mar. 20O-473'--6

(3) Remove control box cover capscrews (3) that secure control box cover (9) to temperature control box, and remove cover from control box.

(4) Remove capscrews that secure scale plate (2) to control box.

(5) Using temperature setting adjusting knob, set temperature setting pointer (1) to same position as temperature indicating pointer (8), and slide scale plate from control box.

(6) Disconnect, and tag electrical wires of temperature control.

(7) Remove capscrews that secure element flange (5) to control case, and remove temperature control element (6) and element flange from control case.

(8) Remove capscrews that secure control head to oven, and remove control head from oven.

*c*1. (Added) *Installation (M533 Bakery Oven).* Reverse procedures in a.1 above.

37.1. Temperature Control Element (Added)

a. Removal.

(1) Disconnect electrical power to oven unit.

(2) Remove capscrews that secure element flange (5, fig. 14.1) to control case, and remove element (6) and element flange from control case.

(3) Remove capscrews that secure element guard to side of storage compartment, and remove guard.

(4) Unscrew threaded collar (3, fig. 15.1) that secures split connector gland (4) and element (1) to heater duct tube (2), and remove split connector gland from element.

(5) Remove element bulb from heater duct tube, and remove threaded collar from element.

(6) Remove element and bulb from oven trailer, being careful not to form sharp bends in element or to puncture bulb.

(7) Unscrew and remove element flange from element.

b. Installation. Reverse procedures in a above.

Caution. Be careful not to form sharp bends in element or puncture bulb.

38. Combustion Tunnel and Gaskets (Superseded)

a. Removal.

(1) Lift burner from burner head plate, and place burner in the storage compartment.

Warning. Make certain the burner has cooled completely before removing it for storage.

(2) Remove nut and washer that secures burner handle, and remove burner handle from burner head plate.

(3) Remove remaining nuts and washers from burner head plate, and lift off burner head plate.

(4) Remove burner head plate gasket.

(5) Withdraw combustion tunnel from oven as shown in figure 16.

(6) Remove combustion tunnel gasket.

b. Installation. Reverse procedures in a above using new gaskets.

38.1 Heat Exchanger Tubes (M533 Bakery Oven) (Added)

a. Removal.

(1) Open cleanout doors, and remove retainer straps.

(2) Remove insulation pillows.

(3) Unscrew and remove thimble covers from heat exchanger tubes.

(4) Loosen covers retaining screws, and remove the cleanout covers from the inlet header.

b. Inspection. Inspect heat exchanger tubes for broken thimble covers and for warped cleanout covers. Inspect cleanout covers for stripped threads.

c. Repair. Replace broken thimble covers and warped cleanout covers. Rethread studs on cleanout covers that have stripped threads.

d. Installation. Reverse procedures in a above.

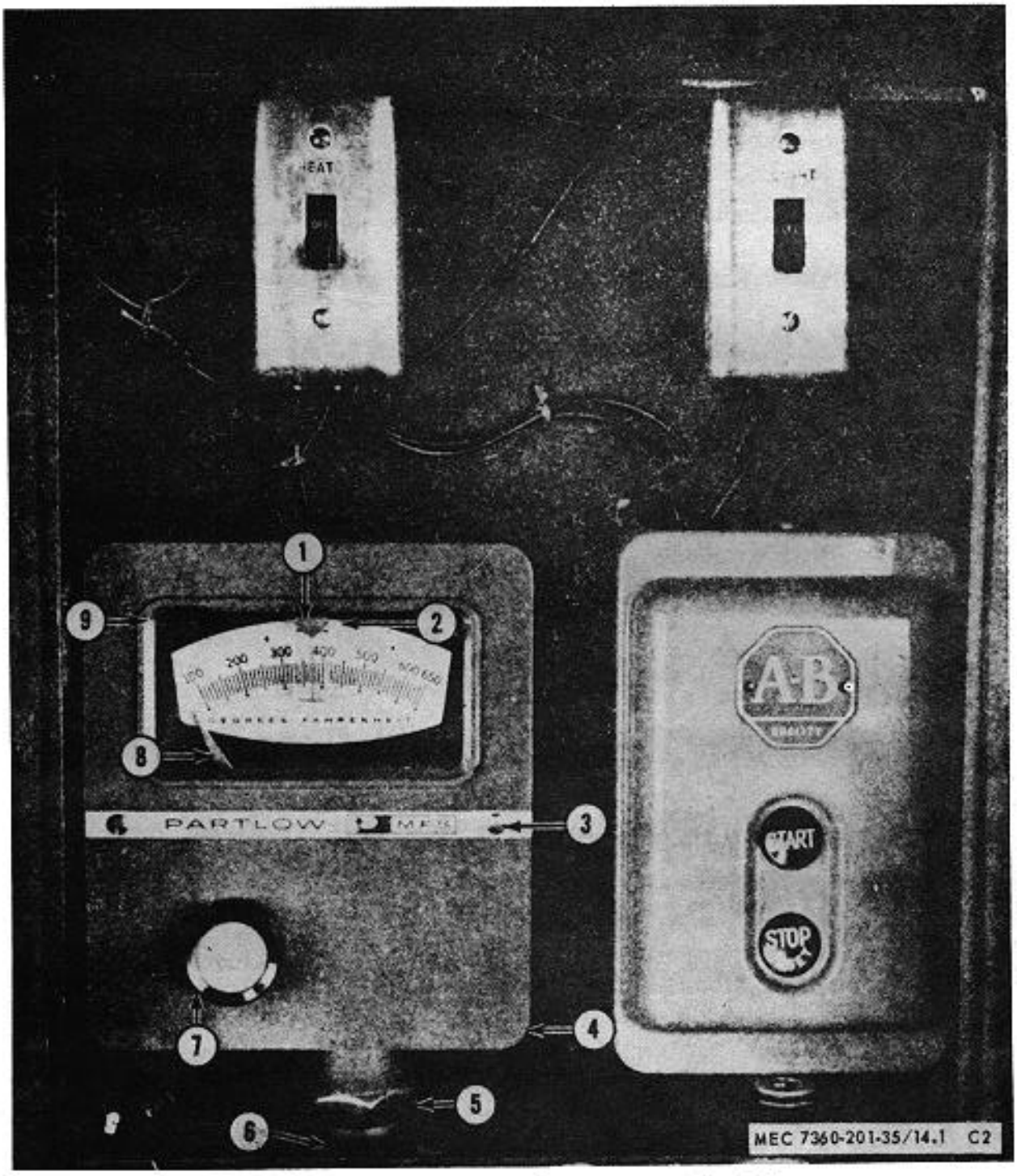
38.2 Insulation Pillows and Retainer Straps (M533 Bakery Oven) (Added)

a. Removal.

(1) Unscrew and remove hexagon nuts that secure retainer straps to bakery oven.

(2) Remove retainer straps.

(3) Remove insulation pillows.



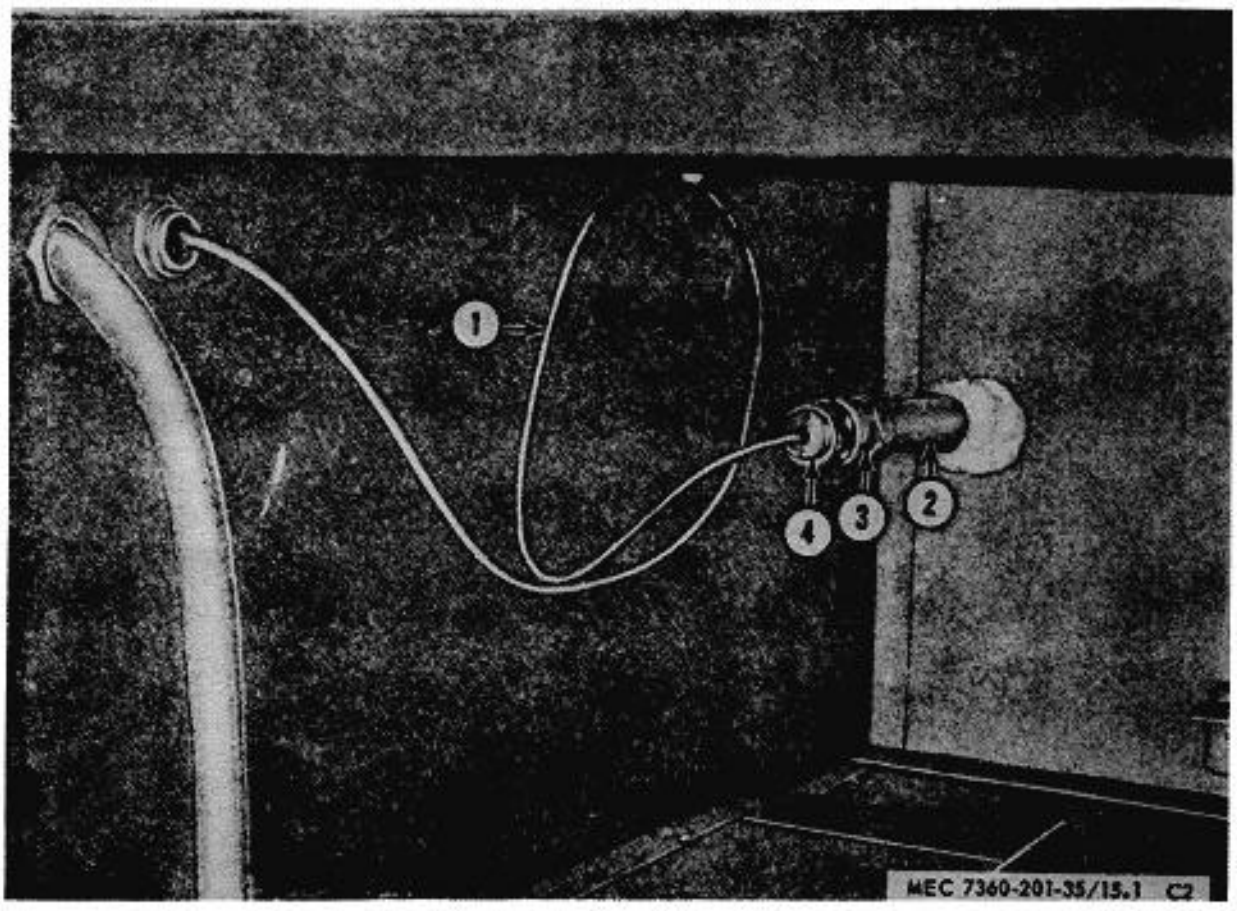
1	Pointer, setting, temperature	6	Element with bulb and sleeve
2	Plate, scale	7	Knob, adjusting, setting, temperature
3	Capscrews, cover, control box	8	Pointer, indicating, temperature
4	Control, temperature	9	Cover, box, control
5	Flange, element		

Figure 14.1 (Added) Temperature control mounted in oven control panel (M533 bakery oven).

b. Inspection. Inspect insulation pillows for torn asbestos fabric and loose or missing staples. Inspect for broken or bent retainer straps. Inspect retainer strap hexagon nuts for stripped threads.

c. Repair. Repair torn insulation pillow asbestos fabric and replace loose or missing staples. Straighten a bent retainer strap and replace a broken retainer strap. Replace hexagon nuts that have stripped threads.

d. Installation. Reverse procedures in *a* above.



1	Element with bulb and sleeve	3	Collar, threaded
2	Tube, duct, heater	4	Gland, connector, split

Figure 15.1 (Added) Temperature control element, installed in oven (M533 bakery oven).

APPENDIX
REFERENCES

TM 10-7360-201-10 (Changed)	Operator's Manual: Bakery Plant, Trailer-Mounted, M-1945 (FSN 7360-221-2418).
TM 10-7360-201-20 (Changed)	Organizational Maintenance Manual: Bakery Plant, Trailer-Mounted, M-1945 (FSN 7360-221-2418).
TM 10-7360-201-20P (Changed)	Organizational Maintenance Repair Parts and Special Tool Lists: Bakery Plant, Trailer-Mounted, M-1945 (FSN 7360-221-2418).
TM 10-7360-201-35P (Changed)	Field and Depot Maintenance Repair Parts and Special Tool Lists: Bakery Plant, Trailer-Mounted, M-1945 (FSN 7360-221-2418).
TM 38-750 (Added)	Army Equipment Record Procedures.

By Order of the Secretary of the Army:

HAROLD K. JOHNSON
General, United States Army,
Chief of Staff.

Official:

J. C. LAMBERT,
Major General, United States Army,
The Adjutant General.

Distribution:
Active Army:

USASA (1)	USASMC (1)	Army Dep (4)
DCSLOG (1)	ARADCOM (2)	POE (2)
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CC-E (1)	Armies (5)	Instl (2)
Dir of Trans (1)	NLABS (4)	QM Fld Maint Shops (2)
USCONARC (2)	DCTSC (10)	Comb Fld Maintenance Shops, Ft
USAMC (12)	USAMEG (46)	Knox (10)
USAMOCOM (2)	Svc Colleges (2)	Units organized under following
USAWECOM (5)	Br Svc Sch (2)	except USAQMIS TOE's (2 copies each)
USAMICOM (5)	(10)	10-105
USAMUCOM (5)	USAQMCENFL (4)	10-107
USAECOM (5)	USMA (1)	1045
USATECOM (5)	USACDCEC (10)	10448

NG: State AG (3).
USAR: Same as Active Army except allowance is one copy to each unit.
For explanation of abbreviations used see AR 320-50.

* U.S. GOVERNMENT PRINTING OFFICE : 1983 0 - 414-272

CHANGE
No. 3

HEADQUARTERS
DEPARTMENT OF THE ARMY
Washington, D. C., 9 September 1970

DS, GS, and Depot Maintenance Manual
BAKERY PLANT, TRAILER MOUNTED, FIELD;
16,000-LB CAPACITY OUTPUT PER 24 HR; MODELS M-1945,
M-1945-50, M-1945-53, M-534-68, FSN 7360-221-2418
CONSISTING OF:
SIFTER MACHINE, FLOUR; ELECTRIC; AGITATOR-TYPE; 110 V, AC, 60 HZ; 55 LB PER MINUTE (ALLIS-CHALMERS MODEL, ARMY MODEL SPE-20) FSN 7320-221-2386 (ARMSTRONG PRODUCTS MODEL 42386) FSN 7320-043-5340
DOUGH MIXING AND MAKEUP OUTFIT; TRAILER MOUNTED (CENTURY MACHINE MODEL, ARMY MODEL SPV-18) FSN 7320-255-7769 (CENTURY MACHINE MODEL TR306, ARMY MODEL SPV-30) FSN 7320-215-5256 (BAKER-PERKINS MODEL TM-BP-68, ARMY MODEL M-534-68) FSN 7320-880-8745
CABINET, DOUGH PROOFING; 36-PAN CAPACITY; ELECTRICALLY HEATED; 220V, AC, 60 HZ (DRYING SYSTEMS MODEL 1950, ARMY MODEL SPE-23) FSN 7320-298-1380 (GREEN AND SONS MODEL 1954, ARMY MODEL SPE-30) FSN 7320-215-5189 (WASHINGTON INDUSTRIAL PRODUCTS INC MODEL 8848) FSN 7320-815-2682 (CAM INDUSTRIES MODEL C-PB30623) FSN 7320-935-6632
BAKERY OVEN, TRAILER MOUNTED; 208 V TO 220 V, AC, 60 HZ, 3-PHASE (AMERICAN MACHINERY MODEL, ARMY MODEL SPV-26) FSN 7310-255-8068 (CENTURY MACHINE MODEL 0-311, ARMY MODEL SPV-31) FSN 7310-215-5260 (CAM INDUSTRIES MODEL 533-235) FSN 7310-903-5402

TM 10-7360-201-35, 9 October 1961, is changed as follows:

Title is changed to read as shown above.

Page 3, paragraph 1*a*(2), line 3. Add to first sentence: or FSN 7320-880-8745.

Paragraph 1*a*(3), line 3. Add to the first sentence: or FSN 7320-935-6632.

Paragraph 1*a*(4). Line 2 is changed to read: FSN 7320-221-2386 or FSN 7320-043-5340.

Paragraph 1*a*(5) is superseded as follows: (5) Model 534-68 Bakery Plant is mounted on a 4-ton, 4-wheel, M-795 trailer chassis (FSN 2330-089-4321).

Paragraph 1*a*(6) is added as follows:

(6) Model 534-68 Bakery Plant has a Champion Model BMA-3M-1 air compressor (FSN 4310-063-7375) mounted on the trailer bed.

Paragraph 1*a*(7) is added as follows:

(7) Two generator sets, PU-406/M (FSN 6115-738-6342) are required to furnish electrical power for the bakery- plant and must be requisitioned separately.

Paragraph 1*b* is superseded as follows:

b. Instructions for operation and maintenance of the generator sets, PU406/M, are found in TM 5-6115-36-15 and TM 5-6115-321-12. The air compressor instructions are in TM 5-4310-333-14; and the 4-wheel trailer instructions are in TM 9-2330-274-14.

Paragraph 1c is superseded as follows:

c. Reporting of errors, omissions, and recommendations for improving this publication by the individual user is encouraged. Reports should be submitted on DA Form 2028 (Recommended Changes to Publications) and forwarded direct to the Commanding General, U.S. Army Mobility Equipment Command, ATTN: AMSME-MPP, 4300 Goodfellow Boulevard, St. Louis, Mo. 63120.

Paragraph 3 is superseded as follows:

3. Forms and Records

Maintenance forms, records, and reports which are to be used by maintenance personnel at all levels of maintenance are listed and described in TM 38-750.

Page 2. Figure 13.1 is added as follows:

KEY to figure 13.1

1 Sockethead screw
2 Spring
3 Ball
4 Handwheel
5 Flathead screw
6 Thumbscrew
7 Cover
8 Key
9 Plate
10 Flathead screw
11 Cover
12 Upper sheeting roll scraper shaft
13 Eccentric gear
14 Setscrew
15 Scraper blade
16 Blade support
17 Setscrew
18 Collar
19 Eccentric gear
20 Setscrew
21 Woodruff key
22 Spring
23 Collar
24 Setscrew
25 Blade support
26 Blade
27 Setscrew
28 Flathead screw
29 Lower sheeting roll scraper shaft
30 Setscrew
31 Eccentric gear
32 Setscrew
33 Collar
34 Setscrew
35 Eccentric gear
36 Duster support bracket
37 Housing
38 Bracket
39 Blade support
40 Capscrew
41 Lockwasher
42 Blade support
43 Blade
44 Housing
45 Pin
46 Spring
47 Nut
48 Idler bar
49 Capscrew
50 Lube Fitting
51 Idler sprocket stud
52 Lockwasher
53 Duster support bracket
54 Key
55 Spring
56 Sockethead screw
57 Ball
58 Handwheel
59 Flathead screw
60 Plate
61 Capscrew
62 Lockwasher
63 Bracket
64 Capscrew
65 Lockwasher
66 Bolt
67 Flatwasher
68 Cotter pin
69 Nut, castellated
70 Lockwasher
71 Capscrew
72 Lockwasher
73 Capscrew
74 Nut
75 Lockwasher
76 Dowel pin (one end threaded)

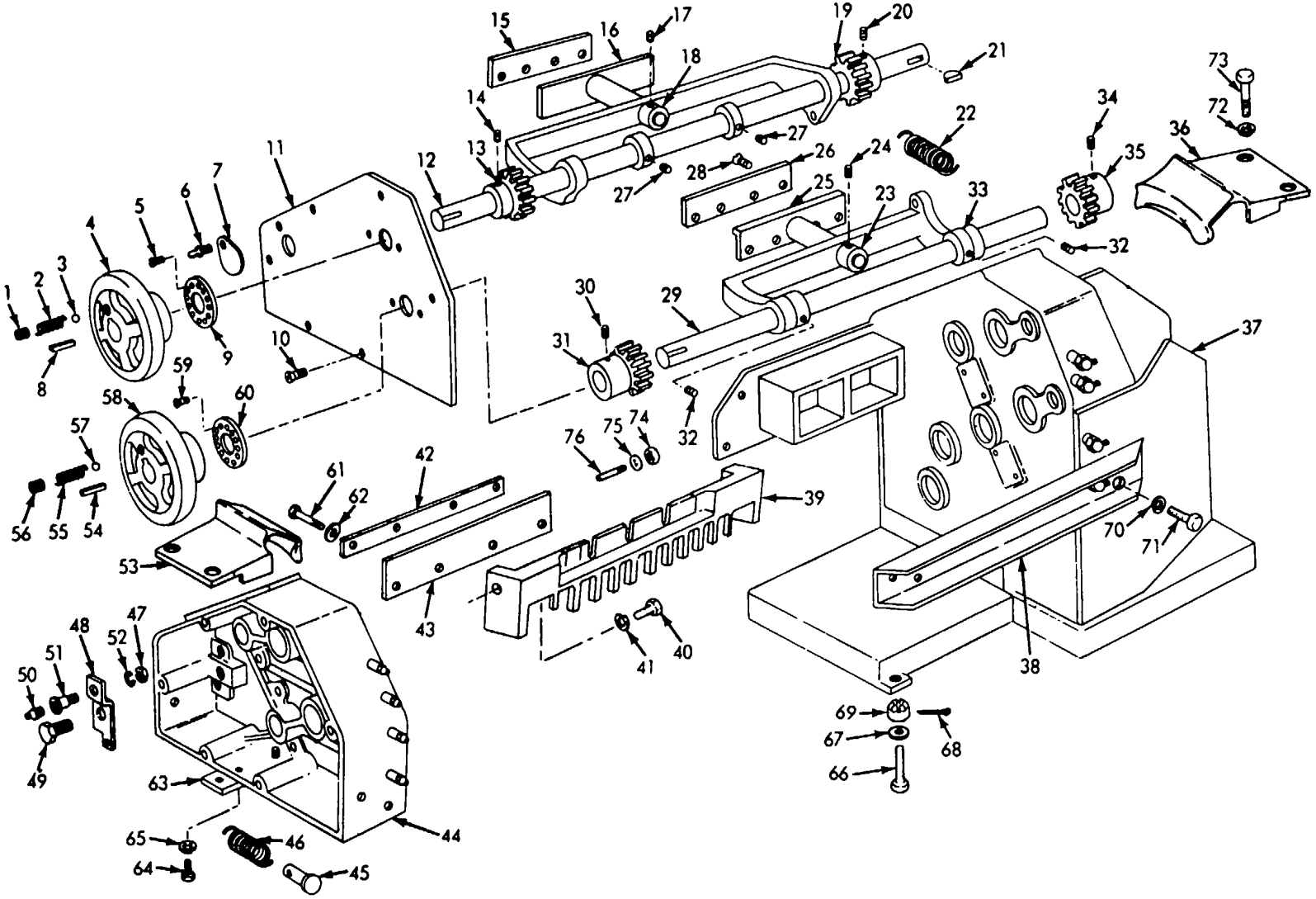


Figure 13.1 Frame, handwheels, and scraper (Model 534-68).

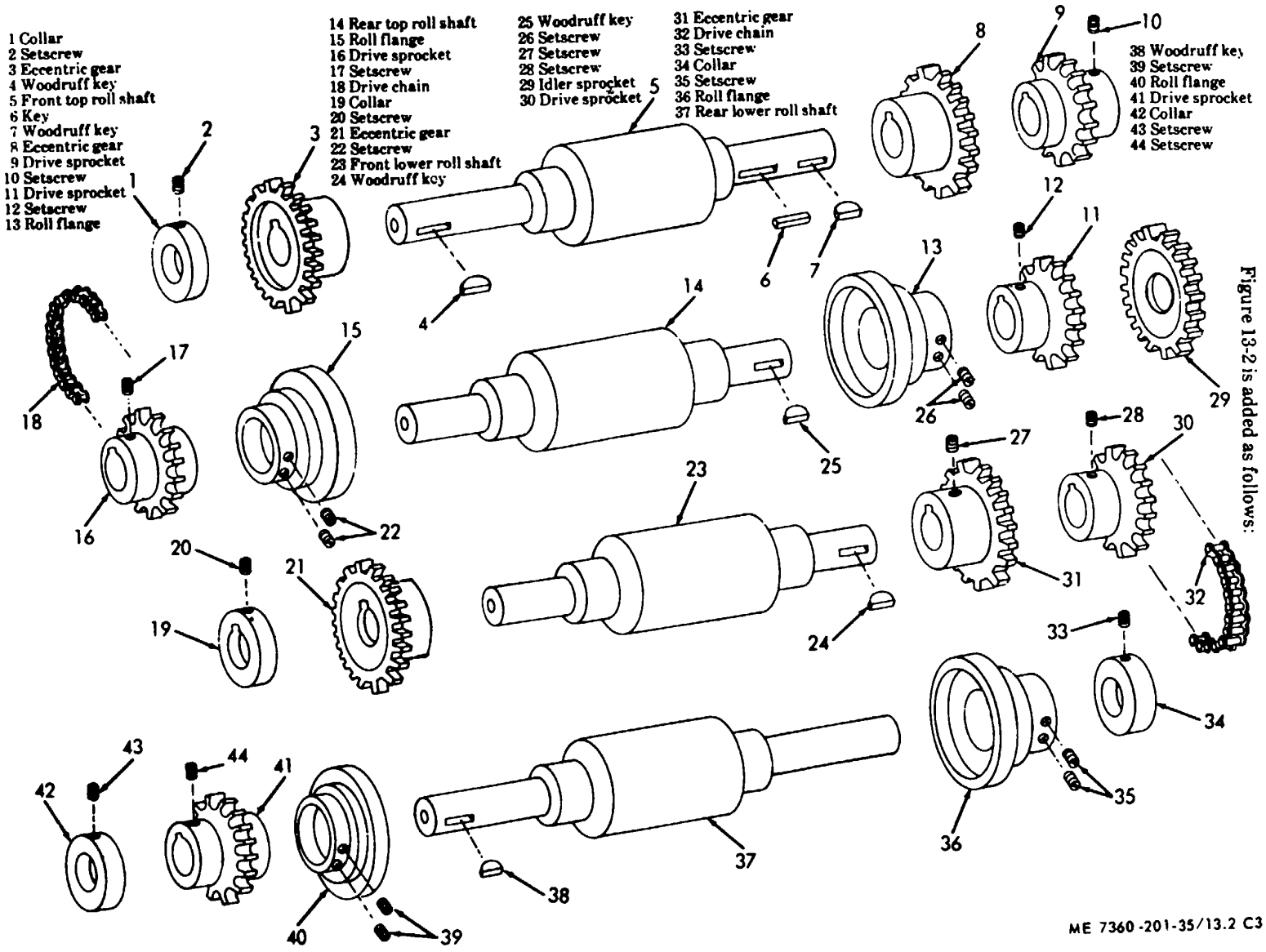


Figure 13-2 is added as follows:

Figure 13.2 Molder sheeting rolls, gears, and shafts (Model 534-68).

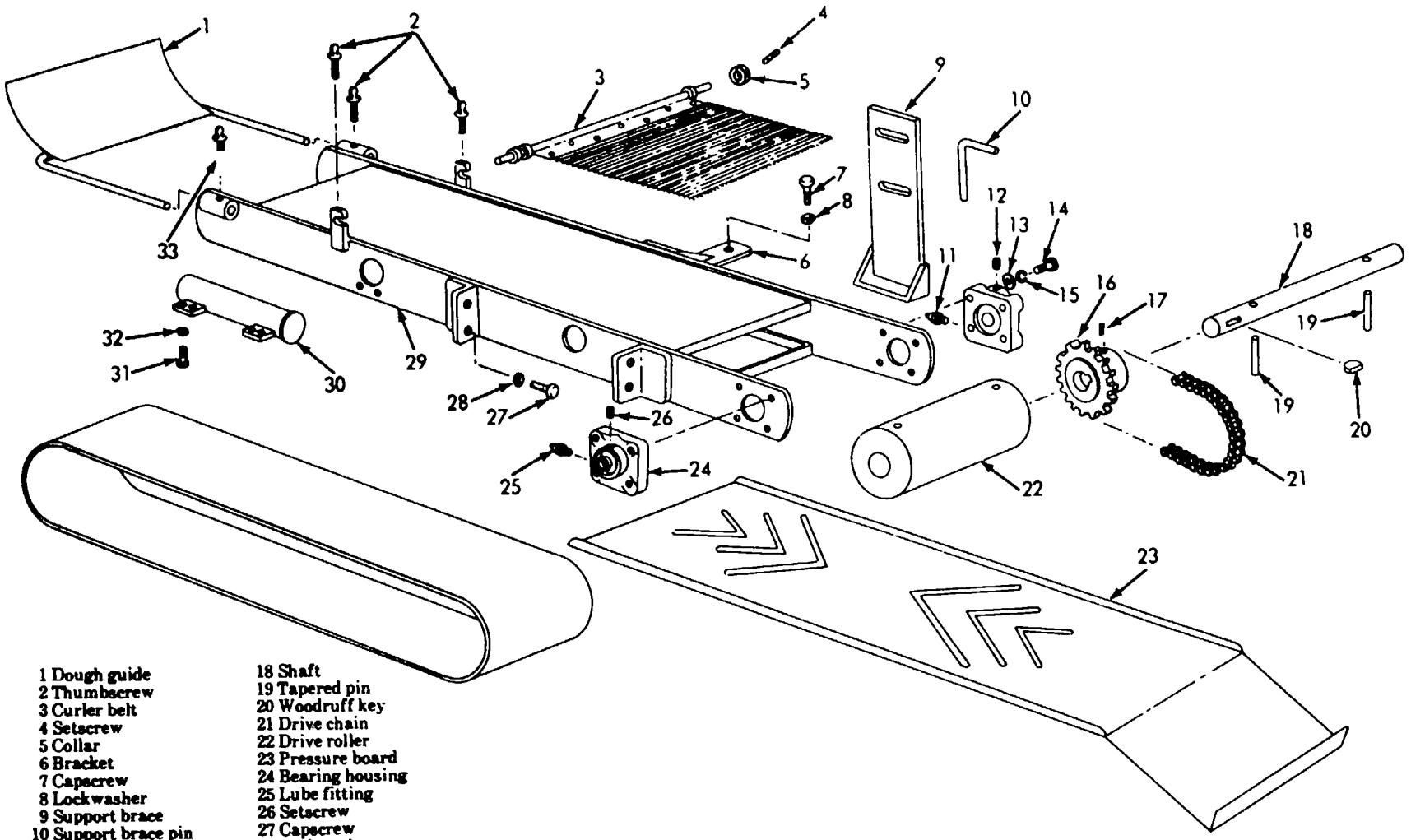


Figure 13.3. Molder conveyor and pressure board (Model 534-68).

Figure 13.4 is added as follows:

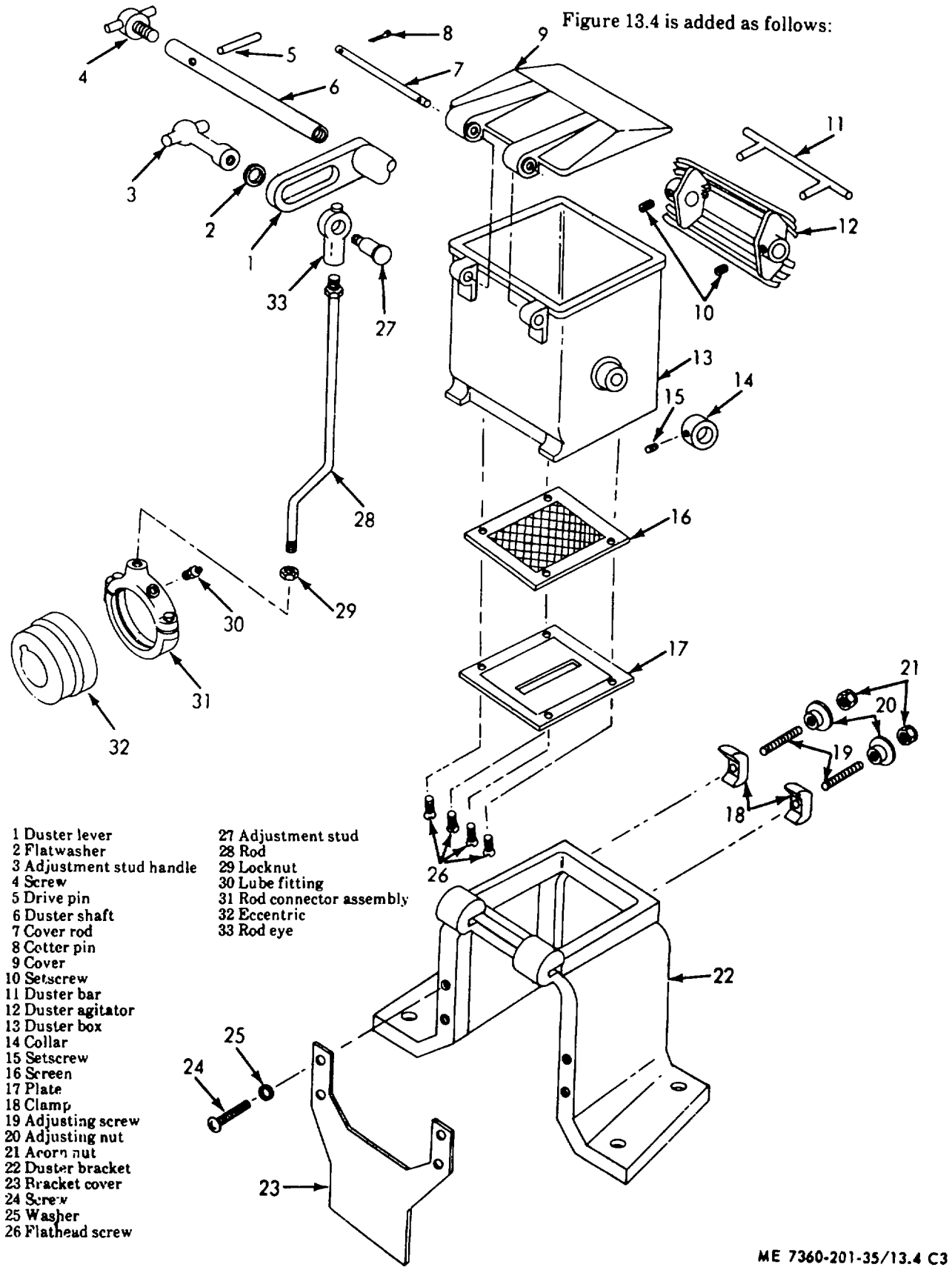


Figure 13.4. Duster assembly (Model 534-68).

Figure 13.5 is added as follows:

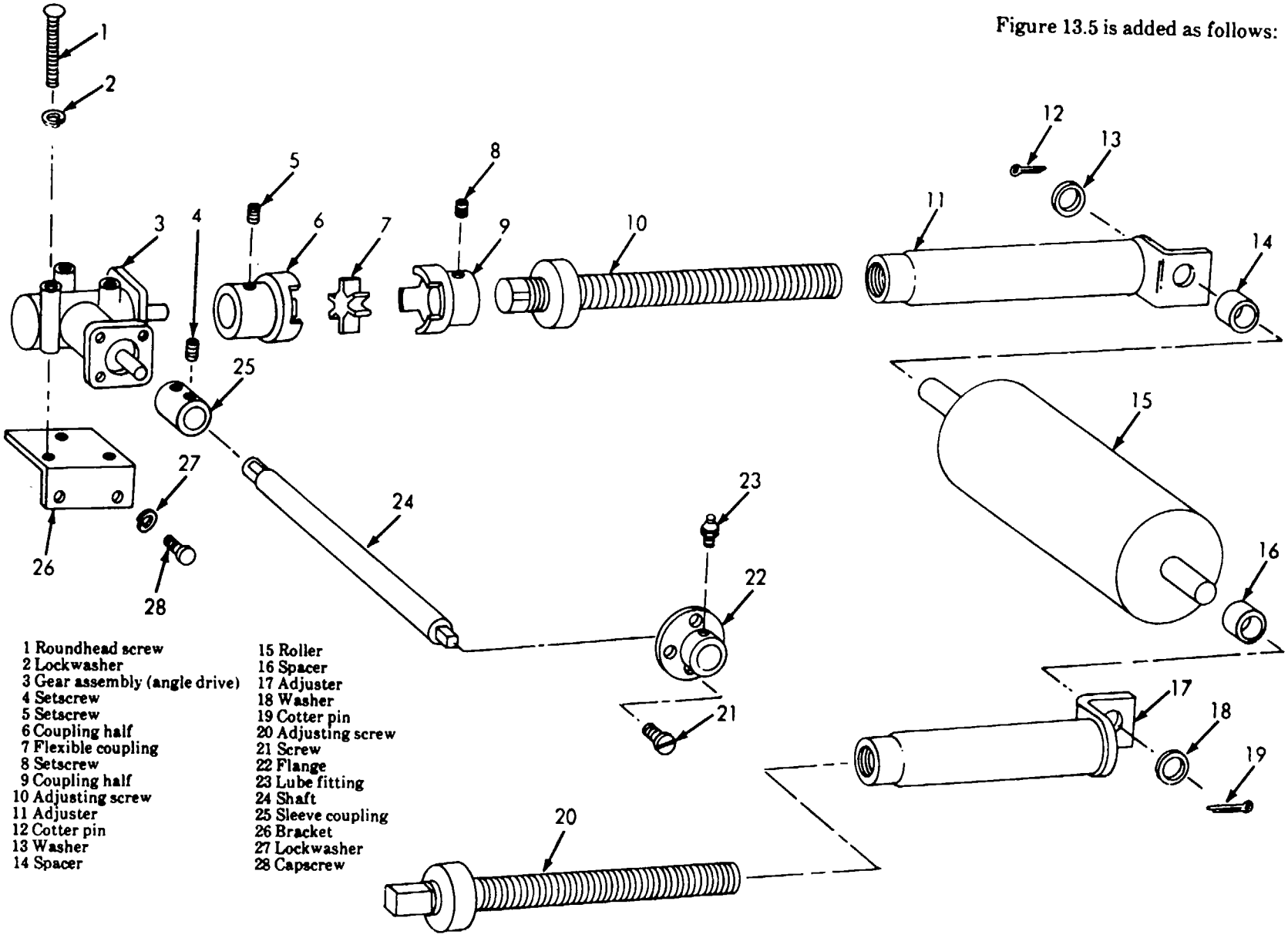
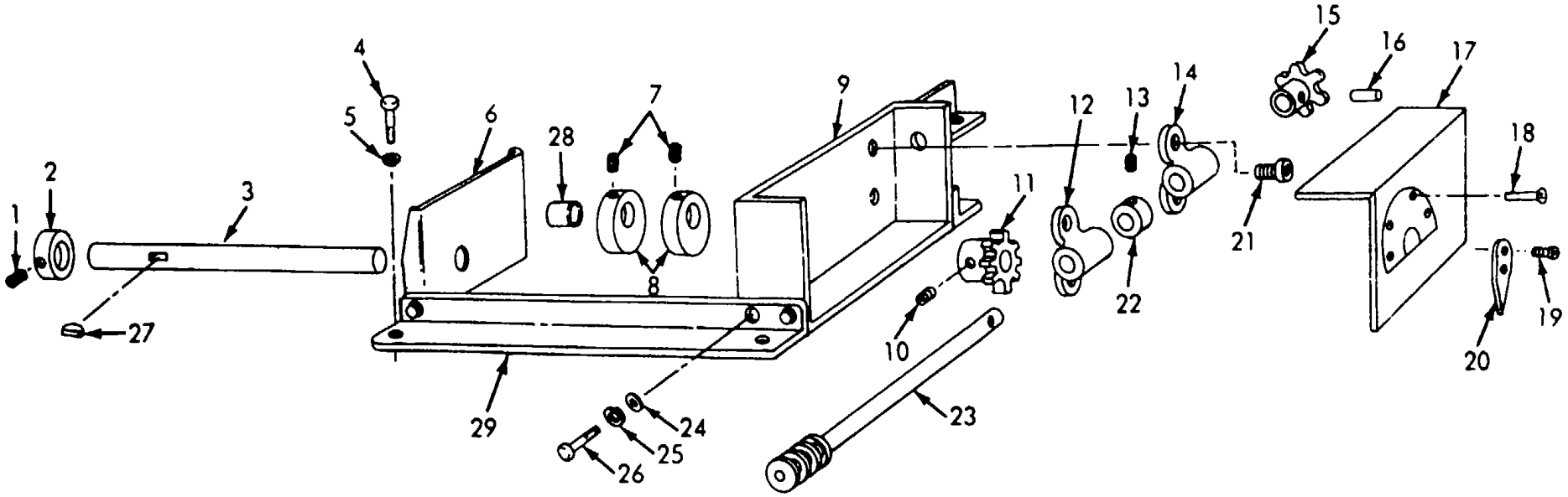


Figure 13.5 Pressure board belt adjustment roller and shaft (model 534-68). **ME 7360-201-35/13.5 C3**



1 Setscrew
2 Collar
3 Camshaft
4 Capscrew
5 Lockwasher
6 Frame
7 Setscrew
8 Cam
9 Frame
10 Setscrew
11 Camshaft worm gear
12 Adjusting shaft bearing
13 Setscrew
14 Adjusting shaft bearing
15 Control knob
16 Roll pin
17 Cover
18 Roundhead screw
19 Roundhead screw
20 Pointer
21 Allenhead screw
22 Collar
23 Adjusting shaft and worm
24 Flatwasher
25 Lockwasher
26 Capscrew
27 Woodruff key
28 Bushing
29 Brace

ME 7360-201-35/13.6 C3

Figure 13.6. Pressure board adjusting cams, gears, and shafts (Model 534-68).

Figure 13.7 is added as follows:

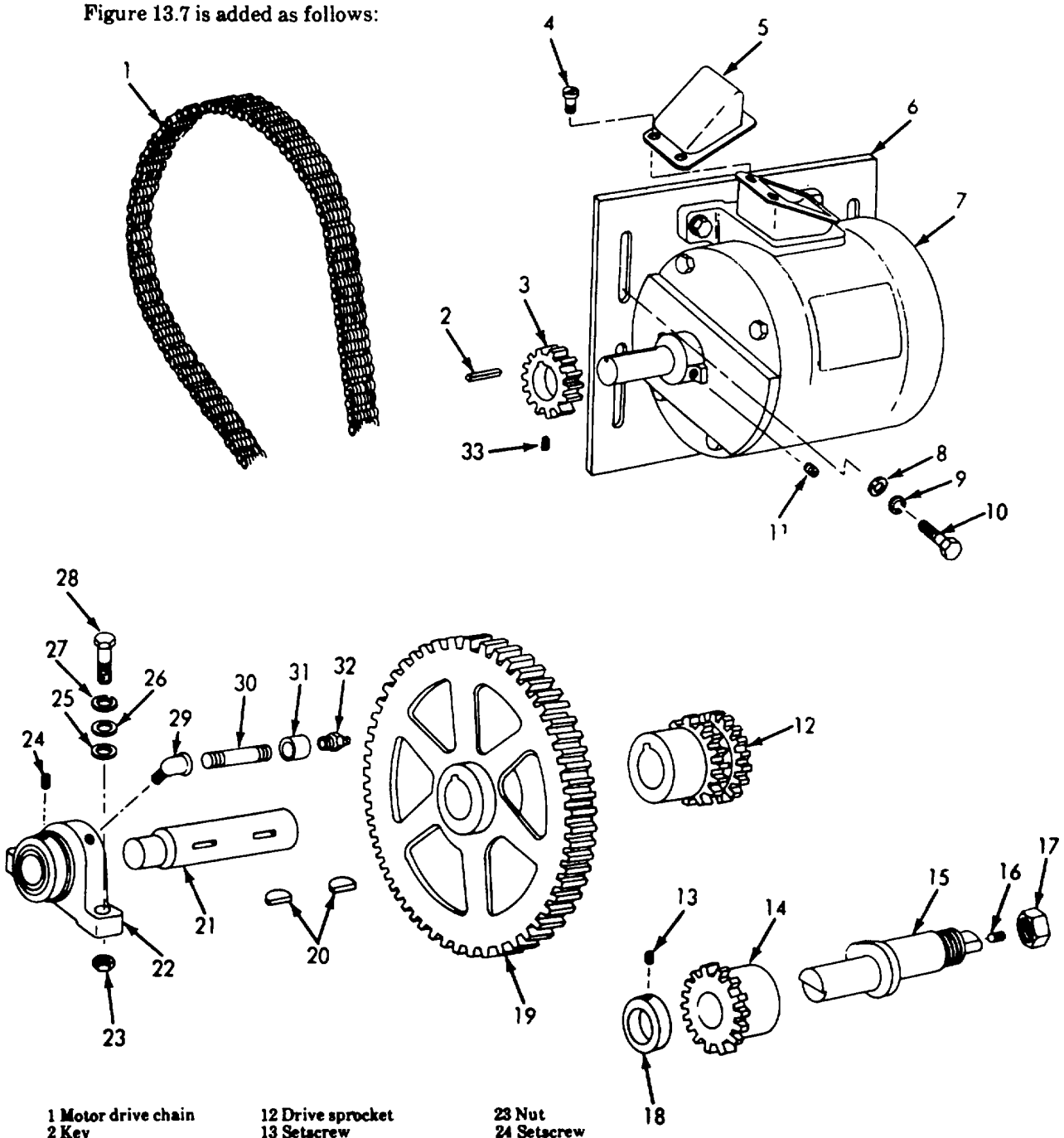


Figure 13.7. Drive motor and drive assembly (Model 534-68).

Page 25. Paragraph 32.1 is added as follows:

32.1. Molder Drive, Model 534-68 (fig. 13.7)

a. Removal.

(1) Remove head frame cover plates

(2) Relieve tension on drive chain by loosening nut on idler sprocket shaft and turning eccentric shaft.

(3) Disconnect drive chains at master links and remove chains.

(4) Unscrew and remove lubrication fitting from street ell.

(5) Loosen setscrews in drive gears.

(6) Remove nuts, washers, and screws that secure bearing pillow block to frame.

(7) Slide main drive shaft from gears and housing, being careful not to bur the shaft or the bronze sleeve bearing in the housing.

(8) Loosen setscrew in pillow block bearing and remove bearing from shaft.

b. Installation. Installation is reverse of removal. When installing shaft in gears, align shaft keys with gear keyways so that shaft slips through in one continuous motion. Align drive gears and chains before tightening gear setscrews.

Page 35. Appendix is superseded as follows:

APPENDIX
REFERENCES

1. Fire Protection

TB 5-4200-200-10	Hand Portable Fire Extinguishers for Army Users.

2. Lubrication

C9100-IL	Fuels, Lubricants, Oils, and Waxes.

3. Painting

TM 9-213	Painting Instructions for Field Use.

4. Cleaning

C6800-IL	Chemicals and Chemical Products.
SB 725-7930-1	Hard-and Soft-Water Cleaning Compounds.

5. Maintenance

TM .-764	Electric Motor and Generator Repair.
TM 5-4310-333-14	Compressor, Air (Champion Pneumatic Model BMA-3M-1) FSN 4310-063,7375.
TM 9-2330-274-14	Chassis, Trailer; 2/2-Ton, 2-Wheel, M-537, FSN 2330-777-2958. Chassis, Trailer; 4-Ton, 4-Wheel, M795, FSN 2330-089-4321.
TM 10-281	Field Bakery Operations.
TM 10-7360-201-10	Bakery Plant, Trailer Mounted;
TM 10-7360-201-20	Field; 16,000-Lb Capacity
TM 10-7360-201-20P	Per 24 Hr; Models M-1945,
TM 10-7360-201-35P	M-1945-50, M-1945-53, M-534-68; FSN 7360-221-2418.
TM 38-750	The Army Maintenance Management System.

6. Shipment and Storage

TB 740-93-2	Preservation of USAMEC Mechanical Equipment for Shipment and Storage.
TM 38-230-1	Preservation and Packing of Military Equipment.
TM 740-90-1	Administrative Storage of Equipment.

7. Demolition

TM 750-244-3	Destruction if Materiel to Prevent Enemy Use.

By Order of the Secretary of the Army:

W. C. WESTMORELAND,
General United States Army,
Chief of Staff.:

Official:

KENNETH G. WICKHAM,
Major General United States Army,
The Adjutant General

Distribution:

To be distributed in accordance with DA Form 12-25, (qty rqr block No. 103) Section I, Direct and General Support Maintenance requirements for Equipment: Baking.

TECHNICAL MANUAL

No. 10-7360-201-385

HEADQUARTERS,
DEPARTMENT OF THE ARMY
WASHINGTON 25, D.C., 9 October 1961

FIELD AND DEPOT MAINTENANCE MANUAL

BAKERY PLANT, MOBILE

FSN 7360-221-2418

*This manual supersedes so much of TM 10-1699A, 1 February 1950, including C 1, 7 March 1952, C 2, 13 January 1953, and C 3, 26 May 1955; TM 10-1699C, 14 October 1949, including C 1, 12 May 1953, C 2, 14 November 1955, and C 3, 16 May 1956; TM 10-1699D, 29 June 1951; and TM 10-1699E, 20 November 1951, including C 1, 14 May 1953, as pertains to field and depot maintenance.

CHAPTER 1
INTRODUCTION

Section I. GENERAL

1. Scope

a. These instructions are published for the use of personnel responsible for field (third and fourth echelon) and depot (fifth echelon) maintenance of the Bakery Plant, Mobile (FSN 7360-221-2418), consisting of:
3 Bakery Ovens, Trailer-Mounted (FSN 7310-215-5260 or 7310-255-8068);
1 Dough Mixing and Makeup Outfit, Trailer Mounted (FSN 7320-2557769 or 7320-215-5256);
3 Cabinets, Dough-Proofing (FSN 7320215-5189 or 7320-298-1380);
1 Sifting Machine, Flour, Electric (FSN 7320-221-2386);
2 Generator Sets (FSN 6115-295-0881, 6115-581-9317, or 6115-295-0880); and
Various accessories.

b. Technical manuals giving complete instructions for the field and depot maintenance of the generators are listed in DA Pam 310-4.

2. References

a. Appendix I contains a list of current references.

b. The maintenance allocation chart is published in TM 10-7360-201-20.

c. The repair parts and special tools lists are published in TM 10-7360-201-35P.

3. Forms and Records

a. DA Form 829 (Rejection Memorandum).

b. DA Form 1510 (Maintenance Readiness and Field Maintenance Costs).

c. DA Form 1546 (Request for Issue and Turn-In).

d. DA Form 2028 (Recommended Changes to DA Technical Manual Parts Lists or Supply Manual 7, 8, or 9).

e. DA Form 9-80 (Job Order File).

f. DA Form 9-81 (Exchange Part or Unit Identification Tag).

4. Orientation

a. Trailers. When the terms right, left, front, and rear are used in connection with the dough mixing and makeup outfit trailers and the oven trailers, they indicate positions from the viewpoint of the operator sitting in the towing vehicle.

b. Proofing Cabinet. When the terms right, left, front, and rear are used in connection with the proofing cabinet, they indicate positions from the viewpoint of the operator facing the cabinet doors and having the control panel and pilot light on his left.

c. Flour Sifter. When the terms right, left, front, and rear are used in connection with the flour sifter, they indicate directions with the manual starting switch considered the front, the discharge hopper door, the rear; the motor side, the left; and the reject hopper door, the right.

Section II. DESCRIPTION AND DATA

5. Description

For information describing the major components of the mobile bakery plant, refer to TM 10-7360-201-10.

6. Tabulated Data

For tabulated data on the major components of the mobile bakery plant, refer to TM 107360-201-10 and TM 10-7360-201-20).

CHAPTER 2
MAINTENANCE INSTRUCTIONS

Section I. MIXING AND MAKEUP OUTFIT TRAILER

7. Brakeshoe Linings

a. Removal.
(1) Remove brakeshoe with lining (TM 10-7360-201-20).
(2) Drive out rivets and remove lining from brakeshoe.

b. Installation. Reverse procedures in a above, and bleed and adjust brakes (TM 10-7360-201-20).

8. Brakedrum

a. Removal and Installation. Follow procedures in TM 10-7360-201-20.

b. Repair.
(1) If brakedrum is scored, turn brakedrum on a lathe and remove scoring.
(2) Remove brakeshoe linings (par. 7a) and place a shim between brakeshoe and lining to compensate for amount cut off by lathe. Install linings.

9. Backing Plate

a. Removal and Installation. Follow procedures in TM 10-7360-201-20.

b. Repair. Inspect backing plate and install new wheel cylinder assembly as necessary. If backing plate is defective, install a serviceable item.

10. Hub

a. Removal and Installation. Follow procedures in TM 10-7360-201-20.

b. Repair. Inspect hub for stripped threads. Replace inner and outer bearing cups as necessary. If hub is damaged, install a serviceable item.

11. Axle

a. Removal.
(1) Jack up and block trailer.
(2) Disconnect handbrake cable (1, fig. 1).
(3) Disconnect hose assembly (2) from master cylinder.
(4) Remove nuts (4) and lockwashers from U-bolts (6).
(5) Remove retainer plate (5) and U-bolts (6).
(6) Remove shackle bolt (8), release front spring shackle (7), and remove spring assembly.
(7) Repeat (4) through (6) above and remove other spring assembly.
(8) Remove axle (3) with wheels from trailer.
(9) Remove wheels (TM 10-7360-201-20).

b. Installation. Reverse procedures in a above.

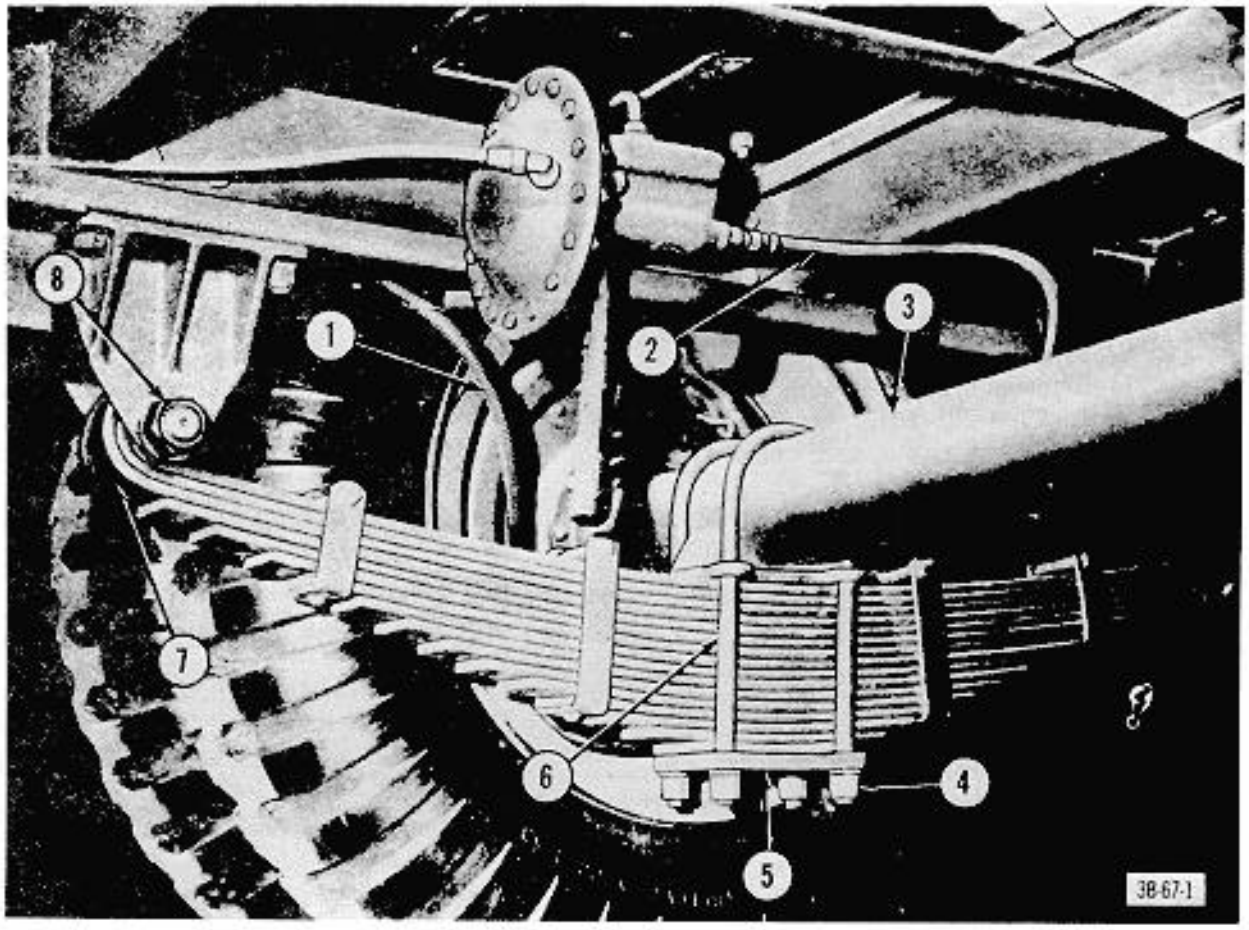
12. Mixer, Divider, and Molder Electric Motors

a. Removal and Installation. Follow procedures in TM 10-7360-201-20.

b. Repair, Testing, and Overhaul. Follow applicable procedures in TM 5-764.

13. Monorail Truck Wheel Assembly

a. Removal.
(1) Support monorail by some suitable device.
(2) Remove bolts (1 and 3, fig. 2), nuts, and lockwashers from left side of front truck.
(3) Remove nuts (5), bolts, lockwashers, and straps from truck.
(4) Remove nuts (2 and 4) from wheel axles.

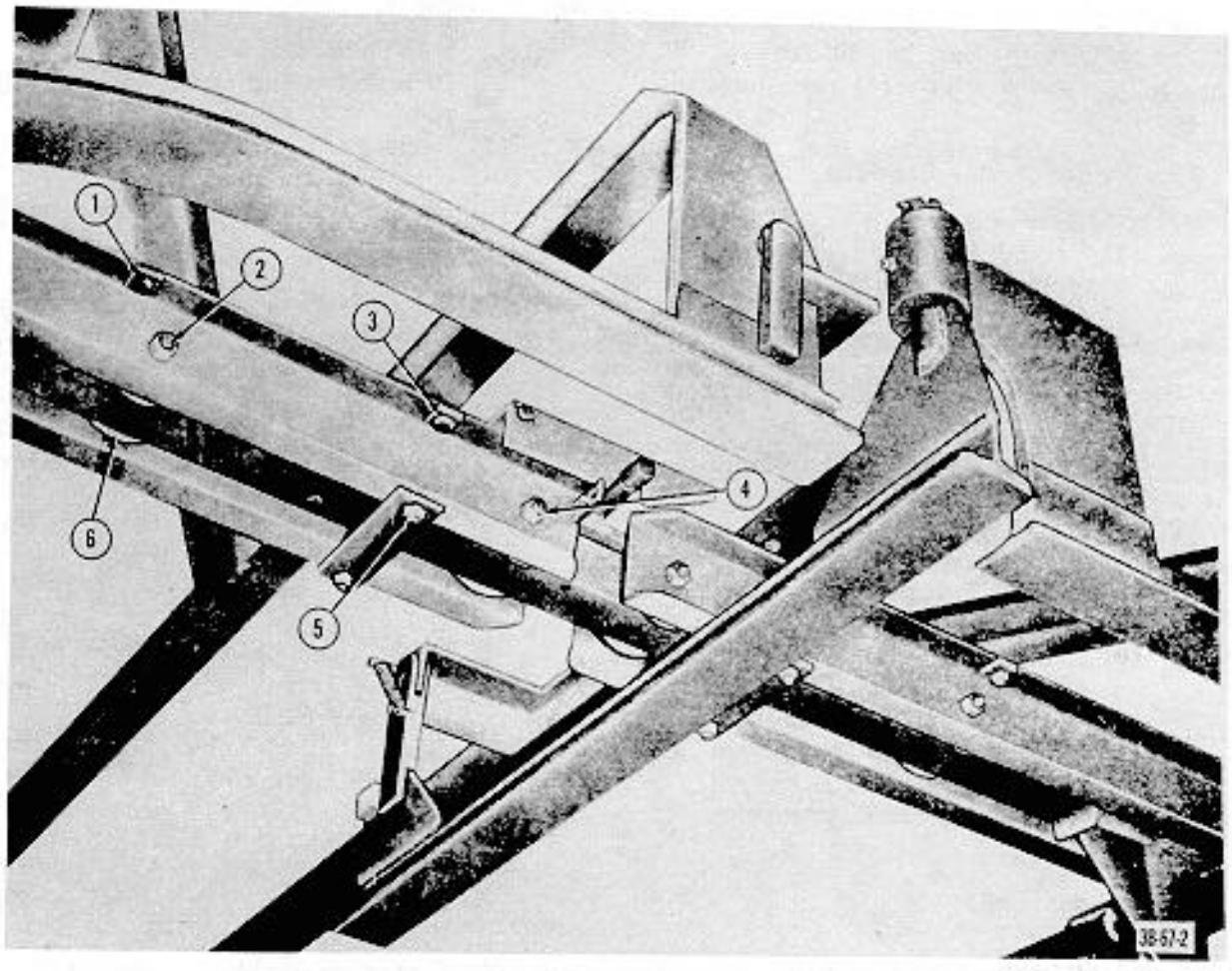


1	Cable, handbrake	5	Plate, spring retainer
2	Hose assembly, master cylinder-to-tee	6	U-bolt, spring-to-axle
3	Axle	7	Shackle, front
4	Nut, U-bolt	8	Bolt, shackle

Figure 1. Trailer axle, installed.

(6) Remove truck wheels.
(7) Repeat procedure for other trucks.

b. Installation. Reverse procedure in *a* above.



1	Bolt, truck	4	Nut and fitting, lubrication
2	Nut and fitting, lubrication	5	Nut, strap bolt
3	Bolt, truck	6	Wheel, monorail truck

Figure 2. Monorail and truck wheels, installed on trailer.

Section II. DIVIDER ASSEMBLY

14. Divider assembly

a. Removal

(1) Disconnect and tag main electrical feed wires in divider motor starter box.
(2) Remove locknut on feed wire conduit and pull conduit and wires from box.
(3) Remove conduit clamp from main feeder conduit on side of divider.
(4) Open junction box on molder motor and disconnect and tag wires.
(5) Remove cotter pins from base anchor bolts. Remove nuts, lock-washers, and anchor bolts from base of divider.
(6) Remove scale (par. 16a) to prevent damage to the scale when removing divider.
(7) Using suitable hoist, remove divider from trailer.

b. Repair. Inspect the divider assembly and all of its components to be sure they are in

serviceable condition. Repair or replace defective parts as necessary and authorized.

c. Installation. Reverse procedures in a above.

15. Divider Duster Bearings

a. Removal.

(1) Remove pins from duster bar located behind upper duster lever (2, fig. 3). Disconnect bar from lever.
(2) Open cover of upper duster box and remove capscrews, nuts, and washers that connect agitator assembly to studs (1 and 3).
(3) Slide studs (1 and 3) from duster box and remove lever (2).
(4) Lift out agitator.
(5) Remove capscrews and flat washers that hold duster box to divider and remove duster box.
(6) Using suitable tool, remove bearings from boss at each side of duster box. There are two bearings in each boss.
(7) Remove bearings from lower duster box in same manner.

b. Installation. Reverse procedures in a above.

16. Divider Scale

a. Removal.

(1) Remove nut and lockwasher from screw that secures holddown clamp to scale, and remove clamp.
(2) Remove mounting nuts that attach scale to bracket and lift off scale.

b. Repair. Inspect parts for defects, damage, and excessive wear. Replace defective scale or clamps with serviceable items.

c. Installation. Reverse procedures in a above.

d. Adjustment. Turn adjusting screw on end of scale until pointer is centered under the zero mark.

17. Conveyor Drive Gear With Pulley, Pinion, Shafts, and Bearings

a. Removal.

(1) Loosen tension on conveyor belt and unlace belt.
(2) Remove conveyor belt from idler pulley (3, fig. 4) and from drive gear with pulley (9).
(3) Remove bearing cap from connecting rod,
(4) Remove master link in conveyor drive chain (11) and remove chain.
(5) Remove collar (16) from pinion shaft (19).
(6) Remove nuts and bolts holding lower duster box to divider and remove duster box.
(7) Remove hexagon nut and washer from drive pulley shaft (23).
(8) Remove nuts and bolts holding drive pulley mounting bracket to conveyor frame.
(9) Remove nuts and bolts holding mounting bracket to divider, remove nut (13) and lockwasher (12) from end of pulley shaft (23), and slide pulley assembly away from divider. Remove drive pinion (17) with bearings from divider.
(10) Remove nuts, lockwashers, and flat washers holding bracket to drive pinion shaft (19), and remove bracket.
(11) Remove nut (22), lockwashers (21), and flat washer (20) from drive pinion shaft (19), and pull shaft from drive pulley support (18).
(12) Remove drive pulley shaft (23).
(13) Remove drive gear with pulley (9) from drive pulley support (18).
(14) With suitable tool, remove sleeve bearings (10) from drive gear with pulley (9), and remove sleeve bearings (15) from drive pinion (17).

b. Installation. Reverse procedures in a above.

18. Conveyor Idler Pulley Bearings

a. Removal.

(1) Remove conveyor belt (par. 17a(1) and (2)).
(2) Remove capscrews holding idler pulley (3, fig. 4) to supports (6), and remove idler pulley.
(3) With suitable tools, remove idler pulley sleeve bearings (4).

b. Installation. Reverse procedures in a above.

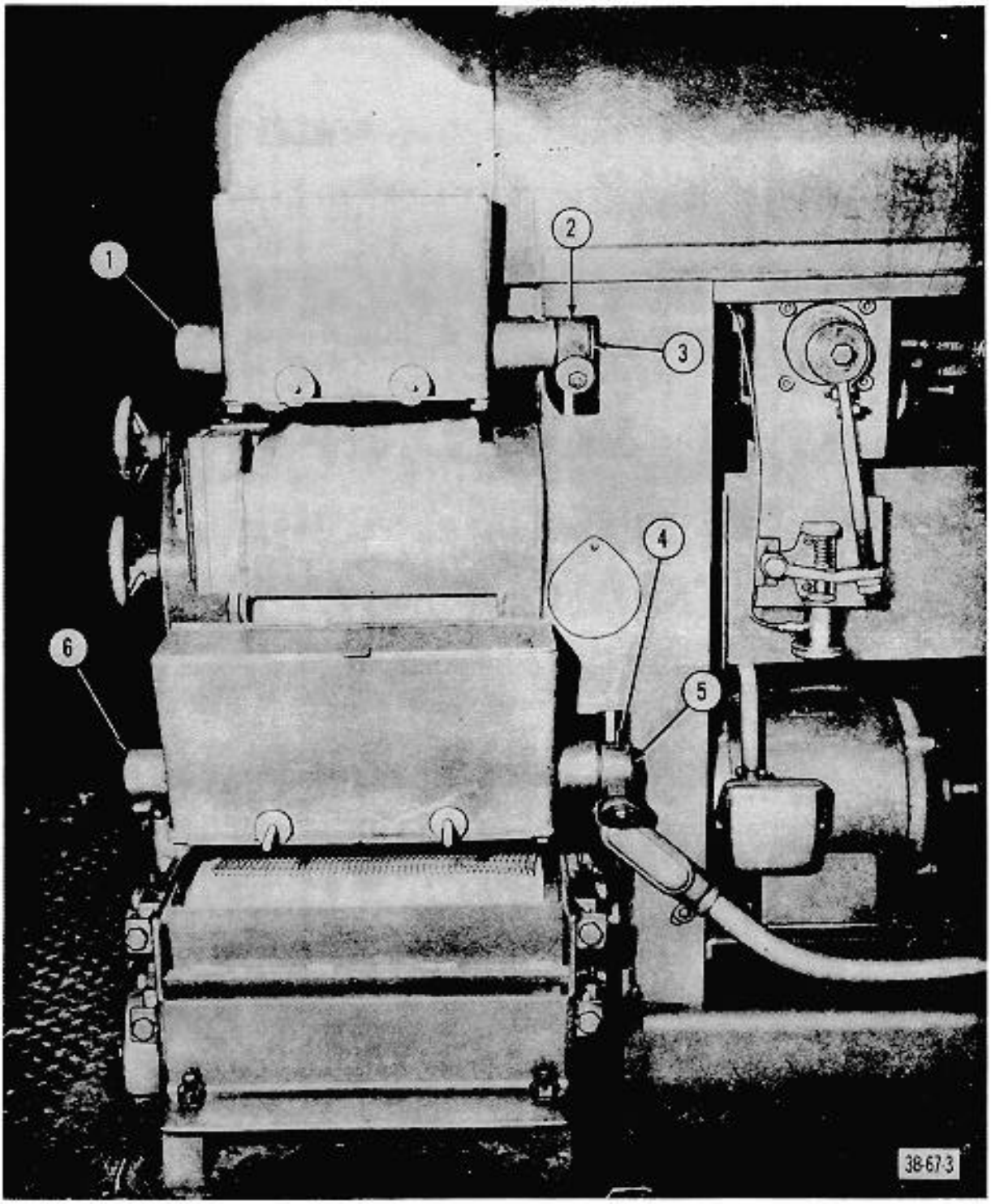
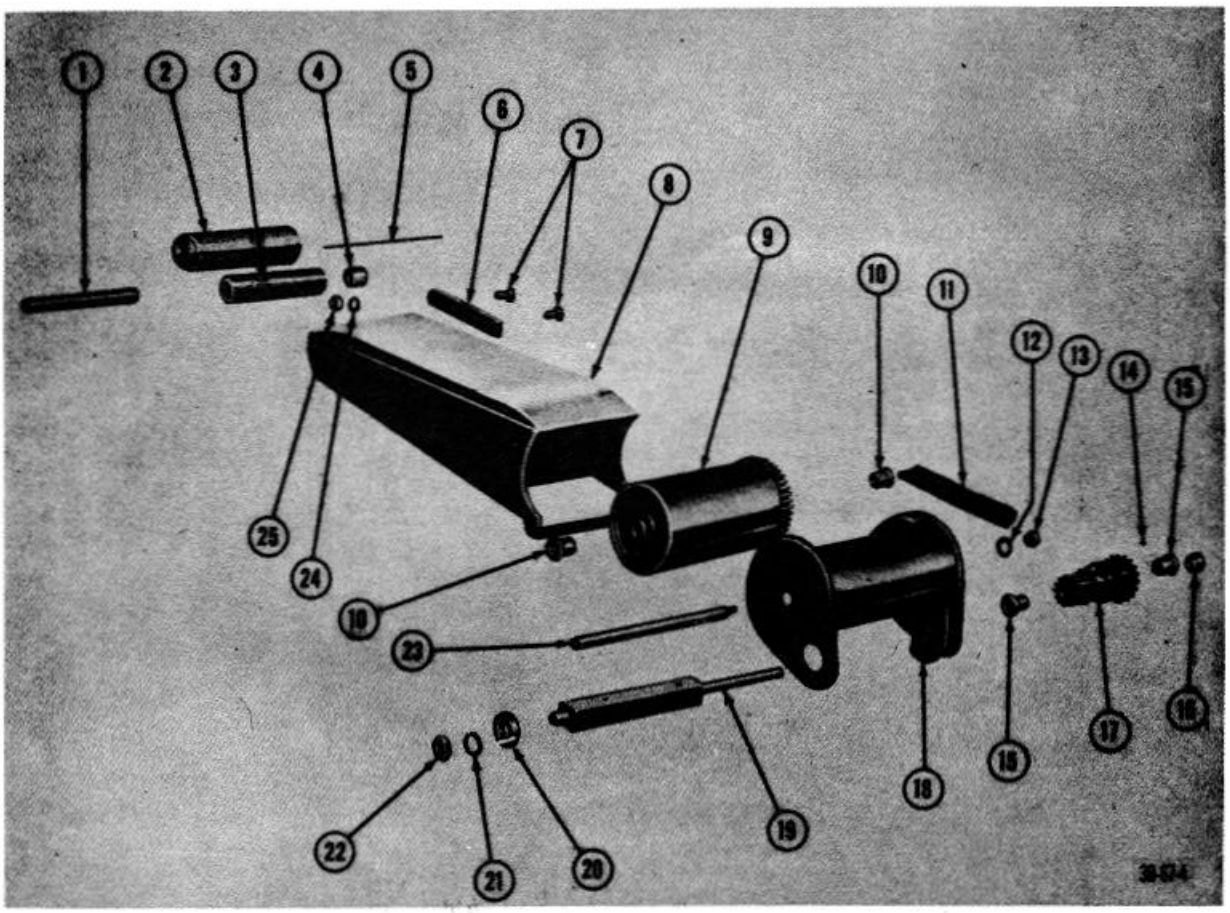


Figure 3. Divider flour dusters, installed.

1 Stud, front, upper duster
2 Lever, upper duster
3 Stud with washer, rear, upper duster
4 Lever, lower duster
5 Stud with washer, rear, lower duster
6 Stud, front, lower duster

Figure 3 - Continued.



1 Shaft, idler pulley
2 Belt, conveyor
3 Pulley, idler
4 Bearing, sleeve, idler pulley
5 Lacing set
6 Support, idler pulley
7 Capscrews, support
8 Frame, conveyor
9 Gear with pulley, drive
10 Bearing, sleeve, drive pulley
11 Chain, drive
12 Lockwasher, shaft, pulley drive
13 Nut, shaft, pulley drive
14 Setscrew, collar
15 Bearing, sleeve, drive pinion shaft
16 Collar, shaft, drive pinion
17 Pinion, drive
18 Support, drive pulley
19 Shaft, drive pinion
20 Washer, shaft, drive pinion
21 Lockwasher, shaft, drive pinion
22 Nut, shaft, drive pinion
23 Shaft, drive pulley
24 Lockwasher, support
25 Nut, support

Figure 4. Divider conveyor assembly, exploded view.

19. Divider Crankshaft and Related Parts

a. Removal.

(1) Remove knife and plunger with upper connecting links (TM 10-7360-201-10).
(2) Loosen setscrew and remove stud that attaches divider cylinder lever to dough box cylinder.
(3) Remove bolts (16, fig. 5) and lock-washers (15) from pins (12 and 14) that attach lower connecting links (6 and 11, fig. 6) to lever sides (11 and 13, fig. 5), and remove pins with clamps.
(4) Remove 'capscrews (8 and 10, fig. 6) and lockwashers (7 and 9) that attach caps (19 and 21) to lower connecting links (6 and 11), and remove caps and links.
(5) Remove capscrews (13) and lock-washers (14) that attach cap (12) to lever (20), and remove cap and lever.
(6) Remove capscrew that attaches oil pump drive rod bearing to crankshaft.
(7) Lift and remove oil reservoir.
(8) Disconnect oil line at pump.
(9) Remove capscrews that attach oil pump bracket to pillow block, and pump.
(10) Remove master link in gear reduction unit-to-crankshaft drive chain, and remove chain from sprockets.
(11) Block up crankshaft.
(12) Remove bolts that attach pillow blocks (1 and 16) to divider frame, and slide pillow blocks off bearings (2 and 17).
(13) Slide bearings (2 and 17) off crank-shaft.
(14) Lift out crankshaft (18) with sprocket (5).
(15) Loosen jamnut (3) and remove set-screw (4) from sprocket (5).
(16) Remove sprocket from crankshaft.

b. Repair. Inspect parts for serviceability, and replace defective items as authorized.

c. Installation. Reverse procedures in a above.

d. Adjustment. Adjust the gear reduction unit-to-crankshaft drive chain to a 1/2-inch finger-pressure deflection by adding or removing shims under the gear reduction unit.

20. Divider Compression Springs and Related Parts

a. Removal and Disassembly.

(1) Remove knife and plunger with connecting links (TM 10-7360-201-10).
(2) Disconnect knife and plunger lever sides (11 and 13, fig. 5) from plunger lever pivot blocks (27), and raise and support lever sides.
(3) Place supports between compression springs and motor.
(4) Remove bracket capscrews (20) and lockwashers (19), and pull springs (30) through opening in rear of divider.
(5) Compress spring (30) slightly.
(6) Remove jamnuts (32) from spacer plate (31), release tension on spring, and remove plate, spring, spacer (29), plate (28), and block (27) from rods.
(7) Unscrew setscrew (21) and jamnut (22) from bracket (23).
(8) Remove jamnut from setscrew.
(9) Repeat (5) through (8) above to remove other compression spring.

b. Repair.

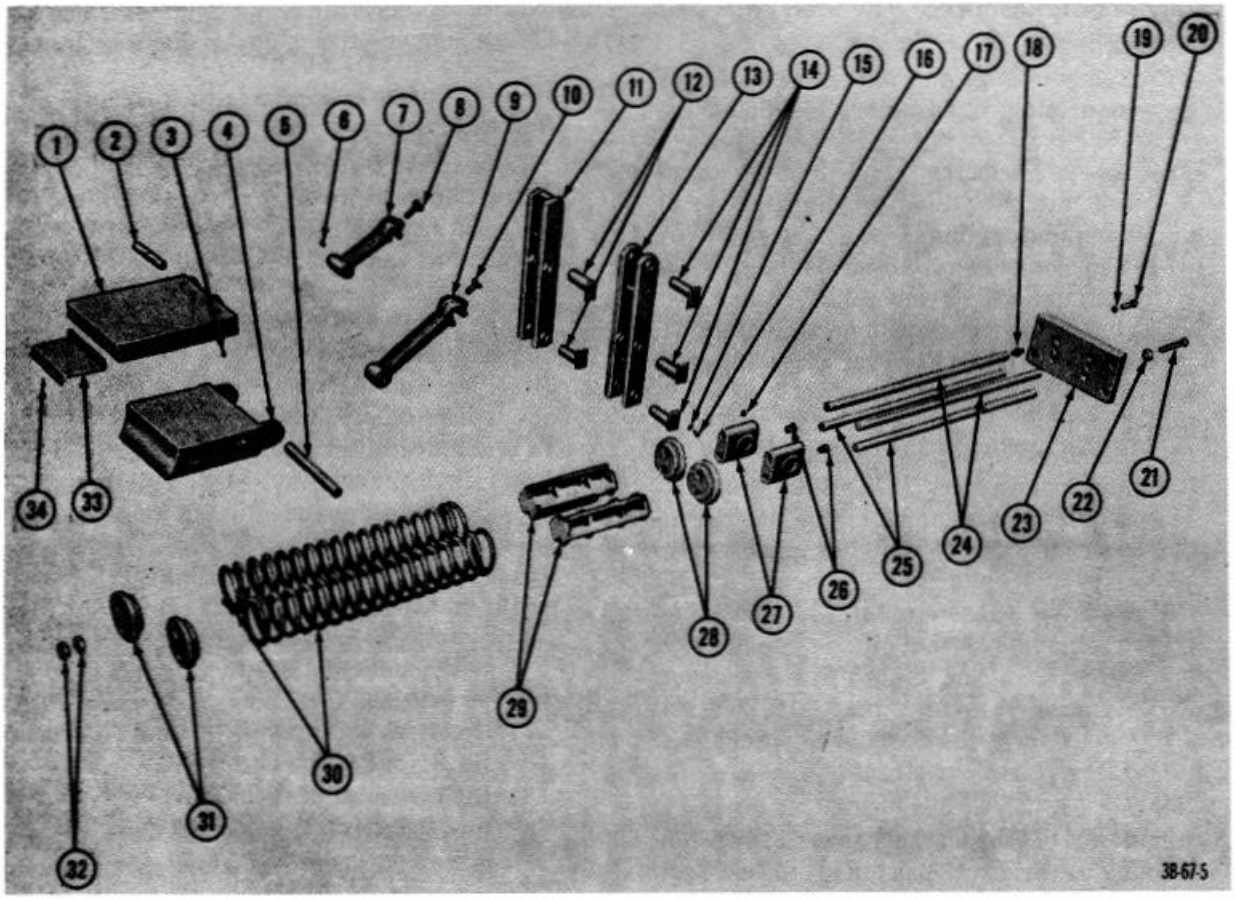
(1) Inspect all parts for serviceability.
(2) Weld splits and cracks, and straighten bent rods.
(3) Replace defective parts with serviceable' items as authorized.

c. Assembly and Installation. Reverse procedures in a above.

21. Divider Cylinder Assembly

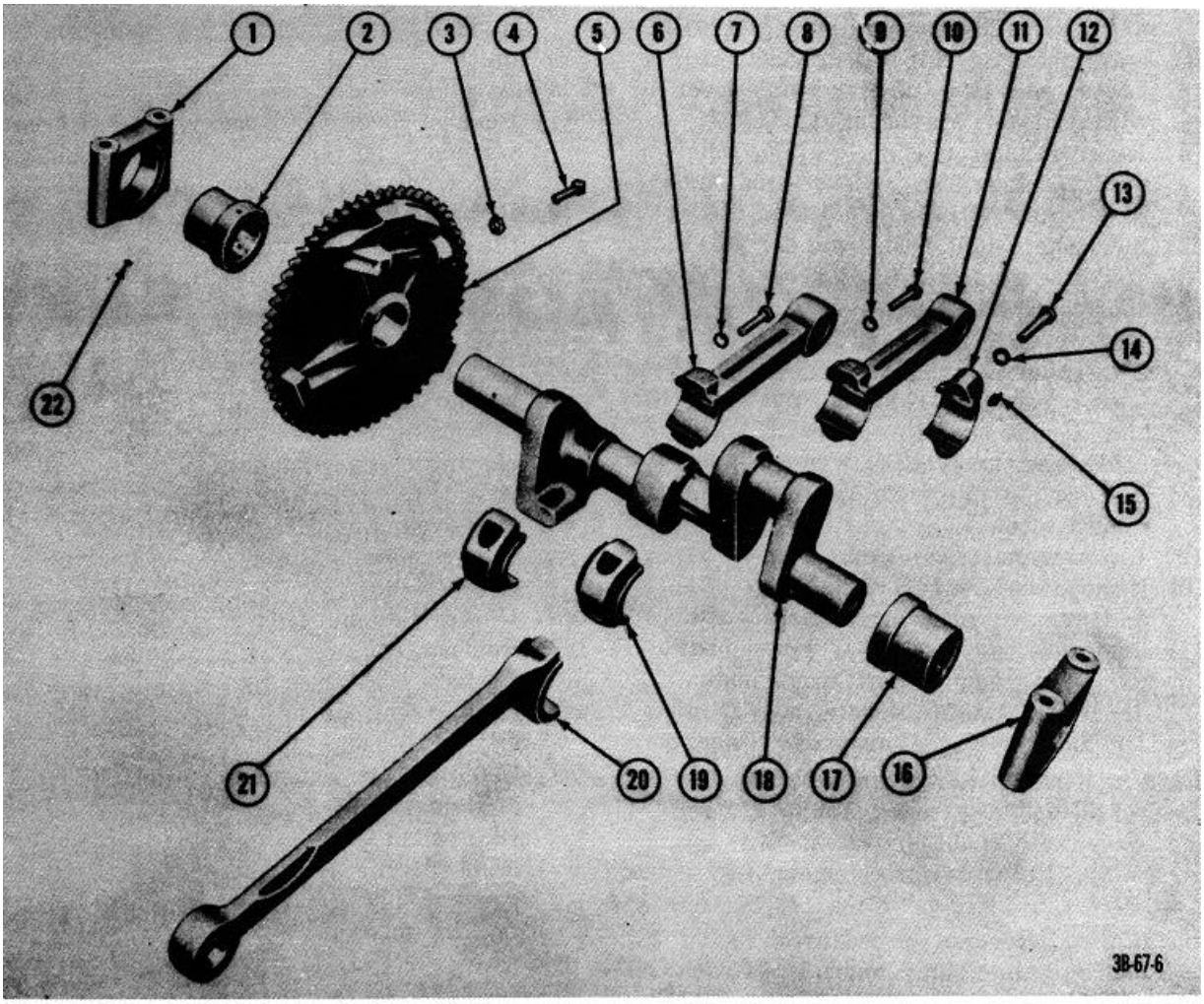
a. Removal.

(1) Remove knife and plunger (TM 10-7360-201-10).
(2) Remove sockethead screws that attach cylinder covers to divider frame, and lift off covers.
(3) Loosen setscrews (30, fig. 7) and remove stud (33) to free connecting link.
(4) Remove capscrews and lockwashers that attach caps to bearing blocks and lift off caps.



1 Knife, dough
2 Pin, knife and lever connecting link
3 Setscrew, connecting link
4 Plunger, dough
5 Pin, plunger and lever connecting link
6 Setscrew, connecting link
7 Link, connecting, knife and lever
8 Stud with wingnut, connecting link
9 Link, connecting, plunger lever
10 Stud with wingnut, connecting link
11 Lever side, knife
12 Pins with clamps, knife
13 Lever side, plunger
14 Pins with clamps, plunger
15 Lockwasher, pin
16 Bolt, pin
17 Setscrew, pivot block
18 Fittings, lubrication, compression spring upper rod
19 Lockwasher, bracket
20 Capscrew, bracket
21 Setscrew bracket
22 Jamnut, setscrew
23 Bracket, compression spring
24 Rods, compression spring, upper
25 Rods, compression spring, lower
26 Plugs, pivot blocks
27 Blocks, plunger lever pivot
28 Plates, compression spring spacer
29 Spacers, compression spring
30 Springs, compression
31 Plates, compression spring spacer
32 Jamnuts, upper and lower rods
33 Pan, oil catch
34 Screw, oil catch pan

Figure 5. Divider knife, plunger, and related parts, exploded view.



1 Block, pillow, crankshaft bearing, left
2 Bearing, sleeve, crankshaft
3 Jamnut, sprocket
4 Setscrew, sprocket
5 Sprocket, drive, crankshaft
6 Link, connecting, knife lever and crankshaft
7 Lockwasher, connecting link
8 Capscrew, connecting link
9 Lockwasher, connecting link
10 Capscrew, connecting link
11 Link, connecting, plunger lever and crankshaft
12 Cap, cylinder lever
13 Capscrew, lever
14 Lockwasher, lever
15 Fitting, lubrication, lever
16 Block, pillow, crankshaft bearing, right
17 Bearing, sleeve, crankshaft
18 Crankshaft, divider
19 Cap, connecting link
20 Lever, cylinder
21 Cap, connecting link
22 Setscrew, pillow block, left

Figure 6. Divider crankshaft and related parts, exploded view.

(5) Lift cylinder (31) with bearings from bearing blocks.

(6) Slide bearings off ends of cylinder.

b. Disassembly.

(1) Disengage discharge lever (28, fig. 7) from collar (27) and lift out piston (8).

(2) Using suitable tool, push collar (27) and lever (28) against spring (29), and remove key (18) from shaft (25).
(3) Loosen setscrew (22), and slide lever with stud (24) off shaft (25).
(4) Remove collar pin (20), slide roller with bearing (23) off lever stud, and remove key (19).
(5) Slide shaft (25) from cylinder (31), and lift off collar (27), lever (28), and spring (29).
(6) Remove screw (17) and spring (16) from collar (27).
(7) Loosen setscrew (15) on nut (10), and remove adjusting screw (3), nut (10), and knob (2) from cylinder.
(8) Remove pin (1) from screw (3) and remove screw.
(9) Unscrew nut (10) from screw (3).
(10) Remove screws (4) from stop (7), and remove stop from piston (8).
(11) Remove screw (5) from piston bar (6), and remove bar from piston.
(12) Remove sockethead screws from cylinder, and pry apart halves of cylinder.

c. Repair. Remove burs from shaft and piston. Inspect all parts for serviceability and replace defective items as authorized.

d. Assembly. Reverse procedures in *b* above.

e. Installation. Reverse procedures in i above. Be sure to align sump in bearings with oilholes in cylinder bearing blocks, and place bearing flanges to the inside of cylinder.

22. Dough Box Assembly

a. Removal, Inspection, Cleaning, and Installation. Follow procedures in TM 10-7360-201-20.

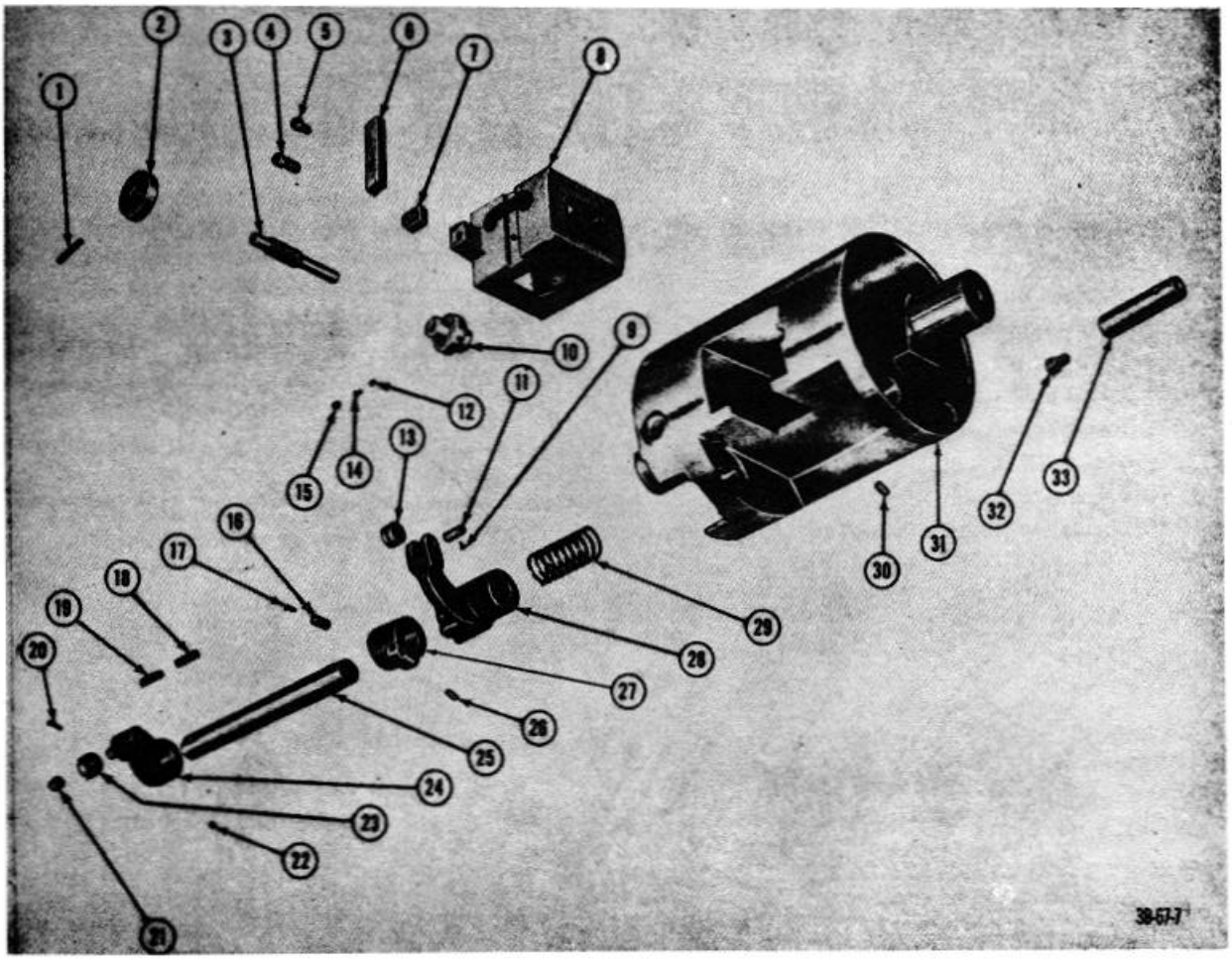
b. Repair.
(1) File burs, straighten bent pins, and retap any stripped threads.
(2) Replace dough box if it is damaged beyond repair.

23. Divider Gear Reduction Unit

a. Removal.
(1) Remove both divider side doors.
(2) Remove drive chains and motor (TM 10-7360-201-20).
(3) Remove nuts that attach housing to divider frame, and lift out reduction unit.

b. Disassembly.

(1) Remove cover bolts, screws, and lock-washers, and remove covers and gaskets from gear reduction unit (fig. 8).
(2) Remove drain plug (17) and drain the gear reduction unit.
(3) Remove cotter pins (72), slide the sprocket wheel (23) off wormshaft (70), and remove key (71).
(4) Remove capscrews (22) and lock-washers (21) that attach retainer (20 to housing (10), and remove retainer, bearing cup (19), and cone and rollers (18).
(5) Loosen jamnut (67) on setscrew (66), and remove setscrew from bearing retainer (68).
(6) Unscrew jamnut from setscrew.
(7) Remove capscrews (65) and lock-washers (64) from retainer (68), and remove retainer, adjusting plate (69), and bearing cup (63).
(8) Using a drift, remove wormshaft (70) and shim -(61) from sprocket wheel (23) end of the housing (10).
(9) Remove cone and rollers (62) from housing (10).
(10) Loosen setscrew (59) on sprocket wheel (60), and remove wheel and key (51) from shaft (50).
(11) Remove bolts (58) and lockwashers (57) from retainer cap (56), and remove cap.
(12) Remove nuts (30 and 43) from shafts (7 and 50), and lift off lock-washers (31 and 44) and flat washers (32 and 45).
(13) Remove capscrews (54) from retainer (53), and remove retainer, bearings (49 and 55), shaft (50), and bevel gear (47) as a unit from bevel gear-box (40).
(14) Loosen setscrew (46) on bevel gear (47), and remove gear and dey from shaft.
(15) Using a drift, remove shaft and bearings from retainer (53), and lift off spacer (52) and shim (48).



1 Pin, tapered
2 Knob,screw
3 Screw, adjusting, cylinder discharge lever
4 Screw, piston stop
5 Screw, piston bar
6 Bar, piston
7 Stop,piston
8 Piston, dough measuring and discharge
9 Screw, drive, piston discharge lever pin
10 Nut, adjusting screw
11 Pin, piston discharge lever
12 Plug, adjusting screw
13 Roller, piston discharge lever
14 Spring, adjusting screw
15 Setscrew, adjusting screw nut
16 Spring, shaft collar
17 Screw, collar spring
18 Key, machine, discharge lever
19 Key, machine, discharge lever
20 Pin, cotter, discharge roller
21 Bearing, sleeve, piston discharge lever roller
22 Setscrew, cylinder discharge lever
23 Roller with bearing, cylinder discharge
24 Lever with stud, cylinder discharge
25 Shaft, cylinder discharge lever
26 Setscrew, collar
27 Collar, discharge lever shaft
28 Lever, cylinder piston discharge
29 Spring, cylinder discharge lever shaft
30 Setscrew, lever stud
31 Cylinder, dough box
32 Fitting, lubrication, connecting stud
33 Stud, connecting, cylinder and lever

Figure 7. Divider cylinder, exploded view.

(16) Loosen setscrew (1) on sprocket (2), and remove sprocket from shaft (7).
(17) Remove capscrews (75) from retainer (3), and pry retainer from housing (10).
(18) Loosen setscrew (74) on gear (6).
(19) Using a drift, remove shaft (7) from sprocket (2) end of the housing, and remove key (73), bearing cups (4 and 34), and cones and rollers (5 and 35).
(20) Lift gear (6) from housing (10).
(21) Remove capscrews that attach gearbox (40) to housing (10), and pry off gearbox.
(22) Unscrew gage (9), stud (38), and nut (37) from housing (10), and remove washer (36).

c. Repair. Inspect parts for defects and install serviceable items as authorized.

d. Assembly. Reverse procedures in b above. Be sure to align worn wheel gear (6) under worn shaft (70).

e. Installation. Reverse procedures in a above, and service unit according to instructions on LO 10-7360-201-20-2.

f. Adjustments.

(1) Adjust setscrew (66) on retainer (68) so that wormshaft (70) turns freely in its bearings with only slight

end movement.

(2) Adjust chains (TM 10-7360-201-20).

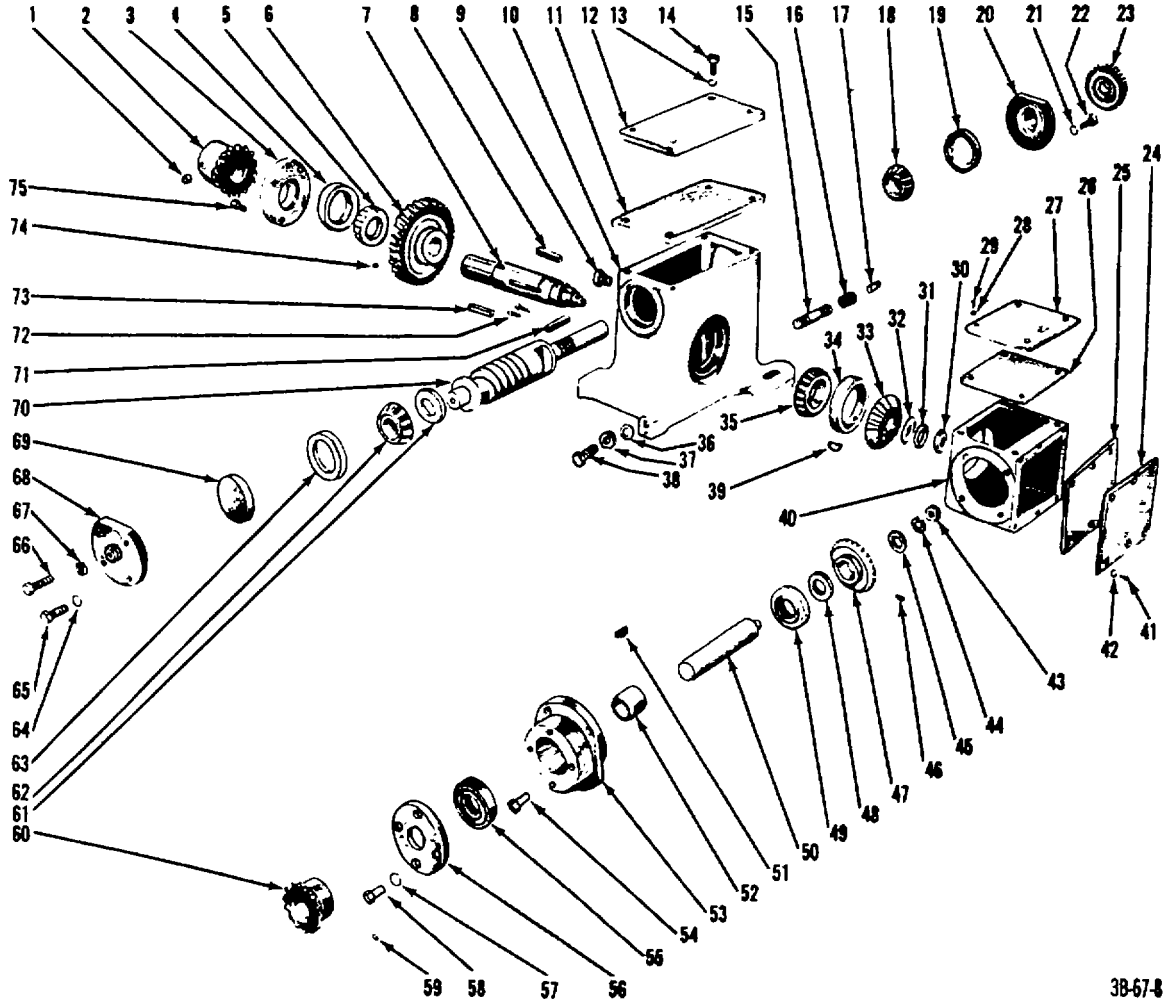


Figure 8. Divider gear reduction unit, exploded view.

1 Setscrew, worm wheel shaft sprocket
2 Sprocket, worm wheel shaft
3 Retainer, bearing, worm wheel shaft
4 Cup, bearing, worm wheel shaft
5 Cone and rollers, bearing, worm wheel shaft
6 Gear, worm wheel
7 Shaft, worm wheel
8 Key, worm wheel gear
9 Gage, oil level
10 Housing, reduction unit
11 Gasket, top cover, reduction unit
12 Cover, housing, reduction unit
13 Lockwasher, cover bolt
14 Bolt, cover
15 Nipple, oil drain
16 Coupling, oil drain
17 Plug, oil drain
18 Cone and rollers, bearing wormshaft
19 Cup, bearing, wormshaft
20 Retainer, bearing, wormshaft rear
21 Lockwasher, retainer
22 Capscrew, retainer
23 Wheel, sprocket, wormshaft drive
24 Cover, side, bevel gearbox
25 Gasket, side cover, bevel gearbox
26 Gasket, top cover, bevel gearbox
27 Cover, top, bevel gearbox
28 Lockwasher, top cover
29 Screw, top cover
30 Nut, worm wheel shaft
31 Lockwasher, worm wheel shaft
32 Washer, flat, worm wheel shaft
33 Gear, bevel
34 Cup, bearing, worm wheel shaft
35 Cone and rollers, bearing, worm wheel shaft
36 Washer, flat, adjusting stud
37 Nut, adjusting stud
38 Stud, adjusting, housing
39 Key, woodruff, bevel gear
40 Gearbox, bevel
41 Screw, side cover
42 Lockwasher, side cover
43 Nut, bevel gear shaft
44 Lockwasher, bevel gear shaft
45 Washer, flat, bevel gear shaft
46 Setscrew, bevel gear
47 Gear, bevel
48 Shim, bevel gear hub
49 Bearing, ball, bevel gear shaft
50 Shaft, bevel gear
51 Key, woodruff, bevel gear shaft sprocket wheel
52 Spacer, sleeve, bevel gear shaft bearing
53 Retainer, bearing, bevel gear shaft
54 Capscrew, retainer
55 Bearing, ball, bevel gear shaft
56 Cap, retainer, bevel gear shaft bearing
57 Lockwasher, retainer cap
58 Bolt, retainer cap
59 Setscrew, sprocket wheel
60 Wheel, sprocket, bevel gear shaft
61 Shim, wormshaft
62 Cone and rollers, bearing, wormshaft
63 Cup, bearing, wormshaft
64 Lockwasher, retainer
65 Capscrew, retainer
66 Setscrew, retainer
67 Jamnut, retainer
68 Retainer, bearing, wormshaft front
69 Plate, wormshaft adjusting
70 Wormshaft
71 Key, machine, wormshaft drive sprocket wheel
72 Pin, cotter, wormshaft drive sprocket wheel
73 Key, machine, worm wheel shaft sprocket
74 Setscrew, worm wheel gear
75 Capscrew, retainer, worm wheel shaft bearing

Figure 8 - Continued.

Section III. MIXER ASSEMBLY

24. Mixer Assembly

a. Removal.

(1) Disconnect and tag all electrical wiring.
(2) Remove cotter pins, nuts, bolts, and lockwashers that attach mixer assembly to floor plate of trailer.
(3) Using a crane, remove mixer assembly from trailer.

b. Repair. Inspect the mixer assembly and all of its components to be sure they are in serviceable 'condition. Repair or replace defective parts as necessary and authorized.

c. Installation. Reverse procedures in *a* above.

25. Mixer Bowl Assembly

a. Removal and Disassembly.

(1) Turn bowl dump handle so that bowl is placed in a three-quarter dump position.
(2) Remove bowl dump handle capscrew, and remove handle and key.
(3) Remove side cover capscrews and lift off both side covers.

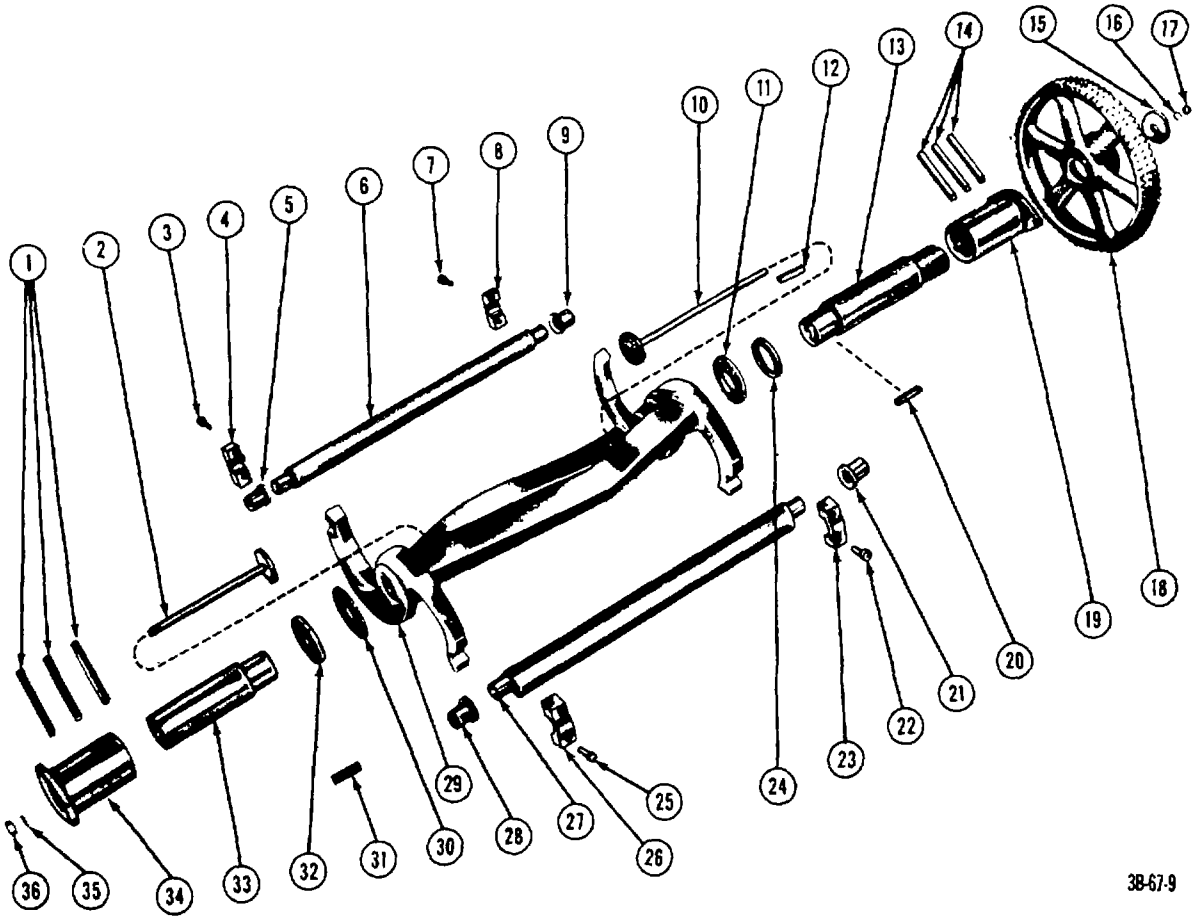
(4) Remove master link in mixer agitator drive chain, and remove chain.
(5) Remove jamnut (17, fig. 9), lock-washer (16), and flat washer (15) from rod (10).
(6) Using a gear puller, remove sprocket wheel (18) and key (12) from shaft (13).
(7) Remove nut (36) and lockwasher (35) from rod (2).
(8) Support agitator (29) with two 2 x 4's.
(9) Remove rods (2 and 10) from shafts (13 and 33).
(10) Remove cotter pins and nuts that attach bearings (19 and 34) to mixer bowl trunnion, and use a pry bar to remove bearings.
(11) Carefully remove flax packing (1 and 14) from around shafts (13 and 33).
(12) Using a drift inside of bowl, remove shafts (13 and 33) and keys (20 and 31) from trunnions.
(13) Remove agitator (29) and washers (11 and 30) from bowl.
(14) Remove glands (24 and 32) from trunnions.
(15) Unlatch mixer bowl cover clamps.
(16) Remove bolts, nuts, and lockwashers that attach bowl cover to water tempering tank and that attach bowl cover support to mixer frame. Remove cover with support.
(17) Remove bolts, nuts, and lockwashers that attach water tempering tank to mixer frame, and lift off tank.
(18) Remove bolts, nuts, and lock-washers that attach right top cover to mixer frame, and liftoff cover.
(19) Remove capscrews that attach pillow block cap to pillow block on each side of mixer, and remove caps.
(20) Attach chain hoist around mixer bowl and take up slack.
(21) Remove lubrication lines to trunnion on each side of mixer.
(22) Support trunnion that is attached to bowl on each side of mixer.
(23) Remove bolts and lockwashers that attach trunnion on each side of mixer, and lift out trunnions.
(24) Lift out mixer bowl.
(25) Remove roller cap bolts (3, 7, 22, and 25) and roller caps (4, 8, 23, and 26). Lift off rollers (6 and 27) with bushings (5, 9, 21, and 28) from agitator (29).
(26) Slide bushings off rollers.

b. Repair.
(1) File burs from shafts, rollers, and bushings.
(2) Inspect parts for defects and install serviceable items as authorized.

c. Assembly and Installation. Using new flax packing, reverse procedures in *a* above. Be sure to align sump in shaft bearing with hole in trunnion on each side of mixer.

26. Mixer Bowl Dump Assembly

a. Removal and Disassembly.
(1) Remove mixer bowl (par. 25a).
(2) Remove grease line to handwheel shaft.
(3) Remove bolts that attach bearing support to mixer frame, and remove support, handwheel shaft, and bevel gear.
(4) Remove -capscrews and lockwashers that attach housing cover (7, fig. 10) and grease line support to housing, and remove cover, support, and gasket.
(5) Remove capscrew that attaches dump shaft washer to dump shaft, and remove washer.
(6) Loosen setscrew on worm wheel (5, fig. 11) and, using a gear puller, remove worm wheel.
(7) Remove capscrews and lockwashers that attach cap (1) to housing, and remove cap and grease line support.
(8) Loosen setscrew on bevel pinion (3) and slide pinion off wormshaft (2).
Remove key.
(9) Remove nut from wormshaft and, using a pry bar, remove wormshaft from the cap end of the housing.
(10) Remove capscrew and washer that attach dump pinion to dump shaft, and remove pinion and key.
(11) Pull out dump shaft.



1 Packing, flax, agitator shaft
2 Rod, agitator left shaft
3 Bolt, roller cap
4 Cap, roller, agitator bushing
5 Bushing, small roller
6 Roller, small, agitator
7 Bolt, roller cap
8 Cap, roller, agitator bushing
9 Bushing, small roller
10 Rod, agitator right shaft
11 Washer, keyway, agitator
12 Key, machine, sprocket
13 Shaft with sleeve, agitator, right
14 Packing, flax, agitator shaft
15 Washer, flat, right shaft rod
16 Lockwasher, right shaft rod
17 Jamnut, right shaft rod
18 Wheel, sprocket, agitator
19 Bearing, sleeve, agitator right shaft
20 Key, machine, right shaft
21 Bushing, eccentric roller
22 Bolt, roller cap
23 Cap, roller, agitator bushing
24 Gland, packing, agitator shaft
25 Bolt, roller cap
26 Cap, roller, agitator bushing
27 Roller, eccentric, agitator
28 Bushing, eccentric roller
29 Agitator
30 Washer, keyway, agitator
31 Key, machine, left shaft
32 Gland, packing, agitator shaft
33 Shaft with sleeve, agitator, left
34 Bearing, sleeve, agitator left shaft
35 Lockwasher, left shaft rod
36 Nut, left shaft rod

Figure 9. Mixer bowl agitator assembly, exploded view.

(12) Remove capscrews that attach worm wheel housing to mixer frame, and remove housing.
(13) If bearing or bushing require replacement, press them off.

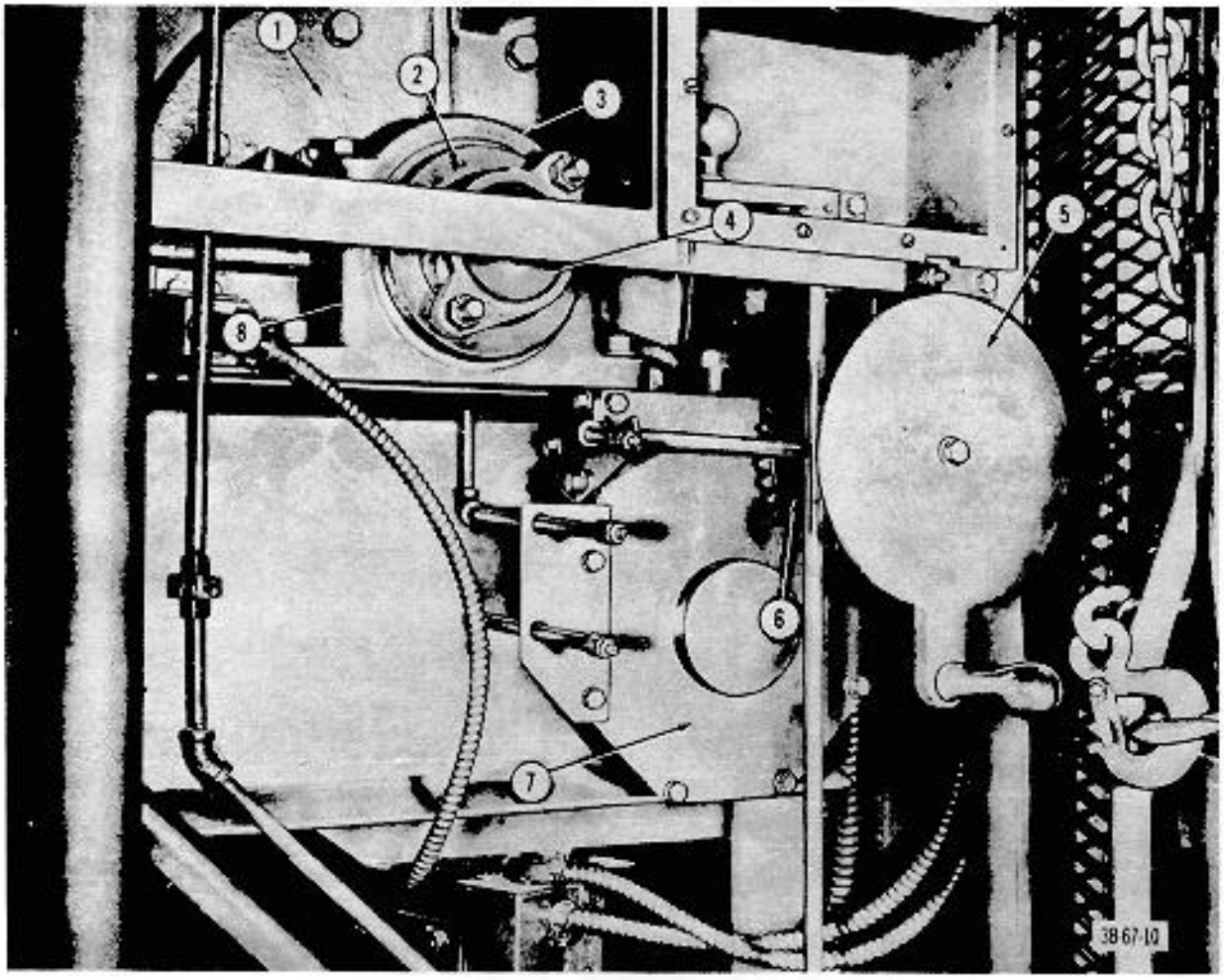
b. Repair. Inspect parts for defects and install serviceable items as necessary and authorized.

c. Assembly and Installation. Using a new housing gasket, reverse procedures in *a* above.

27. Mixer Gear Reduction Unit

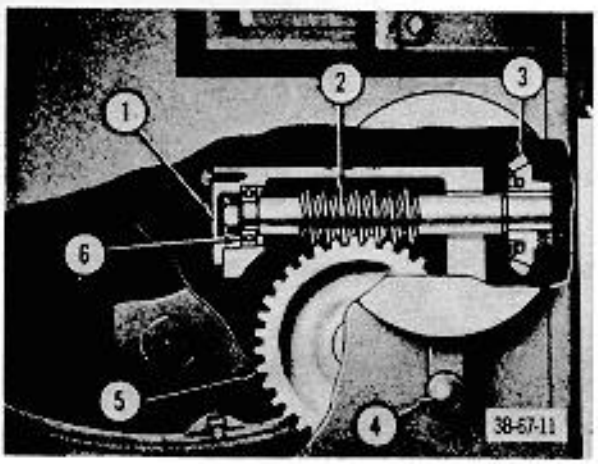
a. Removal and Disassembly.

(1) Remove the mixer motor and gear reduction unit (TM 10-7360-20120).
(2) Remove nuts (37, fig. 12) that attach bars (36) to housing (4), and remove bars.
(3) Pry seal ring (35) from opening in housing.



1 Flange, trunnion
2 Trunnion, agitator left
3 Cap, pillow block
4 Shaft with sleeve, agitator, left
5 Handwheel, dump
6 Gear, bevel
7 Cover, worm wheel housing
8 Block, pillow

Figure 10. Mixer bowl dump assembly, installed on mixer.



1 Cap, bearing, wormshaft
2 Wormshaft
3 Pinion, bevel
4 Handwheel, dump
5 Wheel, worm
6 Bearing, ball, dump wormshaft

Figure 11. Mixer bowl dump assembly, partially cutaway view.

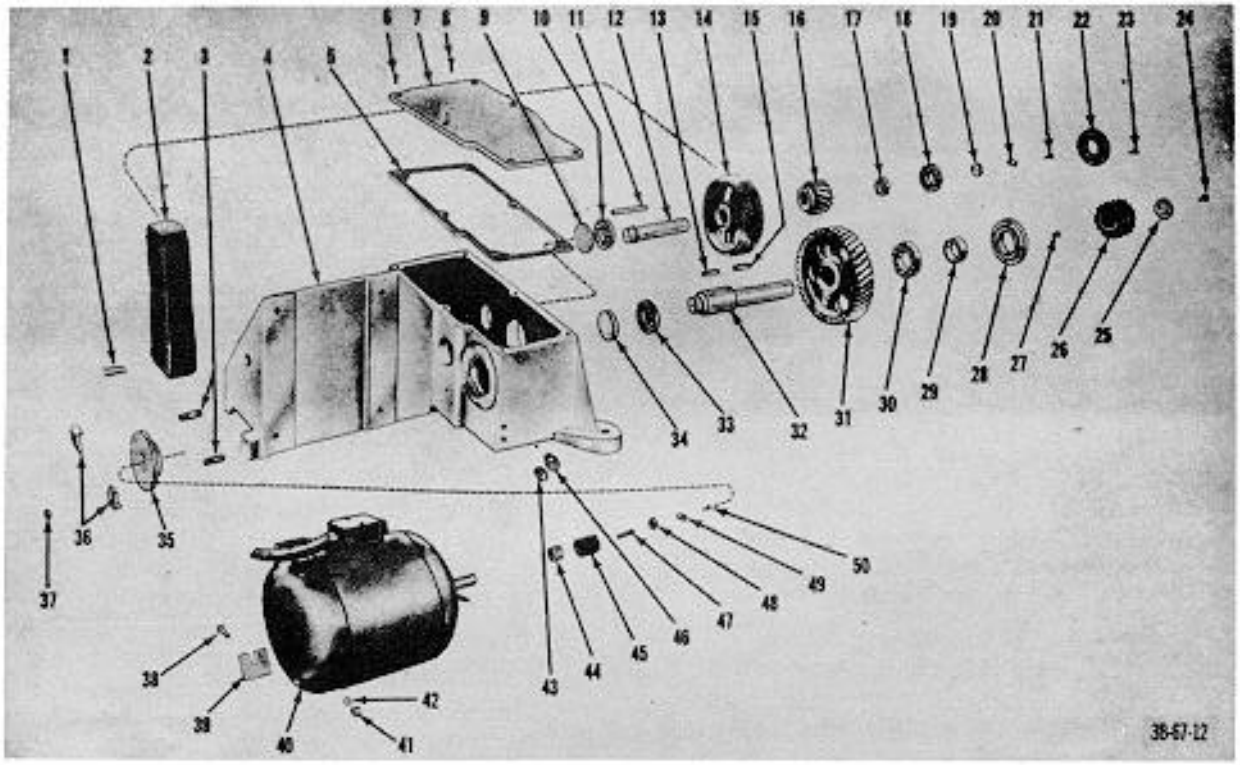
(4) Remove bolts (38), nuts (41), lockwashers (42), and shims (39) from housing.
(5) Pivot the motor so the silent chain (2) loosens, and remove chain from sprocket wheel (45).
(6) Separate motor (40) and housing
(7) Remove bolts (6 and 8), cover (7), and gasket (5) from housing.
(8) Lift silent chain (2) off sprocket wheel (14) and lift it out of housing.
(9) Remove capscrews (24) and retaining washer (25) . Using a gear puller, remove pinion (26) and key (15) from shaft (32) .
(10) Remove bolts (27) from cap (28), and remove cap and sleeve (29) from shaft (32).
(11) Using a drift, drive the shaft (32) out the motor end of the housing. Remove key (13).
(12) Lift gear (31) from housing.
(13) Tap bearing (30) from housing.
(14) Remove bolts (23) from cup (22), and remove cup.
(15) Remove bolts (21) from pad (20), and remove pad and washer (19) from jackshaft (12).
(16) Using a drift, drive the jackshaft (12) to the motor end of housing, and remove cup (9) and bearing (10).
(17) Slide gear (16) and sprocket wheel (14) off jackshaft (12), and remove key (11).
(18) Lift jackshaft (12) from housing.

b. Repair. Inspect parts for defects and install serviceable items as authorized.

c. Assembly and Installation. Using a new gasket, reverse procedures in *a* above.

d. Adjustments.

(1) The mixer agitator drive chain adjustment is made by adding or removing shims under the housing (4) until there is a 1/2-inch figure-pressure deflection between the sprocket w heel and pinion (26).
(2) The silent chain (2) adjustment is made by adding or removing shims between the motor (40) and housing (4) until there is a 1/2-inch fingerpressure deflection between the sprocket wheels (14 and 45).



1 Pin, connecting, silent chain
2 Chain, silent, mixer gear reducer
3 Studs, ring clamp bar
4 Housing, gear reduction unit
5 Gasket, housing cover
6 Bolt, housing cover
7 Cover, housing
8 Bolt, housing cover
9 Cup, bearing, jackshaft
10 Bearing, ball, jackshaft
11 Key, machine, jackshaft gear
12 Jackshaft
13 Key, machine, drive shaft gear
14 Wheel, sprocket, jackshaft
15 Key, machine, drive shaft pinion
16 Gear, helical, jackshaft
17 Spacer, sleeve, jackshaft
18 Bearing, ball, jackshaft
19 Washer, retaining, jackshaft
20 Pad, locking
21 Bolt, jackshaft retaining washer
22 Cup, jackshaft bearing
23 Bolt, jackshaft bearing cap
24 Capscrew, retaining washer
25 Washer, retaining, drive shaft pinion
26 Pinion, drive shaft
27 Bolt, bearing cap
28 Cap, bearing, drive shaft
29 Sleeve, oil return, drive pinion shaft
30 Bearing, ball, drive shaft
31 Gear, helical, drive shaft
32 Shaft, drive pinion
33 Bearing, ball, drive shaft
34 Cup, bearing, drive shaft
35 Ring, seal, motor shaft
36 Bars with pads, seal ring clamp
37 Nut, clamp bar stud
38 Bolt, motor mounting
39 Shim, mixer motor-to-housing
40 Motor, mixer
41 Nut, motor mounting
42 Lockwasher, motor mounting
43 Plug, pipe, housing
44 Sleeve, oil return, motor shaft
45 Wheel, sprocket, motor
46 Gage, oil level, housing
47 Key, machine, motor sprocket wheel
48 Washer, retaining, motor sprocket wheel
49 Pad, locking, motor sprocket wheel
50 Bolt, motor sprocket wheel

Figure 12. Mixer gear reduction unit, exploded view.

Section IV. MOLDER ASSEMBLY

28. Molder Assembly

a. Removal.

(1) Remove screws from molder motor junction box cover, remove cover, disconnect and tag wiring, and disconnect conduit from junction box.
(2) Remove cotter pins, nuts, and bolts that attach molder to trailer bed.
(3) Attach suitable lift to molder and remove it from trailer.

b. Repair. Inspect molder and all of its components to be sure they are in serviceable condition. Repair or replace defective parts as necessary and authorized.

c. Installation. Reverse procedures in *a* above.

29. Molder Duster Bearings

a. Removal.

(1) Disconnect sheeting roll duster drive rod at regulating lever.
(2) Loosen knobs that hold duster in place, and slide duster from support.
(3) Loosen setscrew in shaft collar, and remove collar from end of shaft.
(4) Loosen setscrews in duster agitator, slide shaft from duster, and lift out agitator.
(5) Press out sleeve bearings from duster housing.

b. Installation. Reverse procedures in *a* above.

30. Molder Sheeting Rolls-and-Conveyor Drive Shaft and Bearings

a. Removal.

(1) Remove headframe cover plates (TM 10-7360-201-20).
(2) Remove chains in left side headframe (TM 10-7360-201-20).
(3) Loosen setscrew in sheeting roll-and conveyor drive gear, and remove gear from drive shaft in left side headframe.
(4) Slide the drive shaft out the right side headframe.
(5) Using a bearing puller, remove bearings from each headframe.

b. Installation. Using a bearing puller, press serviceable bearings into headframes and reverse procedures in *a* above.

31. Molder Sheeing Roll Shaft Assemblies and Bearings

a. Removal.

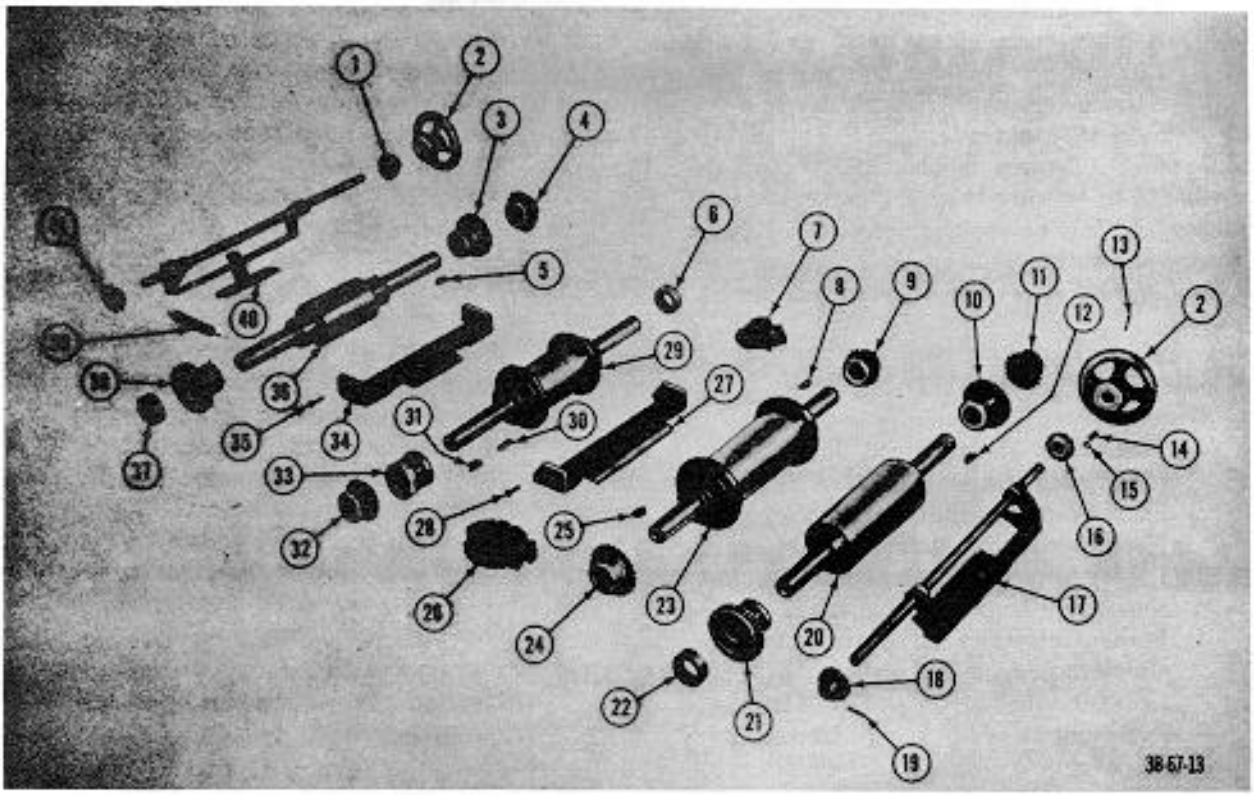
(1) Disconnect sheeting roll duster drive rod at regulating lever.
(2) Remove capscrews that attach duster frame to headframes, and remove duster frame.
(3) Remove headframe cover plates, chains, and motor (TM 10-7360-20120).
(4) Loosen setscrews in collars (6, 22, and 37, fig. 13), sprocket wheels (9, 11, and 24), and hubs with sprockets (4 and 32). Remove collars, sprocket wheels, and hubs with sprockets.
(5) Remove eccentric bearings (3, 10, 21, and 38) from ends of shafts (20 and 36).
(6) Remove capscrews that attach conveyor frame to each headframe, and remove shims.
(7) Remove socket head screws and tapered pins that attach left side headframe to base plate and to headframe support.
(8) Remove lower and upper front supports with blades (par. 32a(2)-(4)).
(9) Remove bolts (28 and 35) that attach lower and upper rear supports with blades (27 and 34) to left side headframe.
(10) Loosen setscrew in drive gear and remove gear from drive shaft in left side headframe. Slide the drive shaft out the right side headframe.
(11) Remove upper and lower front sheeting roll shafts with rolls (20 and 36) and eccentric (33) from right side headframe.
(12) Remove socket head screws that attach supports with blades (27 and 34) to right side headframe, and remove supports with blades.

(13) Lift out upper and lower rear sheeting roll shafts with rolls (23 and 29). (14) Press out bearings.

b. Repair. File burs from shaft collars, sprocket wheels, and sprockets. Replace defective parts with serviceable items as authorized.

c. Installation. Reverse procedures in *a* above.

d. *Adjustment*. To adjust chains in left side headframe to 1/2-inch figure-pressure deflection, loosen nut on idler sprocket eccentric shaft, turn sprocket to adjust chain, and tighten nut to secure chain adjustment.



1 Pinion upper front sheeting roll adjusting shaft
2 Handwheel, sheeting roll, adjusting
3 Bearing with gear and pin stop, eccentric, upper front sheeting roll shaft
4 Hub with sprocket, upper front sheeting roll shaft
5 Key, woodruff, hub with sprocket
6 Collar, shaft, upper rear sheeting roll
7 Chain, roller, front sheeting roll drive
8 Key, woodruff, lower gear sheeting roll shaft sprocket wheel
9 Wheel, sprocket, lower rear sheeting roll shaft
10 Bearing with gear and pin stop, eccentric, lower front sheeting roll shaft
11 Wheel, sprocket, lower front sheeting roll shaft
12 Key, woodruff, lower front sheeting roll shaft sprocket wheel
13 Pin, tapered, handwheel
14 Spring, clicking device
15 Ball, clicking device
16 Pinion, lower front sheeting roll adjusting shaft
17 Support with blade, lower front sheeting roll
18 Pinion, lower front sheeting roll adjusting shaft
19 Pin, tapered, pinion
20 Shaft with roll, lower front sheeting roll
21 Bearing with gear and pin stop, eccentric, lower front sheeting roll shaft
22 Collar, shaft, lower front sheeting roll
23 Shaft with roll, lower rear sheeting roll
24 Wheel, sprocket, lower rear sheeting roll shaft

Figure 13. Molder sheeting rolls, exploded view.

25 Key, woodruff, lower gear sheeting roll shaft sprocket wheel
26 Chain, roller, rear sheeting roll drive
27 Support with blade, lower rear sheeting roll
28 Bolt, support
29 Shaft with roll, upper rear sheeting roll
30 Key, machine, eccentric
31 Key, woodruff, hub with sprocket
32 Hub with sprocket, upper rear sheeting roll shaft
33 Eccentric, upper rear sheeting roll shaft
34 Support with blade, upper rear sheeting roll
35 Bolt, support
36 Shaft with rod. upper front sheeting roll
37 Collar, shaft, upper front sheeting roll shaft
38 Bearing with gear and coin stop, eccentric, upper front sheeting pin shaft aft
39 Spring, compression, front sheeting.; roll adjusting shaft handwheel
40 Support with blade, upper front sheeting roll
41 Pinion, upper front sheeting roll adjusting shaft

Figure 13-Continued.

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32. Molder Sheeting Roll Adjusting Shaft Bearings

a. Removal.
(1) Remove headframe cover plates (TM 10-7360-201-20).
(2) Release springs (39, fig. 13) that hold supports with blades (17 and 40) against shafts with rolls (20 and 36).
(3) Drive tapered pins (19) out large ends of pinions (1, 16, 18, and 41), and remove pinions from shaft.
(4) Loosen setscrews in shaft 'collars, slide shafts from headframes, and lift off collars and supports with blades (17 and 40).
(5) Using a bearing puller, remove sleeve bearing from each headframe.

b. Installation. Using a bearing puller, install serviceable sleeve bearings and reverse procedures in *a* above.

Section V. OVEN TRAILER

33. Brakedrum

Follow procedures in paragraph 8.

34. Hub

Follow procedures in paragraph 9.

35. Axle

Follow procedures in paragraph 11.

36. Oven Blower Motor Assembly

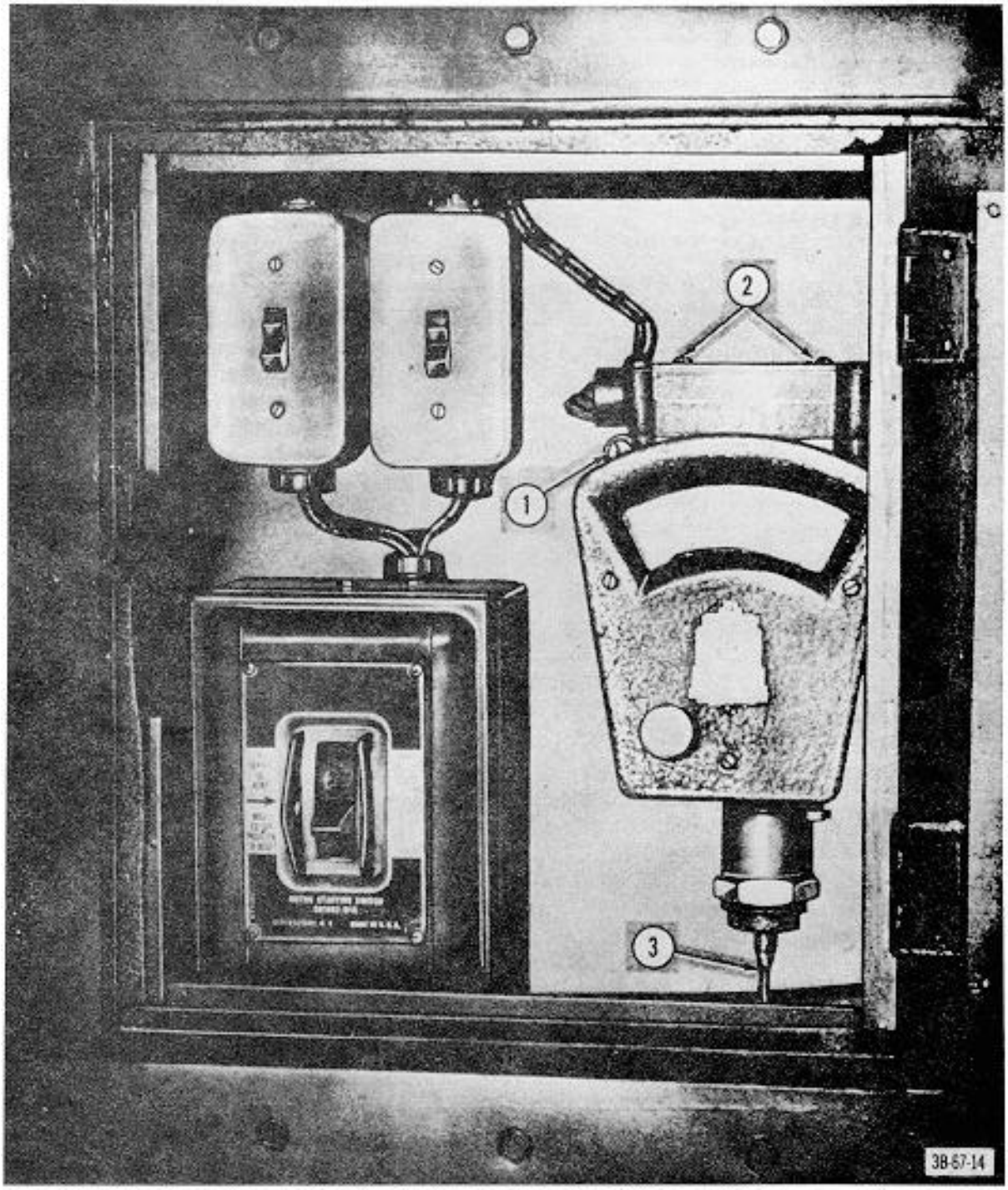
a. Removal and Installation. Follow procedures in TM 10-7360-201-20.

b. *Repair and Overhaul*. Follow applicable procedures in TM 5-764.

Section VI. OVEN MACHINERY

37. Temperature Control

a. Removal.
(1) Remove mounting screws (1, fig. 14) from the temperature control.
(2) Remove screws (2) on top of temperature "control box, and disconnect and tag wires.
(3) Remove temperature control, being careful not to bend element with bulb and sleeve (3) attached to bottom of control.
(4) Follow element through cylindrical case to the storage compartment, and (2, fig. 15) from the oven.
(5) Remove split rubber grommet (1) surrounding element.
(6) Straighten element, being careful not to get any kinks or sharp bends in it, and draw it through the cylindrical case.
(7) Remove temperature control element, bulb, and sleeve as a unit, being careful not to damage the parts.



1 Screw, mounting
2 Screws, box cover
3 Element with bulb and sleeve

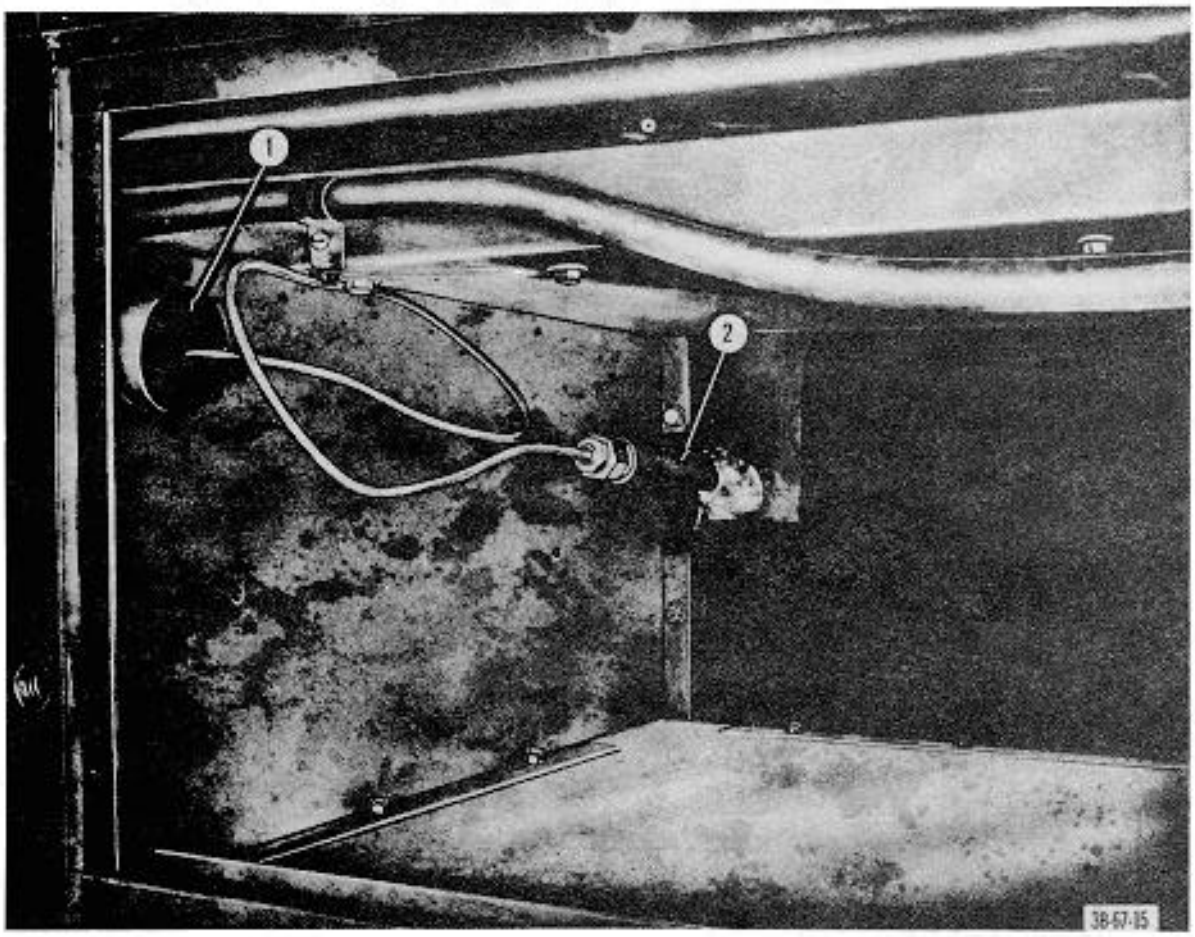
Figure 14. Temperature control, mounted in oven control panel.

b. Repair.

(1) Inspect wiring for defects and replace it as necessary.

(2) Inspect the temperature control and the element for defects, and install serviceable items as necessary and authorized.

c. Installation. Reverse procedures in *a* above. Special care must be taken to avoid damaging the element when inserting it into the heater duct. Do not kink, strain, puncture, or collapse the element.



1 Grommet, rubber

2 Element with bulb and sleeve

Figure 15. Sensitive element. installed in oven.

38. Combustion Tunnel

a. Removal.

(1) Lift burner from burner head plate, and place it in the storage compartment.

(2) Remove nuts from burner head plate, and lift off head plate.

(3) Withdraw combustion tunnel from oven as shown in figure 16.

b. Installation. Reverse procedures in *a* above.

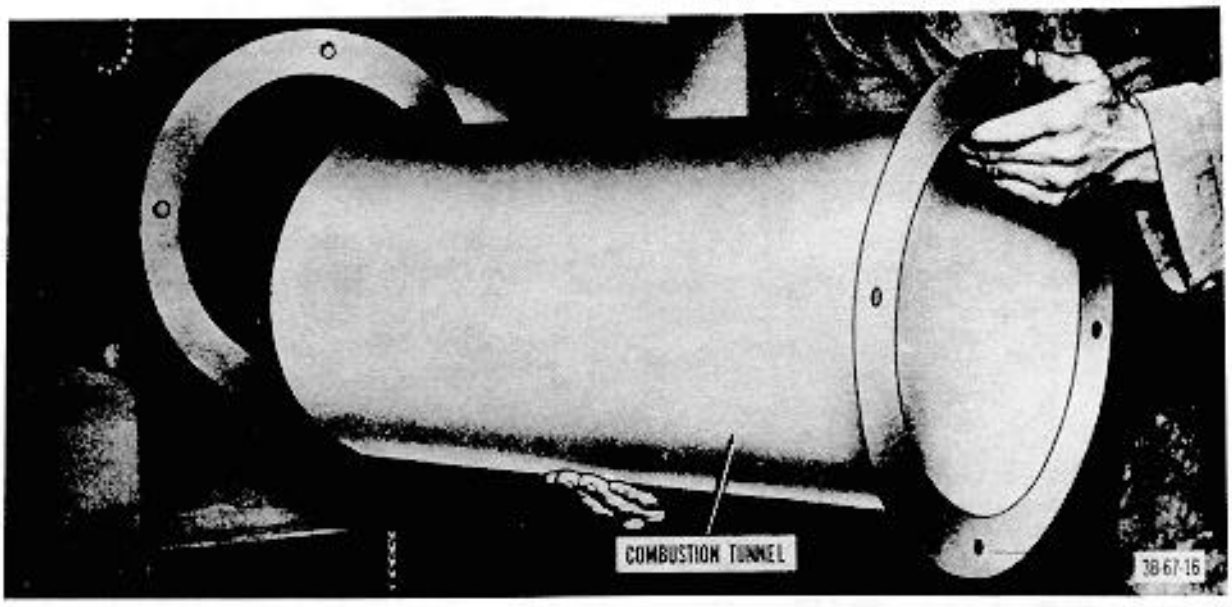


Figure 16. Removing combustion tunnel.

Section VII. PROOFING CABINET AND FLOUR SIFTER

39. Proofing Cabinet Thermostatic Switch

a. Removal.

(1) Loosen thumbscrews and open control box door.
(2) Remove dial knob (3, fig. 17) by pulling on it.
(3) Remove small screws from dial shield (2), and remove shield.
(4) Remove screws from cover plate (1).
(5) Pull switch forward from control box.
(6) Disconnect and tag ground wire connection (5).
(7) Remove and tag both wires from screw of input terminal; one wire is from the power cable and the other goes to the indicating light.
(8) Remove and tag wire's from input terminal.
(9) Disconnect and tag wires leading from output terminals (7 and 8) to strip heaters inside the cabinet.
(10) Remove thermostatic switch from control box.

b. installation. Reverse procedures in *a* above.

c. Adjustment.

(1) Loosen thumbscrews and open control box door.

(2) Remove dial knob (3, fig. 17) by pulling on it.
(3) Loosen screws which lock slotted disk (4) to 'cylinder.
(4) Turn slotted disk to obtain variation of temperature ranges.
(v) When desired range is found for cabinet heat, tighten the two screws to hold the disk in the proper position.
(6) Install dial knob, close door, and tighten thumbscrews.

40. Flour Sifter Electric Motor

a. Removal and Installation. Follow procedures in TM 10-7360-201-20.

b. Repair, Testing, and Overhaul. Follow applicable procedures in TM 5-764.

41. Flour Sifter Counterbalance Sheave Assembly

a. Removal and Disassembly.
(1) Loosen lower clamp (4, fig. 18), release barrel bolts (2 and 17),and lift off feed hopper (1).
(2) Remove rod nuts (16) from top of holddown box, and lift off top.
(3) Lift off sieve frames (15).
(4) Remove bolts from each of the lower hanger rod supports, and lift off sieve frame bed with hanger rods (8).
(5) Loosen nut and bolt in motor adjusting bracket (12), swing motor (11) toward counterbalance sheave (14), and remove V-belt (13) from sheaves.
(6) Lift off counterbalance sheave, spider (1, fig. 19), spindle (10), and bearings (2, 11, and 13) as a unit.
(7) Remove capscrews (8) and lockwashers (9) that attach spindle to sheave, and remove spindle, bearings, and spacer (12) from sheave.
(8) Press bearings and spacer from spindles
(9) Remove bolts that attach housing (14) to sifter frame, and lift off housing.
(10) Remove screws with lockwashers (3) that attach cover (4) to sheave, and remove counterweights (5 and 7).
(11) Press bearing (2) from spider (1).

b. Repair. Inspect parts for defects and install serviceable items as authorized.

c. Assembly and Installation. Reverse procedures in *a* above.

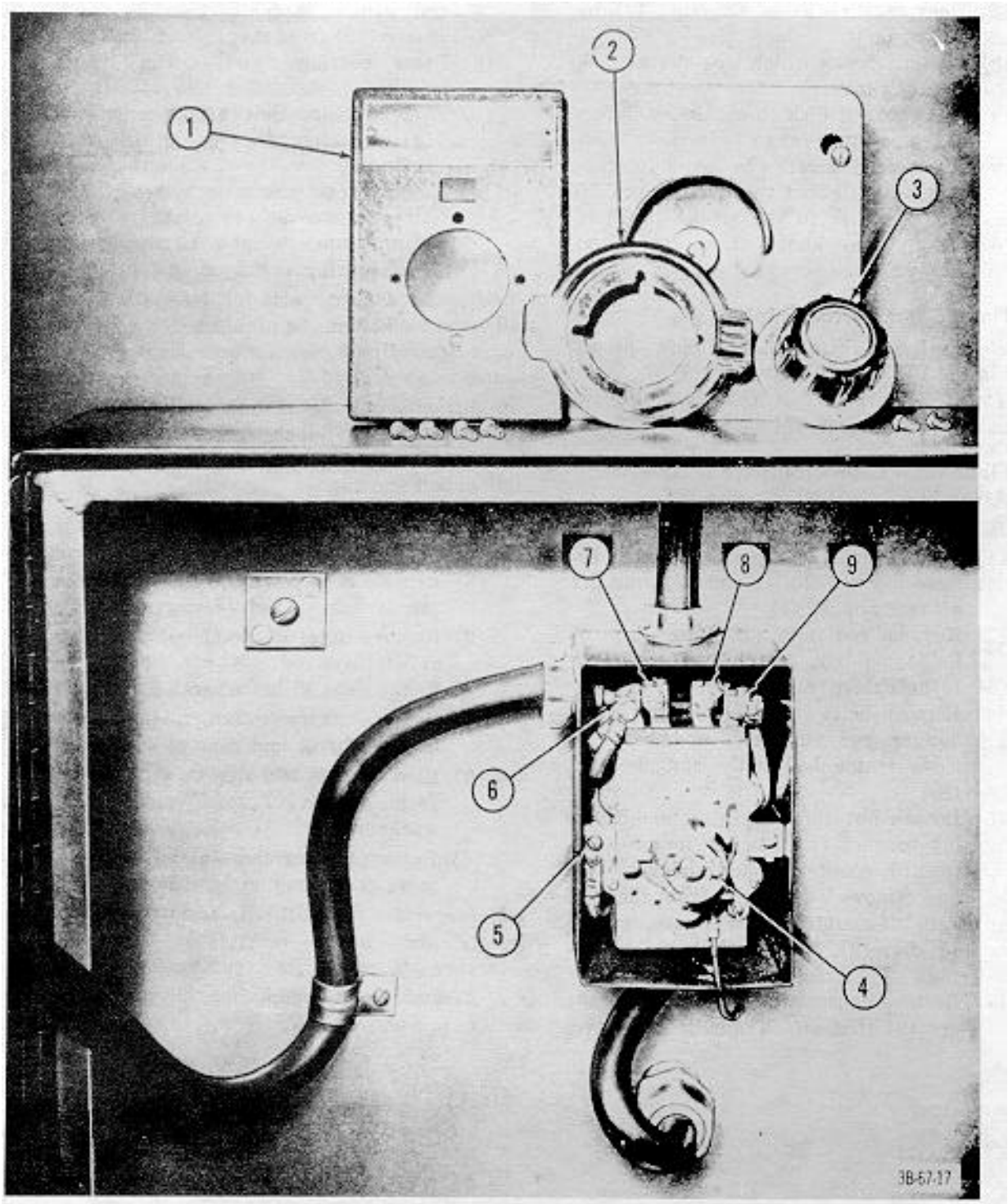
d. Adjustment. Set motor and adjusting bracket to allow 1/2-inch finger-pressure deflection in V-belt, between sheave centers. Tighten bolt and nut.

42. Sieve Frame Hanger Rods

a. Removal and Disassembly.
(1) Remove capscrews and lockwashers at top of hanger rod (8, fig. 18).
(2) Remove nuts, lockwashers, and bolts at bottom of rod.
(3) Remove rod with washers.
(4) Remove capscrew and retaining cap at top of rod, and remove washers.
(5) Remove nuts and sleeves with flanges from bottom of rods, and remove washers.
(6) Repeat (1) through (5) above to remove other rods and washers

b. Inspection. Inspect rods and washers for defects and install serviceable items as necessary.

c. Assembly and Installation. Reverse procedures in *a* above.



1 Plate, cover
2 Shield, dial
3 Knob, dial
4 Disk, slotted

Figure 17. Thermostatic switch, partially disassembled.

5	Connection, ground wire	8	Terminal, output
6	Terminal input	9	Terminal, input
7	Terminal, output		

Figure 17. - Continued

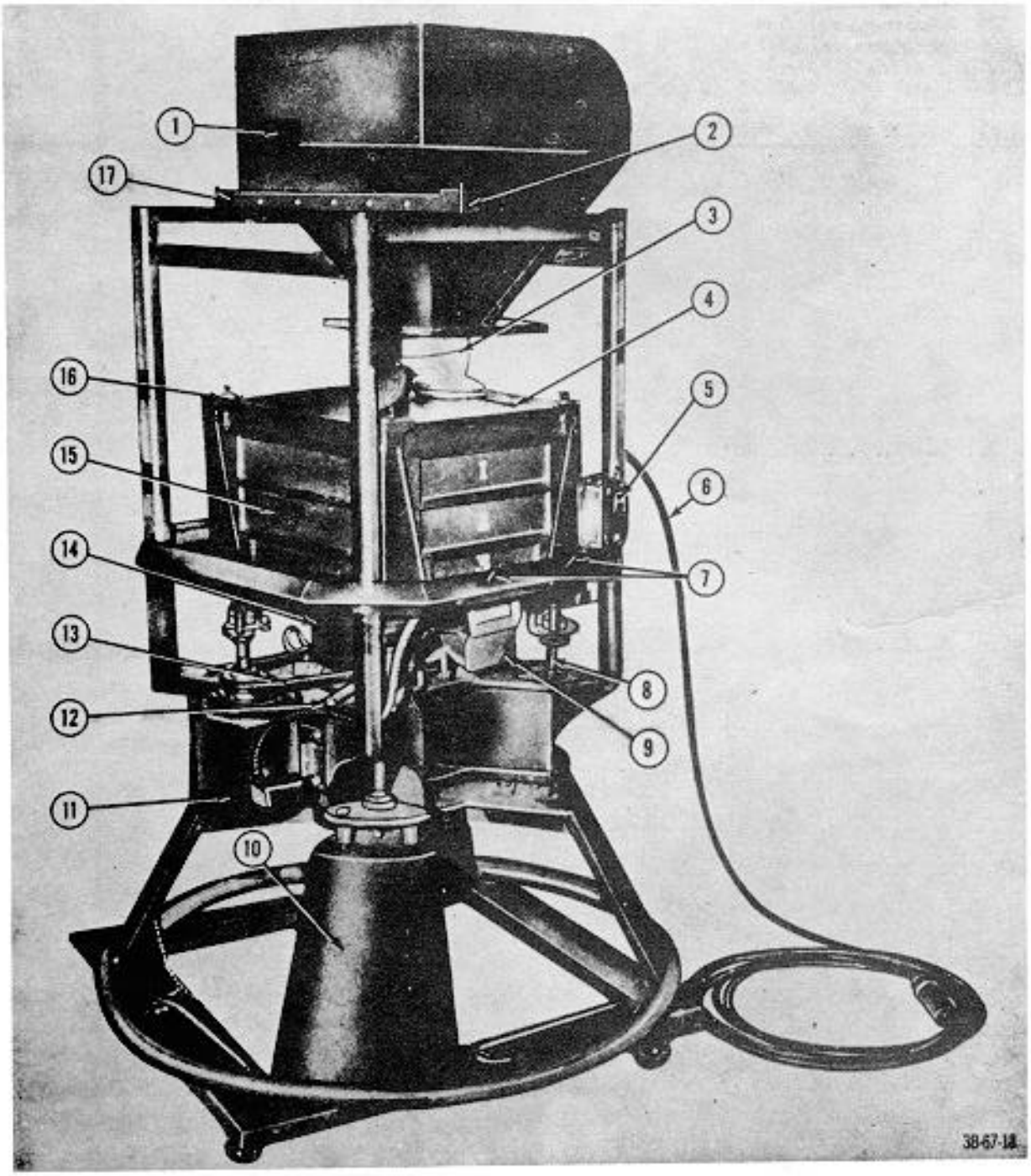
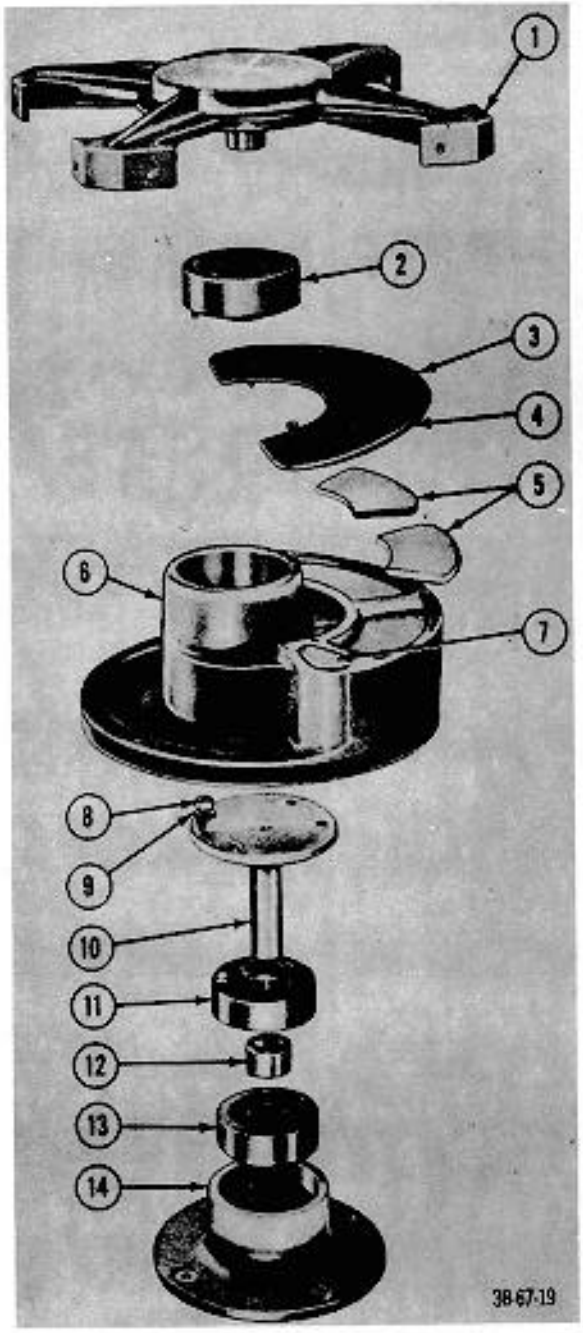


Figure 18. Flour sifter, assembled.

1	Hopper, feed	10	Base, sifter
2	Bolt, barrel	11	Motor
3	Tube, cloth	12	Bracket, adjusting, motor
4	Clamp, lower	13	V-belt, drive
5	Starter, manual	14	Sheave, counterbalance
6	Cable, power	15	Frames, sieve
7	Spurs. sack	16	Nut, holddown box rod
8	Rod, hanger, sieve frame	17	Bolt, barrel
9	Door, discharge hopper		

Figure 18-Continued.



1 Spider, counterbalance sheave
2 Bearing, ball, spider
3 Screw with lockwasher, cover
4 Cover, counterweight

1 Spider, counterbalance sheeve
2 Bearing, ball, spider
3 Screw with lockwasher, cover
4 Cover, counterweight
5 Counterweights
6 Sheave, counterbalance
7 Counterweight
8 Capscrew, sheave-to-spindle
9 Lockwasher, sheave-to-spindle
10 Spindle, counterbalance sheave
11 Bearing, ball, spindle upper
12 Spacer, sleeve, spindle bearing
13 Bearing, ball, spindle lower
14 Housing, spindle

Figure 19-Continued.

Figure 19. Flour sifter counterbalance sheave assembly, exploded view.

APPENDIX
REFERENCES

AR 320-5	Dictionary of United States Army Terms
AR 320-50	Authorized Abbreviations and Brevity Codes
DA Pam 108-1	Index of Army Motion Pictures, Film Strips, Slides, and Phono-Recordings
DA Pam 310-1	Military Publications: Index of Administrative Publications
DA Pam 310-2	Military Publications: Index of Blank Forms
DA Pam 310-3	Military Publications: Index of Training Publications
DA Pam 310-4	Military Publications: Index of Technical Manuals, Technical Bulletins,
FM 21-5	Supply Bulletins, Lubrication Orders, and Modification Work Orders Military Training
FM 21-6	Techniques of Military Instruction
FM 21-30	Military Symbols
TM 6-764	Electric Motor and Generator Repair
TM 10-7360-201-10	Operator's Manual: Bakery Plant, Mobile M-1946 (FSN 7860-221-2418)
TM 10-7360-201-20	Organizational Maintenance Manual: Bakery Plant, Mobile M-1946 (FSN 7360-221-2418)
TM 17360-201-20P	Organizational Maintenance Repair Parts and Special Tool Lists: Bakery Plant, Mobile, M 1945 (FSN 7360-221-2418)
TM 17360-201-35P	Field and Depot Maintenance Repair Parts and Special Tool Lists: Bakery Plant, Mobile, M 1946 (FSN 7360-221-2418)

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