

# Operations Manual

Flex X1 - Economy Manual Clamshell Dough Press

Model #: PP1818



**PROLUXE**  
WWW.PROLUXE.COM

Version: 52619

Congratulations on your selection of the Flex X1 Manual Dough Press.

Proluxe is a leading manufacturer of food preparation and cooking equipment designed for the most demanding commercial kitchens. Proluxe equipment is a result of the highest quality engineering and time-tested design.

This manual includes installation, operation, and maintenance procedures for your new Flex X1 Dough Press. Please read this manual carefully and keep it with your machine for proper operation and lasting service.

## INSTALLATION

### Domestic

Use a separate 15 amp AC circuit. Only industrial extension cords with proper wire size should be used; size 16/3 wire for distance up to 25 feet, and size 14/3 for distance up to 50 feet.

### International

Use a designated 16 amp AC circuit. Only industrial extension cords with proper wire size (2.5 sq. mm) shall be used. Make sure there is a proper electrical wall outlet located within reach of the cord and plug attached to the press.

Then place the press in an area which allows vertical clearance of the press itself.

## Limited Machine Warranty

Proluxe warrants this dough press machine, when operated under normal conditions, to be free from manufacturing defects in material and workmanship for a period of one year on parts and labor from the invoice date.

This warranty will be effective only when Proluxe authorizes the original purchaser to return the product to the factory in Perris, California freight prepaid and only when the product, upon examination, has proven to be defective. This warranty does not apply to any machine that has been subjected to misuse, negligence or accident. Proluxe shall not be liable for the injury, loss or damage, direct or consequential, arising out of the use or the inability to use the product. No claim of any kind shall be greater in amount than the sale price of the product or part to which claim is made.

This is the sole warranty given by the company, it is in lieu of any other warranties, expressed or implied, in law or in fact, including the warranties of merchantability and fitness for a particular use, and is accepted such by the purchaser in taking delivery of this product.

## SPECIFICATIONS

### Electrical:

120V/50-60Hz/1450W/12.5Amps/AC

Also available; specify when ordering:

- Voltage: 120/240

- Amps: 12.5/6
- Watts: 1450

Includes: 72" cord and NEMA approved plug.

Shipping Weight:

150lbs. (70kg.) – PP1818

## SAFETY SUMMARY

### Warning

In case of power cord damage, do not attempt to repair or replace the power cord. Please contact the manufacturer or the local distributor.

Avoid touching hot surfaces while operating the machine.

### Caution

During normal operation, the base of the machine must be installed or placed above the wall socket.

When servicing or cleaning the machine, make sure that the power cord is removed from the wall socket.

## OPERATION TEMPERATURE & TIMER CONTROL

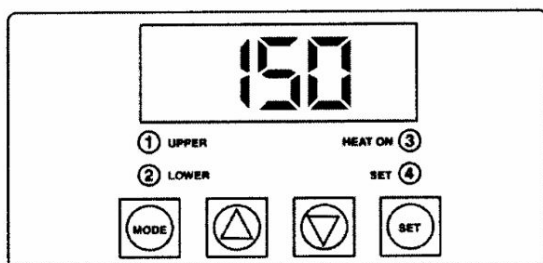


FIG. A

## Solid State Controller

This controller has three (3) control features:

1. Temperature – May be set from 100°-425°F (38°-163°C)
2. Time – Time may be set from 1 second to 10 minutes.
3. Counter – Cycle counter counts the number of applications from 1 to 9999 (see additional Notes – Counter).
4. “2 Lower” (Fig. A) Refers to models using upper and lower heated surfaces.

## Controller Operation

### 1. Viewing the Modes of Operation:

To view the set points of temperature, timer and counter, press MODE button to view the desired mode of operation.

### 2. Changing Temperature:

Press MODE button until temperature is displayed.

Press and hold SET button while pressing the UP ( ↑ ) and DOWN ( ↓ ) arrow buttons to desired temperature setting.

### 3. Changing Time:

Press MODE button until time is displayed. Press and hold SET button while pressing the UP ( ↑ ) and DOWN ( ↓ ) arrow buttons to desired timer setting.

### 4. Resetting the Counter:

Press MODE button until the counter is displayed.

To reset the counter (# of cycles), simultaneously push UP ( ↑ ) or DOWN ( ↓ ) arrow buttons (approx. 5 seconds).

### Pressing Dough:

For best results, your dough should be proofed before pressing, but it will also press directly out of your refrigerator. Flour is not required to press a crust and **should not** be dusted on any part of the machine.

Please allow 15-20 minutes for your machine to warm up.

2. Press the On/Off button.

*Note: Initial temperature setting of 150°F has been shown to be acceptable for most dough formulations; however, you may have to determine the best temperature for your own dough by trial and error testing of your product at different temperature settings.*

3. Set the timer in accordance with the following information:

2-4 seconds – For warm dough with moderate yeast content.

2-6 seconds – For room temperature dough with moderate yeast content.

6-8 seconds – For cold dough right out of the refrigerator with low yeast content.

\*Remember that the timer does not actuate until the upper platen mates with the lower platen and resistance is felt.

*Note: Diameter and thickness is determined through experimenting with your own dough and is a product of dough weight, temperature, pressing time, and thickness setting.*

4. Apply a quick spray of a good water based food release on the lower platen. Proluxe offers its own food release spray NATURALLY CLEAR Model No. DPPC1. (See our catalog and price list for information.) This spray will not affect the taste of your crust in any way.

5. Place your pre-portioned ball of dough in the center of the lower platen. Add another dash of spray to the top of the dough ball.

6. Pull down the handle with two hands to close the platen until it locks in place.

7. The timer will actuate and, when the time cycle is completed, pull up the handle.

8. Remove the crust, place on a pan or peel, add toppings and bake.

## RECOMMENDED SEASONING & CLEANING PROCEDURES

Before use you must properly season your platens to prevent your dough from sticking.

### Tools Required:

- Food release
- Soapy water solution
- Washcloth
- Paper towels

**DO NOT** use steel wool or harsh abrasives, it will you will cause costly damage.

1. Before cleaning make sure the unit is turned off.
2. Spray lower platen with approved food release/oil spray.
3. Wipe oil across lower platen with paper towel.
4. Wipe oil across upper platen.
5. Mix a warm dish soap and water solution.
6. Soak washcloth and wring to remove excess water.
7. Wipe lower and upper platen with damp cloth.

2. Exterior surfaces: Wipe daily with mild soap and warm water will do the job quite nicely.

#### Service Problems:

Contact our factory at (800) 624-6717 (U.S. only) or approved service agency. When contacting the factory for information, parts or service instructions, please provide the serial number of the machine be provided. This number can be found on the serial plate located on the rear of the machine.

## PREVENTATIVE MAINTENANCE

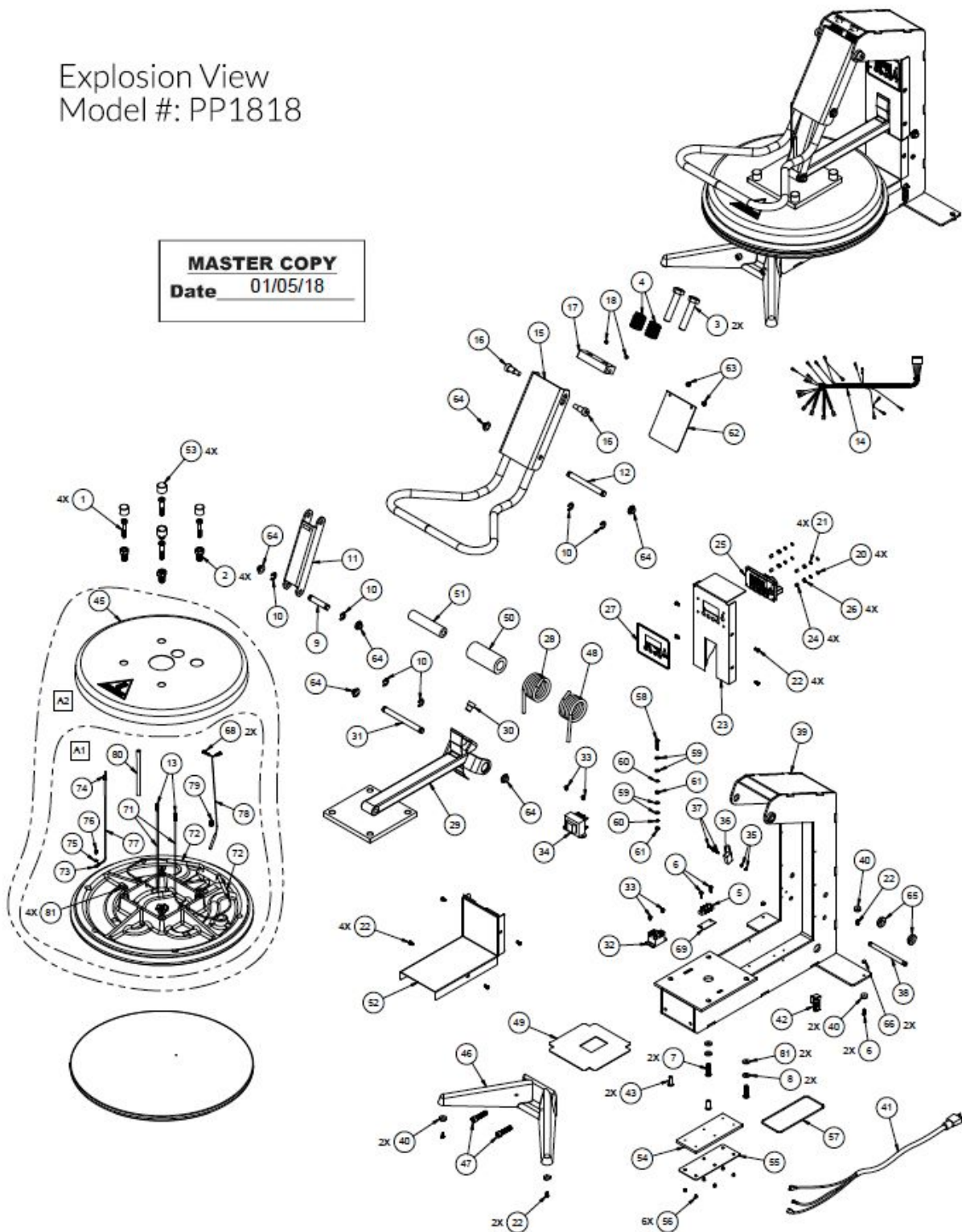
Proluxe machines are relatively maintenance free. For a long lifespan, the following preventative maintenance should be followed:

#### Daily Care:

1. Platens: Turn your machine off and allow to cool down before attempting to clean. These platens should only be cleaned with mild soap and warm water then wiped off with a clean, soft cloth or soft sponge.

# Explosion View Model #: PP1818

**MASTER COPY**  
Date 01/05/18



PP1818 RC 120717 CUSTOMER MANUAL

## Flex X1 Part List - Model #: PP1818

ITEM #	DESCRIPTION	PP1818A ~120V AC	PP1818B ~240V AC	PP1818TA ~120V AC	PP1818TB ~240V AC	QTY.
1	BOLT, HEX 5/16-18 X 1 3/4 GR5	BH51618134G 5	BH51618134G 5	BH51618134G 5	BH51618134G 5	4
2	BOLT, LEVEL ADJUSTMENT	1109367	1109367	1109367	1109367	4
3	BOLT, HEX 5/8-11 X 3	BH58113	BH58113	BH58113	BH58113	2
4	SPRING, DIE OIL TEMP, 1-1/4 X 5/8	110969093	110969093	110969093	110969093	2
5	TERMINAL BLOCK	11096914	11096914	11096914	11096914	1
6	SCREW, PAN HD 8-32 X 1/2" PHILLIPS	SP83212	SP83212	SP83212	SP83212	4
7	SCREW, BUTTON HD.5/16-18 X 1-1/4"	SB51618114	SB51618114	SB51618114	SB51618114	2
8	WASHER, BELLVILLE, 5/16"	WB516	WB516	WB516	WB516	2
9	BOTTOM PRESSURE PIN	11094961	11094961	11094961	11094961	1
10	CLIP "E" RETAINING 1/2	MPSC240	MPSC240	MPSC240	MPSC240	6
11	LINK, LOWER	110949530	110949530	110949530	110949530	1
12	PIN, PRESSURE HANDLE	11094962	11094962	11094962	11094962	1
13	TERM. 1/4 x .032 x 14-16, INSUL,Q.D FEMALE MOLEX	MPSQ100	MPSQ100	MPSQ100	MPSQ100	2
14	WIRE HARNESS	1101098050	1101098050	1101098050	1101098050	1
15	HANDLE CHANNEL ASSEMBLY	PP17002	PP17002	PP17002	PP17002	1
16	BOLT, STRIPPER 1/2 X 3/4 PLATED	BS1234P	BS1234P	BS1234P	BS1234P	2
17	PRESSURE PIVOT BLOCK	1101098174	1101098174	1101098174	1101098174	1
18	SCREW, SET 1/4-20 X 1/4	SST142014	SST142014	SST142014	SST142014	2
19	SERIAL PROPROCESS TAG	SERIALTAG	SERIALTAG	SERIALTAG	SERIALTAG	1
20	WASHER, .311 OD x .150 ID x .20 THK	311150019	311150019	311150019	311150019	4
21	WASHER, LOCK #6	WLIT6	WLIT6	WLIT6	WLIT6	4
22	SCREW PAN HD PHILLIPS 8-32 X 3/8	SP83238	SP83238	SP83238	SP83238	11
23	CONTROLLER PANEL	110109822	110109822	110109822	110109822	1
24	SPACER, NYLON	110969111	110969111	110969111	110969111	4
25	DIGITAL CONTROL	110969052	110969052	110969052	110969052	1

26	NUT, HEX 6-32	NH632	NH632	NH632	NH632	4
27	CONTROL PANEL OVERLAY	ODP1300	ODP1300	ODP1300	ODP1300	1
28	COUNTERBALANCE SPRING, LEFT	110949154L	110949154L	110949154L	110949154L	1
29	ARM ASSEMBLY	110109821	110109821	110109821	110109821	1
30	BUMPER, POLY	110969455	110969455	110969455	110969455	1
31	ARM PIVOT PIN	11094963	11094963	11094963	11094963	1
32	RELAY	110942520	110942520	110942520	110942520	1
33	SCREW, PHIL.PN.HD. 8-32 X 1/4"	SP83214	SP83214	SP83214	SP83214	4
34	TRANSFORMER	11096975	11096975	11096975	11096975	1
35	NUT, MICROSWITCH	NH440	NH440	NH440	NH440	2
36	MICRO SWITCH	110969044	110969044	110969044	110969044	1
37	SCREW, ROUND HEAD 4-40 X 3/4	SR44034	SR44034	SR44034	SR44034	2
38	SPRING RETAINER BAR	11094926	11094926	11094926	11094926	1
39	BASE FRAME ASSEMBLY	PP11002	PP11002	PP11002	PP11002	1
40	BUMPER BLACK FEET	4269014	4269014	4269014	4269014	5
41	POWER CORD	110969174	110969175	110969174	110969175	1
42	STRAIN, RELIEF HEYCO	MPS90014	MPS90014	MPS90014	MPS90014	1
43	SCREW, BUTTON HD 5/16-18 X 1"	SB516181	SB516181	SB516181	SB516181	2
45	SHROUD, UPPER PLATEN	1109336	1109336	1109336	1109336	1
46	FRONT LEG	11094902	11094902	11094902	11094902	1
47	SCREW, SOCKET HEAD 3/8-16 X 1 1/2	SSH3816112	SSH3816112	SSH3816112	SSH3816112	2
48	COUNTERBALANCE SPRING, RIGHT	110949154R	110949154R	110949154R	110949154R	1
49	PLATE GASKET	110969140	110969140	110969140	110969140	1
50	TUBE FOR SPRING	11094930	11094930	11094930	11094930	1
51	PIVOT TUBE	11094923	11094923	11094923	11094923	1
52	LOWER COVER	PP11003	PP11003	PP11003	PP11003	1
53	CAP, VINYL	SC0687	SC0687	SC0687	SC0687	4
54	SUCTION PAD	11096942	11096942	11096942	11096942	1
55	SUCTION RETAINING PLATE	11094940	11094940	11094940	11094940	1
56	SCREW, FLAT HD PHIL 8-32 X 1/4 STAINLESS STEEL	SF83214S	SF83214S	SF83214S	SF83214S	6
57	O-RING	110969113	110969113	110969113	110969113	1



58	SCREW, PAN HEAD PHILLIPS 8-32 X 1	SP8321	SP8321	SP8321	SP8321	1
59	WASHER, SAE #8	WSAE8	WSAE8	WSAE8	WSAE8	4
60	WASHER, INTERNAL TOOTH LOCK #8	WLIT8	WLIT8	WLIT8	WLIT8	2
61	NUT, HEX 8-32	NH832	NH832	NH832	NH832	2
62	CHANNEL COVER	110109888	110109888	110109888	110109888	1
63	SCREW, BUTTON HEAD 1/4-20 X 1/4	SB142014	SB142014	SB142014	SB142014	2
64	NUT, CAP DEEP DRAWN 1/2 STUD	AW500T1427	AW500T1427	AW500T1427	AW500T1427	6
65	SPACER WASHER	1101098111	1101098111	1101098111	1101098111	2
66	NUT, ACORN	NA832	NA832	NA832	NA832	2
67	OVERLAY, PRESSING INSTRUCTION	OPROPP18181 0	OPROPP18181 0	OPROPP18181 0	OPROPP18181 0	1
68	TERM. QD 3/16 X 18/22GA INS., ETC MOLEX AA2137	2280	2280	2280	2280	2
69	MARKING STRIP #2	MS6992	MS6992	MS6992	MS6992	1
71	WIRE, TGGT, 14 GA. (HEATER)	110069	110069	110069	110069	6 FT
72	TFE, SHRINK TUBING 7AWG	110131	110131	110131	110131	0.33 FT
73	TERMINAL, RING #6 14-16 GA HIGH TEMP	1601HT	1601HT	1601HT	1601HT	1
74	TERMINAL, RING #8 14-16 GA	1604	1604	1604	1604	1
75	WASHER, SAE #6	WSAE6	WSAE6	WSAE6	WSAE6	1
76	SCREW, PAN HEAD PHILLIPS 6-32 X 1/4	SP63214	SP63214	SP63214	SP63214	1
77	WIRE, TFE 14GA. GREEN	WTFE14G	WTFE14G	WTFE14G	WTFE14G	3 FT
78	RTD, SENSOR ASSEMBLY	110949110	110949110	110949110	110949110	1
79	SCREW, SET 3/8-16 X 1/2	SST381612	SST381612	SST381612	SST381612	1
80	SLEEVING, SILICONE #1 GA, BLACK	T117EA1BK	T117EA1BK	T117EA1BK	T117EA1BK	2 FT
81	WASHER, SAE 5/16	WSAE516	WSAE516	WSAE516	WSAE516	6
82	MANUAL, PP1818	MPP1818	MPP1818	MPP1818	MPP1818	1
A1	UPPER PLATEN WIRE ONLY	110949074100 P	110949075100 P	110949074100	110949075100	1
A2	UPPER PLATEN COMPLETE ASSEMBLY	110949074200 P	110949075200 P	110949074200	110949075200	1

## Warranty & Return Policy

Proluxe warrants all products manufactured by it against defects in workmanship or materials from the date of purchase for a period of 1 year on parts and labor. This warranty applies to only equipment purchased and used in the United States.

Warranty period shall begin when equipment ships. Warranty travel will only be covered for 60 miles.

ALL WARRANTY SERVICE CALLS MUST BE APPROVED BY PROLUXE. IF THIS PROCEDURE IS NOT FOLLOWED, WARRANTY SERVICE WILL NOT BE COVERED. WARRANTY SERVICE WILL BE PAID ON STRAIGHT TIME, OVERTIME WILL NOT BE COVERED.

### EXCLUSIONS

#### Wood & Gas Fired Ovens

Warranty applies to the main body of the oven being steel / refractory and insulation shall be free from defects in materials and workmanship for a period of four years from the date of purchase. The gas equipment shall be free from defects in materials and workmanship for a period of one (1) year from the date of purchase. Lifetime warranty against cracks on the oven floor.

#### Air Compressors

Are excluded from this warranty, but Proluxe may act as a warranty expeditor in certain instances regarding these compressors. The air compressor manufacturer provides a

limited warranty and a copy of this warranty is furnished with all compressors sold by Proluxe. For prompt handling of compressor warranty claims the instructions of the compressor manufacturer must be adhered to.

#### Special Order Equipment and Accessories

Cannot be canceled and are not returnable unless defective within the terms of this warranty.

In no event shall Proluxe be liable for consequential damages arising out of the failure of any of its products if operated improperly or caused by normal wear or damaged by operator abuse.

#### Limited Lifetime Warranty on Heating Elements

If replacement is needed, Proluxe will send the new part at no charge but labor will not be covered unless the unit is still under the 1 year manufacturer warranty.

### RETURNED MERCHANDISE POLICY

Should it become necessary to return any of the company's products, the following instructions must be adhered to: First, contact our customer service department for approval and a return authorization number. Please have the serial number of your item available at that time. All merchandise must be shipped freight prepaid by customer or

service agency. Subject to the inspection of the product by the company, a restocking charge of 20% of the Net purchased price paid to Proluxe will be assessed.

Merchandise may not be returned for credit without prior written approval of Proluxe.

Collect shipments will not be accepted. No returns after 60 days of original shipment date on machines. Purchased parts may not be returned after 30 days. If upon inspection by Proluxe or its authorized agent it is determined the equipment has not been used in an appropriate manner, has been modified, or has not been properly maintained, or has been subject to misuse, misapplication, neglect, abuse, accident, unauthorized modification, damage during transit, delivery, fire, flood, act or war, riot or act of God, then this warranty shall be deemed null and void.

## TERMS & CONDITIONS

1. Price List prices are suggested retail prices and are shown in U.S. Dollars.

2. Terms of Payment: 1% 10 days, NET 30 days.

3. New Accounts: Satisfactory credit information must be provided before open account status can be extended.

Unless agreed otherwise, all shipments will be made C.O.D., Cash in advance.

4. Pricing: Prices, specifications, model numbers, capacities and accessories are subject to change without notice.

5. Freight/Routing: Method of shipment will be determined by Proluxe unless otherwise advised by purchaser.

6. Damaged Claims: All merchandise shipped at purchaser's risk. Inspection must be made by purchaser at time goods are received. If goods are damaged, the PURCHASER shall request that the agent of the transportation company make a written notation on the proper shipping documents immediately and then file a claim for damages.

*Note: Goods damaged in shipping are non-returnable.*

7. Returns: Machines may not be returned after 60 days. Purchased parts may not be returned after 30 days. A restocking fee of 20% will be assessed on non-warranty returns.

8. Taxes: Prices indicated herein DO NOT include State, Federal, Local or foreign taxes or duties, nor do they include fees, permits, insurance or other levies, all of which are the responsibility of the purchaser.

9. All orders are subject to acceptance by Proluxe.

10. Possession of this price list shall not be considered an offer to sell.