

# Moline Trim Return Systems



*Custom built to provide efficient automated trim removal and reuse.*



*Reverse  
Trim Pickup  
Unit*

*Trim Return  
Incline  
Conveyor With  
Profile Belt*

*Trim Return  
Cross  
Conveyor*

*Trim Return Incline  
Conveyor With  
Open Trough Bed  
and Cantilevered  
Frame*

- **Conveyor systems to suit nearly any trim return application.**
- **Standoff mounting for optimal sanitation.**
- **The latest in conveyor technology, custom built.**

*The Moline trim return system is a series of conveyors designed to automatically remove trim dough (scrap) from the production line and return it to the dough delivery system for reuse. The trim return conveyors are available in a variety of shapes and sizes and are custom-manufactured to suit customer requirements. Conveyor belt materials vary, with neoprene and plastic as the most commonly used. Belts are driven by variable speed drives and several types of drive rollers, depending upon the application, for smooth continuous operation. In some cases, a trim dough chunker and dough former are also used to process and portion the trim dough back into the production system for optimum reintegration. The trim return*

*system is typically controlled through the production system's operator interface.*

*The new open trough bed design with large diameter belt support rollers and cantilevered frame provides optimum transfer of trim dough.*

*Profile belts, divided by pockets (or flights) are also available. The pockets assist with dough transfer over the course of steep inclines for certain types of trim.*

*These versatile designs provide efficient automation along with easy sanitation and low maintenance.*



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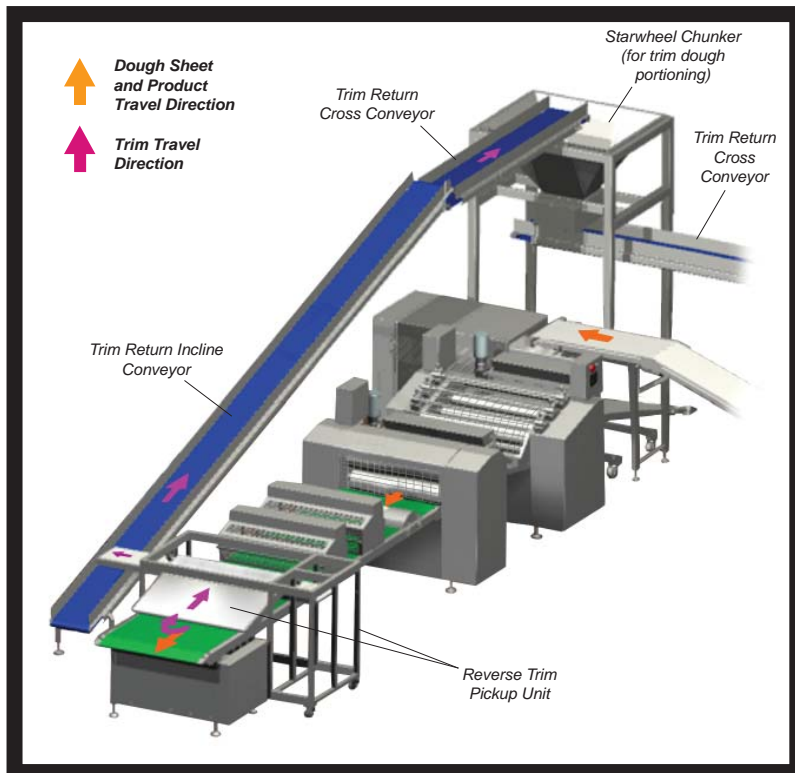
# Moline Trim Return Systems

## Trim Return Systems

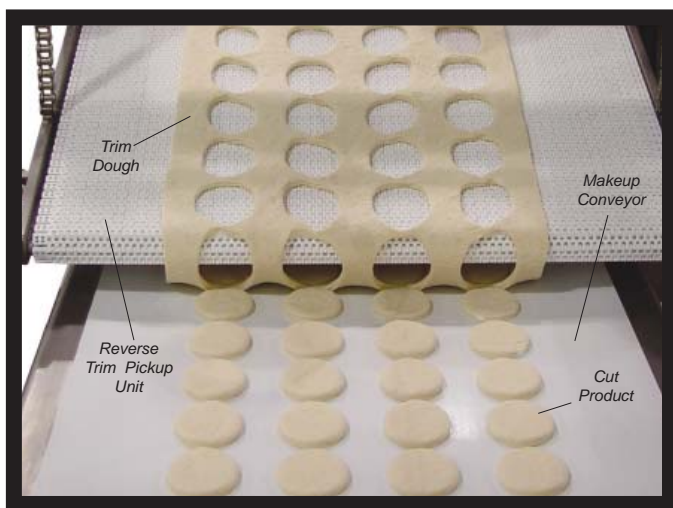
Typically, trim is routed from the production system by a reverse trim pickup unit. The cut dough sheet dough moves through the makeup system and under the trim pickup unit. The cut product continues on through the production system while the trim dough is reversed, traveling up onto the pickup conveyor on the reverse trim pickup unit and on to the trim return conveyors (see photo below).

In some cases, trim is cut from the sides of the dough sheet and routed directly off the makeup conveyor to the trim return conveyors for reuse.

The trim return conveyors typically include cross conveyors and an incline conveyor, as shown in the drawing at right. This raises the trim dough high enough to be routed to the production system's dough portioning system where it is integrated with fresh dough and reused.



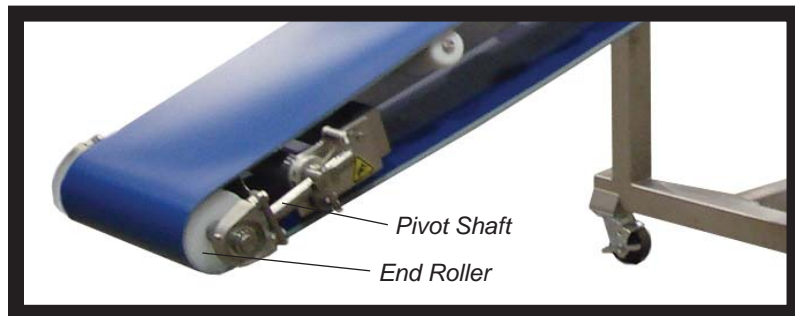
**Transfer Conveyor**



**Reverse Trim Pickup Unit**

The trim return conveyors are built of stainless steel and contain various types of belt tensioners, scrapers and trackers.

Belt tension is typically provided by the conveyor end roller. Several types are used including telescoping and pivoting end rollers.



**Pivoting End Roller Belt Tension Mechanism**



**Telescoping Belt Tension Mechanism, Belt Scraper and Catch Pan**

Belt scrapers and catch pans are provided when necessary to efficiently and automatically clean the belt during operation.