The Moline starwheel chunker is designed to deliver uniformly measured dough pieces, or chunks, to a dough former or extruder installed below the chunker hopper.

From a mixer, dough is delivered to the chunker hopper where chunks are formed by “starwheel” paddles rotating 120° per cycle. The chunks are released to the dough former below at the desired interval. Electronic dough sensors, mounted on the sides of the chunker frame, detect dough level in the dough former hopper and signal when the next dough chunk should be released from the chunker. The starwheels are driven by a drive motor and gear reducer.

The starwheel chunker is electronically synchronized with the Moline dough former to automatically maintain a constant level of dough in the hopper. This provides a consistent dough sheet to the sheeting line and greatly improves product uniformity and weight control.
The Moline
Starwheel Chunker

Features

• **Construction:**
  Heavy-gauge stainless steel with precision-machined components. Chunker hopper interior can be specially coated for optimum dough release.

  Optional dough former guide bars and connection hardware for chunker/dough former use.

• **Control Functions:**
  Activation and speeds are easily accessed through the production system’s operator interface. Electronic dough sensors mounted on the chunker frame (see photo at right) detect dough levels in the extruder hopper and signal dough release.

• **Drive System:**
  Standard: direct drive with motor, gear reducer and drive gears.

• **Electrical System:**
  Standard Electrical Requirements: 480 Volt / 60 Hertz / 3 Phase (other options are available).

  In-position switch between starwheel chunker frame and dough former frame ensure correct positioning for optimum operation.

Using a Dough Former

The chunker is typically used with a Moline low stress dough former. The two units provide synchronized delivery of portioned dough chunks to maintain a constant level in the dough former hopper. This system provides a continuous and consistent dough sheet which greatly improves weight control of the final product.

The portable dough former is easily moved into position beneath the chunker. Optional guide brackets can be installed (see photo above) to make the process simple even in confined or low-visibility areas.

The chunker and dough former are electronically interlocked to ensure correct positioning for optimum operation.