



Model SPC20



Model #: _____

Serial #: _____



**Instruction Manual for Globe Mixers
(Models SPC10, SPC20, SPC25, SPC30, SPC30P,
SPC40, SPC60, SPC62P and SPC80PL)**

Units Comply to the Following Canadian Standards

- NF 454-00
- CSA Z432-04
- CSA, C22.2

For all after sales support, visit www.globefoodequip.com

- **Complete the Warranty Registration**
- **Find an Authorized Servicer**
- **View Parts Catalogs**

For additional Technical Support call Globe at 1-866-260-0522.

- IMPORTANT SAFETY NOTICE -

This manual contains important safety instructions which must be strictly followed when using this equipment.

Maintain and use this manual as a reference for training.

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GLOBE FOOD EQUIPMENT COMPANY
2153 DRYDEN RD.
DAYTON, OH 45439
PHONE: 937-299-5493
TOLL FREE: 800-347-5423
E-MAIL: info@globefoodequip.com
WEBSITE: www.globefoodequip.com

Attention Owners and Operators

Globe equipment is designed to provide safe and productive processing of food products as long as the equipment is used in accordance with the instructions in this manual and is properly maintained. Unless the operator is adequately trained and supervised there is a possibility of serious injury. Owners of this equipment bear the responsibility to make certain that this equipment is used properly and safely, and to strictly follow all of the instructions contained in this manual and the requirements of local, state and/or federal law.

Owners should not permit anyone to touch this equipment unless they are 18 years of age or older, are adequately trained and supervised, and have read and understand this manual. Owners should also ensure that no customers, visitors or other unauthorized personnel come in contact with this equipment. Please remember that Globe cannot anticipate every circumstance or environment in which its equipment will be operated. It is the responsibility of the owner and the operator to remain alert to any hazards posed by the function of this equipment. If you are ever uncertain about a particular task or the proper method of operating this equipment, ask your supervisor.

This manual contains a number of precautions to follow to help promote safe use of this equipment. Throughout the manual you will see additional warnings to help alert you to potential hazards.

Warnings affecting your personal safety are indicated by:



or



Warnings related to possible damage to the equipment are indicated by:



Globe has put several warning labels in English on its mixers. French labels are also available and can replace the English labels at the owner's discretion. If the warning labels or this manual are misplaced, damaged, or illegible, or if you require additional copies, please contact your nearest representative or contact Globe directly to request these items at no charge.

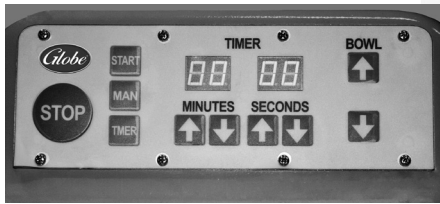
Please remember that neither manual nor the warning labels replace the need to be alert, to properly train and supervise operators, and to use common sense when using this equipment.

Key Components of the Mixer

- Minute Up/Down Controls
- Start Button
- Stop Button
- Attachment Hub
- Planetary Grease Fitting
- Planetary Shaft
- Bowl Handle
- Bowl Clamp
- Digital Timer Display
- Seconds Up/Down Controls
- Attachment Hub Thumbscrew
- Bowl Lift Lever
- Bowl Guard Handle

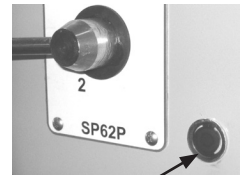


SPC20 FRONT VIEW



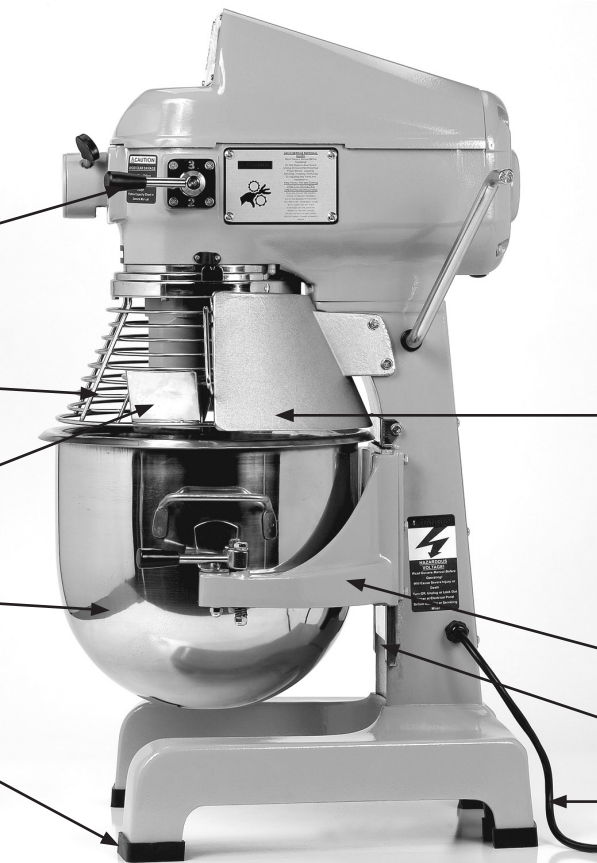
Power Bowl Lift, Mode & Timer Controls (Models SP62P and SP80PL)

Bowl Lift Wheel (Models SPC40 and SPC60)



Gear Oil Meter (Models SPC62P and SPC80PL)

- Speed Control
- Bowl Guard
- Built in Ingredient Chute
- Bowl
- Rubber Feet
- Splash Guard
- Bowl Cradle
- Bowl Slides
- Power Cord



SPC20 SIDE VIEW

Installation

UNPACKING

Unpack the mixer immediately after receipt. If the machine is found to be damaged, immediately contact us at help@globefoodequip.com or call 1-800-347-5423 ext. 256. Please include your name, serial #, item that is damaged, explanation of the damage and photographs if possible. The damage must be reported to Globe within 7 days from the time of shipment. Refer to Globe's Freight Damage policy for more information. <https://globefoodequip.com/support/order-return-policy.html>



TO AVOID SERIOUS PERSONAL INJURY:

- **ALWAYS** install equipment in work area with adequate light and space.
- **ONLY** operate mixer on a solid, **LEVEL**, non-skid surface that is nonflammable.
- **NEVER** bypass, alter, or modify this equipment in any way from its original condition. Doing so can create hazards and will void the warranty.
- **NEVER** operate mixer without all warnings attached.
- **DO NOT** attempt to lift mixer alone.

INSTALLATION

1. Read this manual thoroughly before installation and operation. **DO NOT** proceed with installation and operation if you have any questions or do not understand everything in this manual. Contact your local representative or Globe first.
2. Remove the corrugated box from the skid by removing the bands on the box.

NOTE: The SPC62P and SPC80PL are shipped in a wooden crate; only the bolts at the bottom of the crate (all four sides) need to be removed.

3. Carefully unbolt mixer from the skid using an 11/16" or 3/4" wrench.
4. Select a location for mixer keeping these points in mind:
 - Floor or counter must be level.
 - Easy access for maintenance and service.
 - Clearance for operating controls, installing and removing agitators, bowl, or attachments.
 - Sufficient space for adding ingredients during mixing periods.
 - Make sure rear ventilation outlet of mixer is not blocked.
5. Use at least two other people to tilt the unit and install the rubber feet.
6. A bolt down template and bolts are available for the SPC10, SPC20, or SPC25. Contact Globe if needed.
7. Inspect mixer to make sure all parts have been provided (i.e. bowl, beater, whip and dough hook). The SPC60, SPC62P and SPC80PL only have a bowl, dough hook and bowl truck.
8. Read the electrical information found on the data plate located at the rear of the machine. The incoming power must match the rating on the data plate.

CONNECTING TO ELECTRICAL POWER



Cord Connected Units: This machine is provided with a three-prong grounding plug. The outlet that this plug is connected to must be properly grounded. If the receptacle is not the proper grounding type, contact an electrician. **Do not under any circumstances cut or remove the third ground prong from the power cord or use an adapter plug. Never use an extension cord. Low power supply could damage the mixer and/or cause a fire.**

Installation

CONNECTING TO ELECTRICAL POWER cont'd.



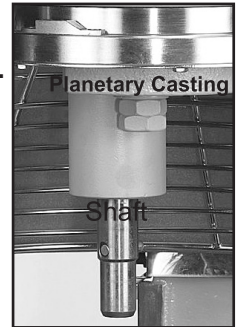
WARNING

If the unit needs to be hard-wired have a licensed electrician connect the unit to the power supply.

Three Phase Units:

You must confirm proper rotation of all 3 phase mixers before use of mixer. There is a 50% chance your 3 phase mixer is properly rotating if you are using it on 3 phase power.

1. Make sure there is not a mixing tool on the mixer shaft and the bowl is empty.
2. Put the speed lever on one speed and turn the unit on.
3. Make sure the large, gray planetary casting is going in the direction of the arrow on the mixer as you stand in front of mixer (clockwise). (Do not pay attention to the shaft rotation.) If it is traveling in the wrong direction have a licensed electrician switch the electrical connection and retest.



9. Complete and register the warranty information online at:
www.globefoodequip.com/support/warranty-registration-form.

10. Clean mixer before use. Refer to Cleaning Instructions section of this manual.

NOTE: It is normal for the factory to apply a generous amount of grease in and on the machine. Excess grease (brown in color) will be on all metal surfaces (e.g. top portion of bowl guard, speed control, bowl clamps, bowl lift lever and attachment hub thumbscrew). Excess high-pressured grease (brownish-black) may also be found on the planetary shaft and some drippings may be found in the bowl.

Operating Instructions

TO AVOID SERIOUS PERSONAL INJURY:



WARNING

- **DO NOT** operate mixer before reading the instruction manual first.
- **ALWAYS** disconnect or unplug electrical power before cleaning, servicing, or adjusting any parts or attachments.
- **ALWAYS** keep hands, hair and clothing away from moving parts.

ABOUT REMOVABLE BOWL GUARD

The bowl guard can be rotated or removed to accommodate the operator's function. The interlocking bowl guard is easy to remove and reattach for easy cleaning in a sink or dishwasher.

NOTE: When bowl guard is open or not properly installed, mixer will not operate.

NOTE: Rotate bowl guard clockwise (open) and counterclockwise (closed) to attach agitators to mixer.

Opening / Rotating Bowl Guard:

Rotating bowl guard clockwise (open) and counterclockwise (closed), allows the operator to easily add ingredients and to properly remove agitator and bowl from mixer.

1. When the separated handles are lined up together and pushed securely to the right of mixer, the bowl guard is in the locked position and is ready to operate (Fig. 7-1).



Fig. 7-1

Operating Instructions

2. To rotate bowl guard to its open position, grasp the separated handles on the bowl guard and move them, together as one, clockwise to open/rotate bowl guard. To close bowl guard, grasp the separated handles and move them together as one, counterclockwise to close/rotate bowl guard back into a locked position.

Removing and Attaching Bowl Guard:

NOTE: Before removing or attaching the bowl guard, make sure the bowl is in the down/ lowered position and the agitator tool is off the shaft.

1. To remove bowl guard for cleaning, push the lower part of the separated handle out (clockwise) dividing the handle and releasing the guard from the rotation ring (Fig. 8-1).
2. Once separated, take hold of the lower separated handle and continue turning the guard clockwise until the bowl guard releases from the ring catch (Fig. 8-2).
3. To reattach bowl guard, line up ring catch on the left of mixer; lift guard gently into place and rotate the guard's lower handle counterclockwise until it snaps back into place with the upper part of handle.

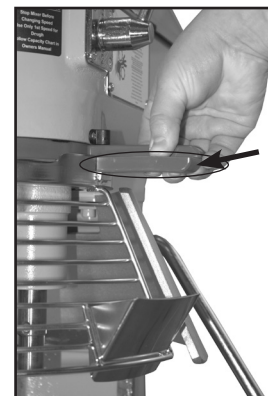


Fig. 8-1



Fig. 8-2

ATTACHING BOWL TO MIXER

NOTE: Install bowl BEFORE attaching agitator.

1. Lower bowl by pulling bowl lift lever forward and down to its resting position. For models SPC40 and SPC60 rotate bowl lift wheel counterclockwise until it stops. For the SPC62P and SPC80PL press the down arrow (blue button) to lower bowl until it stops.
2. Lift bowl by bowl handles and:
 - a. Slowly position locking pin (located on the rear of bowl) into the hole in the middle rear of cradle (Fig. 8-3).
 - b. Lower bowl onto pins located on either side of bowl cradle.
3. Once bowl is positioned on the cradle, secure bowl by pulling each bowl clamp forward until bowl is locked tight (Fig. 8-4).



Fig. 8-3



Fig. 8-4

Operating Instructions

ATTACHING THE AGITATOR TO THE MIXER (i.e. Beater, Hook, Whip)

NOTE: It is easier to install the agitator before adding the ingredients into the bowl.

1. Rotate bowl guard to the left so it rests in the open position (Fig. 9-1).

CAUTION Using excessive force to open and close the bowl guard can damage the spring lock and bowl guard microswitch, and will void the warranty.

2. Slide the agitator slowly upwards onto the planetary shaft, fitting the shaft pin through the slot in the agitator (Fig. 9-2).

3. Rotate the agitator clockwise to secure it onto the planetary shaft.



Fig. 9-1

MIXING INGREDIENTS

CAUTION Overloading or not following capacity chart guidelines may damage the mixer and void the warranty. Refer to Capacity Chart section.

Agitators must always rotate in a counterclockwise direction around the bowl.

CAUTION If the agitator moves clockwise, contact a licensed electrician immediately to remedy incorrect wiring.

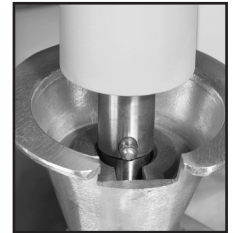


Fig. 9-2

IMPORTANT: Make sure the speed control lever is on the first (1) speed.

1. Add the appropriate mixing ingredients into the bowl.
2. Rotate bowl lift lever up until the bowl locks into position. On the SPC40 and SPC60 rotate bowl lift wheel clockwise until bowl is all the way up into position. For the SPC62P and SPC80PL press the up arrow (blue button) until the bowl is up into position.
3. Rotate bowl guard to the right until it locks into the closed position (Fig. 9-3). You will hear it 'click' into place.

NOTE: Mixer will not start if the bowl guard is open or bowl is in the lowered position.

CAUTION Before starting the mixer: **Always change to the desired speed BEFORE starting the mixer. Failure to do so can damage the gears or other parts and WILL void the warranty.**



Fig. 9-3

SETTING and CHANGING THE SPEED

4. Select the appropriate speed setting by lifting or lowering the speed control lever. Three fixed speeds are available for use: first (1), second (2), and third (3).

NOTE: The SPC62P has two speeds and the SPC80PL has four fixed speeds.

Gear Speed: Product Type/Ingredient:

- | | |
|------------|--|
| 1 (low) | Heavy: mixing pizza, bread, pasta and donut doughs, waffle/cake batter, mashing potatoes |
| 2 (medium) | Medium: 2nd stage of mixing for donut dough, etc. |
| 3 (high) | Light: whipping cream, egg whites, meringue |

IMPORTANT: When mixing product always follow the recommended agitator and speed settings according to the Capacity Chart. Refer to Capacity Chart section.

5. Press the green START button to begin mixing.

Operating Instructions



Always STOP mixer BEFORE changing speeds. Failure to do so can damage the gears or other parts and WILL void the warranty!

6. To change the speed while mixing:
 - a. Press the red STOP button, then wait for the agitator to come to a complete stop.
 - b. Change the speed by raising or lowering the speed control lever.
 - c. Press the green START button to restart mixer.

NOTE: The SPC62P and SPC80PL will automatically shut off if the speed is changed while the mixer is in operation.

NOTE: Mixer is equipped with motor overload protection. If mixer shuts off during operation, reduce the batch size and:

- a. SPC25 and smaller models: Press the STOP button then press the Overload Reset button located on the back of the mixer.
- b. Larger models: Wait **two** minutes then press the START button on the control panel.

NOTE: 2nd speed should never be used on 50% Absorption Ratio (AR) or lower with the exception of the SPC60. The SPC60 requires a 50% reduction in batch size to mix in speed 2 with 50% AR doughs.

NOTE: Reduce batch size by 10% if using chilled flour, water below 70°F, ice, or high gluten flour.

7. When the ingredients have been thoroughly mixed, press the red STOP button to stop mixer.

NOTE: If the timer was used, the mixer will automatically stop when the time has expired.

8. Lower bowl by pulling bowl lift lever forward and down to its resting position. For models SPC40 and SPC60, rotate bowl lift wheel counterclockwise until it stops. For models SPC62P and SPC80PL, press the down arrow (blue button) until bowl stops.
9. Rotate bowl guard to the left so it is in the open position.
10. Remove the agitator from the planetary shaft by lifting it upwards, then rotating it counterclockwise until it is unlocked. Lower the agitator and remove from the planetary shaft.
11. Push each bowl clamp backwards to unlock the bowl from the bowl cradle.
12. Lift up slightly on bowl so it clears pins on the bowl cradle.



Most batches are heavy. Always use two people to remove and transport the loaded bowl after mixing is complete. A bowl truck is included with the SPC60, SPC62P and SPC80PL models and must be used to unload bowls containing more than 50 lbs. per batch.

Operating Instructions



Before starting mixer: **Always change speeds BEFORE starting the Mixer. Failure to do so can damage the gears or other parts and WILL void the warranty!**

USING MIXER'S DIGITAL CONTROLS AND TIMER

Read through this section and continue to page 13 for further operating instructions for use of the digital controls on your mixer.

Mixer is equipped with a digital timer display, minutes and seconds buttons (to adjust the timed operations) and Start / Stop buttons. Mixer can function in either timed operation or untimed operation.

Untimed Operation: For simple on/off mixing operation in an untimed operating mode, verify that bowl guard and bowl lift are closed and locked into position.

- The display should read 00:00 to operate in untimed mode. Pressing the STOP button twice within one second will reset the timer back to zero.
- Press the START button to begin mixing. The display will scroll zeros from left to right while mixing. Press the STOP button when the desired mixing is complete.

NOTE: Pressing STOP button twice within one second to reset the timer back to zero (00.00) is a feature only available for models SP10-SP60.

Timed Operation: The timer on the mixer can be set from 5 seconds to 60 minutes.

1. Set desired time. Minutes advance by one and seconds advance by fives before rolling over to zero.

NOTE: Press and continuously hold the up arrow button to the desired minutes and seconds. Press and continuously hold as the button scrolls through the number cycles quickly. (To slow down the selection and to better control the setting time, press the up or down arrow button (Do NOT continuously hold the button down).

2. Once the desired time is set, make sure that the bowl guard and bowl lift are closed and locked into position and then press START.
3. Wait for the timed cycle to end or press STOP to pause mixing cycle.
 - Pressing the STOP button once stops mixer and pauses the timer during operation.
 - Pressing the STOP button once while mixer is not in operation will reset the timer to the last programmed/set time.
 - Double clicking the STOP button twice within one second while the mixer is not in operation will reset the timer back to zero (00:00).

NOTE: Pressing STOP button twice within one second to reset the timer back to zero (00.00) is a feature only available for models SP10-SP60.

NOTE: If a cycle is interrupted by the bowl guard being opened or by lowering the bowl lift lever, the mixer will stop. After the bowl guard and bowl lift are closed and locked into position, The START button can be pressed to continue the programmed/set time.

To add additional minutes or seconds to a mix time, STOP the mixer, and adjust the cycle mixing time.

4. Once a timed cycle ends, the mixer will beep for 5 seconds and the digital display will flash for two minutes (if not reset) indicating the timed cycle is complete.

Operating Instructions

HOW TO USE ATTACHMENT HUB

WARNING Never put hands into the feed chute when using a mixer attachment.

CAUTION Only operate the attachment hub in **MANUAL** mode.
DO NOT attempt to mix ingredients in the bowl while using the hub.

Mixer must be OFF before installing attachment. Do NOT use attachments while mixing.

1. Loosen and remove the attachment hub thumbscrew (Fig. 12-1).
2. Remove the plastic cover from the attachment hub (Fig. 12-1).
3. Lubricate the attachment shaft with a food quality grease or mineral oil.
4. Insert the attachment shaft into the hub making sure to line up the alignment pin with the hub hole.
5. Tighten the thumbscrew back into the hub and securely tighten it.
6. Select the appropriate speed setting by lifting or lowering the speed control lever.



Fig. 12-1

Recommended Speed while using attachments:

<u>Attachment:</u>	<u>Recommended Speed:</u>
Vegetable Slicer	1 or 2
Cheese Shredder/Grater	1 or 2
Meat Grinder	1 only

NOTE: Make sure the bowl is up and the bowl guard is closed. Mixer will not start if the bowl and the bowl guard are not in the proper operating position.

7. Adjust the timer using the untimed operation described on the previous page.
8. Press the green START button located on the control panel.

CAUTION Always **STOP** the mixer **BEFORE** changing speeds. Failure to do so can damage the gears or other parts and **WILL** void the warranty.

9. To change the speed while using mixer attachments:
 - a. Press the red STOP button, then wait for the agitator to come to a complete stop.
 - b. Change the speed by raising or lowering the speed control lever.
 - c. Press the green START button to restart the mixer.

NOTE: The SPC62P and SPC80PL will automatically shut off if the speeds are changed while the mixer is in operation.

Operating Instructions

DIGITAL CONTROL INSTRUCTIONS

Untimed / Manual Mode instructions and controls for the SPC62P and SPC80PL

Always STOP mixer before installing attachments. Do NOT use attachments while mixing.

NOTE: Make sure the bowl is up and the bowl guard is closed. The mixer will not start if the bowl and the bowl guard are not in the proper operating position.

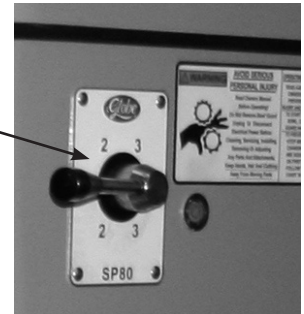
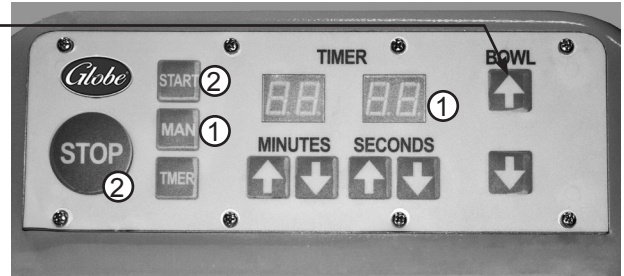
Press the BOWL "Up" arrow to activate the power bowl lift.
Set the speed control to the desired speed.

Untimed - MANUAL MODE

1. To begin operation of mixer in Manual mode, press the MAN button. The display will illuminate a small dot of light in the lower right-hand corner of the seconds timer display.

NOTE: Mixer will not start if bowl is not all the way up. Bowl guard must be completely closed.

2. Press the START button to begin mixing. Press STOP to discontinue mixing.



Always STOP the mixer BEFORE changing speeds.

NOTE: The SPC62P and SPC80PL will automatically shut off if the speeds are changed while the mixer is in operation.

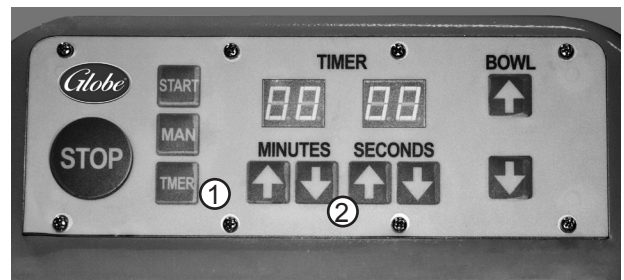
NOTE: The timer does not work in Manual Mode.
To use the timer feature, follow the Timer Mode instructions.

TIMER MODE

1. To begin operating mixer in timer mode, press the TIMER button.

If starting mixer for the first time, or if power is lost, the TIMER display will only illuminate in all zeros "0"; otherwise, it will display the last mixing time that was entered.

2. Select the number of minutes and seconds by using the up and down arrows located under the timer digital display. The first set of up-down arrow buttons control the minutes and the second set of up/down arrow buttons controls the seconds.



Press and continuously hold the up arrow buttons to the desired minutes and seconds. Press and continuously hold as the button scrolls through the number cycles quickly. (To slow down the selection and to better control the setting time, press the up or down arrow button do not continuously hold the button down).

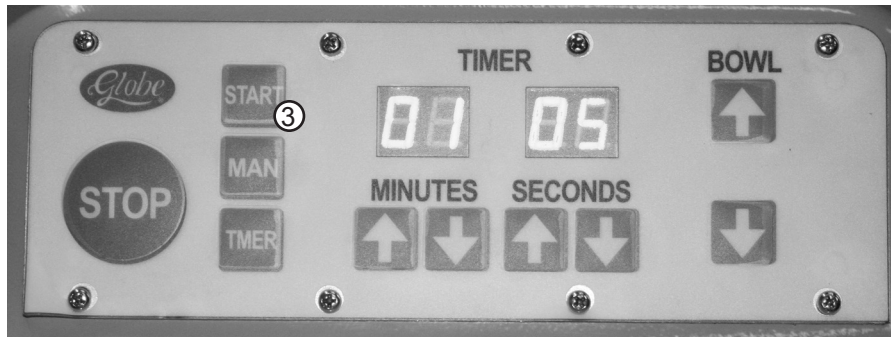
3. Once the desired mix time has been set on the timer, press the START button to begin mixing.



Always STOP mixer BEFORE changing speeds.

NOTE: The SPC62P and SPC80PL will automatically shut off if the speeds are changed while mixer is in operation.

Operating Instructions



4. Once the START button is pressed, mixer timer numbers will begin to descend.

The timer and mixer can be interrupted at any time by pressing the STOP button. If the timer cycle is interrupted and the mixer has not yet finished its set mixing time, the mixing cycle can be continued from where it left off by pressing the START button.

NOTE: If a cycle is interrupted by the bowl guard being opened or the speed of the mixer being changed, the mixer will stop. After bowl guard and bowl lift are closed and locked into position, the START button can be pressed to continue the programmed/set time.

To add additional minutes or seconds to a mix time, STOP the mixer, press TIMER, and adjust the cycle mixing time.

Press the START button to begin mixing once again.

5. At the end of a timed mixing cycle the timer will count down to "00" minutes and "00" seconds, the mixer will stop, and the timer will display the last mix cycle time.
6. To begin another mix cycle with the same set time as the previous mix, press the START button.

If the mix cycle time needs to be adjusted up or down, set the new desired time and then press the START button to begin mixing.

Mixer timer will always reset back to the last mix time that was set unless the plug or power is disconnected to the mixer. If power is lost to the mixer, the mixing time will need to be reset to the desired time.

Cleaning Instructions

CAUTION

- Dilute detergent per supplier's instruction.
- **DO NOT** hose down or pressure wash any part of the mixer.
- **NEVER** use a scrubber pad, steel wool, or abrasive material to clean the mixer.
- **NEVER** use bleach (sodium hypochlorite) or bleach-based cleaner.
- **ALWAYS** remove the agitator after each batch as the agitator can become stuck on the shaft and may be difficult to remove.



The entire mixer, including removable parts, must be thoroughly cleaned and sanitized using the procedures identified by your local health department and the ServSafe Essentials published by the National Restaurant Association Educational Foundation (NRAEF). Visit www.servsafe.com for more details.



It is extremely important to sanitize the mixer and to follow the instructions on the quaternary sanitizer container to ensure proper sanitation is achieved.



ALWAYS DISCONNECT OR UNPLUG ELECTRICAL POWER FROM THE MIXER BEFORE CLEANING.

RECOMMENDED CLEANING

PART	REQUIRED ACTION	FREQUENCY
Agitators	Hand wash using mild soap and water; rinse, dry and sanitize.	Clean after each use.
Removable Bowl Guard	Hand wash using mild soap and water; rinse, dry and sanitize or place in dishwasher.	Clean after each use.
Bowl	Using a sponge or cloth, mild soap and water, apply pressure to make sure the bowl is clean; rinse, dry, and sanitize. The bowl can also be placed in a dishwasher.	Clean after each use.
Rear Splash Guard	Hand wash using mild soap and water; rinse, dry and sanitize.	Clean after each use.
Bowl Cradle	Hand wash using mild soap and water; rinse, dry and sanitize.	Daily
Planetary Shaft	Wipe with clean damp cloth; dry and sanitize. Apply a light quantity of Globe oil (mineral oil) to the planetary shaft after cleaning.	Clean after each use.
Exterior	Hand wash using mild soap and water; rinse, dry, and sanitize. DO NOT use a water hose.	Daily
Hub Interior	Wipe with clean damp cloth; dry, and sanitize.	Daily

Important Points

This Globe mixer will provide years of uninterrupted service if you do the following:

Installation

- Do not use an extension cord to connect electrical power.
- Make sure all 3 Phase units (see data plate) run in the direction of the arrow on the front of the machine.

Operation

- Turn off mixer before changing speeds.
- Follow the Capacity Chart for mixing dough. Refer to Capacity Chart section.
- Use only first (1) speed for mixing dough. Second (2) speed should never be used on 50% AR or lower with the exception of the SPC60. The SPC60 requires a 50% reduction in batch size to mix in speed 2 with 50% AR dough.
- If the unit shuts off during mixing (overload protection trips), reduce the batch size.

Maintenance

Recommended Maintenance

PART	REQUIRED ACTION	FREQUENCY
Bowl Slide Rods	Apply Globe oil (mineral oil) on the bowl slide rods. Raise and lower the bowl to distribute the oil onto the rods.	If the bowl becomes difficult to raise or lower.
Gear Oil Meter (SPC62P and SPC80PL only)	Contact a Globe authorized servicer to change the gear oil.	Once a year. When the gear oil meter shows the oil below half of the circle.

Capacity Chart

The following maximum capacities are intended as a guideline only. Varying factors such as the type of flour used, temperature of water used and other conditions may require the batch to be reduced.

Product	Agitator and Speed	SPC5	SPC8	SPC10	SPC20	SPC25	SPC30/ SPC30P	SPC40	SPC60	SPC62P	SPC80PL
Waffle or Hotcake Batter	Flat Beater	2 qts.	3 qts.	5 qts.	8 qts.	10 qts.	12 qts.	16 qts.	24 qts.	----	30 qts.
Whipped Cream	Wire Whip	2 qts.	2 qts.	2 qts.	4 qts.	5 qts.	6 qts.	9 qts.	12 qts.	----	16 qts.
Mashed Potatoes	Flat Beater	4 lbs.	4 lbs.	8 lbs.	15 lbs.	18 lbs.	23 lbs.	30 lbs.	40 lbs.	----	50 lbs.
Egg Whites	Wire Whip	¾ pts.	¾ pts.	1 pt.	1 qt.	1¼ qts.	1½ qts.	1¾ qts.	2 qts.	----	2 qts.
Meringue (Qty. of Water)	Wire Whip	¼ pts.	½ pts.	¾ pts.	1½ pts.	1¾ pts.	1 qt.	1¼ qts.	1¾ qts.	----	3 qts.
Raised Donut Dough (65% AR) *◆	Dough Hook 1st and 2nd	2 lbs.	2 lbs.	4½ lbs.	9 lbs.	12 lbs.	15 lbs./ 20 lbs.	25 lbs.	60 lbs.	75 lbs.	80 lbs.
Heavy Bread Dough (55% AR) *◆	Dough Hook 1st only	4 lbs.	3 lbs.	7½ lbs.	15 lbs.	20 lbs.	30 lbs./ 35 lbs.	40 lbs.	70 lbs.	75 lbs.	80 lbs.
Bread and Roll Dough (60% AR) *◆	Dough Hook 1st only	5 lbs.	5 lbs.	12½ lbs.	25 lbs.	25 lbs.	45 lbs.	60 lbs.	80 lbs.	90 lbs.	90 lbs.
Pizza Dough, Thin (40% AR) *◆□	Dough Hook 1st only	3 lbs.	2 lbs.	5 lbs.	9 lbs.	12 lbs.	16 lbs./ 25 lbs.	30 lbs.	40 lbs. (1st)	50 lbs. 35 lbs. (2nd)	50 lbs.
Pizza Dough, Medium (50% AR) *◆□	Dough Hook 1st only	4 lbs.	4 lbs.	5 lbs.	10 lbs.	15 lbs.	25 lbs./ 36 lbs.	40 lbs.	70 lbs. (1st) 35 lbs. (2nd)	80 lbs. (1st) 60 lbs. (2nd)	90 lbs.
Pizza Dough, Thick (60% AR) *◆	Dough Hook 1st only	5 lbs.	5 lbs.	10 lbs.	20 lbs.	25 lbs.	40 lbs./ 45 lbs.	50 lbs.	70 lbs.	90 lbs.	100 lbs.
Fondant Icing	Flat Beater	4 lbs.	3 lbs.	6 lbs.	12 lbs.	15 lbs.	18 lbs.	25 lbs.	36 lbs.	----	60 lbs.
Cake	Flat Beater	5 lbs.	6 lbs.	10 lbs.	20 lbs.	25 lbs.	30 lbs.	40 lbs.	60 lbs.	----	90 lbs.
Pie Dough	Flat Beater	5 lbs.	4 lbs.	10 lbs.	18 lbs.	22 lbs.	27 lbs.	35 lbs.	50 lbs.	60 lbs.	70 lbs.
Pasta, Basic Egg Noodle	Dough Hook	1 lb.	2 lbs.	3 lbs.	5 lbs.	6 lbs.	8 lbs./ 15 lbs.	17 lbs.	35 lbs.	40 lbs.	50 lbs.

* **NOTE:** The mixer capacity depends on the moisture content of the dough. When mixing dough (pizza, bread, or bagels) check your Absorption Ratio Percentage (AR%). %AR = water weight divided by flour weight. The capacities listed above are based on flour at room temperature and 70°F water temperature.

NOTE: 1 gallon of water weighs 8.33 lbs.

✖ Maximum Mixing Time - 7 Minutes

• If high gluten flour is used, reduce the batch size by 10%.

◆ If using chilled flour, water below 70°F, or ice, reduce batch size by 10%.

□ Second (2) speed should never be used on 50% AR or lower with the exception of the SPC60. The SPC60 requires a 50% reduction in batch size to mix in speed 2 with 50% AR dough.

Do not use attachments on hub while mixing!

Troubleshooting

Problem	Possible Causes	Action Required
Mixer will not operate	Bowl guard not in closed position.	Rotate guard to the right until fully closed.
	Bowl not raised.	Raise bowl to highest position.
	Power not connected properly.	Check all power connections. Plug into a live socket. <i>(Do not use extension cord!)</i> Test socket with another item.
	Building circuit breaker is off.	Check breaker box.
	Internal overload tripped.	<u>SPC25 & smaller models:</u> Press STOP button, then press Reset button located on the back of the mixer. <u>Larger models:</u> Wait two minutes. Then press START to restart the mixer. <i>(If overload continues to trip, reduce batch size and/or adjust recipe!)</i>
	Gear not engaged.	Switch gear fully into position. <i>(Mixer will not operate if the speed control lever is positioned in between speeds)</i>
Mixer stops during mixing cycle	Internal overload tripped.	<u>SPC25 & smaller models:</u> Press the STOP button, then press the Reset button located on the back of the mixer. <u>Larger models:</u> Wait two minutes. Then press START to restart the mixer. <i>(If overload continues to trip, reduce batch size and/or adjust recipe!)</i>
	Damaged or broken transmission belt.	Contact a technician to replace belt.
	Speeds were changed during mixing, SPC80PL only.	Return speed control lever to a speed model position and restart the mixer.
Mixer is noisy	Mixer is not installed on level surface.	Adjust surface or relocate mixer. Make sure rubber feet are installed.
	Bowl not seated correctly or clamps not in place.	Make sure bowl is seated into bowl cradle correctly and bowl clamps are locked into place.
	Agitator not fitted properly.	Remove and attach agitator into position properly.
	Overloading bowl.	Reduce batch size. Refer to <i>Capacity Chart section</i> .
	Damaged or worn belt.	Replace belt
Safety guard seized (will not move freely).	Clean & lubricate slide sheath.	Technician must drop down planetary assembly to access mat & sheath. Contact technician.
Agitators won't go onto the planetary shaft easily.	Lack of lubrication and/or cleaning of the planetary shaft.	Wipe planetary shaft with a clean damp cloth and lubricate the shaft with mineral oil or food quality grease.
Display not lit.	No power to unit	Check power
	Internal fuse blown	Call for service

Troubleshooting

Problem	Possible Causes	Action Required
Mixing time is too long	Three-phase mixer is wired wrong	Agitators should rotate clockwise around bowl. If not, electrician must rewire.
	Batch size too small	Increase batch size <u>or</u> use smaller bowl adapter kit. (<i>Contact dealer for purchase</i>)
	Incorrect recipe portions <u>or</u> temperatures	Follow portions and temperatures per recipe instructions.
Bowl lift sticking or not operational	Lack of lubrication on bowl slides	Lubricate bowl slides with mineral oil or food quality grease. If still sticking, technician must clean bowl-lift mechanism.
One or more gears not working	Broken belt	Technician to replace belt.
	Damaged or broken gear	Technician to replace gear. <i>Always stop mixer before shifting gears!</i>
Mixer will not mix medium or heavy loads.	Incorrect or low voltage	Contact electrician.
	Belt slipping	Technician to replace belt.
Residue leaking from hub	Contaminated hub due to build-up of meat and/or vegetable juices (especially tomatoes)	Technician to remove hub and clean interior. To avoid problem, wipe hub and dry after each use. <i>*Note: Acid from tomato juices will corrode/contaminate interior parts! Don't mix tomatoes in meat grinder!</i>
Agitators touching bottom or sides of bowl	Defective or dented bowl	Remove dents or replace bowl.
	Defective agitator	Replace agitator.
Broken whip wires	Batch size too large for mixer. Adjust recipe.	Reduce batch size. <i>Refer to Capacity Chart section.</i> Mixture too firm, speed too high. Reduce speed.
	Hand utensil dropped into bowl while mixing	Stop mixer
Broken flat beater	Ingredients too cold or too large (e.g. frozen butter, cream cheese cut in chunks)	Wait for ingredients to reach room temperature before mixing. Reduce chunk size.
Broken dough hook	Batch size too large for mixer	Reduce batch size. <i>Refer to Capacity Chart section.</i> Adjust recipe.
	Ingredients too cold or too large	Wait for ingredients to reach room temperature before mixing. Reduce chunk size.
Mixture climbs up dough hook	Three-phase mixer is wired incorrectly	Electrician to rewire.
Discoloration of mixed product	Bowl has not been thoroughly cleaned	Clean bowl again. <i>Refer to Cleaning Instructions.</i>
Mixer beeps when start button is pressed	Bowl guard not in closed position.	Rotate guard to the right until fully closed.
	Bowl not raised.	Raise bowl to highest position.

In the event of a power failure, the unit will shut down and the timer display will not be illuminated. Once power has been restored, the timer will display the last programmed/set time. Pressing the START button will begin the mixing operation.