

Primo

DOUGH SHEETER

PDS-50

Compact Reversible Dough Sheeter

Installation, Operation & Maintenance Manual

Read this manual completely before installing or operating the machine.

BELT
13.8 × 49.2 in

ROLLER GAP
0.04 – 0.98 in

ELECTRICAL
110 V · 60 Hz



IMPORTANT

Keep this manual with the machine for future reference.

mvpgroupcorp.com
MVP Group LLC · Fort Lauderdale, FL

Welcome

Thank you for choosing the Primo PDS-50. Before you install or use the sheeter, read every section of this manual carefully — it explains how to set the machine up, operate it safely and keep it in top condition.

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ABOUT THIS MANUAL

This manual covers the Primo **PDS-50** compact reversible dough sheeter. Keep it in a safe place near the machine, and make sure everyone who operates, cleans or services the sheeter has read it.

Safety messages use the signal words **DANGER**, **WARNING**, **CAUTION** and **NOTICE**. Their meaning is explained in Section 01.

PLEASE NOTE

MVP Group LLC reserves the right to modify the product at any time without prior notice. Illustrations are for reference only; the actual product may vary slightly as a result of ongoing product improvements.

PRODUCT RECORD

MODEL **PDS-50**

SERIAL NUMBER

DATE OF PURCHASE

DEALER

INSTALLED BY / DATE

The model and serial number are printed on the machine's rating plate. Record them here — you will need them whenever you contact service.

01 Safety

Dough sheeters have powered rollers and moving belts. Read and follow every instruction in this section before operating the machine.

SIGNAL WORDS USED IN THIS MANUAL

ANGER

A hazardous situation that, if not avoided, **will** result in death or serious injury.

ARNING

A hazardous situation that, if not avoided, **could** result in death or serious injury.

CAUTION

A hazardous situation that, if not avoided, could result in minor or moderate injury.

OTICE

Important information that is not hazard-related, such as messages about property damage.

**ARNING**

Crushing and entanglement hazard. The rollers and belts can draw in fingers, hands, hair and loose clothing. Never reach under the safety guard or into the rollers while the machine is running, and never operate it with the guard raised, removed or bypassed.

**ARNING**

Electric shock hazard. Never clean the machine with running water, a hose or a water jet — water can reach the electrical components. Switch off and disconnect power before cleaning, then wipe the machine with a damp cloth.

IMPORTANT SAFETY INSTRUCTIONS

- 01** Read this entire manual before installing, operating, cleaning or servicing the machine, and keep it with the machine for future reference.
- 02** Use the machine only for sheeting and stretching dough in commercial bakeries and food-service kitchens. Any other use is improper and may be dangerous.
- 03** Only trained adults may operate the machine. It must not be used by persons (including children) with reduced physical, sensory or mental capabilities, or by anyone who lacks the necessary experience and knowledge.
- 04** Keep hands, fingers, hair, jewelry and loose clothing away from the rollers and belts while the machine is running.
- 05** Never operate the machine with the safety guard raised, removed or bypassed, and never tamper with the safety switches.
- 06** If the machine malfunctions, switch it off and disconnect the power first. Repairs must be carried out only by a qualified electrician. Repairing the machine with the power connected is strictly prohibited.
- 07** Switch off and disconnect the power before cleaning, adjusting the belts or carrying out any maintenance.
- 08** Connect the machine only to a properly grounded supply protected by a ground-fault (residual-current) circuit breaker.
- 09** Never leave the machine running unattended.
- 10** Use only original replacement parts. Unauthorized modifications void the warranty and may create hazards.

02 Product Overview

A compact countertop sheeter that delivers even, consistent dough — pass after pass.

The Primo PDS-50 is a compact reversible dough sheeter designed to meet Baking Industry Sanitation Standards. It is ideal for sheeting and stretching a wide range of doughs, including puff pastry, Danish, bread, donut, croissant, pie, cookie, strudel and pizza dough.

Dough travels on a food-grade conveyor belt between two rollers. With each pass you close the gap between the rollers a little further and reverse the belts with the direction lever, until the sheet reaches exactly the thickness you need.

When the job is done, the conveyor tables fold up, so the machine takes up very little bench space.

FEATURES

- ✓ Compact sheeter with foldable, extractable conveyor tables
- ✓ High-quality food-grade conveyor belt
- ✓ Scraper assemblies are easy to remove and clean
- ✓ Safety guards, an emergency stop switch and thermal overload protection
- ✓ Roller gap from 0.04 to 0.98 in (1–25 mm), set with a hand wheel and thickness scale
- ✓ Forward and reverse belt travel from a single direction lever



CONVEYOR BELT

13.8 × 49.2 in

350 × 1250 mm

ROLLER GAP

0.04–0.98 in

1–25 mm

MAX. DOUGH

6.6 lb

3 kg per batch

ELECTRICAL

110 V

60 Hz · 0.4 kW

02 Key Components

Get to know the controls and main assemblies before running the machine.

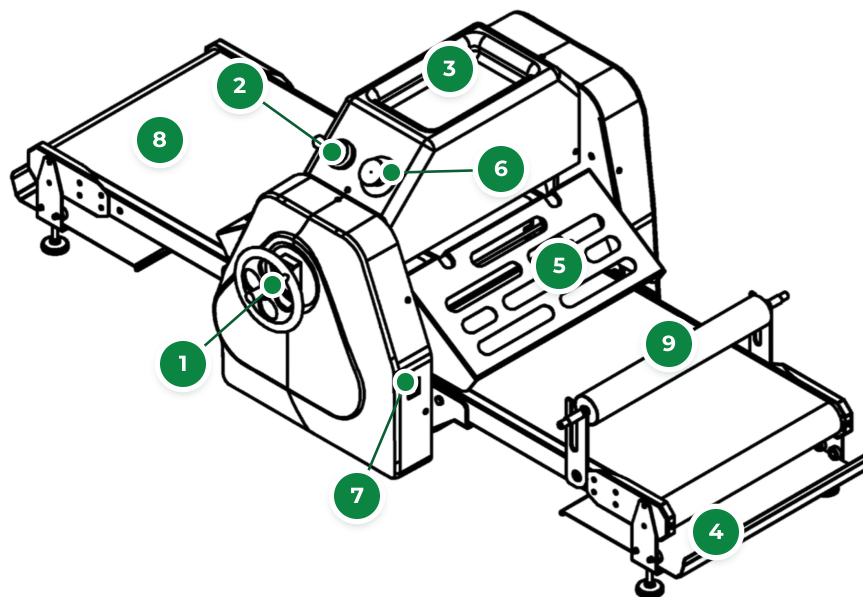


FIG. 1 PDS-50 main components. Illustration for reference; details may vary slightly.

1	Thickness adjusting wheel	Raises and lowers the upper roller to set the roller gap. Read the setting on the thickness scale behind the wheel.
2	Direction lever	Center position: belts stopped. Move the lever to either side to run the belts and rollers in that direction.
3	Flour box	Holds flour for dusting the dough during sheeting.
4	Flour receiving tray	Catches excess flour and small dough trimmings at the end of the conveyor.
5	Safety guard	Covers the roller entry. The machine runs only when the guard is lowered.
6	Emergency stop with power light	Press to stop all motion immediately. The built-in light shows that the machine is powered.
7	Power switch	Main ON/OFF switch.
8	Conveyor tables and belts	Carry the dough to and from the rollers. The tables fold up for storage.
9	Roller pin	Removable pin for winding up and lifting finished dough sheets.

03 Technical Specifications

Nominal data for the Primo PDS-50. Always confirm the electrical rating on the machine's rating plate before connecting it.

Specification	US	Metric
Electrical		
Electrical supply	110 V · 60 Hz · single phase — confirm on the rating plate	
Motor power	0.4 kW (0.54 hp)	
Motor protection	Thermal overload protection	
Capacity		
Conveyor belt (width × length)	13.8 × 49.2 in	350 × 1250 mm
Roller gap	0.04 – 0.98 in	1 – 25 mm
Maximum dough weight per batch	6.6 lb	3 kg
Dimensions & Weight		
Overall (length × depth × height)	64.2 × 29.9 × 21.1 in	1630 × 760 × 537 mm
Resting position, tables folded (length × height)	15.7 × 23.6 in	400 × 600 mm
Net weight	165 lb	75 kg

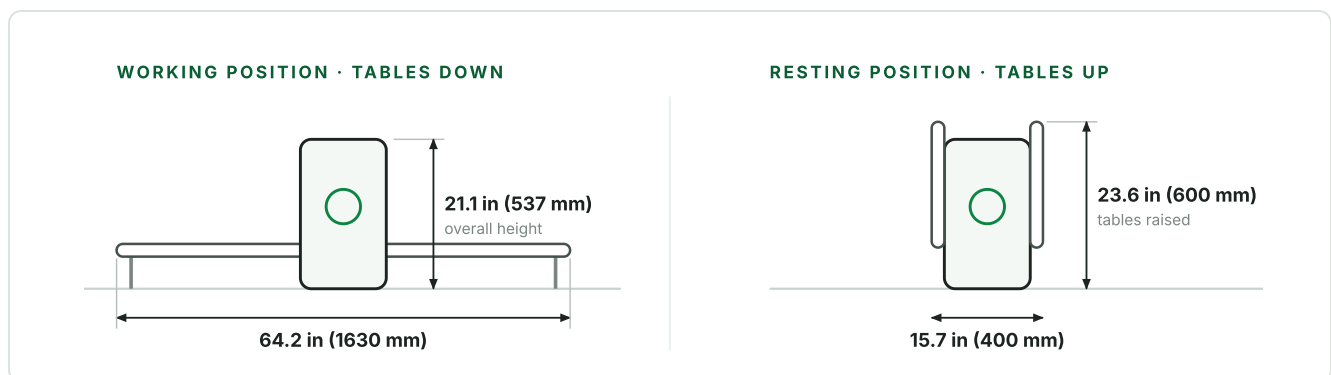


FIG. 2 Working and resting positions (schematic, not to scale).

- Electrical data are taken from the Primo product specification. The rating plate on the machine is the definitive reference — always check it before connecting the machine.
- Maximum dough weight refers to a single piece of dough processed at one time.
- Allow at least 12 in (300 mm) of clearance between the machine and any wall (see Section 04).

04 Installation

Unpacking, positioning, electrical connection and the checks to run before first use.

A Unpacking and inspection

- Remove all packaging and inspect the machine and its accessories immediately for shipping damage. If you find any, note it on the delivery receipt and report it to the carrier right away.
- The PDS-50 weighs **165 lb (75 kg)**. Lift it with at least two people or suitable lifting equipment — never by the conveyor tables, the rollers or the safety guard.
- Dispose of the packaging in accordance with local regulations.

B Location

- Place the machine on a **flat, level and sturdy** table or workbench that can safely carry its weight, then lower the conveyor tables on each side.
- Adjust the feet so the machine sits level and firm and cannot move while it is working.
- Leave at least **12 in (300 mm)** between the machine and any wall, plus enough room at both ends for the conveyor tables and the operator.

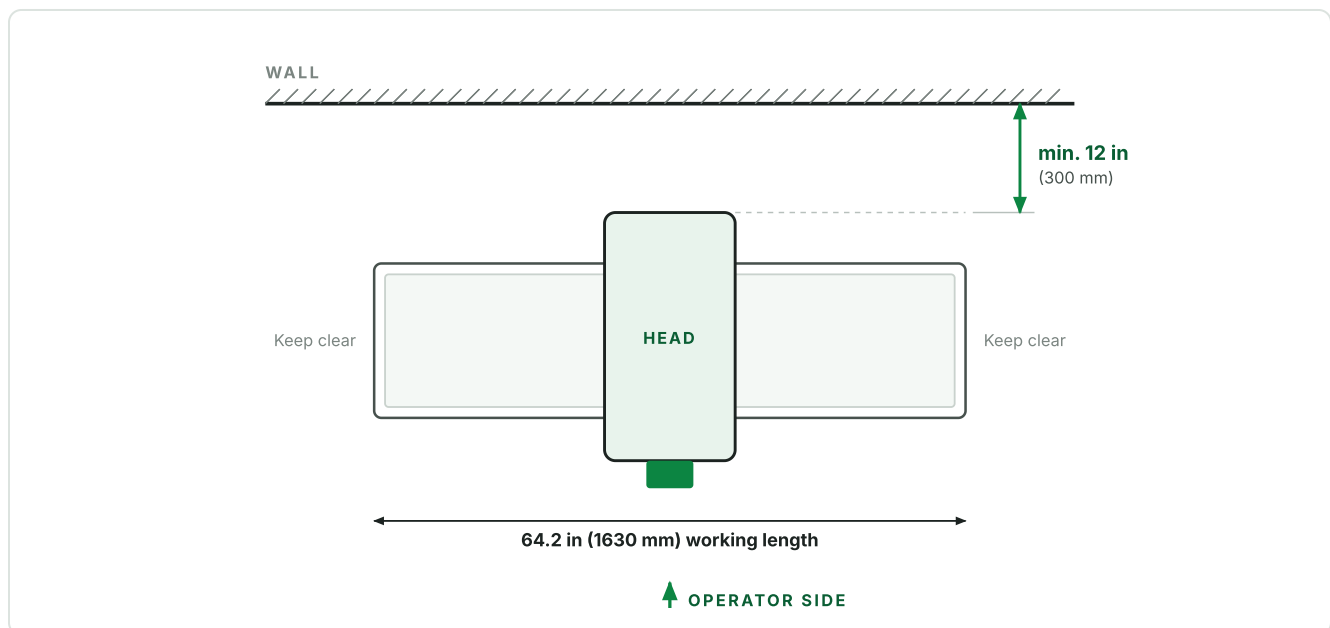


FIG. 3 Minimum clearance — plan view (schematic, not to scale).

C Electrical connection

- The electrical connection must be made by a **qualified electrician** in compliance with all applicable local and national electrical codes.
- Confirm that the supply voltage, frequency and phase match the **rating plate** on the machine (PDS-50: 110 V / 60 Hz).
- The supply circuit must be protected by a **ground-fault (residual-current) circuit breaker**.
- The machine **must be grounded**. Never defeat the ground connection or use an ungrounded adapter or extension cord.

WHY A GROUND-FAULT BREAKER?

A ground-fault (residual-current) breaker disconnects the supply within milliseconds if current leaks to ground — for example through moisture — protecting the operator from electric shock.

D First-run checks

Carry out these checks after installation and before the first production run. Do not use the machine until every check has passed.

- 1 Thickness wheel.** Turn the thickness adjusting wheel through its full range. It must move the upper roller smoothly.
- 2 Belt direction.** Lower the safety guard, switch the machine on and move the direction lever to each side in turn. The belts must travel in the direction selected.
- 3 Belt tracking.** Watch both belts while they run. If a belt drifts to one side, switch off and balance its tension with the adjusting screws on both sides of the conveyor table. Do not over-tighten.
- 4 Safety guard.** With the belts running, raise the safety guard — the machine must stop. Lower the guard again.
- 5 Emergency stop.** Press the emergency stop button — all motion must stop immediately. Release it before continuing.

COMMISSIONING RECORD

☐ Thickness control

☐ Belt direction

☐ Belt tracking

☐ Safety guard stop

☐ Emergency stop

☐ Initial cleaning (Section 06)

INSTALLED BY / COMPANY

SUPPLY VOLTAGE MEASURED

DATE

05 Operation

Sheet the dough in gradual passes until it reaches the thickness you need.

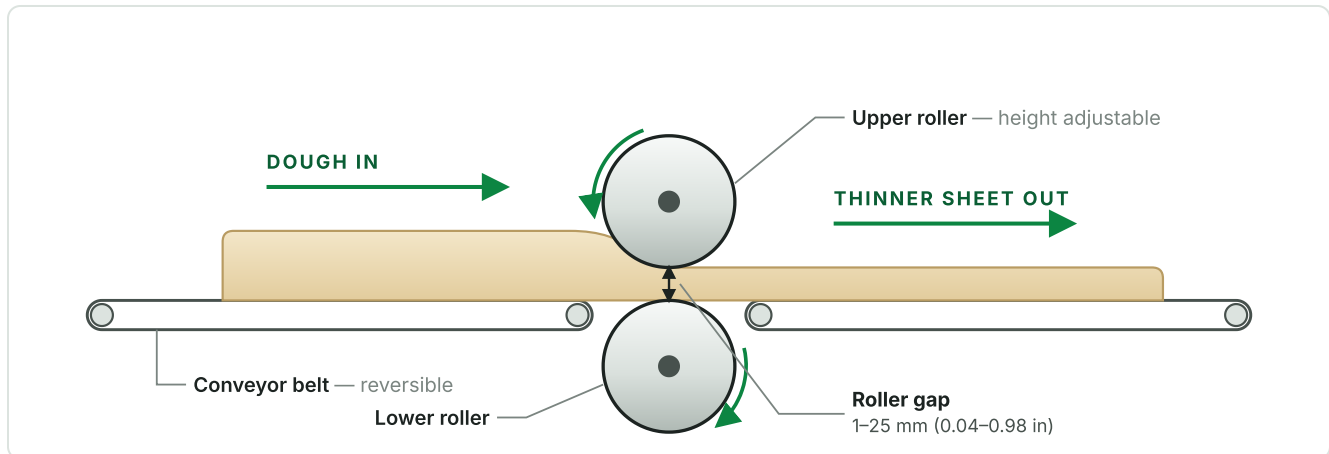


FIG. 4 Each pass through the rollers makes the dough thinner. The direction lever reverses the belts.

BEFORE YOU START

Make sure nothing — tools, packaging or dough scraps — can obstruct the rollers or belts, and that the work area is clear.

SHEETING PROCEDURE

- 1 Lower both conveyor tables and the safety guard.
- 2 Put the direction lever in the **center** position, then switch the machine on. The light in the emergency stop button shows that the machine is powered.
- 3 Set the starting roller gap with the thickness adjusting wheel, using the thickness scale behind the wheel.
- 4 Dust the belt and the dough lightly with flour to prevent sticking, then place the dough on the belt.
- 5 Move the direction lever to carry the dough through the rollers.
- 6 Lower the upper roller slightly with the wheel, then move the lever the other way to send the dough back. Repeat, making the dough thinner with each pass.
- 7 When the sheet reaches the required thickness, return the lever to the center and remove the dough. Wind long sheets onto the roller pin to lift them.



NOTICE

Reduce the gap gradually. Close the roller gap by no more than **5/16 in (8 mm)** per pass. Larger steps tear the dough and overload the drive.

Maximum dough load: 6.6 lb (3 kg) per batch.



WARNING

Emergency stop. Press the red button to stop all motion at once. Clear the cause, release the button, then restart with the direction lever in the center.

AFTER USE

- Return the direction lever to the center and switch the machine off.
- Check the rollers for residual dough and keep the belts clean (Section 06).
- Fold the conveyor tables up to save space.

06 Cleaning & Maintenance

A few minutes of cleaning at the end of every shift keeps the rollers true, the belts tracking straight and the dough free of residue.



WARNING

Switch the machine off and **disconnect it from the power supply** before cleaning. Never clean the machine with running water or a water jet — use a damp cloth.

DAILY CLEANING

At the end of each working day, switch the machine off, disconnect it, then:

- 1 Fold up the conveyor tables and remove residual dough and debris from the conveyor belt rollers.
- 2 Remove all residual dough from the upper and lower rollers and their scrapers. Make sure nothing is left on the rollers or scrapers.
- 3 Wipe the rollers and all external surfaces with a clean, damp cloth.
- 4 Clean the belt surfaces with a plastic scraper and a damp cloth.
- 5 Empty and wipe the flour receiving tray.
- 6 Let all parts dry completely before reconnecting the power.

USE — AND NEVER USE



Damp cloth

For the rollers, scrapers and all external surfaces.



Plastic scraper

For dough residue on the conveyor belts.



No water jet or hose

Water can reach the electrical parts.



No knives or metal blades

They score the rollers and cut the belts.

Maintenance schedule

Recommended intervals for a machine in daily use. Increase the frequency for heavy or multi-shift operation.

INTERVAL	TASK	BY
Daily	Clean the rollers, scrapers, belts and flour receiving tray as described in this section. Check that no dough residue remains on the rollers.	Operator
Weekly	Check belt tracking and tension. Inspect the scrapers and belts for wear or damage. Test the emergency stop and the safety guard switch.	Operator
Every 3 months	Check the lubrication of moving parts, the drive-chain tension and the condition of the bearings. Inspect the power cable and electrical connections.	Qualified technician
As required	Replace worn scrapers, belts or bearings with original Primo spare parts.	Qualified technician

Belt tracking and tension

The conveyor belts should run centered on their rollers. If a belt drifts toward one side:

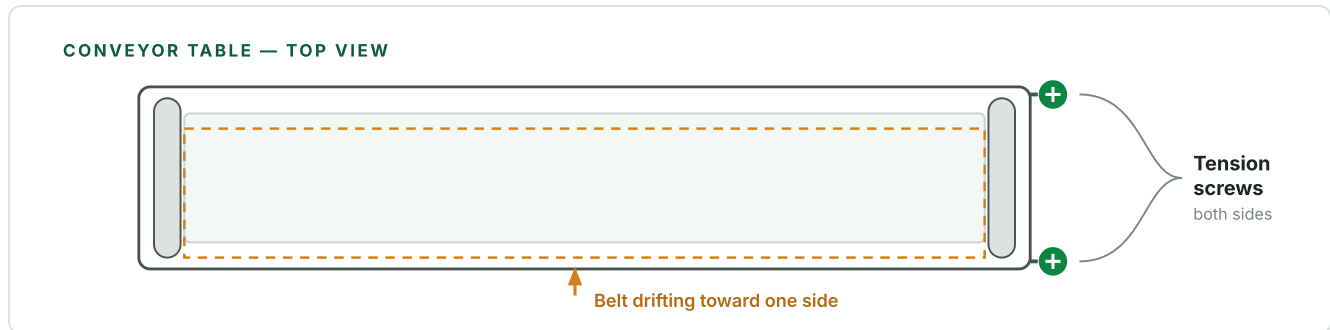


FIG. 5 Belt tension screws — one on each side of the conveyor table (schematic).

- 1 Switch off, disconnect the power and check that nothing is trapped between the belt and its rollers.
- 2 Adjust the tension screws on **both sides** of the conveyor table a little at a time — a quarter turn is usually enough — then run the belt and watch it for a few revolutions.
- 3 Repeat until the belt runs centered. Keep the tension balanced on both sides and **do not over-tighten**: an over-tight belt wears quickly and loads the bearings.



WARNING

Lubrication, drive-chain adjustment, bearing replacement and all electrical work must be carried out by a qualified technician with the machine disconnected from the power supply.

LONG PERIODS OUT OF USE

- 1 Clean the machine thoroughly and let it dry.
- 2 Disconnect it from the power supply.
- 3 Fold the conveyor tables up and cover the machine to keep dust off.
- 4 Before returning it to service, repeat the first-run checks in Section 04.

SPARE PARTS

Use only original Primo spare parts. Non-original parts can affect safety and performance and void the warranty.

To order parts, contact MVP Group LLC at service@mvpgroupcorp.com or 888.275.4538, quoting the model and serial number from the rating plate.

07 Troubleshooting

Most stoppages have a simple cause. Work through the checks below before calling for service.

**WARNING**

Switch the machine off and disconnect it from the power supply before checking or clearing anything inside the machine. Repairs must be carried out only by a qualified electrician or authorized service technician.

SYMPTOM	POSSIBLE CAUSE	REMEDY
Machine does not start No response when switched on	No power at the supply	Check the power supply, plug and circuit breaker.
	Power switch is off	Switch the power switch on.
	Safety guard is raised	Lower the safety guard fully.
	Direction lever is not in position	Return the lever to the center, then move it fully to the required side.
	Emergency stop is pressed	Clear the cause, then release the emergency stop button.
Machine is noisy Unusual noise during operation	Moving parts are not sufficiently lubricated	Have a qualified technician lubricate the drive components.
	Transmission chain is too loose	Have a qualified technician adjust the chain tension.
	Bearings are worn or damaged	Have the bearings inspected and replaced.
Belt runs off track Conveyor belt drifts to one side	An object is caught between the belt and a roller	Switch off, disconnect the power and remove it.
	Belt tension is uneven	Adjust the tension screws at both ends of the conveyor table evenly.

STILL NOT WORKING?

If the problem persists, stop using the machine and contact MVP Group service at service@mvpgroupcorp.com or **888.275.4538**. Have the model and serial number from the rating plate ready, together with the supply voltage and a short description of the fault.

Service Record

Record every inspection, adjustment and repair. A complete history helps technicians diagnose faults faster and supports warranty claims.



DOUGH SHEETER
PDS-50

Service & Support

CONTACT

MVP Group LLC

3590 NW 54th Street, Suite 1
Fort Lauderdale, FL 33309
United States

PHONE & EMAIL

Tel.	786.600.4687
Toll free	888.275.4538
Sales	sales@mvpgroupcorp.com
Service	service@mvpgroupcorp.com
Web	www.mvpgroupcorp.com

BEFORE YOU CALL

Have the model and serial number from the rating plate, the supply voltage at the machine and a short description of the fault ready. Authorized service agent listings are published at mvpgroupcorp.com.

WARRANTY

Installation or repair by unauthorized personnel, the use of non-original spare parts and unauthorized technical modifications void the manufacturer's warranty and product liability. Keep this manual with the machine for the life of the equipment.

QUICK REFERENCE • PDS-50

CONVEYOR BELT

13.8 × 49.2 in

350 × 1250 mm

ROLLER GAP

0.04–0.98 in

1–25 mm

MAX. DOUGH

6.6 lb

3 kg per batch

ELECTRICAL

110 V

60 Hz • 0.4 kW



PRIMO PDS-50 • SEPTEMBER 2026

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