

Holland Manufacturing, Inc.  
6851 – 51<sup>st</sup> Street Kenosha, WI 53144  
Ph 262-654-5300 Fax 262-654-6449

**MODEL "AT2F" ICE CREAM VARIEGATOR**

**GENERAL INSTRUCTIONS**

Your model AT2F ice cream variegator is a precision unit. Properly installed and maintained, it will give you trouble-free service and become a valuable part of your processing equipment.

The air motor warranty is as specified by the manufacturer and should be returned there for any claims. For the remaining portions of the variegator, material and workmanship are guaranteed for a period of six months after shipment from our factory. If the unit has been misused, not properly installed, or is improperly maintained all warranties or guarantees are void.

**INSTALLATION**

The model AT2F variegator should be installed directly over the ice cream filler as close as possible to the filler head. The flavors are introduced to the unit by means of the two upper 1 1/2" connections. The ice cream supply is connected to the lower port. The connection types may vary as specified by the user; threaded bevel seat is standard. Flavor and ice cream inlets are noted on line drawing.

An air supply of 100PSIG capable of 20CFM should be connected to the filter regulator lubricator.

**NOTE! DO NOT SUPPORT THE PRODUCT LINES WITH THE VARIEGATOR!**

**OPERATION**

The operation of the model AT2F variegator may vary from one installation to another depending on the conditions and the patterns desired. The speed of the internal revolving flavor tube is controlled by the adjustment knob of the flow control valve mounted on the air motor. Changing this will decrease or increase the number of swirls per minute of flavor laid into the flow of the ice cream. Changing the flow rate of the ice cream or the incoming flavor will also affect the pattern of the finished product.

**NOTE! DO NOT OPERATE THE VARIEGATOR WITHOUT PRODUCT CIRCULATING THROUGH IT AS DAMAGE TO THE SEALS MAY OCCUR!!**

**ASSEMBLY & DISASSEMBLY FOR CLEANING**

All parts of the model AT2F variegator have been constructed as closely as possible in accordance with sanitary practices for ease of assembly, disassembly, and cleaning.

1. Remove the variegating unit from the processing lines.
2. Remove item #10 o-ring from item #9 drive

pin and then pull the drive pin from the drive pin hole.

3. Pull item #2 flavor tube out of the variegator through the outlet port of item #1 body.

4. All of the item #5 clamps may now be removed.

5. Remove the item #4 seals from item #3 and item #8 seal retainers.

6. Clean all of the component parts manually using customary procedures for acceptable cleanliness.

7. When reassembling the unit it is recommended that the item #4 seals be lubricated with a sanitary lubricant.

8. Reassemble using proper precautions to avoid damage to seals and to assure proper alignment of retainers and the flavor tube.

**MAINTENANCE AND SERVICING**

The air motor and gear reducer should be inspected every month or every 200 hours of operation. Maintenance and lubrication should be followed as directed by the manufacturer specification sheet included with the variegator.

**SERVICE AND SPARE PARTS**

Service and spare parts may be ordered from:

HOLLAND MANUFACTURING, INC.  
6851-51 STREET  
KENOSHAWI53144

Please specify the model number, variegator size, item no., description, and the desired quantity of the parts being ordered. Also include any other information that is pertinent to your order, such as port connection style.

*example:* MODEL AT2F-3" variegator  
1-Item #1, body with bevel seat connections