



# Known for Reliability Since 1921

The BIRO F1000N, & F2000PLUSB Patty/Food Forming Machines are designed for production of a wide variety of meat and food products, with maximum production output capability from approximately 1000 to 3500 cycles per hour. A large number of drum mold die shapes are available. They vary from the standard round shapes of different diameters, to special shapes such as square, oval, rectangle, chicken nuggets, pork chop, etc. Call your representative for more information.

The key feature of this machine is the design of the Mold (die) in the drum. The operator can select product weights by changing the drum die depth (thickness) up to 1¼" (32mm). You do not need different die cups and plates each time you want to change weights. The Food Former Models are compact, have a small foot print, and are easy to clean-up. They are reliable, versatile and are a true Value-Added Profit Center all their own.



Model F1000N Shown  
with Manual Wire Cleaner



Model F2000PLUSB Shown  
with Manual Wire Cleaner



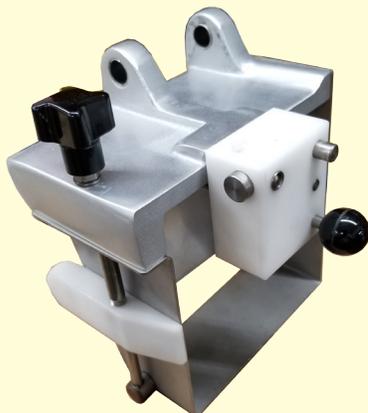
Single Round Hole Drum

**F1000N / F2000PLUSB  
PATTY/FOOD FORMERS**

# MODEL SPECIFICATIONS

Models:	F1000N	F2000PLUSB
Approximate Cycles per hour	1300 C/hr. Max	1000-3500 C/hr.
Product Type	Protein: Red Meat, Pork, Chicken, Fish, etc..	
Motor: ½ HP (.37Kw), 115 Volt, 60 Cy, 1 Ph. Optional EC, 230 Volt, 50/60 Cy, 1 Ph.	1 Phase - uses Inverter card to power 3 Phase Motor	N/A
Motor: 1 HP (.75Kw), 115 Volt, 60 Cy, 1 Ph. Optional EC, 230 Volt, 50/60 Cy, 1 Ph.	N/A	1 Phase - uses Inverter card to power 3 Phase Motor
Drum Mold	<b>White Poly</b> - Select One Single Hole Mold Drum as Standard Equipment Select from the Standard and Optional Selection Chart.	
2 or more Drum Molds	Optional - Extra Cost - Advise Shape or Shapes required and Item No.	
Foot Switch - Start/stops former and conveyor	Optional - Extra Cost	Standard Equipment
Hopper Capacity	16 Liters (22 lbs.)	25 Liters (35 lbs.)
Extended Hopper Capacity [40 Liters (56 lbs.)]	N/A	Optional - Extra Cost
Manual Wire Cleaner for Drum	Standard Equipment	Standard Equipment
Pneumatic Wire Cleaner for Drum EC - Minimum of 45 PSI	N/A	Optional - Extra Cost
Conveyor and Conveyor Belt, 15¾" (390.5 mm) long	Standard Equipment	Standard Equipment
Conveyor and Longer Conveyor Belt, 35¾" (898.5 mm) long	Optional - Extra Cost	Optional - Extra Cost
Stainless steel feed paddle	Standard Equipment	
Patty Paper Attachment - Accepts up to 5½" (139.7 mm) Square	Two - Sample Packs Included, 5" x 5" square, Approximately 1330 sheets	
Variable Speed - Drum & Conveyor Synchronized	N/A	Standard Equipment
Cleaning Tilt Stand	N/A	Standard Equipment
Certification:	NSF & ETL(115V - 60Hz Only)	NSF & ETL(115V - 60Hz Only)
Ledger:	C/hr. = Cycles per hour; EC = Extra Cost; N/A = Not Available; Std. = Standard; S.S. = Stainless Steel;.	

Dimensions & Weight:	
Model:	F1000N
Dims. (Std. Conv.)	L22.8" (579mm) x W20.5" (519mm) x H24" (607mm)
W/Long Conv.	L42.5" (1079mm) x W20.5" (519mm) x H24" (607mm)
Weight	126 lbs. (57 kg)
Shipping Weight	168 lbs. (76.2 kg)
Wood Box Dims.	L30.3" (770mm) x W27.6" (700mm) x H29.5" (750mm)



**Paper Holder**  
standard on machines

Dimensions & Weight:	
Model:	F2000PLUSB
Dims. (Std. Conv.)	L25.6" (650mm) x W21.5" (545mm) x H24.8" (630mm)
W/Long Conv.	L43.1" (1095mm) x W21.5" (545mm) x H24.8" (630mm)
Weight	158.7 lbs. (72 kg)
Shipping Weight	198.5 lbs. (90 kg)
Wood Box Dims.	L30.3" (770mm) x W27.6" (700mm) x H37.8" (960mm)



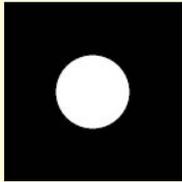
**Manual drum wire cleaner is standard.**  
**Automatic drum wire cleaner optional, extra cost**  
**on F2000PLUSB. (not shown)**

# FOOD FORMER DRUM MOLDS SELECTION CHART

**NOTE: Standard Poly Drum Molds:**

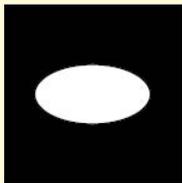
Select from below ONE Drum, Single Hole (Round, Oval or Square shape) to be supplied (no charge) with each machine

**Standard Poly (Drum Single Hole Round) Molds:**



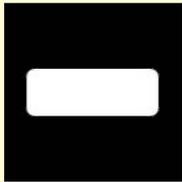
F9320000-50	50MM (1.96") diameter	F9320000-100	100MM (3.93") diameter
F9320000-55	55MM (2.16") diameter	F9320000-101.6	101.6MM (4") diameter
F9320000-60	60MM (2.36") diameter	F9320000-104	104MM (4.09") diameter
F9320000-63.5	63.5MM (2.5") diameter	F9320000-108	108MM (4.25") diameter
F9320000-70	70MM (2.75") diameter	F9320000-110	110MM (4.33") diameter
F9320000-76.2	76.2MM (3") diameter	F9320000-115	115MM (4.53") diameter
F9320000-80	80MM (3.14") diameter	F9320000-120	120MM (4.72") diameter
F9320000-90	90MM (3.54") diameter	F9320000-127	127MM (5.0") diameter
F9320000-95	95MM (3.74") diameter	F9320000-130	130MM (5.12") diameter

**Standard Poly (Drum Single Hole Oval) Molds:**



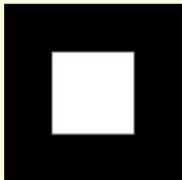
F9320000-1-100127	100MM x 127MM (3.9" x 5")
F9320000-1-10076	100MM x 76MM (3.9" x 3")
F9320000-1-11070	110MM x 70MM (4.3" x 2.7")
F9320000-1-11090	110MM x 90MM (4.3" x 3.5")
F9320000-1-12080	120MM x 80MM (4.7" x 3.1")
F9320000-1-13098	130MM x 98MM (5.1" x 3.8")

**Standard Poly (Drum Single Hole Rectangle) Molds:**



F9320000-7-10070	100MM x 70MM (3.9" x 2.7")
F9320000-7-108127	108MM x 127MM (4.2" x 5")
F9320000-7-12038.25	120MM x 38.25MM (4.7" x 1.5")
F9320000-7-13070	130MM x 70MM (5" x 2.7")

**Standard Poly (Drum Single Hole Square) Molds:**

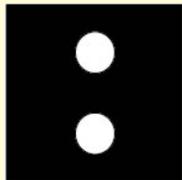


F9320000-3-50.850.8	50.8MM x 50.8MM (2" x 2")
F9320000-3-8686	86MM x 86MM (3.4" x 3.4")
F9320000-3-9090	90MM x 90MM (3.5" x 3.5")
F9320000-3-100100	100MM x 100MM (3.9" x 3.9")
F9320000-3-102102	102MM x 102MM (4" x 4")
F9320000-3-114.3114.3	114.3MM x 114.3MM (4.5" x 4.5")
F9320000-3-120120	120MM x 120MM (4.7" x 4.7")

**NOTE: All other drums (not listed above) and shown below are Optional, Extra Charge:**

**Optional Poly Drum Molds:**

**Drum Double 2 Round Holes Molds:**

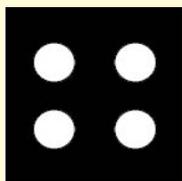


F9320002-8-35	2 x 35MM (1.4") diameter
F9320002-8-40	2 x 40MM (1.6") diameter
F9320002-8-45	2 x 45MM (1.8") diameter
F9320002-8-50	2 x 50MM (1.96") diameter

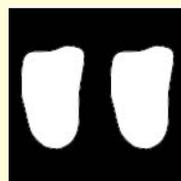
**Additional Optional Poly Drum Molds:**



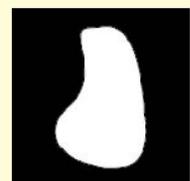
F9320002-2-9030  
Double Rectangle  
90MM x 30MM  
(3.5" x 1.2")



F9320003-14-35  
Quadruple Round  
35MM diameter  
(1.4") diameter



F9320002-23  
Double Chicken Nugget  
35MM x 55MM  
(1.4" x 2.16")



F9320000-10  
Pork Chop

## BIRO Food Formers

### General Information

1. The Formers Models F1000N, F2000PLUSB approximate per-hour output is achieved under absolute best conditions, i.e., quality of product, cold product, low environment temperature and a cold machine. This output capacity does not take into account stopping and filling the hopper with product or stopping the machine to collect patties from the conveyor, etc.
2. This BIRO Food Former literature illustrates various mold shapes and will help you decide what is available. One Poly Drum Single-Hole Mold is supplied as standard equipment (no charge) with each former. See Poly Drum Single Hole (Round, Oval, Rectangle or Square Shape) Molds selection chart and other optional extra cost Drum Molds.
3. A two-hole mold drum is available in small round shapes, but the product will be flat on the top and bottom and round on the sides. This style Drum Mold is available at optional extra cost.
4. A floor foot switch (optional on the F1000N, standard on the F2000PLUSB) turns the forming machine and conveyor on and off synchronized by the operator. This feature allows the operator's hands to control the collection of products at the end of the conveyor belt.
5. The F2000PLUSB optional (extra cost) automatic pneumatic (minimum 65 P.S.I. air pressure required) wire cleaner assembly is available to free the operator's hands. This selected option allows the operator to have free hands to collect the product as the product comes off the end of the conveyor belt.
6. The auto patty paper leafing assembly is standard on both former models. The paper leafer deposits one sheet of paper on one side of each patty. We recommend that the patty paper leafer assembly be removed before cleaning. Do not allow the patty paper to become damp or wet. Should the paper become damp, the leafing will not work correctly. Always store patty paper in a dry environment.
7. One of the major advantages of the BIRO food former is the adjustable weight capability. For example, using a 100mm diameter mold, the patty thickness is adjustable up to 1-1/4" (31.75mm) maximum thickness and up to 1" (25.4mm) maximum thickness on the 5.12" (130mm) diameter single hole drum. Therefore, a variety of patty weights can be obtained using the same 100mm diameter die mold. The weight variance between patties will not have a variance of  $\pm 2$  grams ( $\pm 0.07$  ounces) assuming the forming temperature is correct. (See Numbers 8, 9 & 10).
8. All former machine models operate best in a cold consistent temperature environment, i.e., 28°F to 33°F (-2°C to  $\pm 1$ °C) so the meat product inside the hopper remains cold, the same temperature as the environment. This is very important.
9. The batch of meat going into the hopper must also be cold, i.e., 28°F to 33°F (-2°C to  $\pm 1$ °C).
10. If the product, environment, and machines are not kept cold, the product will become too soft, mushy, and sticky. The formed patty will want to stick to the drum mold upon discharge. As the wire cleaner, manual or pneumatic, peels the patty off the drum, the patty will look a bit rough and ragged around the edges because the meat is too warm and sticky.
11. The patty is rolled out rather than compressed stamped. The formed patty will be lighter, fluffier and looser than a compressed stamped patty.
12. Easy to disassemble for cleaning (no tools required).
13. These Food Formers have been manufactured since 1995. The machines are designed well, have a robust construction, and very compact, i.e. small foot print, compared to other patty formers on the market.



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*All specifications contained herein are subject to change without notification.*

ITEM NO.: LIT-FOODFORMER  
FORM NO.: LIT-FOODFORMER-5-22-2

Service is available from locations worldwide