



# VENTURA FLEX

## OWNER'S MANUAL

MODEL: TM-105 VENTURA FLEX PL



Intertek

5011305  
CONFORMS TO UL  
STD. 763  
CERT. TO CSA  
STD. C22.2 #195



Website: [www.tortillamachine.com](http://www.tortillamachine.com)

Phone: 281-994-7010

Email: [info@tortillamasters.com](mailto:info@tortillamasters.com)

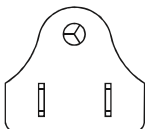
Address: 5005 Gessner Rd. Ste C, Houston TX, 77041

Rev 06222018

## IMPORTANT SAFEGUARDS

When using an electrical machine, basic safety precautions should always be followed to reduce the risk of fire, electric shock and/or injury, including the following:

1. READ ALL INSTRUCTIONS BEFORE USING.
2. Switch off and unplug before fitting or removing tools and/or attachments, after use and before cleaning.
3. Close supervision is necessary when machine is connected. Tortilla Masters Equipment does not recommend the use of this machine by children.
4. Avoid contact with moving parts and fitted attachments. Keep hands, hair, clothing, as well utensils, away from rollers and conveyor belt during operation to reduce the risk of injury to people and/or damage to the machine.
5. The use of attachments not recommended or sold by Tortilla Masters Equipment may cause fire, electric shock or injury.
6. Do not use more than one attachment at a time.
7. Do not use the machine if it is damaged or if the cord is damaged. Have the machine checked and serviced before resuming use.
8. When using an attachment make sure that you have read the safety instructions.
9. Do not use outdoors.
10. To protect against the risk of electric shock do not put the power unit in water or other liquid.
11. Remove all attachments and accessories from machine before cleaning.
12. Do not let cord hang over edge of table or counter.



NEMA 5015P 110V

## SAVE THESE INSTRUCTIONS

### FOR COMMERCIAL USE

#### WARNING: RISK OF FIRE OR ELECTRIC SHOCK



The lightning flash with arrowhead symbol within an equilateral triangle is intended to alert the user to the presence of un-insulated dangerous voltage within the product's enclosure that may be of sufficient magnitude to constitute a risk of fire or electric shock to persons.



The hands between the two circles within an equilateral triangle is intended to alert the user to the presence of entanglement hazard. Rotating parts. Keep hands clear of rollers. Do NOT operate with exposed long hair, jewelry, or loose clothing.

#### SPECIAL CORD SET INSTRUCTIONS

A short power-supply cord is provided to reduce the risks resulting from becoming entangled in or tripping over a longer cord.

Longer extension cords are available and may be used if care is exercised in their use.

If a long extension cord is used, the marked electrical rating of the extension cord must be at least as great as the electrical rating of the machine, and the longer cord should be arranged so that it will not drape over the countertop or tabletop where it can be pulled on by children or tripped over.

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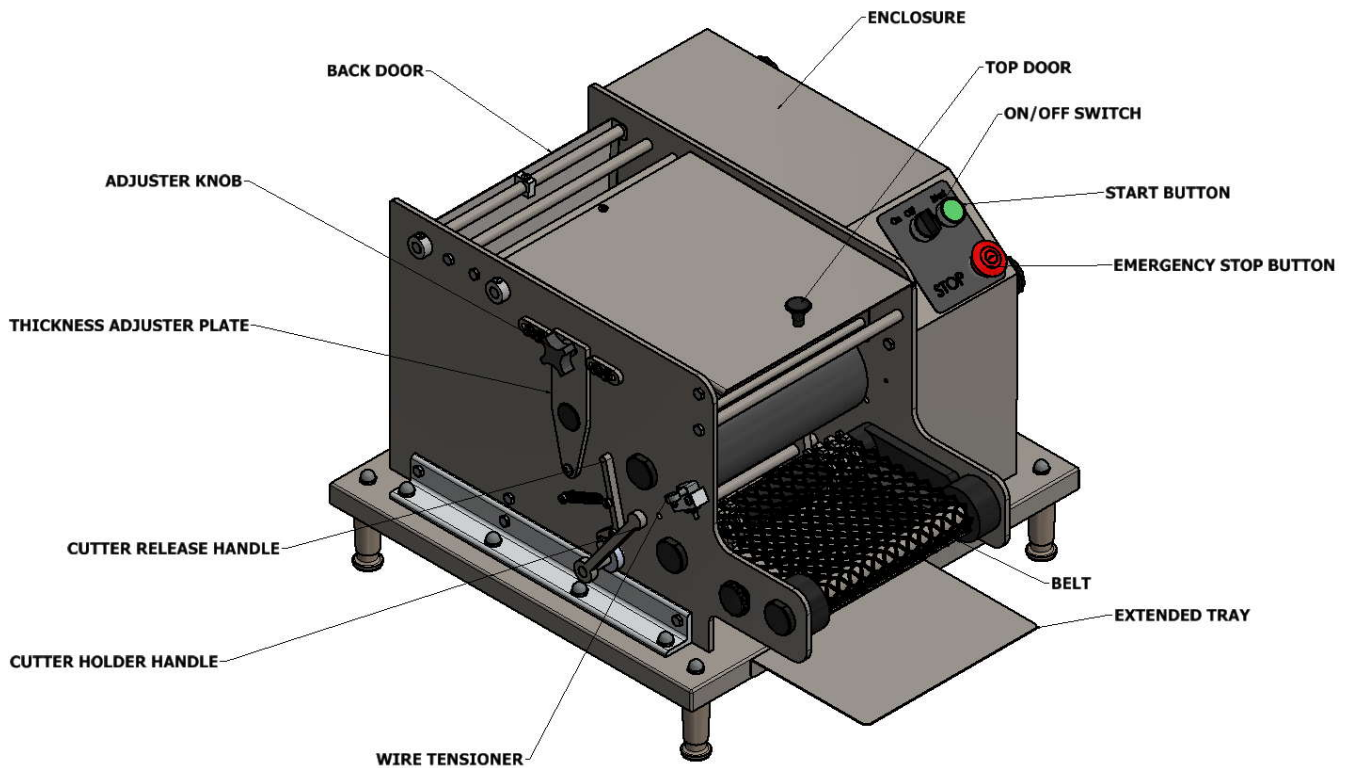
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# INTRODUCTION

Congratulations on your purchase of the Ventura Flex! The TM-105 Ventura Flex is the first tabletop corn tortilla machine by Tortilla Masters Equipment. Ideal for restaurants, this machine's specialty is to produce a perfect corn tortilla that is ready to cook. The Ventura Flex is NSF and ETL certified.

Creating a perfect, ready to cook corn tortilla has never been easier! Your kitchen will be able to produce more, better corn tortillas in a faster and more efficient manner. The Ventura Flex is reliable – manufactured from the highest-grade materials and produced in the USA. Its small footprint allows the machine to be flexible and placed in your kitchen.

## PARTS OVERVIEW



# OPERATING INSTRUCTIONS

## TORTILLA MACHINE OPERATION INSTRUCTIONS

1. Place a clean tortilla cutter in the unit as described in the “Installation of a Tortilla Cutter”
2. Make sure the cutting wire is on properly and tightened with the metal straps
3. Place about half pound of dough, over between and along the two black rollers, making sure that the dough is along the length of the rollers
4. Pull the hand lever on disengage the tortilla cutter
5. Turn ON the machine using the ON/OFF Selector Switch
6. Press the Green Start Button
7. Make sure that the dough is along the length of the rollers, so when the rollers are pulling the dough in between, the front roller will be completely covered with dough
8. You will see a sheet of dough dropping into the wire belt, take it by hand and place it over the front roller until this front roller is completely covered with dough
9. Pull the interlock spring loaded lever to engage the tortilla cutter
10. Now cut tortillas will drop onto the wire belt
11. Place the tortillas by hand on the griddle. Keep doing this until the griddle is filled with tortillas
12. Turn OFF the unit while you are cooking the tortillas, so the dough will not overmix
13. Turn on the machine and keep feeding the machine with dough ball (about 1 lbs.) to continue making tortillas

## **TORTILLA THICKNESS ADJUSTMENT**

The Ventura Flex has the capacity to produce tortillas from 1/16 to 1/8 of an inch with the thickness adjuster plates on both sides, simply by loosening the knobs and adjusting the distance between the rollers to the desired thickness for the tortilla. The thickness adjuster plate is in between the two slotted locks that indicate the thickness limit allowed.

## **INSTALLATION OF A TORTILLA CUTTER**

1. Turn OFF and unplug the unit
2. Open the back cover
3. Pull down the hand lever and hold by hand
4. Insert the tortilla cutter thru the opening
5. Engage the tortilla cutter into the tortilla cutter support
6. Pull the interlock spring loaded lever to engage the tortilla cutter
7. Close the back cover
8. The unit is ready to use

## **UNINSTALL THE TORTILLA CUTTER**

1. Turn OFF and unplug the unit
2. Open the back cover
3. Pull the hand lever on disengage position
4. Take the tortilla cutter in one hand and with the other hand pull down the hand lever until the tortilla cutter is released
5. Now that the tortilla cutter is free, you can remove it from the machine
6. Close the back cover

## COOKING INSTRUCTIONS

### MAKING THE MASA (TORTILLA DOUGH)

#### Ingredients:

Corn Flour      1.0 pounds (~ 0.45 kg)  
Water            1.3 pounds (~ 20.0 fl-oz)

In a mixer, thoroughly stir the corn flour and water until it is all incorporated (about 4 minutes) and a smooth dough is formed which does not stick to your hands. If the dough feels dry, add water. Once the dough is ready, cover with a damp towel so that it does not dry out.

### COOKING THE TORTILLAS

Once the tortilla is ready, cook on a hot griddle for 10 seconds the first side, cook the second side for 20 seconds and again the first side for 15 seconds, or until the tortilla fluffs up. The temperature of the griddle should be between 450 F to 500 F.

### KEEPING THE TORTILLAS WARM

Keep the tortillas in an air-tight, insulated container covered with a clean cloth  
After one hour, the tortillas will be about 130° F, good enough to be served  
After Two hours, the tortillas will be about 110° F, good enough to be served

### TORTILLA CAPACITY GUIDELINE

<i>GRIDDLE SIZE</i>	<i>MAX PER HOUR</i>
2 x 4	630 / Hour
2 x 3	450 / Hour
2 x 2	270 / Hour

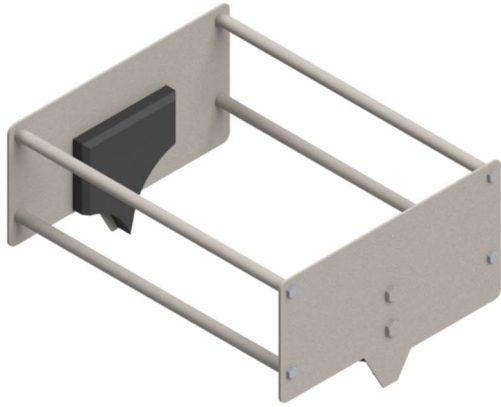
*\*Max Per Hour rate is an approximation*

## TIPS AND HINTS

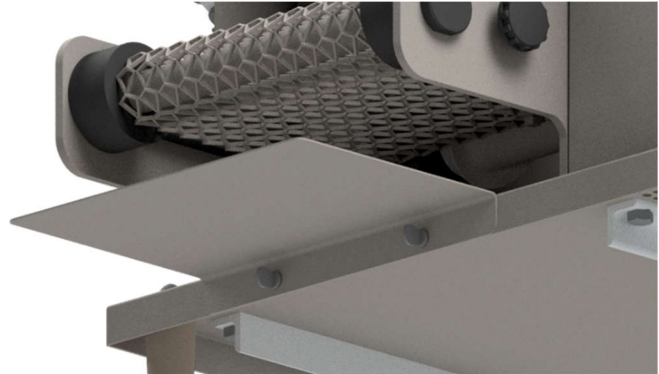
- Have the prepared dough ready to feed the machine.
- Disengage the tortilla cutter before you place the first piece of dough over the black rollers.
- The first piece of dough you place over the black rollers, needs to be about half pound in tubular shape laydown.
- The following pieces of dough you place over the black rollers, need to be no more than 1½ pounds in tubular shape in the center of the black rollers.
- If the unit starts to run out of dough, the unit will produce holes in the tortilla.
- Do not return a bad tortilla or a tortilla with holes onto the rollers. Put the bad tortillas aside and mix it by hand or with a mixer.
- Turn OFF the unit after you filled the griddle with tortillas. If the unit is not turned OFF, tortillas will continue to drop to the table and the masa could overmix.
- The Ventura Flex is NOT a machine that you plug in and it will produce tortillas, this is a production machine that require some expertise gained by practice. This machine will help you produce fast and high-quality tortillas for you.
- Keep a recipe with procedures to make the dough in your kitchen, so any operator can make always the same recipe and tortillas.
- Following the recipe is very important for you to have a good dough and good tortillas. Not following the masa recipe and procedures will yield poor quality tortillas.
- You can make different tortilla sizes.
- See the chart for the different tortilla cutter size.



## STANDARD ACCESSORIES



**Tortilla Hopper System**



**Extended Tray**



**TC16 Tortilla Cutter**



**TMSA-200**

Metal Straps – 10 pcs

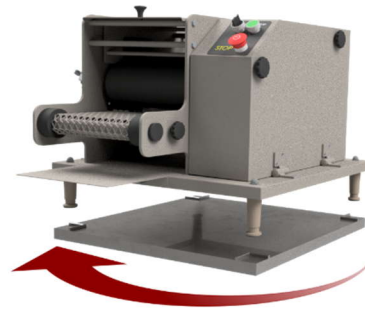
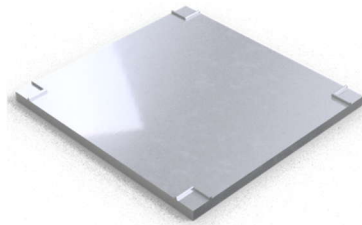


**TMSA-201**

Metal Wire – 10 pcs

## ADDITIONAL ACCESSORIES

<i>Item</i>	<i>Raw Tortilla (centimeters)</i>	<i>Cooked Tortilla (centimeters)</i>	<i>Cooked Tortilla (Inches)</i>
TC10	10	9	3 ½''
TC11	11	10	4''
TC12	12	11	4 5/16''
TC13	13	12	4 ¾''
TC14	14	13	5 1/8''
TC15	15	14	5 ½''



### TMSA-100 Easy Access Turn Table

Easily access the Ventura Flex in any spot of your kitchen. Just turn it on the spin tray! For accessible removal of the tortilla cutters and easy cleaning.



#### TMSA-200

Metal Straps – 10 pcs per bag

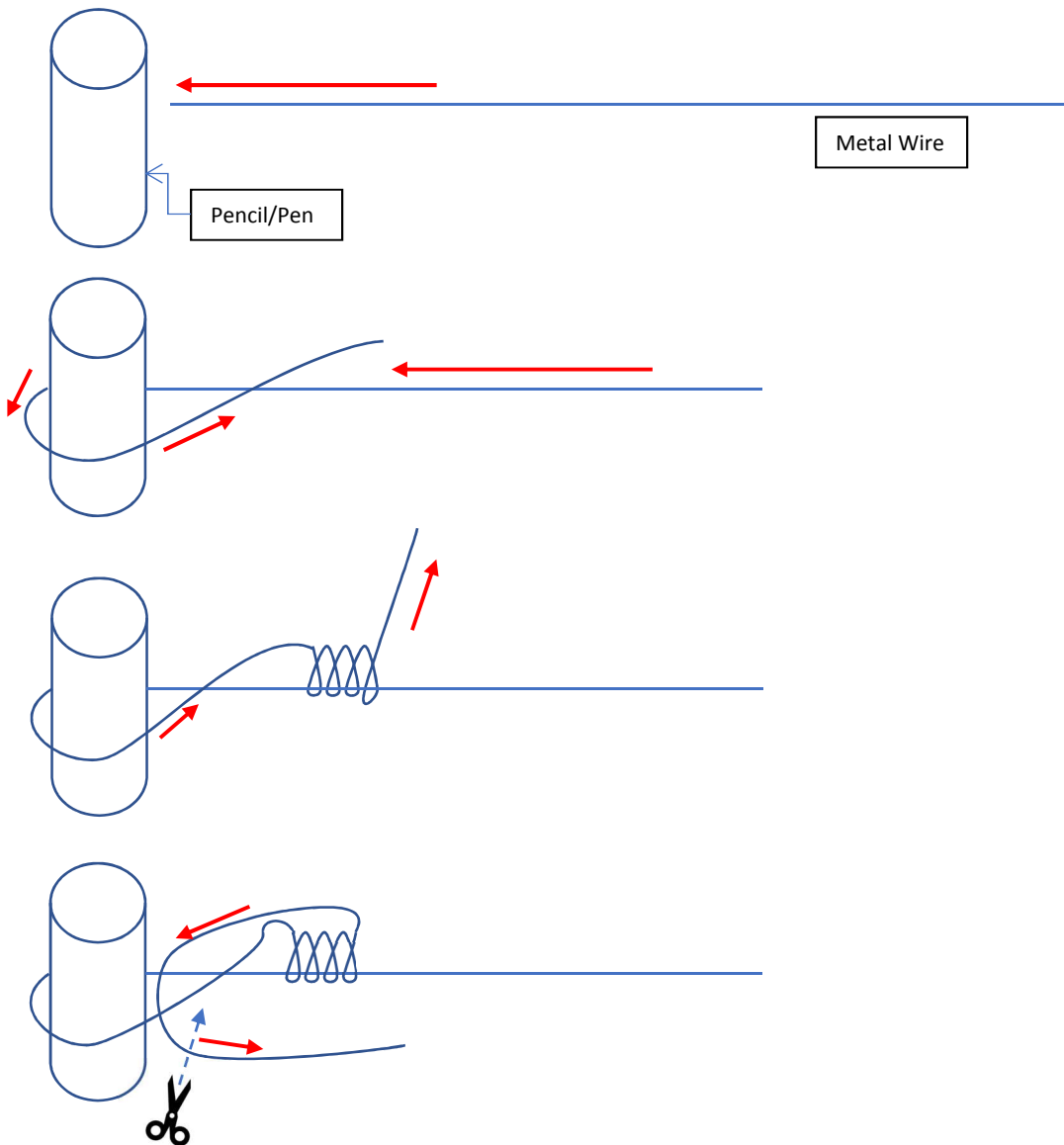


#### TMSA-201

Metal Wire – 10 pcs per bag

## TORTILLA RELEASE WIRE PREPARATION

- Pull about 3½ inches of wire around a pen or pencil.
- With one end of the wire, rotate the pen or pencil to make four tight wraps with the tail around the line wire creating a loop. Tighten firmly using included pliers.
- Bring the tail of the wrapped wire and over the loop.
- Cut off excess wire and tighten firmly.



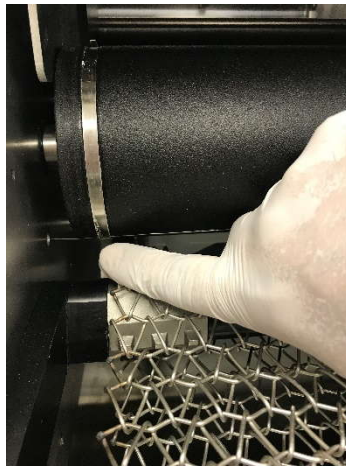
## TORTILLA RELEASE WIRE INSTALLATION

1. Turn OFF and unplug the unit.
2. Remove both metal straps OFF the frontal roller.
3. Open the side cover.
4. Take a wire from the spare bag.
5. Make loop as shown in previous page (page 9 “TORTILLA RELEASE WIRE PREPARATION”)
6. Insert the loop of the wire into the bolt located close to the opening on the gears side.
7. Take the wire and pass it through that opening.
8. Take the tip of the wire and pass it through the opening on the opposite side.
9. Again, take the tip of the wire and pass it to the opening of the wire tensioner.
10. Turn the wire tensioner knob and tighten a little bit. It cannot be too tight.
11. Cut the excess wire.
12. Install the metal straps.

***Important: The wire should be in between the roller and the metals straps. This is the wire that aids in separating the tortilla from the roller***



To install the wire, secure it by placing a loop on the screw.



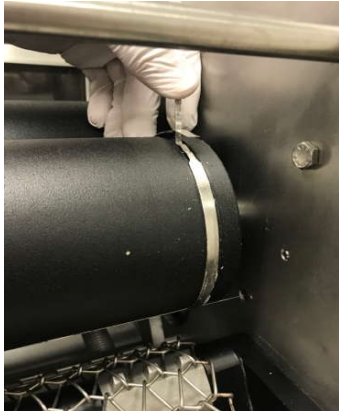
Run the wire along the length of the roller and insert the wire through the opening on both sides of the roller.



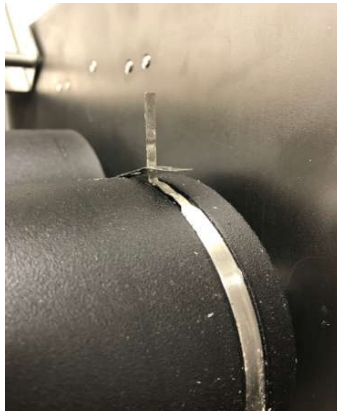
Insert the wire in the guiding peg and turn the peg to tighten the wire.  
Note: The wire will break easily if over tightened.

## INSTALLING METAL STRAPS

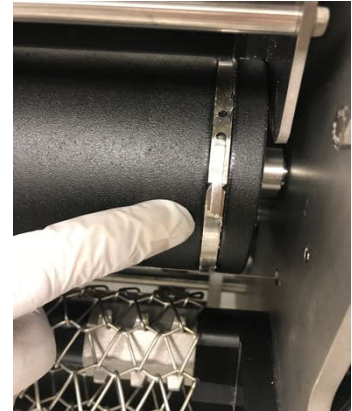
**Important:** The wire must be installed completely from the right side to the left side and tightened with the guitar tuning peg before beginning this step.



Once the wire is installed, the metal straps (on both sides) are placed **over** the wire.

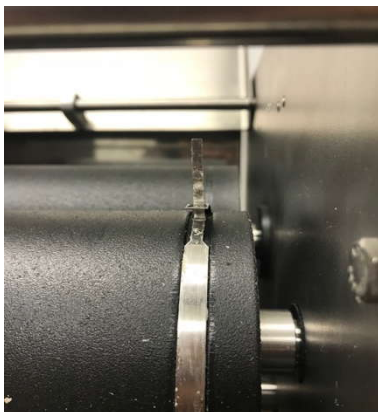


It's important that the tail end is placed running in the opposite direction to the rollers, otherwise it will encounter the roller and break the metal strap.

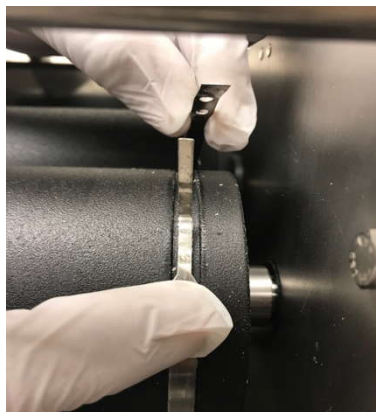


Close and secure the metal strap. Lower the tail end securing the metal strap.

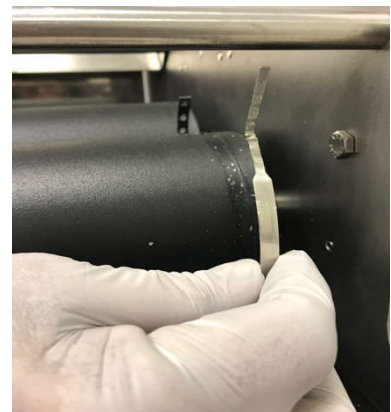
## REMOVING METAL STRAPS



Open the metal straps to unlock them as shown in the picture above.



Pull on the straps to have the two ends separate.

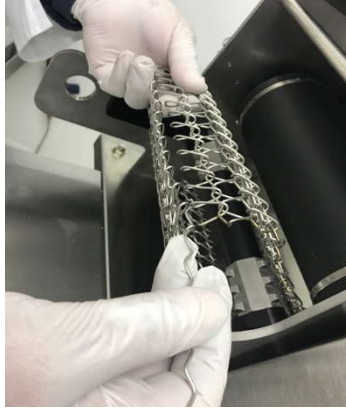


Gently remove the metal strap and take it out of the black roller.

## INSTALLING CONVEYOR MESH



Wrap the conveyor mesh around the sprockets.



Insert the lock in between the two links while twisting it.



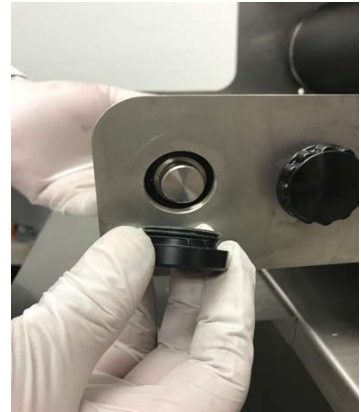
Above is how the conveyor mesh should look with the lock installed.



Insert the stainless-steel shaft through the opening with the black spacer.  
Don't forget to insert the black spacer on the left and right sides.



Continue inserting the stainless-steel shaft through the conveyor mesh to the other side.



Twist the black cap on to the stainless-steel shaft to the left and secure tightly.

## REMOVING CONVEYOR MESH



Twist the black roller caps and remove them from both sides.



Push the stainless-steel shaft with your finger.



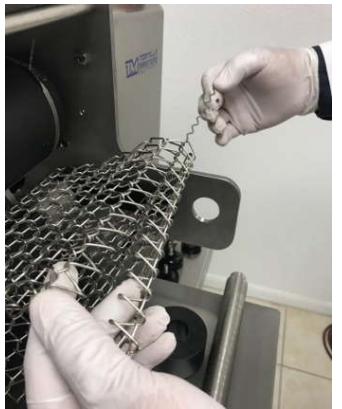
Pull the stainless-steel shaft and remove it.



After disassembling the conveyor system your Ventura Flex should look like the picture above.



Find opening in the conveyor mesh (which is around where the finger in the picture is).



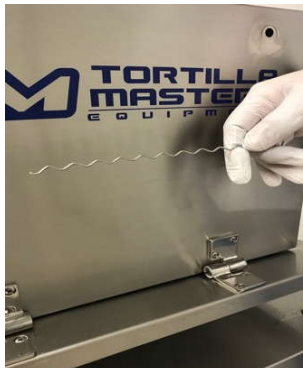
Pull the lock from the end as shown in the photo and remove it.



Shown in the picture is another view of the lock being pulled away from the conveyor mesh.

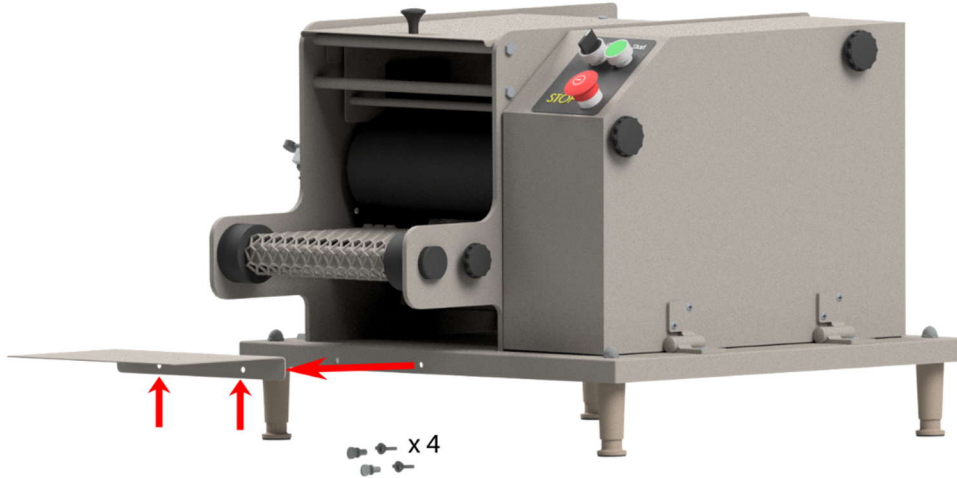


Remove the Conveyor Mesh.



Pictured above is the lock once removed.

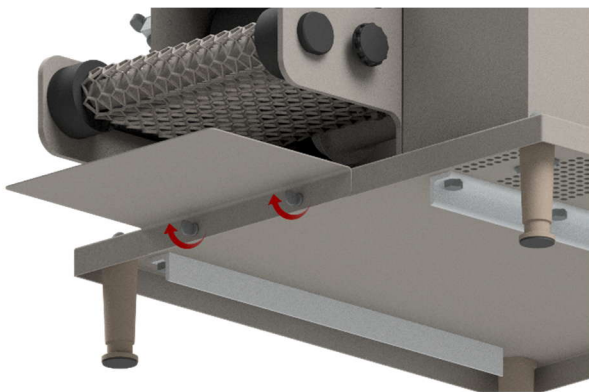
## INSTALLING EXTENDED TRAY



Included should be 2 screws and 2 butterfly nuts, along with the extended tray. Total, there will be five parts. Begin by lining up the screw holes as shown by the red arrows.



After lining up the holes, insert the screws through the holes. Don't tighten yet, just loosely adjust the screw and butterfly pairs together. Ensure that the parts fit together, and no force should be used in installation. Stop here if the parts don't fit together or are warped.



If all the parts fit together and no issues are seen, proceed to hand tighten the screws and butterfly nuts. Do one at a time and ensure that there is no play in the tray or the bolts. The extended tray should be firmly attached if installed correctly. If there is any warping or wrong fitting, stop and inspect the parts.



## CLEANING INSTRUCTIONS

**WARNING:** The unit must be disconnected from power source prior to cleaning. Allow unit to cool if still warm. Do not use power-cleaning equipment.

**DO NOT** hose down or pressure wash any part of the Ventura Flex

**NEVER** use a scrubber pad or abrasive material to clean the Ventura Flex

**NEVER** use bleach or bleach-based cleaner

*Dilute detergent per supplier's instructions*

The entire Ventura Flex, including removable parts, must be thoroughly cleaned and sanitized using the procedures identified by your local health department.

### RECOMMENDED CLEANING

**Black Rollers:** Run the machine for about 5 minutes alone with no dough so small pieces of left over dough will drop off from the rollers. Then, hand wash using a damp cloth, mild soap and water to rinse, dry, and sanitize.



Step 1: Using a damp cloth, wipe the front roller as shown.



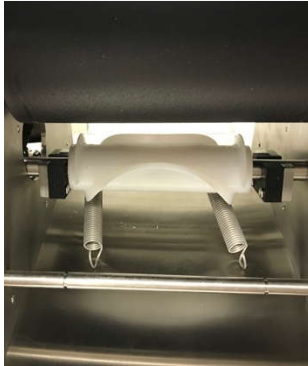
Step 2: Proceed to clean the back roller.



Step 3: Clean around and underneath the rollers.

**Tortilla Cutter:** Remove and hand wash using mild soap and water, then rinse, dry, and sanitize.

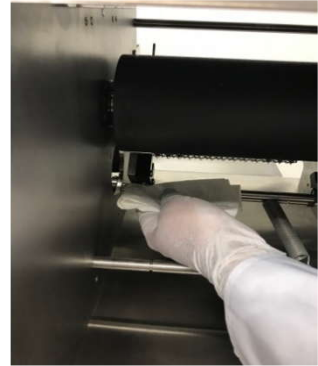
**Tortilla Cutter Support:** Hand wash using a damp cloth, mild soap and water. Then rinse, dry, and sanitize.



Remove/Release the springs connecting to the silver bar.



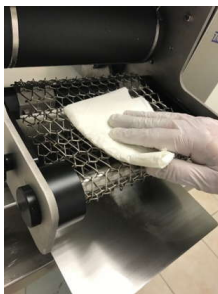
Remove the Tortilla Cutter.



Proceed with cleaning with a damp cloth.

**Exterior:** Hand wash with a damp cloth using mild soap and water. Then rinse, dry, and sanitize.

**Tortilla Hopper:** Remove to hand wash using mild soap and water, rinse, dry, and sanitize or place in dishwasher.



**Conveyor Mesh:** Wash by hand and dry thoroughly. You can use a bristle brush, steel wool, or place in dishwasher. With a damp cloth, wipe clean the conveyor belt while it is on the machine. For deeper cleaning, a bristle brush may be used.

**Metal Straps:** Remove and hand wash using mild soap and water. Then rinse, dry, and sanitize.

<b>TROUBLESHOOTING</b>	
<i>Dough sticks on the back roller</i>	
<b>Cause</b>	<b>Remedy</b>
The dough is too wet	Make new dough with less amount of water
<i>Dough will not stick on front roller</i>	
<b>Cause</b>	<b>Remedy</b>
The metal straps do not rotate with the roller	The metal straps must be firmly tightened to the roller
The dough is too dry	Add more water to the dough
The dough may not be special for corn tortillas	Make dough using nixtamalized corn flour or nixtamalized corn dough
Incorrect installation of the release wire.	The release wire must be in between the black rollers and the metal straps.
The metal straps are not installed correctly.	The metal straps must be firmly tightened to the roller The tail end of the metal straps must be completely bended.
<i>The tortilla cutter does not cut tortillas</i>	
<b>Cause</b>	<b>Remedy</b>
The tortilla cutter is not installed correctly	Adjust the bolts in the tortilla cutter brackets
The tortilla cutter is not in working condition	With #200 grit sand paper, sand the 3D edge of the round shape of the tortilla cutter. Change the tortilla cutter
<i>The release wire breaks constantly</i>	
<b>Cause</b>	<b>Remedy</b>
The release wire is too tight	Loosen the wire slightly
It is not the recommended wire	Use the correct wire
The metal straps are not clean	<ul style="list-style-type: none"> <li>i. Clean the metal straps every day by running the machine for about 5 minutes.</li> <li>ii. Clean with a damp cloth</li> </ul>
<i>The tortillas drop below the back roller into the base plate</i>	
<b>Cause</b>	<b>Remedy</b>
The rollers are separated too much	Adjust rollers to make tortillas from 1/16 to 1/8 of an inch
The dough is too dry	Make new dough with more water
The tortilla cutter is not in working condition	Change the tortilla cutter
<i>The tortillas have holes</i>	
<b>Cause</b>	<b>Remedy</b>
The dough is not well mixed	Mix the dough correctly
The dough ball is more than 1.5 Lbs.	Feed the Ventura Flex with dough balls no more than 1.5 lbs.
The dough is too dry	Make new dough with more water
<i>Machine is not working</i>	
<b>Cause</b>	<b>Remedy</b>
The machine does not start	Pull the Emergency Stop Red Button. Verify the 3 covers are closed. Check the fuse is in working conditions
Overload motor protector is tripped	Check the building's electrical source. Wait 5 minutes and restart the machine
<i>To buy extra metal straps, release wires and other parts, contact Tortilla Masters Equipment at 281-994-7010</i>	

*VENTURA FLEX*  
*Tabletop Corn Tortilla Machine*

This machine’s specialty is to produce perfect corn tortillas ready to cook.



### Standards Features

- Production: 840 raw tortillas per hour
- NSF & ETL certified
- Stainless steel construction
- Food grade plastic rollers
- Interlocked covers & doors
- Motor sealed for life
- Gear transmission
- Thermal overload protection

### Technical Data

Current (amps)	2
Voltage (volts)	115
Height	18"
Width	24"
Depth	23"
Weight	128 #
Cord Length	6'

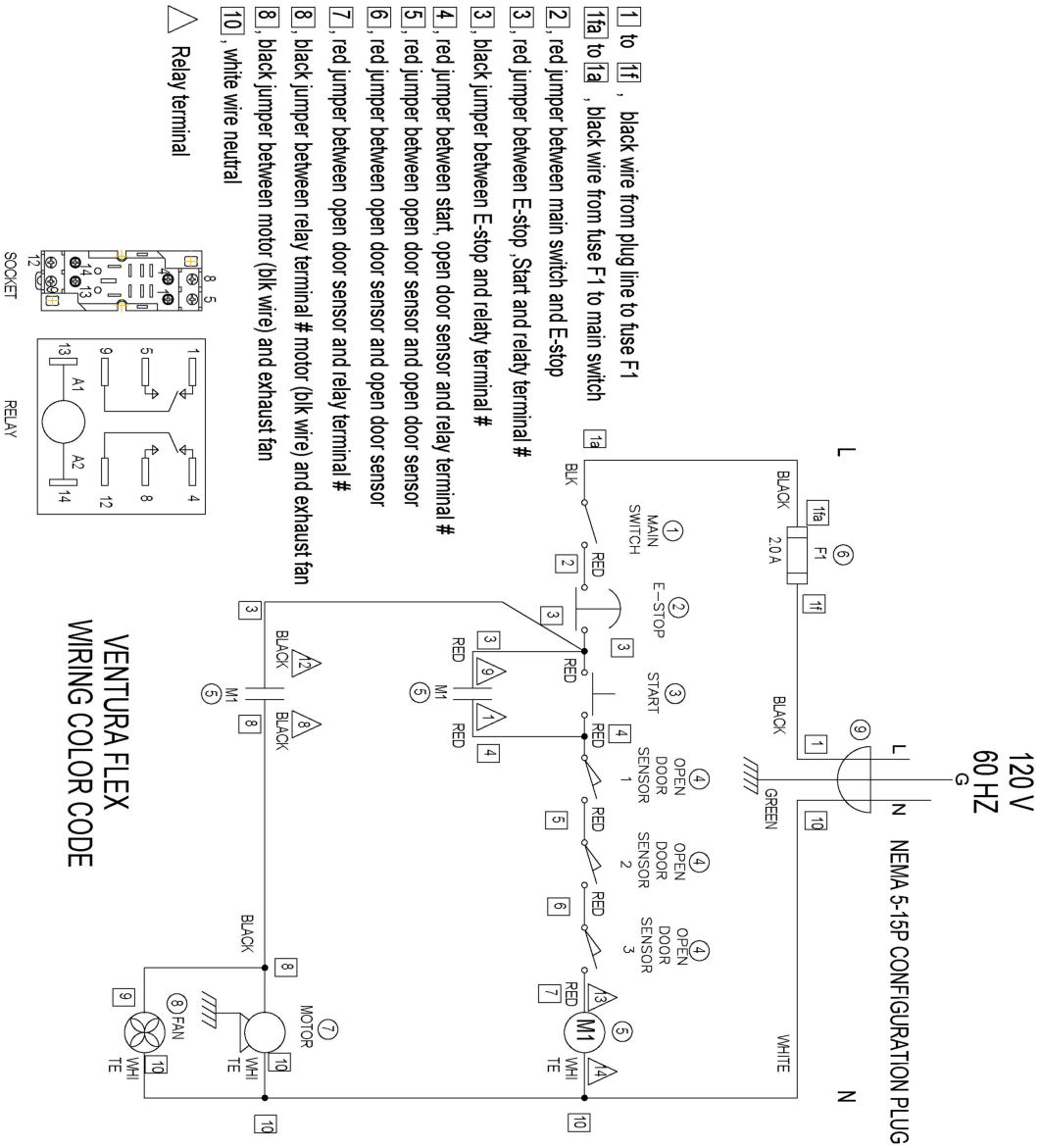
### Description

This Ventura Flex gear driven Tabletop Corn Tortilla machine specialty is to produce perfect corn tortillas ready to cook at your small restaurant kitchen.

A stainless-steel construction, Food grade plastic rollers and a 6 ¼ tortilla cutter are included.

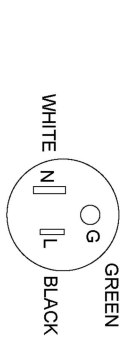
The Ventura Flex has a 115 V single phase electrical rating.

# ELECTRICAL DIAGRAM



- 1 to 1f, black wire from plug line to fuse F1
- 1fa to 1fb, black wire from fuse F1 to main switch
- 2, red jumper between main switch and E-stop
- 3, red jumper between E-stop, Start and relay terminal #
- 3, black jumper between E-stop and relay terminal #
- 4, red jumper between start, open door sensor and relay terminal #
- 5, red jumper between open door sensor and open door sensor
- 6, red jumper between open door sensor and open door sensor
- 7, red jumper between open door sensor and relay terminal #
- 8, black jumper between relay terminal # and exhaust fan
- 8, black jumper between motor (blk wire) and exhaust fan
- 10, white wire neutral

△ Relay terminal



- 1.- MAIN SWITCH RVW41D1123
  - 2.- E-STOP 2AMPp4
  - 3.- START PUSH BUTTON 2AF3
  - 4.- LIMIT SWITCH SS 5GL111T
  - 5.- RELAY 782 2C 120A
  - 6.- 2 AMP FUSE
  - 7.- MOTOR AND GEAR
  - 8.- UF92B AXIAL FAN
  - 9.- NEMA 5-15 PLUG
- UNIT TO BE FED FROM A GFCI PROTECTED SOURCE.
- FEEDER CABLE : S10W-3 CONDUCTORS  
INTERNAL CONTROL WIRE MTW/AVG  
GROUND TO BE BONDED TO CASE.
- NOTE:  
BLACK WIRE - POWER SYSTEM WIRE  
RED WIRE- CONTROL SYSTEM WIRE

# WARRANTY

Tortilla Masters Equipment (“TME”) warrants to the original purchaser of new equipment that said equipment, when installed in accordance with our instructions within North America and subjected to normal use, is free from defects in material or workmanship for a period of 1 year on parts (excludes wear/expendable parts). The labor warranty is 1 year on labor from original installation, or 12 months from actual shipment date, whichever date occurs first.

THIS WARRANTY IS IN LIEU OF ALL OTHER WARRANTIES, WHETHER EXPRESSED OR IMPLIED. Tortilla Masters Equipment EXPRESSLY DISCLAIMS ANY IMPLIED WARRANTY OF MERCHANTABILITY OR EXPRESSED OR IMPLIED WARRANTY OF FITNESS FOR A PARTICULAR PURPOSE.

Tortilla Masters Equipment OBLIGATION AND LIABILITY UNDER THIS WARRANTY IS EXPRESSLY LIMITED TO REPAIRING AND REPLACING EQUIPMENT WHICH PROVES TO BE DEFECTIVE IN MATERIAL OR WORKMANSHIP WITHIN THE APPLICABLE WARRANTY PERIOD. All repairs pursuant to this Warranty will be performed by an Authorized Designated Tortilla Masters Equipment Service Location during normal working hours. IN NO EVENT SHALL Tortilla Masters Equipment BE LIABLE FOR INCIDENTAL OR CONSEQUENTIAL DAMAGES TO BUYER OR ANY THIRD PARTY, INCLUDING, WITHOUT LIMITATION, LOSS OF PROPERTY, PERSONAL INJURY, LOSS OF BUSINESS OR PROFITS OR OTHER ECONOMIC LOSSES, OR STATUTORY OR EXEMPLARY DAMAGES, WHETHER IN NEGLIGENCE, WARRANTY, STRICT LIABILITY, OR OTHERWISE.

This warranty is given only to the first purchaser from a retail dealer. No warranty is given to subsequent transferees.

This warranty does not cover product failures caused by: failure to maintain, neglect, abuse, damage due to excess water, fire, normal wear, improper set up and use. Periodic maintenance is not covered.

THE FOREGOING WARRANTY PROVISIONS ARE A COMPLETE AND EXCLUSIVE STATEMENT BETWEEN THE BUYER AND SELLER. Tortilla Masters Equipment NEITHER ASSUMES NOR AUTHORIZES ANY PERSONS TO ASSUME FOR IT ANY OTHER OBLIGATION OR LIABILITY IN CONNECTION WITH SAID EQUIPMENT.

Example of items not covered under warranty, but not limited to just these items:

1. Acts of God, fire, water damage, vandalism, accident, theft.
2. Freight damage.
3. Improper installation or alteration of equipment.
4. Use of generic or after-market parts.
5. Repairs made by anyone other than a Tortilla Masters Equipment designated servicer.
6. Lubrication.
7. Expendable wear parts. (This includes the tortilla cutter, metal straps, conveyor belt, wire tensioner.)
8. Cleaning of equipment.
9. Misuse or abuse.