

Champion

The Dishwashing Machine Specialists

Technical Manual

No Heat Tray
Dryer

Model
CTD-1800H

November, 1992

111483

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LIMITED WARRANTY

Champion Industries Inc. (herein referred to as Champion), P.O. Box 4149, Winston-Salem, North Carolina 27115. warrants machines, and pans, as set out below.

Warranty of Machines: Champion warrants all new machines of its manufacture bearing the name "Champion" and installed within the United States to be free from defects in material and workmanship for a period of one (1) year after the date of installation or fifteen (15) months after the date of shipment by Champion, whichever occurs first. (See below for special provisions relating to glasswashers.) The warranty registration card must be returned to Champion within ten (10) days after installation. If warranty card is not returned to Champion within such period, the warranty will expire after one year from the date of shipment.

Champion will not assume any responsibility for extra costs for installation in any area where there are jurisdictional problems with local trades or unions.

If a defect in workmanship or material is found to exist within the warranty period, Champion, at its election, will either repair or replace the defective machine or accept return of the machine for full credit; provided, however, as to glasswashers, Champion's obligation with respect to labor associated with any repairs shall end (a) 120 days after shipment, or (b) 90 days after installation, whichever occurs first. In the event that Champion elects to repair, the labor and work to be performed in connection with the warranty shall be done during regular working hours by a Champion authorized service technician. Defective pans become the property of Champion. Use of replacement parts not authorized by Champion will relieve Champion of all further liability in connection with its warranty. In no event will Champion's warranty obligation exceed Champion's charge for the machine. The following are not covered by Champion's warranty:

- a. Lighting of gas pilots or burners.
- b. Cleaning of gas lines.
- c. Replacement of fuses or resetting of overload breakers.
- d. Adjustment of thermostats.
- e. Adjustment of clutches.
- f. Opening or closing of utility supply valves or switching of electrical supply current.
- g. Cleaning of valves, strainers, screens, nozzles, or spray pipes.
- h. Performance of regular maintenance and cleaning as outlined in operator's guide.
- i. Damages resulting from water conditions, accidents, alterations, improper use, abuse, tampering, improper installation, or failure to follow maintenance and operation procedures.
- j. Wear on Pulper cutter blocks, pulse vanes, and auger brush.

Examples of the defects not covered by warranty include, but are not limited to: (1) Damage to the exterior or interior finish as a result of the above, (2) Use with utility service other than that designated on the rating plate. (3) Improper connection to utility service. (4) Inadequate or excessive water pressure. (5) Corrosion from chemicals dispensed in excess of recommended concentrations. (6) Failure of electrical components due to connection of chemical dispensing equipment installed by others. (7) Leaks or damage resulting from such leaks caused by the installer, including those at machine table connections or by connection of chemical dispensing equipment installed by others. (8) Failure to comply with local building codes. (9) Damage caused by labor dispute.

Warranty of Parts: Champion warrants all new machine pans produced or authorized by Champion to be free from defects in material and workmanship for a period of 90 days from date of invoice. If any defect in material and workmanship is found to exist within the warranty period Champion will replace the defective pan without charge.

DISCLAIMER OF WARRANTIES AND LIMITATIONS OF LIABILITY. CHAMPION'S WARRANTY IS ONLY TO THE EXTENT REFLECTED ABOVE. CHAMPION MAKES NO OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED, TO ANY WARRANTY OF MERCHANTABILITY, OR FITNESS OF PURPOSE. CHAMPION SHALL NOT BE LIABLE FOR INCIDENTAL OR CONSEQUENTIAL DAMAGES. THE REMEDIES SET OUT ABOVE ARE THE EXCLUSIVE REMEDIES FOR ANY DEFECTS FOUND TO EXIST IN CHAMPION DISHWASHING MACHINES AND CHAMPION PARTS. AND ALL OTHER REMEDIES ARE EXCLUDED, INCLUDING ANY LIABILITY FOR INCIDENTALS OR CONSEQUENTIAL DAMAGES.

Champion does not authorize any other person, including persons who deal in Champion dishwashing machines to change this warranty or create any other obligation in connection with Champion Dishwashing Machines.

INTRODUCTION

Welcome to **Champion**.

Thank you for choosing **Champion** and for allowing us to take care of your tray drying needs.

This manual covers the model **CTD-1800H**.

Your machine has been completely assembled, inspected, and thoroughly tested at our factory to eliminate problems at installation before it was shipped to your installation site. This manual provides:

- Warranty information and registration card
- Installation and operation procedures
- Maintenance instructions
- Troubleshooting guide
- Replacement pans lists.

Complete and return your warrant) registration card as soon as possible.

Champion constantly improves its products; therefore, specifications contained in this manual may have changed.

For your protection, factory authorized parts should always be used.

Replacement pans may be ordered directly from **Champion Industries**, or from your **Champion** authorized pans distributor or service agency*. When ordering parts, supply the model number, serial number, voltage and phase of your machine, the pan number, pan description, and quantity.

***Champion** can only ship pans 10 customers with accounts or by **C.O.D.**

GENERAL

This manual covers the **Champion** "no heat" horizontal tray dryer with tray accumulator. This machine is fully automatic and is equipped with (two) 3-horsepower blower assemblies. The model CTD-1800H can be used for either direction operation.

Standard equipment includes:

- | | |
|---|---|
| -Common utility connections | -Receptacle for plug |
| -120 volt control circuit | -Tray accumulator |
| -Convenient top-mounted controls | -Stainless steel heavy-gauge construction |
| -Enclosure panels (4 sides) | -Easy access for cleaning |
| -Energy sentinel (full tray accumulator shut-off) | -Power cords with a 240V, 30A plug |
| -Portable (casters) | -Easily removable filter |

This model tray dryer, CTD-1800H, has a maximum drying speed of 1800 trays per hour (based on a 14 inch by 18-inch tray).

Options

- Machine Electrical Options:
 - 208V-60Hz-3PH
 - 240V-60Hz-3PH
- Tray Accumulator Options:
 - Load and tray shelves for tray sizes: 14 inch by 18 inch, and 15 inch by 20 inch.

INSTALLATION

Unpacking



WARNING:

Care should be taken when lifting the machine. The Tray Dryer and Accumulator should be totally supported from underneath when it is being handled or moved.

1. Immediately after unpacking your machine, inspect it for any shipping damage. If damage is found, save the packing material and contact the carrier within 10 days.
2. Remove the tray dryer from the skid. Move it to the desired location.

Electrical Connections



WARNING:

Electrical and grounding connections must comply with the National Electrical Code and/or Local Electrical Codes.



WARNING:

When working on the tray dryer, disconnect the electric service and unplug the machine from the receptacle.

1. The tray dryer comes equipped with a 9-foot power cord and mating receptacle. Select a location for the receptacle convenient to the tray dryer working area.
2. A fused disconnect switch or circuit breaker (supplied by user) is required to protect the power supply circuit.
3. Have a licensed electrician install the receptacle.
4. The electrician should compare the electrical specifications on the machine electrical connection plate (located inside the control cabinet) to the electrical power supply before connecting it to the incoming service at a fused disconnect switch.
5. Insert the power cord plug into the receptacle. Turn the disconnect **ON**. Push the power switch **ON**. The internal pilot light will come on indicating the unit is ready to start. Depress the green **START** button to start the unit.
6. Motor rotation was set at the factory (red arrow shows direction of rotation). Remove the upper end panel on the unload end to verify correct motor rotation. Reversing the motor direction is done in the Control Cabinet by reversing the wires **L1** and **L2** on the disconnect switch side of the main electrical connection terminal block. (Refer to the electrical diagrams, Fig. 11 and 12).

Plumbing Connections



CAUTION:

Plumbing connections must comply with local sanitary and plumbing codes.

1. The tray dryer is supplied with a gravity drain and a 1 -1 /4 inch I.D. flexible drain hose (located near the load end of the unit). The end of the drain hose is approximately 3 inches above the floor. The drain water should be directed to a floor drain. The drain rate could reach approximately 1 quart per hour depending upon usage.

Completing Installation

1. Remove any foreign material from inside the machine.
2. Check to ensure that the drain strainer is clean.
3. Peel away any plastic protective coating from the exterior of the machine.

Tray Accumulator Set-Up

There are many types of trays used today, making it difficult to accurately predetermine the correct tray-lowering rate for each installation.

The tray accumulator is supplied with a limit switch that stops the tray dryer when the accumulator is full, avoiding an overloading situation.

The ideal height of stacked trays in the accumulator is 21 inches when the limit switch is tripped (activated).

To check your tray accumulator limit switch, begin by depressing the **START** button. Feed the trays (cupped side up) into the tray dryer until the accumulator is filled. If properly adjusted, the limit switch should stop the tray dryer. If not properly adjusted, you should depress the **STOP** button when the accumulator is full. You must adjust the tray accumulator by following the tray accumulator adjustment procedure.

Tray Accumulator Adjustment

1. Locate the access door on the end of the accumulator and remove the screw from the upper center of the door.
2. Remove the access door by lifting up and pulling out this expose a series of springs.
3. If the accumulator limit switch did not stop the tray dryer, there are too many springs engaged.
4. Remove one spring at a time until the accumulator limit switch trips with a full stack of trays.
5. In the unlikely event that the limit switch stops the tray dryer before the tray accumulator is full, additional springs must be added. Refer to Figure 3 to order additional springs.

OPERATION

The operation of your tray dryer will be more efficient when these procedures are followed:

1. Check that the filter holder assembly is in place. It is located at the unload end of the dryer.
2. Push the power switch to the **ON** position.
3. Depress the **START** button on the control panel.
4. Load trays in the center of the load shelf, cupped side up.
5. Push each tray into the tray dryer until the conveyor pulls it into the machine.



CAUTION:

DO NOT OVERLOAD. Loading trays too quickly will cause them to overlap which could result in a tray dryer jam. This machine is designed to process 1800 trays per hour.

6. The machine will automatically stop when the tray accumulator is full. You must depress the **START** button to restart the dryer.
7. The machine may be stopped at any time by depressing the **STOP** button on the control panel.
8. **CLEAN** the drain strainer by lifting up the load shelf after each meal period.

MAINTENANCE

The efficiency and life of your machine **is** increased by regularly scheduled preventive maintenance. A well-maintained machine gives better results and service. An investment of a **few** minutes of daily maintenance will be worthwhile.

The best maintenance you can provide is to keep your machine clean. Components that are not regularly cleaned will clog and become inoperative.

Intervals shown in the following schedules represent an average length of time between necessary maintenance. Maintenance intervals should be shortened whenever your machine is faced with abnormal working conditions, hard water, or multiple shift operations.

Maintenance Schedule

• **Daily (Every 8 Hours)**

1. Turn the power switch to **OFF**.
2. Lift the access door and load shelf and clean the drain strainer (Item #1, Figure 9).
3. Check and clear the air discharge ducts of any obstructions.
4. Wipe down the interior of the machine from the loading end.
5. Check the bells for any damage and make sure they are engaged in the pulleys.
6. Close the access door and load shelf.
7. Open the unload access door.
8. Check the bottom of the blower support (Item #12, Figure 8) for any obstructions covering the upper blower air intake holes.
9. Wipe down the interior of the machine from the unloading end.
10. Close the access door.
11. Check and clean the louvers on the air intake panel (Item #22, Figure 9) of any obstructions.
12. Check the filter (Item #20, Figure 9) for any obstructions.
 - a. With the operator facing the load end of the tray dryer, the filter holder is located on the right side of the unload end.
 - b. To remove the filter holder, insert finger into opening, lift up and pull out.
 - c. To remove filter from holder, slide up and pull out from the bottom.
13. Report any unusual conditions to your supervisor.

· Weekly

1. Wash the air intake filter.



NOTE:

The filter should be washed with hot water **AT LEAST** once per week. More frequent cleaning will improve the performance of your tray dryer. The filter can be cleaned by sending it through the dishwasher.

2. Clean the exterior of the machine of all foreign residue.
3. Check the alignment of the belt on the pulleys.
4. Check all bearings for free rotation. Grease the bearings using the fittings provided.

Deliming

Depending on the mineral content of your water, your tray dryer may need deliming.

Inspect your machine interior for lime deposits. If deliming is required, a deliming agent should be used for best results.



DANGER:

Deliming solution, rinse agents, or other acids must not come in contact with household bleach (sodium hypochlorite) or any chemicals containing chlorine, iodine, bromine, or flourine. Mixing may cause hazardous gases to form. Consult your chemical supplier.

TROUBLESHOOTING

Before determining any specific cause of a breakdown or abnormal operation of your tray dryer, check that:

1. Power switch is **ON**
2. Tray accumulator is not full.

If a problem still exists, use the following table for troubleshooting.

CONDITION	CAUSE	SOLUTION
Machine will not start	Tray accumulator full	Remove trays
	Start switch faulty	Contact your service agency
	Main switch off	Check disconnect
	Overload protector tripped	Reset overload in Control Box
Any motor not running	Overload protector tripped	Reset overload in Control Box
	Defective motor	Contact your service agency
Trays jamming	Bell not on pulley	Check, locate belt on pulley
	Pulley not aligned	Align and lighten pulley set screw
	Bell broken	Check or replace belt
	Feeding trays too fast	Slower insertion of trays
Trays not drying	Filter needs cleaning	
	Bottom blower not working	Reset overload switch and clean filter
	Top blower not working	Reset overload switch and clean upper blower air intake holes (Item #12. Figure 8)
Conveyor not running	Bell broken	Check or replace bell
	Drive belt loose	Adjust drive motor

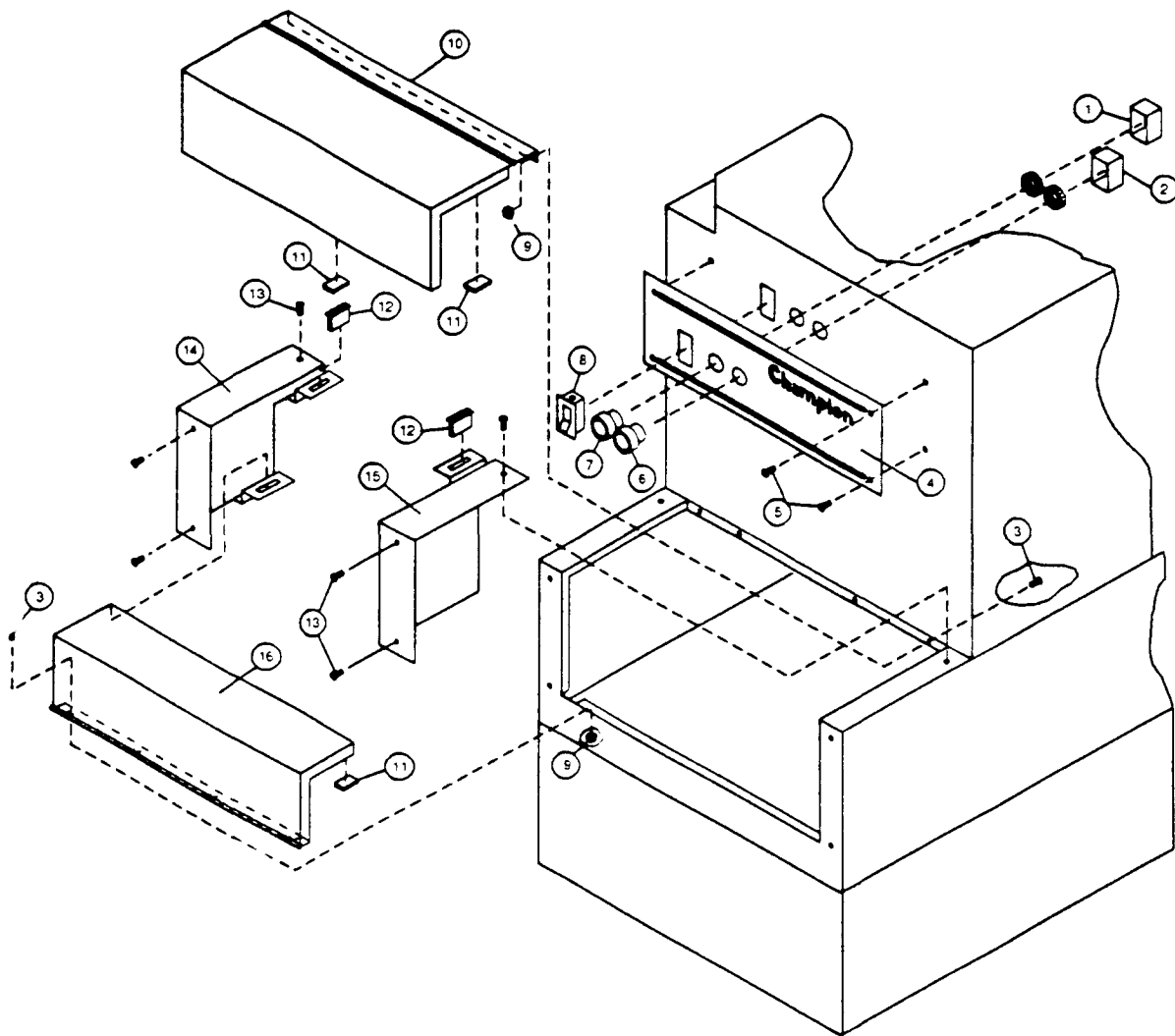


Figure 1—Load Access Cover/Start-Stop Assembly

LOAD ACCESS COVER/START-STOP ASSEMBLY

Fig. 1 Item No.	Part No.	Part Description	Qty.
1	110817	Contact Block. N.O. (Start)	1
2	110818	Contact Block. N.C. (Stop)	1
3	100007	Screw. 10-32 x 3/8" Hex Head	8
4	111317	Name Decal	1
5	108390	Rivet. Pop 3/32"	4
6	110815	Pushbutton - (Red) - Stop	1
7	110814	Pushbutton - (Green) - Start	1
8	110843	Power Switch/Circuit Breaker - 3A	1
9	100194	Nut. Grip 10-32	8
10	316700	Access Door, Upper	1
11	109989	Strike Plate	4
12	109988	Catch. Magnetic	4
13	100778	Screw, 1/4-20 x 3/8" Truss Head	6
14	316745	Panel. Side LH	1
15	316744	Panel. Side RH	1
16	316743	Access Door. Lower	1

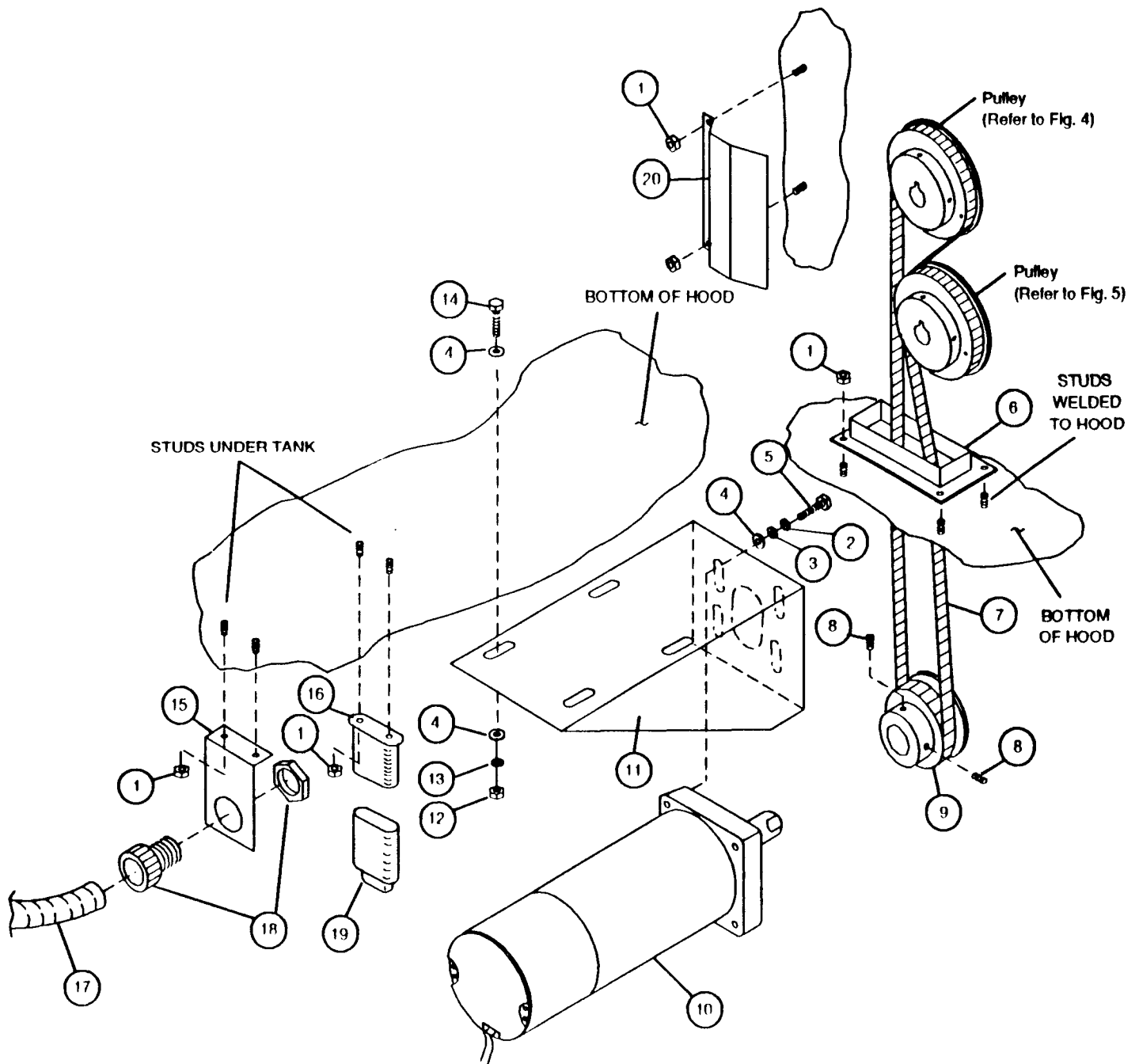


Figure 2 – Drive Assembly

DRIVE ASSEMBLY

Fig. 2 Item No.	Part No.	Part Description	Qty.
1	107966	Nut. Grip 10-32 w/nylon insert	10
2	106486	Washer. Lock. #10 Split	4
3	107033	Washer, Flat. #10	4
4	106026	Washer. Flat. 1/4"	12
5	105254	Boll, 10-32 x 1/2" Hex Head	4
6	316602	Splash Guard	1
7	111420	Belt, Drive D-367L050	1
8	100770	Screw, Set 10-32 x 3/8" Dog Point	2
9	111419	Pulley. Motor 21LB050	1
10	111207	Motor. 115V-60Hz-1PH	1
11	316625	Mount. Motor	1
12	100141	Nut. Grip 1/4-20	4
13	106482	Washer. Lock 1/4" Split	4
14	100735	Boll. 1/4-20 x 5/8" Hex Head	4
15	316630	Bracket. Conduit	1
16	111209	Bracket. Capacitor	1
17	110834	Sealtite 1/2"	A/R
18	110836	Connector. Sealtite 1/2" Straight	1
19	111208	Capacitor. Motor	1
20	316629	Deflector. Tray	1

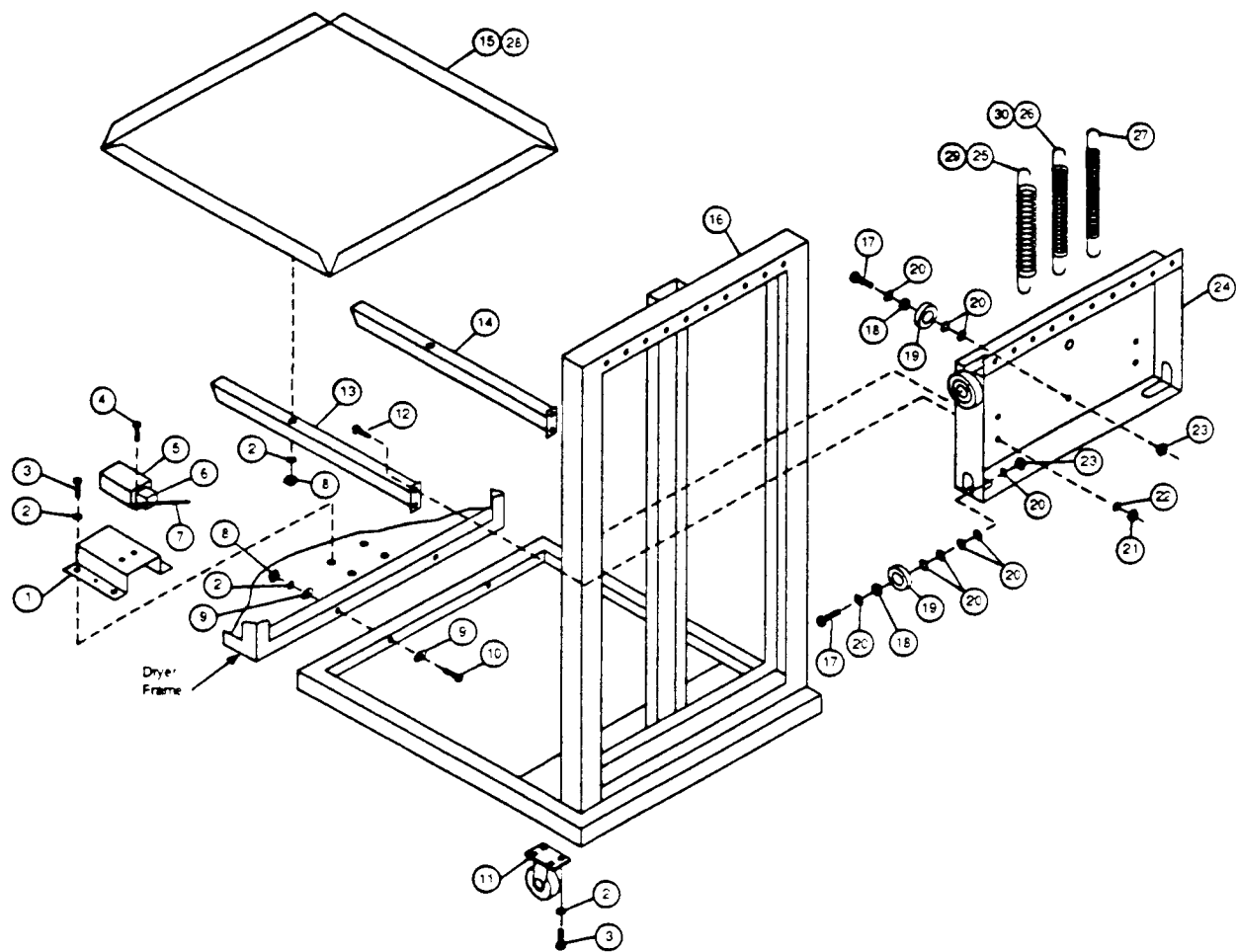


Figure 3—Tray Accumulator Assembly

TRAY ACCUMULATOR ASSEMBLY

Fig. 3 Item No.	Part No.	Part Description	Qty.
1	315919	Bracket. Limit Switch	1
2	106482	Washer. Lock 1/4" Split	14
3	100734	Bolt. 1/4-20 x 1/2" Hex Head	12
4	100097	Screw. 10-32 x 1/2" Truss Head	2
5	107341	Switch, Limit #ZCKL1	1
6	111075	Head. Limit Switch	1
7	111074	Wand, Limit Switch	1
8	107967	Nut, Grip 1/4-20 w/Nylon Insert	4
9	106026	Washer. Flat 1/4"	4
10	106028	Bolt. 1/4-20 x 2-1/2" Hex Head	2
11	111311	Caster, Swivel Plate	2
12	100111	Boll. 5/16-18 x 5/8" Hex Head	4
13	315593	Support, Tray RH	1
14	315594	Support. Tray LH	1
15	315589	Tray Shelf. 14" x 18"	1
16	316647	Frame. Accumulator	1
17	104585	Bolt. 1/4-20 x 1-1/4" Hex Head	6
18	204820	Bushing. Bearing	6
19	111246	Bearing. Roller	6
20	104925	Washer. Flat 1/4" x 1"	23
21	100142	Nut. Grip 5/16-18	4
22	106013	Washer, Lock 5/16" Split	4
23	100141	Nut. Grip 1/4-20	6
24	315591	Slide Assembly	1
25	111242	Spring. Large (w/14" x 18" Tray)	6
26	111243	Spring. Medium (w/14" x 18" Tray)	2
27	111244	Spring, Small (w/14" x 18" Tray)	2
28	316757	Tray Shelf. 15" x 20"	1
29	111242	Spring. Large (w/15" x 20" Tray)	8
30	111243	Spring. Medium (w/15" x 20" Tray)	4

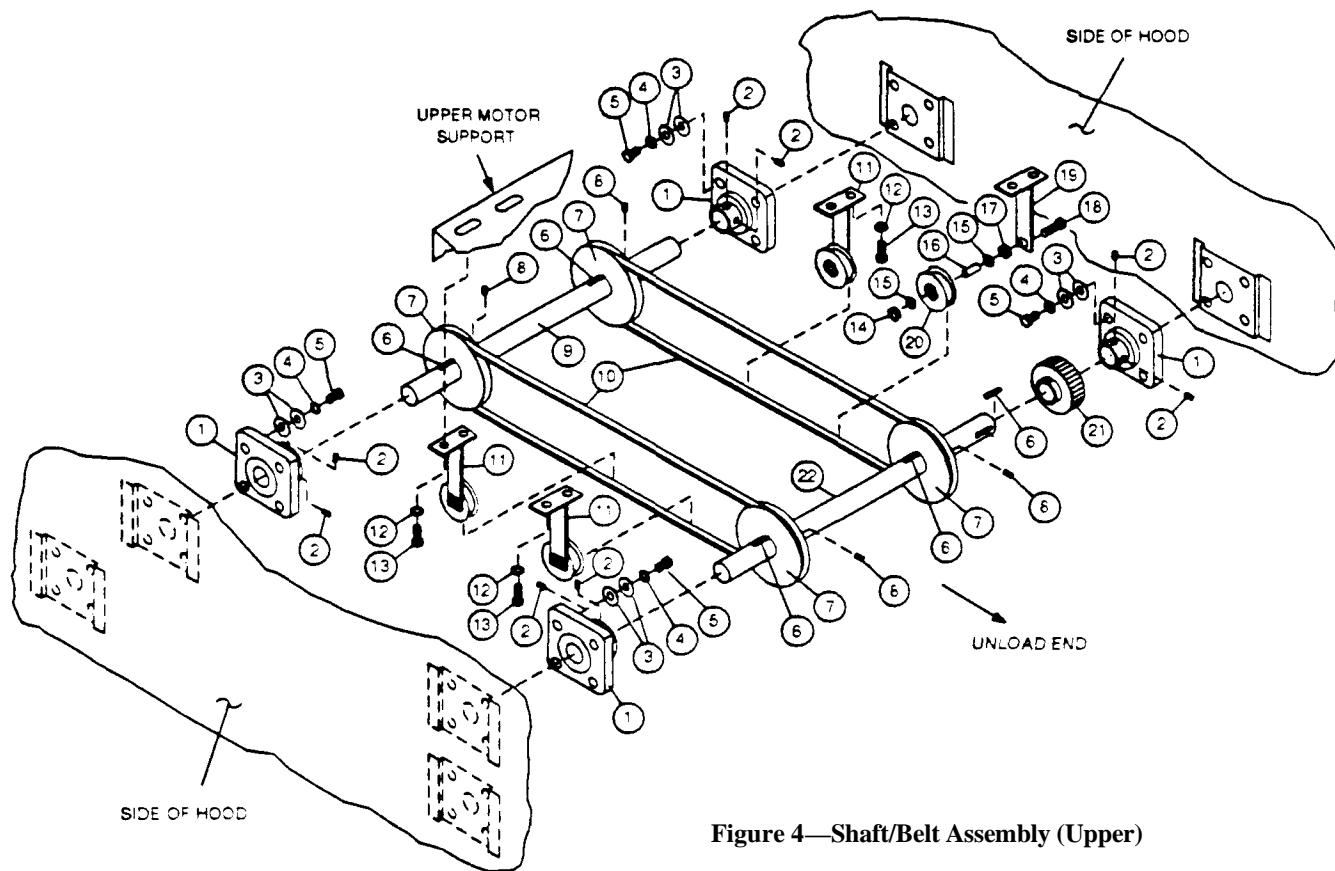


Figure 4—Shaft/Belt Assembly (Upper)

SHAFT/BELT ASSEMBLY (UPPER)

Fig. 4 Item No.	Part No.	Part Description	Qty.
1	204812	Bearing. Block, 3/4" Bore Nickel-Plated	4
2	100771	Screw, Set 1/4-20 x 1/4" Cup Point	8
3	102376	Washer. Flat. 5/16"	32
4	106013	Washer. Lock 5/16" Split	16
5	100740	Boll, 5/16-18 x1" Hex Head	16
6	104917	Key 3/16" x 3/16" x 1-1/2"	5
7	204997	Pulley, Conveyor	4
8	111322	Screw. Set 1/4-20 x 3/4" Dog Point	4
9	204998	Shaft. Conveyor Drive	1
10	205000	Belt. Upper Conveyor Drive	2
11	408015	Guide Assy. Conveyor (Includes items 14-20)	4
12	106482	Washer. Lock 1/4" Split	8
13	100734	Boll. 1/4-20x 1/2" Hex Head	8
14	107966	Nut. Grip 10-32 w/nylon insert	1
15	107033	Washer, Flat #10	2
16	204885	Sleeve, Roller	1
17	104985	Nut, Plain 10-32	1
18	107137	Bolt. 10-32 x 7/8" Hex Head	1
19	316620	Support. Conveyor Belt Guide	1
20	204890	Roller. Conveyor Belt Guide	1
21	111418	Pulley. Main Drive	1
22	204999	Shaft, Main Conveyor Drive	1

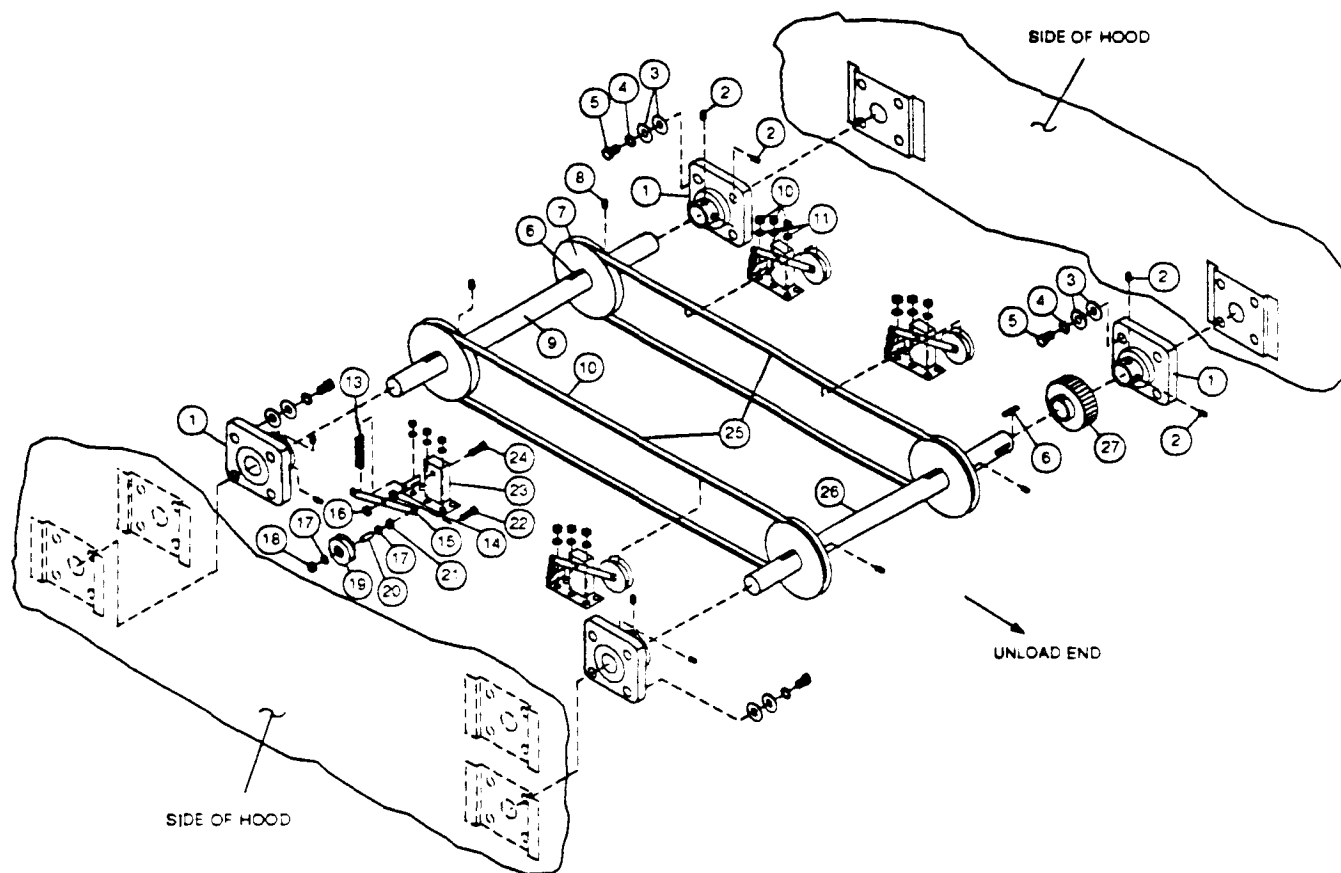


Figure 6 – Blower/Duct Assembly - Lower

SHAFT/BELT ASSEMBLY (LOWER)

Fig. 5	Part	Part Description	Qty.
Item No.	No.		
1	204812	Bearing, Block, 3/4" Bore Nickel-Plated	4
2	100771	Screw, Set 1/4-20 x 1/4" Cup Point	8
3	102376	Washer, Flat, 5/16"	32
4	106013	Washer, Lock 5/16" Split	16
5	100740	Boll. 5/16-18 x 1" Hex Head	16
6	104917	Key 3/16" x 3/16" x 1-1/2"	5
7	204997	Pulley, Conveyor	4
8	111322	Screw, Set 1/4-20 x 3/4" Dog Point	4
9	204998	Shaft, Conveyor Drive	1
10	107967	Nut, Grip 1/4-20 w/nylon insert	12
11	106482	Washer, Flat 1/4"	12
12	408014	Tensioner Assy. Conveyor Belt (includes items 13-24)	4
13	111426	Spring, Tensioner	1
14	100003	Nut, Plain 1/4-20	1
15	205011	Arm, Tensioner	1
16	107967	Nut, Grip 1/4-20 w/nylon insert	1
17	107033	Washer, Flat #10	2
18	107966	Nut, Grip 10-32 w/nylon insert	1
19	204890	Roller, Tensioner	1
20	204885	Sleeve, Roller	1
21	104985	Nut, Plain 10-32	1
22	107137	Boll. 10-32 x 7/8" Hex Head	1
23	316623	Support, Tensioner	1
24	107999	Boll. 1/4-20 x 1-3/4" Hex Head	1
25	204897	Belt, Conveyor, Lower	2
26	204999	Shaft, Main Conveyor Drive	1
27	111418	Pulley, Main Drive #32LB050	1

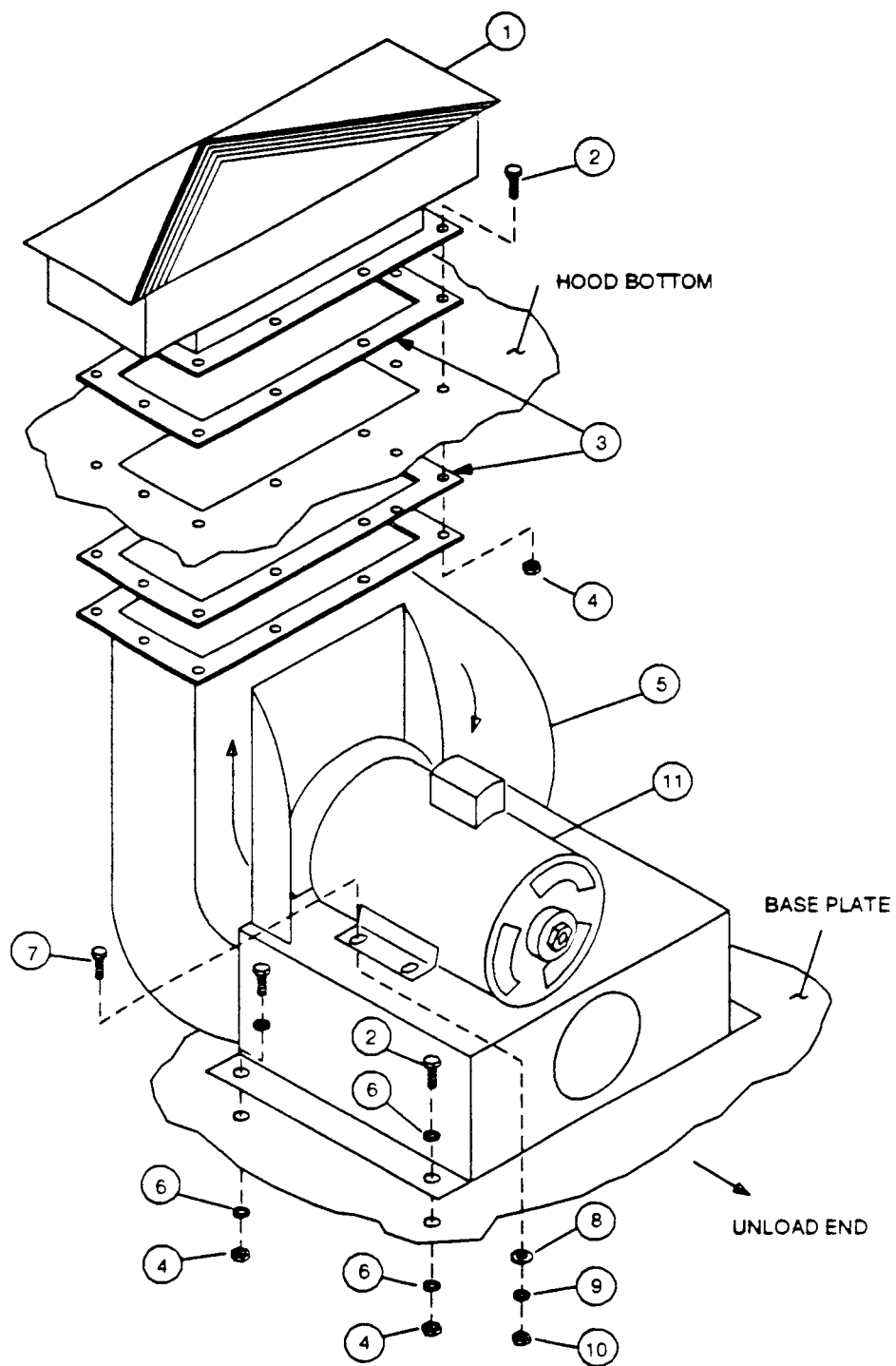


Figure 6—Blower/Duct Assembly - Lower

BLOWER/DUCT ASSEMBLY (LOWER)

Fig. 6 Item No.	Part No.	Part Description	Qty.
	316641	Duct. Blower	1
2	100735	Bolt. 1/4-20 x 5/8" Hex Head	14
3	111417	Gasket. Duct	2
4	100141	Nut, Grip 1/4-20	14
5	111416	Blower Assy. Bottom (Includes item #11)	1
6	106026	Washer. Flat 1/4"	8
7	100740	Bolt. 5/16-18 x 1" Hex Head	4
8	102376	Washer. Flat 5/16"	4
9	106013	Washer. Lock 5/16" Split	4
10	100154	Nut. Plain 5/16-18	4
11	111455	Motor. 3HP 208V-240V-60Hz-3PH	1

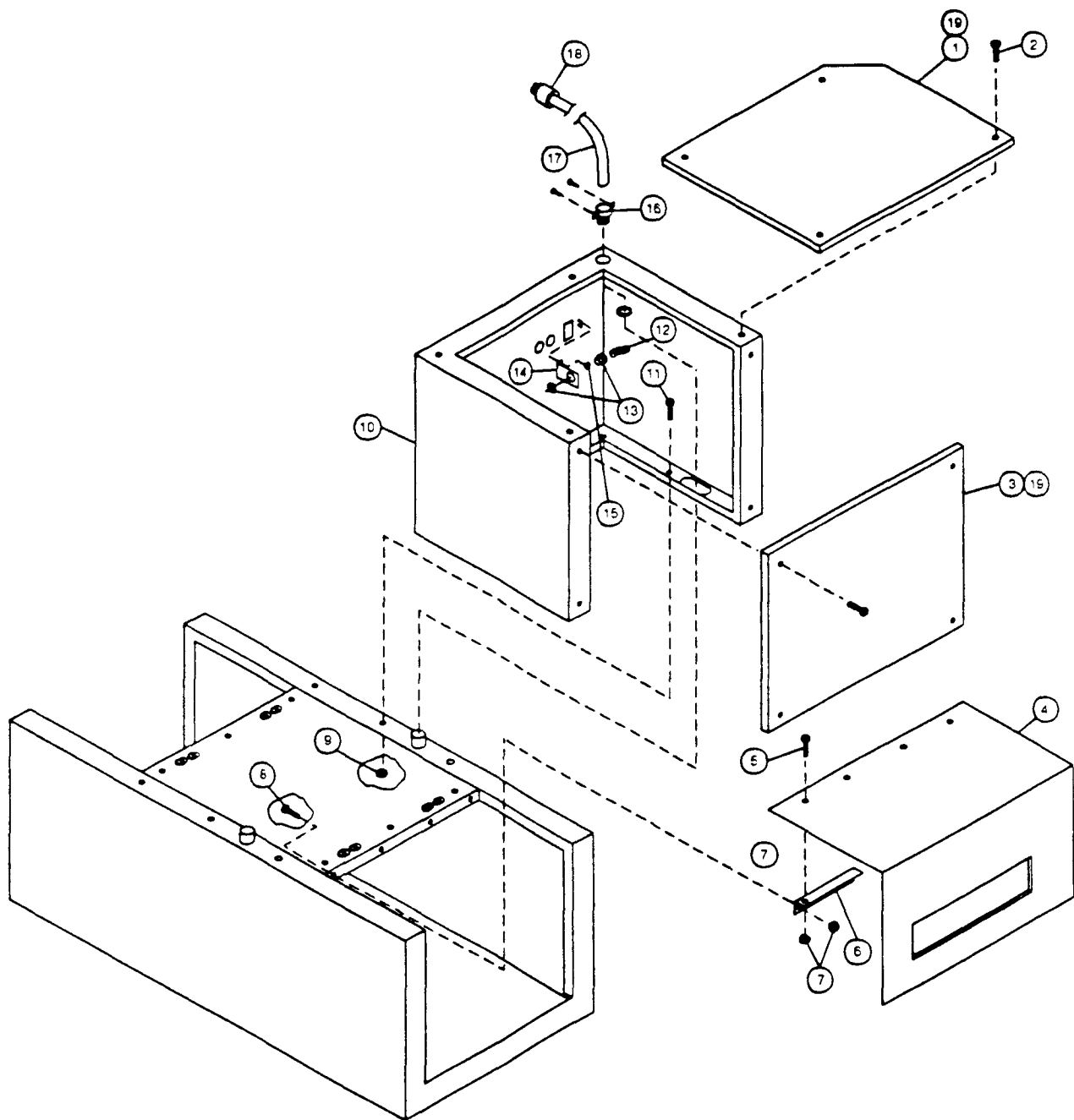


Figure 7—Upper Panel/Unload Access Door Assembly

UPPER PANELS/UNLOAD ACCESS DOOR ASSEMBLY

Fig. 7	Part	Part Description	Qty.
Item No.	No.		
1	316606	Panel, Top	1
2	100211	Screw. 10-32 x 1" Truss Head	8
3	316607	Panel. End	1
4	316699	Access Door. Unload	1
5	100213	Screw. 10-32 x 1/4" Truss Head	4
6	205035	Hinge, Access Door	1
7	100194	Nut. Grip 10-32	4
8	107136	Bolt, 10-32 x 3/8" Hex Head	8
9	100141	Nut. Grip 1/4-20	9
10	316605	Skin Assy	1
11	100734	Bolt. 1/4-20 x 1/2" Hex Head	9
12	110834	Sealtite 1/2"	A/R
13	110836	Connector. Sealtite 1/2" Straight	A/R
14	316630	Bracket. Conduit	1
15	107966	Nut. Grip 10-32 w/Nylon Insert	2
16	111304	Connector. 3/4 Romex	1
17	111223	Power Cord #10-4	15 ft.
18	111210	Plug. Male Twist-lock 30A	1
19	111451	Insulation, 1/2" Adhesive Backed	A/R
-	111211	Receptacle, Female Twist-lock 30A (Not Shown)	1

BLOWER & DUCT ASSEMBLY (UPPER)

Fig. 8	Part	Part Description	Qty.
Item No.	No.		
1	316641	Duct, Blower	1
2	100141	Nut, Grip 1/4-20	18
3	111417	Gasket, Duct	2
4	106026	Washer, Flat 1/4"	8
5	100735	Boll. 1/4-20 x 5/8" Hex Head	14
6	111415	Blower Assy. Upper (Includes item #7)	1
7	111455	Motor, 3HP 208V-240V-60Hz-3PH	1
8	100740	Boll, 5/16-18 x 1" Hex Head	4
9	102376	Washer, Flat 5/16"	4
10	106013	Washer, Lock 5/16" Split	4
11	100154	Nut, Plain 5/16-18	4
12	316598	Blower Support, Top	1
13	100734	Bolt. 1/4-20 x 1/2" Hex Head	4
14	100883	Nipple, Chase 1/2 EMT	1
15	100834	Sealtite 1/2"	A/R
16	110837	Connector, Sealtite 1/2 EMT x 90 °	2
17	101302	Junction Box 4" x 4"	1
18	103290	Cover, Junction Box	1
19	N/A	Screw, 8-32 x 3/8" Round Head (Self Tapping)	2
20	107783	Nut, 1/2 EMT	3

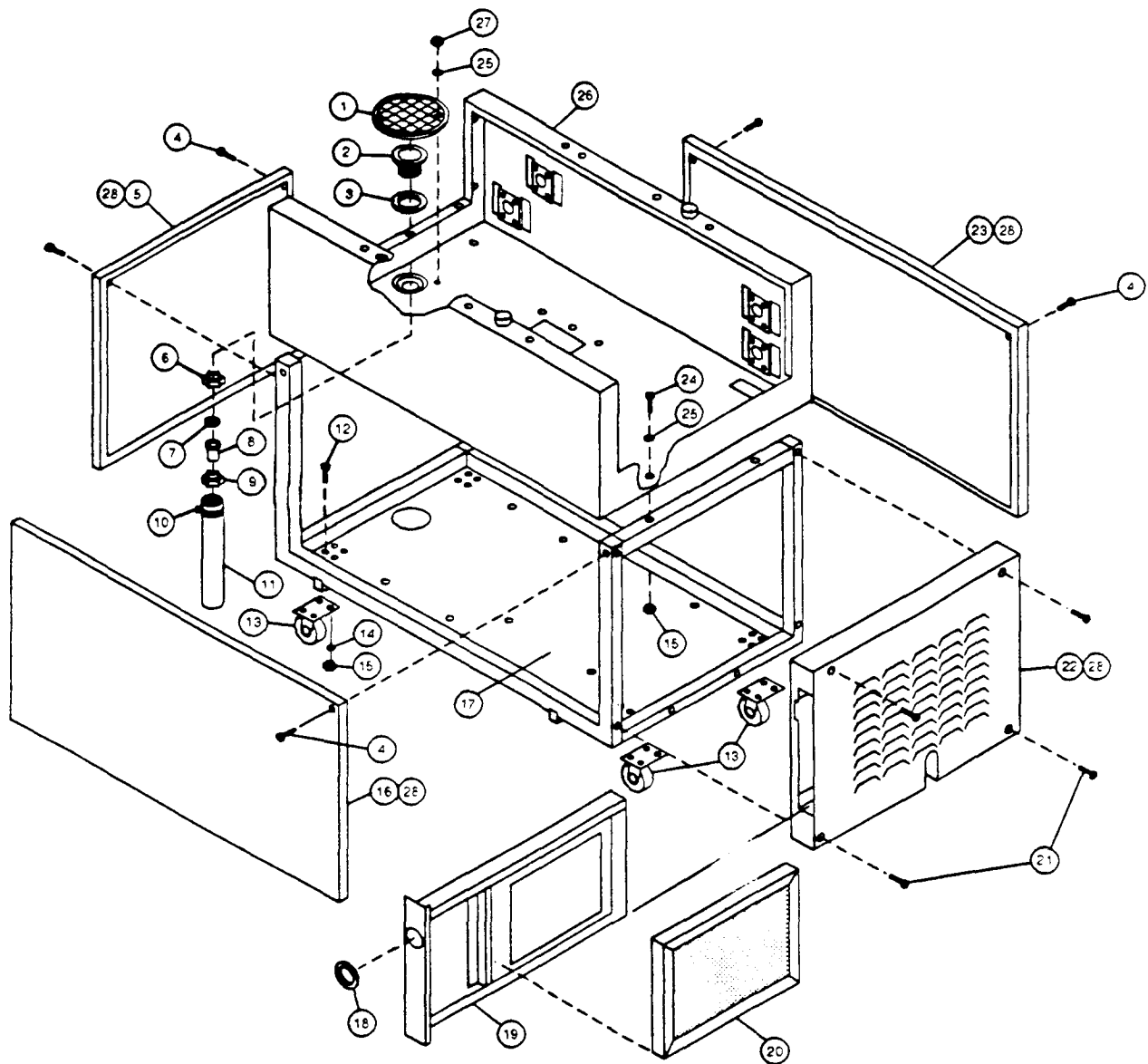


Figure 9—Hood Base/Panel Assembly

HOOD/BASE/PANEL ASSEMBLY

Fig. 9 Item No.	Part No.	Part Description	Oty.
1	304816	Strainer, Drain Body	1
2	107863	Drain Body	1
3	107864	Washer. Drain Body	1
4	105286	Screw, 1/4-20 x 1" Truss Head	6
5	316626	Panel. Load End	1
6	107865	Nut, Drain Body	1
7	107866	Washer. Tail Piece	1
8	109283	Tailpiece	1
9	107867	Nut. Tail Piece	1
10	107340	Hose Clamp - M28	1
11	111032	Hose, Drain	1.5ft.
12	100734	Bolt. 1/4-20 x 1/2" Hex Head	16
13	111311	Caster. Swivel Plate	4
14	106482	Washer. Lock 1/4" Split	16
15	100141	Nut. Grip 1/4-20	20
16	316628	Panel. RH Side	1
17	316612	Base. Dryer	1
18	107050	Grommet, Filter Holder	1
19	316695	Filter Holder Assembly	1
20	111440	Filter. 10" x 15" x 1"	1
21	100782	Screw. 1/4-20 x 2" Truss Head	4
22	316697	Panel. Unload End	1
23	316627	Panel. LH Side	1
24	100002	Bolt. 1/4-20x 1-3/8" Hex Head	4
25	106026	Washer. Flat 1/4"	5
26	316596	Body. Dryer	1
27	107967	Nut. Grip 1/4-20 w/Nylon Insert	1
28	111451	Insulation, 1/2" Adhesive Backed	A/R

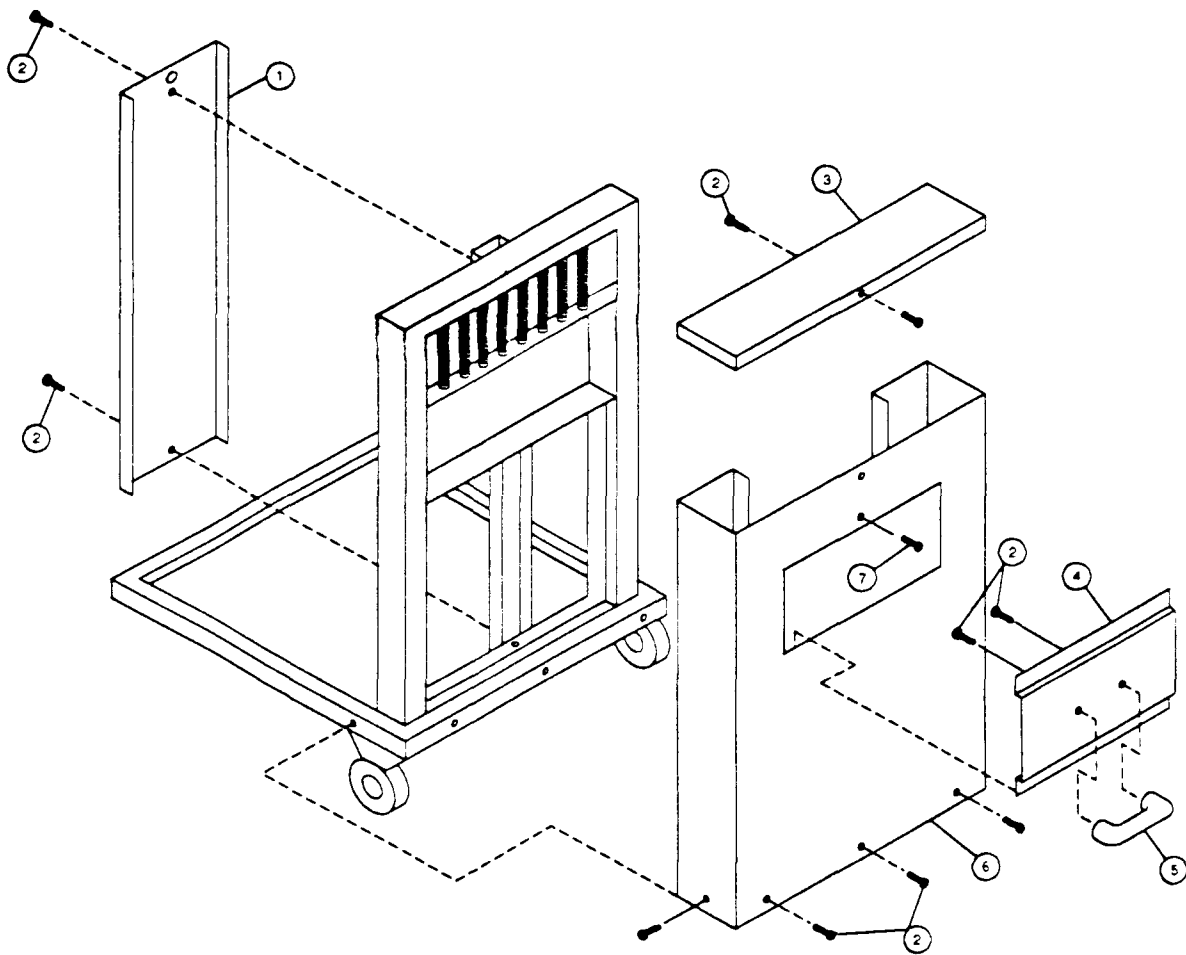


Figure 10—Panel Assembly, Tray Accumulator

PANEL ASSEMBLY, TRAY ACCUMULATOR

Fig. 10 Item No.	Part No.	Part Description	Qty.
1	316649	Panel, Center	1
2	100781	Screw, 1/4-20 x 1/2" Truss Head	11
3	316650	Panel, Top	1
4	315585	Access Door	1
5	108966	Handle, Access Door	1
6	316651	Panel, Skirt	1
7	106460	Screw, 6-32 x 1/4" Truss Head	1

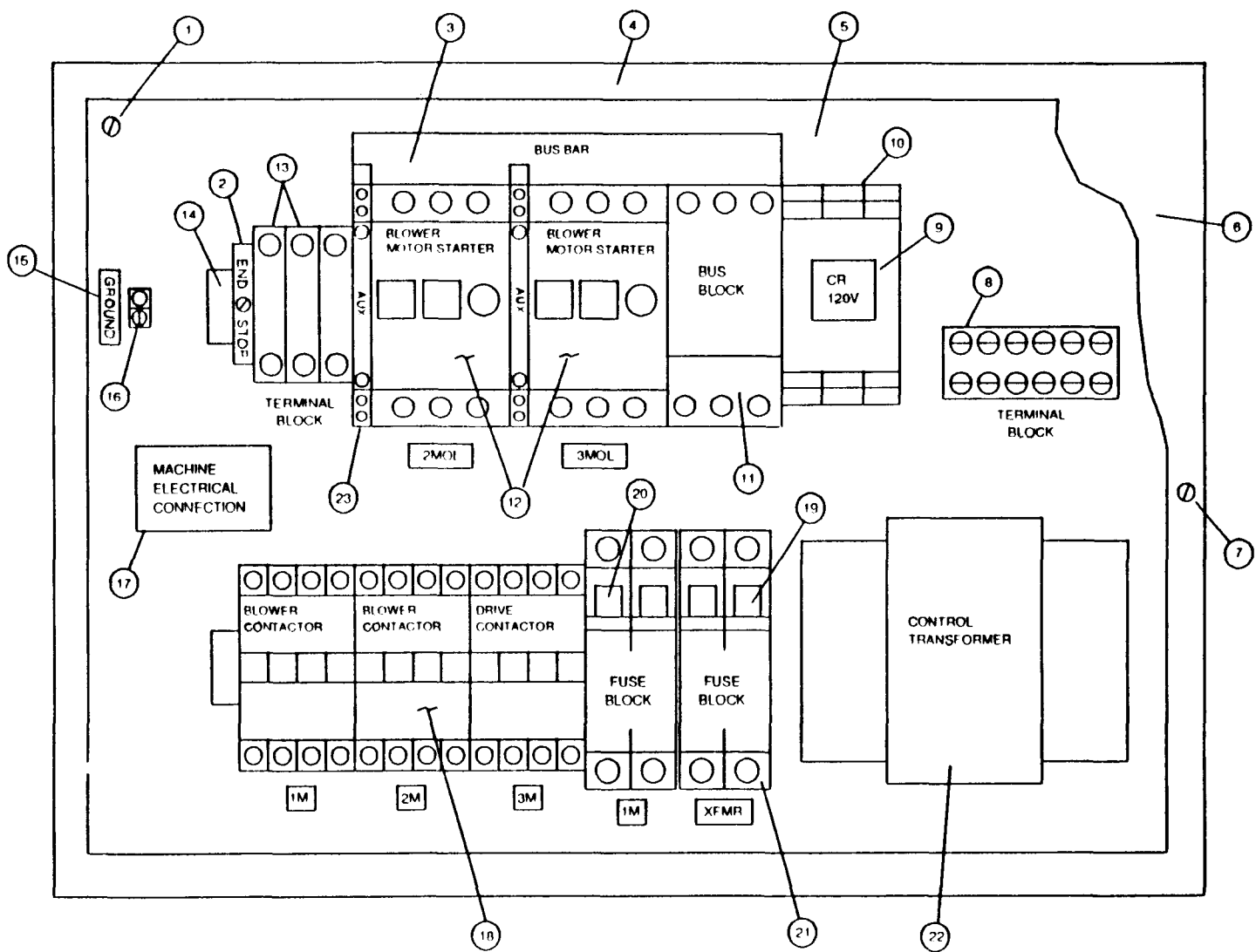


Figure 11 – Electrical Control Panel

Electrical Control Panel

Fig. 11 Item No.	Part No.	Part Description	Qty.
1	106472	Bolt. 1/4-20 x 1-1/4" Truss Head	4
2	110900	End Plate	1
3	110812	Bus Bar - 3 Pole	1
4	307467	Control Box	1
5	316685	Inner Panel	1
6	307470	Cover, Control Box	1
7	100007	Screw. 10-32 x 3/8" Truss Head	4
8	108272	Terminal Strip	1
9	111068	Relay, 120V	1
10	111036	Socket. Relay	1
11	110813	Block. Bus Bar	1
12	110808	Overload. Motor Starter-3 HP Blower(208V-240V/3PH)	2
13	110912	Terminal Block	3
14	110849	Track. Din Rail	2
15	104873	Label. Ground	1
16	103309	Lug. Ground	1
17	108615	Data Plate, Machine Electrical Connection	1
18	108122	Contactor (Motor)-60 Amp, 3 Pole w/ Auxiliary Switch	3
19	107267	Fuse. 3 Amp (250V)	2
20	107288	Fuse. 1 Amp (250V)	2
21	111153	Fuse Block	4
22	109064	Transformer. Control (250VA) (230 460V)	1
23	110811	Auxiliary Contact	2

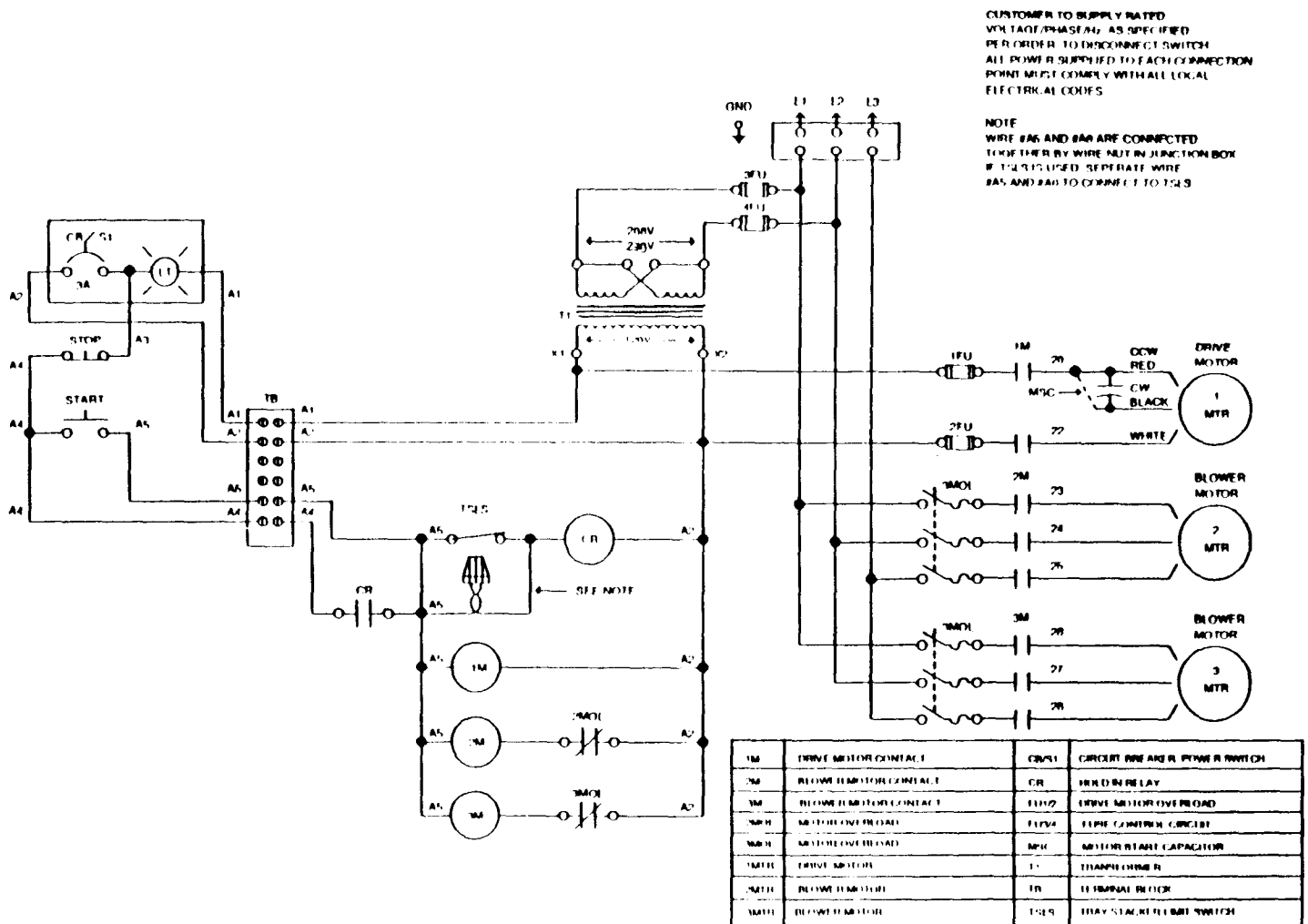


Figure 12 – Wiring Diagram