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OPERATOR'S MANUAL TECHNICAL SUPPLEMENT PARTS AND ELECTRICAL DIAGRAMS



2022

Donut Robot® Mark II / Mark II GP

ITEM NUMBERS

- | | | |
|--|---|--|
| <input type="checkbox"/> 22600 Mark II, 208-240V, 1ø | <input type="checkbox"/> 22618 Mark II, 208-220V, 3ø | <input type="checkbox"/> 22618-1 Mark II, 230-240V, 3ø |
| <input type="checkbox"/> 22601 Mark II, 208-240V, 1ø, Star | <input type="checkbox"/> 22619 Mark II, 208-220V, 3ø, Star | <input type="checkbox"/> 22619-1 Mark II, 230-240V, 3ø, Star |
| <input type="checkbox"/> 22602 Mark II, 208-240V, 1ø, Plain | <input type="checkbox"/> 22620 Mark II, 208-220V, 3ø, Plain | <input type="checkbox"/> 22620-1 Mark II, 230-240V, 3ø, Plain |
| <input type="checkbox"/> 22604 Mark II GP, 208-240V, 1ø, Mini | <input type="checkbox"/> 22621 Mark II GP, 208-220V, 3ø, Mini | <input type="checkbox"/> 22621-1 Mark II GP, 230-240V, 3ø, Mini |
| <input type="checkbox"/> 22635 Mark II, 208-240V, 1 ¹³ / ₁₆ " Plain | <input type="checkbox"/> 22637 Mark II, 208-240V, 1 ¹³ / ₁₆ " Star | |

SERIAL NUMBER

Item Number and Serial Number are listed on a data tag attached to the equipment.
This manual should only be used with the Item Number(s) shown above.



SUPPORT

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Belshaw[®]

Donut Robot[®]

Mark II, & Mark II GP

Mark V & Mark V GP



Operator's Manual

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EQUIPMENT RECORD

Please provide the information below when you correspond with Belshaw about your machine.

Purchased by _____

Installed by _____

Date of Installation _____

Model number _____

Serial number _____

IN CASE OF DAMAGE TO EQUIPMENT

In case of damage to the equipment upon delivery, follow these steps immediately.

1. Inform the freight carrier. The phone number will be on the shipping receipt or label.
2. Take photographs of the equipment, both inside and outside the box or crate.
3. Do not throw away any packaging.
4. Report the damage to the distributor (or other party) from whom you bought the equipment.
5. Email your photos to the distributor (or other party) AND to Belshaw Customer Service at service@belshaw.com. Include a Belshaw Order Number in your communications. Your 6-Digit Order Number should be marked on the box or crate.

IN CASE OF MISSING ITEMS

1. If possible, note the missing items on the delivery receipt of the freight carrier.
2. Take photographs of the entire shipment.
3. Follow steps 1 – 5 above.

MN-0111 05-20-2022

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Technical Supplement – located after Operator's Manual

- Printed separately for CE / European Union manuals

The Donut Robot® Mark II and Mark V are designed to automatically deposit and fry cake donut products, and to fry yeast-raised donut products. It is not designed to deposit or fry any other products.

The Donut Robot is designed to be used on a flat, stationary table or countertop, with the operator standing opposite the heater head of the machine. The operator must work safely at all times and read this manual and follow its instructions and warnings.

The Donut Robot® produces only 71.5 dB(A) of equivalent A-weighted sound pressure at workstations. This has been determined during a dry run of the machine, using a Bruel & Kjaer sound level meter, type 2236.

Study the instructions and warnings in this manual carefully. A thorough understanding of how to install, maintain, and safely operate the Donut Robot® will prevent production delays and injuries.

To use the Donut Robot® safely, heed the following warnings and all other warnings that appear in this manual:

- Make sure the machine is secured to the work surface. Doing so will prevent the machine from moving or falling, which could cause serious injury.
- Never let water and hot shortening come in contact with each other. Moisture causes hot shortening to spatter, which may cause serious burns.

- Do not overfill the kettle with shortening. If shortening overflows the kettle, it could cause serious burns or could cause someone to slip on the floor and be seriously injured.
- Hot shortening can cause serious burns. Make sure that the system and the shortening are cool before attempting any adjustment, repair, disassembly, or cleaning.
- To avoid electrocution or other injury, unplug the machine before attempting any adjustment, repair, disassembly, or cleaning.
- To avoid damaging the machine, never use force to assemble, disassemble, operate, clean, or maintain it.
- Be careful never to get shortening, water, or other materials on the floor. If anything does get spilled on the floor, clean the area immediately. Materials on the floor can cause people to slip or fall, resulting in serious injury or loss of life.
- To prevent unintentional startup and possible fire, unplug the machine if there is a local power outage. When the power is restored, it is safe to plug the machine in again.
- To avoid electrocution, make sure that all electrical cords are not frayed or cracked and that they do not pass through any water or shortening.
- Make sure that all electrical cords are routed so that no one will trip over them.

Major components of the Donut Robot® Mark II and Mark V

The photos below show the major visible components in a Donut Robot® Mark II. The Donut Robot® Mark V is 50% longer. All components apply to Mark II and Mark V, both standard and GP models.

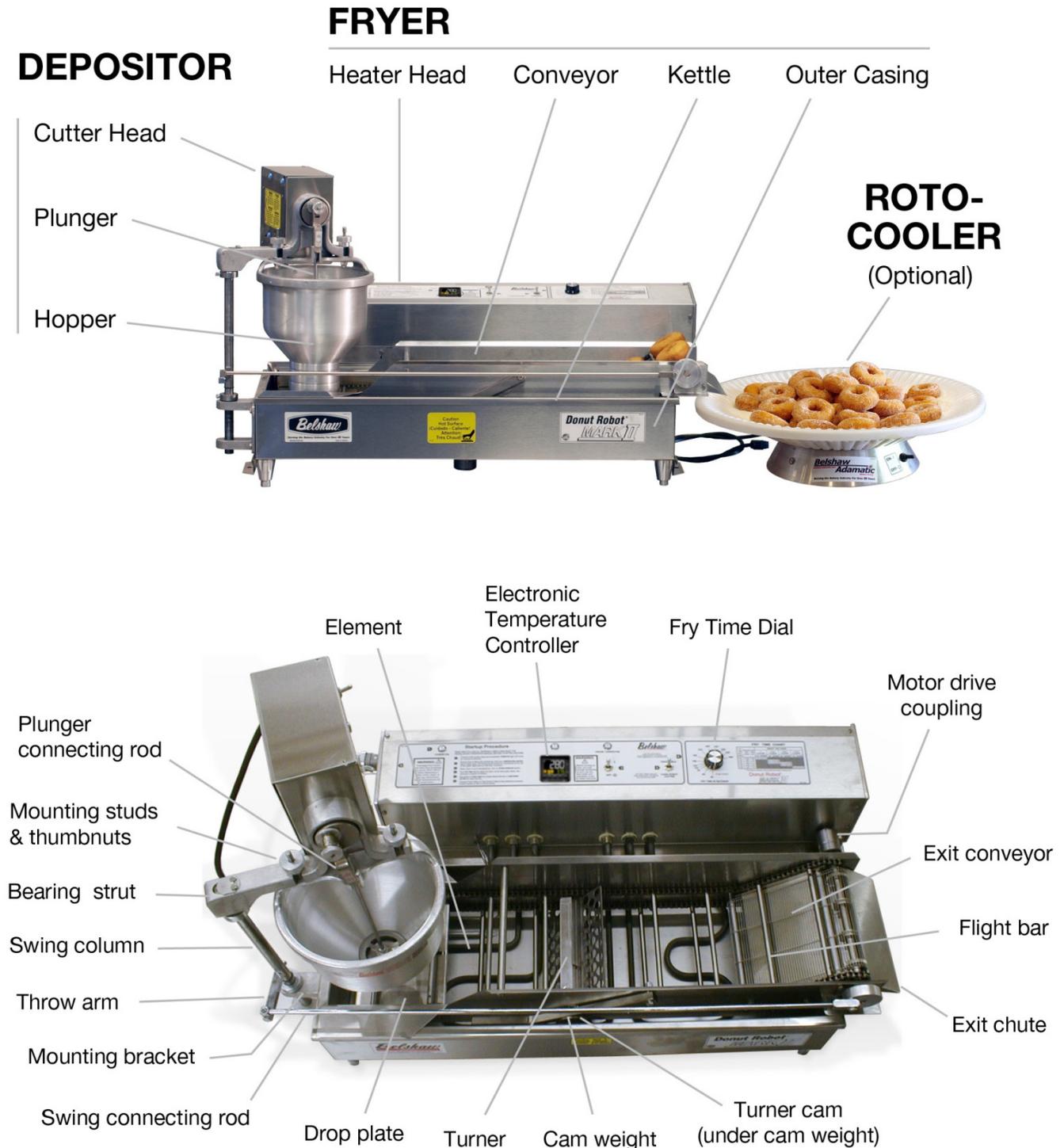


Figure 1.1. Donut Robot® Mark II. (components apply also to Donut Robot® Mark V)

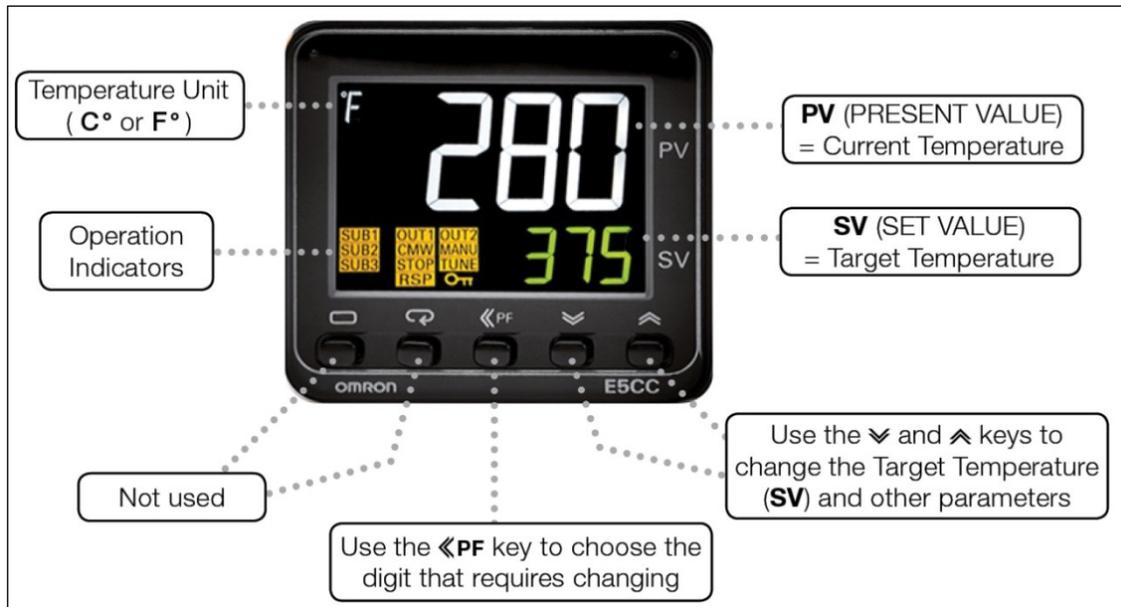


Figure 1.2, Temperature controller

IMPORTANT

To unpack and install your Donut Robot®, follow the installation instructions in the Technical Supplement to this manual.

CAUTION

Read this section completely before operating the machine!

Operating Controls

1. Ensure that the Donut Robot has been connected to correct power source.
2. Ensure the fryer is filled with shortening. If there is no shortening in the fryer, see the section below, “Inserting Shortening”.
3. Turn on the main circuit breaker on the back of the heater head (1) **POWER LIGHT** will turn on).
4. Turn on the (2) **FRYER HEAT** switch (the temperature controller will turn on).
5. Set the (2) **TEMPERATURE CONTROL** to the target frying temperature (See Figure 1.2) (**TEMPERATURE CONTROL** light will turn on when fryer is heating).
6. Set (3) **FRYER CONVEYOR** switch to **AUTO** (the conveyor will start automatically when the target temperature is reached).

NOTE

The **3** FRYER CONVEYOR switch can also be turned to ON (The conveyor will run immediately, make sure the shortening is completely melted before using ON position).

7. Turn the **4** FRY TIME dial to adjust the fry time to the desired speed. As the fry time goes down the speed of the conveyor increases.
8. Set the **5** Feed table/Cake Donut depositor switch to FEED TABLE for yeast-raised donuts or CAKE DONUT DEPOSITOR for cake donuts or mini donuts.
9. Connect the **6** Cake Donut Depositor or Feed Table to the electrical connector socket located at the left end of the control panel.

Inserting Shortening

WARNING

Hot shortening is much hotter than boiling water! It will cause severe burns if it touches your skin. Never touch hot shortening. Always exercise extreme caution with hot shortening. Use oven gloves when working near hot shortening.

1. When the shortening reaches the correct frying temperature, it should reach the top of the flight bars or chains.
2. If your fryer has a drain, close the drain valve.
3. Put shortening in the kettle using one of these methods:
 - a. Pre-melt shortening in a pan on the stove and carefully pour it into the kettle.
 - b. Use the optional EZ Melt to melt shortening and transfer it to the kettle. See your EZ Melt manual.

- c. Put solid shortening into the kettle, packing it tightly around the elements and bulbs without air spaces.

WARNING

Air spaces can cause the shortening to overheat and catch on fire. Pack the shortening tightly without air spaces.

WARNING

Shortening expands as it increases in temperature. Do not fill shortening all the way up to the flight bars or chains, if it is cold. The shortening level will rise by up to 1 inch (25 mm) when it is fully heated.

Heating Shortening

1. Turn on the **2** FRYER HEAT switch (the temperature controller will turn on).
 - a. If you are heating solid shortening using method 2c above, turn the heat switch on and off every 10 seconds, until the solid shortening has melted and no air pockets remain.

IMPORTANT

If you are heating solid shortening, turn the heat switch on and off every 10 seconds, until shortening has melted around the elements and no air pockets remain.

2. Wait for the shortening to reach the desired temperature. When it does, the Temperature Control light on the front of the heater head will turn off and the conveyor will start. DO NOT run the conveyor until all the shortening has melted.
3. If you are using the optional Shortening Reserve Tank, fill it with shortening. Then position it on the conveyor side panels either ahead of or behind the turner, but not above it. The heat of the fryer will melt the shortening in the tank.

NOTE

If the Power light is on but the Temperature Controller fails to turn on, the high temperature limit control could be tripped. Push the red reset button on the back bottom of the heater head.

Making Cake Donuts

1. If not already in place, install the swing column, install the depositor's cutter head, and install the hopper and the plunger.
2. Swing the hopper away from the fryer so it is not directly above the fryer.
 - a. It may be necessary to disengage the swing connecting rod from the swing column throw arm.
3. Adjust the size selector dial on the depositor's crankshaft assembly. This dial regulates the donut weight. The higher the setting, the larger the donuts will be. Adjust the dial setting as follows:
 - a. Unscrew the dial lock nut 1/2 turn.
 - b. Turn the dial to the desired position, as indicated by the marks on the crank plate.
 - c. Tighten the dial in place with the lock nut. Tighten it using your fingers only.
4. Put batter into the hopper. 'PRIME' the hopper to expel any air that may be trapped in the bottom of hopper. To prime the hopper:
 - a. Hold a mixing bowl or other receptacle under the depositor hopper.
 - b. Hold DOWN the switch on the depositor until it has dropped two or three donuts into the bowl.

NOTE

Holding down the prime switch causes the depositor to run continuously without the normal delay between cuts.

- c. Put the batter in the bowl back into the hopper.
5. Return the hopper into position over the fryer and reconnect the swing connecting rod to the swing column throw arm.
 6. Turn the **4** FRY TIME dial to adjust the fry time to the desired speed.
 7. For 2 donuts (or 4 mini donuts) per row, set the **5** Feed table/Cake Donut depositor switch to **CAKE DONUT DEPOSITOR**. For 1 donut (or 2 mini donuts) per row, set the switch to **FEED TABLE**.
 8. Turn on the cake donut depositor by pushing UP the switch on the depositor.
 9. Set **3** FRYER CONVEYOR switch to **AUTO**.

NOTE

If the conveyor becomes jammed, a warning buzzer will sound about a minute later and stop when the conveyor is turned off. The conveyor drive motor is impedance-protected so it will not burn out due to jamming.

WARNING

If the conveyor becomes jammed:

1. Turn off the conveyor drive and the heater.
 2. Allow the system to cool down.
HOT SHORTENING IS DANGEROUS.
 3. Determine the cause of the jamming.
 4. Clear it.
 5. Restart the system.
1. Continue adding shortening to the kettle to maintain the proper shortening level (level chain).
 2. Continue adding batter to the hopper as needed.
 - a. You can add batter to the hopper without priming it again as long as it does not become empty.

- b. If the hopper does become empty, you must prime it again.
- c. When you fill the hopper for the last time, you will want to use all of the batter in the hopper. To do so, push the dough to the bottom of the hopper using a rubber scraper or spatula.

10. Turn on the Feed Table switch to activate the Feed Table.
11. Load proof cloths with donuts onto the Feed Table as needed.

WARNING

To avoid injury, never put your hand in or under the hopper while the machine is on.

If the conveyor becomes jammed:

1. Turn off the conveyor drive and the heater.
2. Allow the system to cool down. HOT SHORTENING IS DANGEROUS.
3. Determine the cause of the jamming.
4. Clear it.
5. Restart the system.

Making Yeast-Raised Donuts

To make yeast-raised donuts, remove both the depositor, and the swing column that supports it. They will not be used for yeast raised donuts.

1. Unplug the depositor power cord of your Donut Robot.
2. Release the plunger from the depositor.
3. Unscrew and lift off the hopper.
4. Lift off the depositor and swing column.
5. Install your Feed Table and plug into the fryer.
6. Refer to Section 5 of this manual for instructions how to use the Feed Table.
7. Ensure there is sufficient shortening in the fryer. The shortening should come up to the level of the chains.
8. Turn the  **FRY TIME** dial to adjust the fry time to the desired speed.
9. Set  **FRYER CONVEYOR** switch to **AUTO**.

WARNING

Thoroughly clean and dry the floor if shortening, water, or other materials are spilled. Materials spilled on the floor can cause serious injury or loss of life.

WARNING

To avoid electric shock or damage to the machine, never allow water, steam, shortening, cleaning solution, or any other liquid to enter the heater head or the depositor.

Cleaning the Hopper and the Plunger

You must clean the hopper and the plunger daily, or after each use. Follow these general guidelines:

- Use household dishwashing detergent. Do not use strong alkali cleaners such as lye, soda ash, or trisodium phosphate, as these discolor and corrode aluminum.
- Wash, dry, and lubricate parts thoroughly to prevent rusting.
- When washing parts by hand, wash each part separately; do not put any other utensil or dish in the sink with the part being washed.

Cleaning method

1. Unplug the depositor power cord.
2. Remove the plunger and the hopper.
 - a. Pull the plunger connecting rod up and away from the plunger to release the top of the plunger.
 - b. Lift out the plunger and set aside
 - c. Loosen the two mounting studs holding the top of the hopper
 - d. Remove the hopper
3. Wash the hopper and the plunger thoroughly in hot water and mild detergent.
4. Rinse the hopper and the plunger separately in clear, hot water.
5. Dry each part completely.
6. Dip the plunger and the hopper cylinder in vegetable oil or shortening to prevent rust and sticking.
7. Wipe the depositor assembly with a soft cloth dampened with hot water and an appropriate cleaner. Wipe it with another damp cloth to remove the cleaner. Wipe it dry.

CAUTION

Never immerse the depositor's cutter head in water. This may cause an electric shock and/or damage to the machine.

Cleaning the Conveyor and the Kettle

The conveyor and fryer kettle should be well cleaned once per week for normal usage.

After cleaning, dry the conveyor, then return the conveyor to the fryer and cover with shortening. If left open to the air overnight, water trapped in the chain may cause staining.

Step 1: Drain the shortening

WARNING

To avoid being burned or electrocuted, disconnect the machine from the power source before cleaning the fryer.

1. Disconnect the machine from the power source.
2. Unplug the depositor power cord.
3. Let the shortening cool to 100°F/38°C.
4. Lift the depositor off the swing column, and set to one side.
5. Lift off the swing connecting rod that extends to the base of the column supporting the depositor.
6. Drain the shortening, using the drain valve under the fryer (if installed) or Filter-Flo Siphon.
 - a. If the fryer has a drain valve and an EZMelt filtration system, open the drain valve and empty the fryer kettle.
 - b. If you have a Filter Flo Siphon, use this to transfer the shortening into a large metal bucket. (See the instructions in Appendix A)

Step 2: Wash the kettle and conveyor

1. Use a small amount of mild liquid dish washing soap and a soft cloth or sponge. Rinse parts with clean water. Dry thoroughly with soft cloth.
2. Connect the machine to the power source. Using the temperature controller, heat the

solution to 200°F/93°C. Turn on the conveyor and keep running for 15-20 minutes.

3. Scrub the soiled parts of the kettle and conveyor while the solution is under heat. Use oven gloves for protection.
4. Turn off the heater and disconnect the machine from the power source.
5. Clean the control panel with a damp cloth only. **DO NOT** clean the control panel while power is connected. **DO NOT** allow cleaning solution or water onto the control panel.

Step 3: Drain the cleaning solution

1. Allow the cleaning solution to cool to 100°F/38°C.
2. Drain the cleaning solution from the kettle using one of these methods. (These are the same methods already used to drain shortening.)
 - a. If the fryer has a drain valve, drain the water into a large bucket. **DO NOT** drain the cleaning solution into the EZMelt.
 - b. If you have a Filter Flo Siphon, remove its filter assembly. Then use the Filter Flo to siphon the cleaning solution into one or more large buckets. (For Filter Flo instructions, see Appendix A.)
3. Pour out the solution down a drain.

WARNING

Clean and dry and floor spills immediately. Liquid on the floor can cause serious injury or loss of life.

Step 4: Rinse with water

1. Pour clean water into the kettle, up to the normal level of the shortening.
2. Connect the machine to the power source. Heat the water to 200°F/93°C.
3. Run the conveyor for 5-10 minutes.

4. Turn off the heater and disconnect the machine from the power source. Allow the water to cool to 100°F/38°C.
5. Drain the rinse water from the kettle using the same method as Step 4

Step 5: Remove the conveyor

1. Ensure that the conveyor is cool to the touch. If possible, ask another person to help you lift it. Use oven gloves.
2. Obtain two clean pieces of wood, at least 1" x 1" x 15" (2.5 cm x 2.5 cm x 38 cm).
3. Remove the conveyor from the fryer as explained below:
 - a. Lift the infeed side of the conveyor UP by 2" (5 cm), to rise above the locator pins on the infeed side.
 - b. Lift the front of the conveyor (the side closest to you) UP by 4" (10 cm)
 - c. Pull the entire conveyor toward you, and away from the control panel .
 - d. The conveyor should now be free from the rest of the fryer
4. Place the conveyor on a clean surface, using the two wood pieces to lift the bottom clear of the surface.
5. OR, rest the conveyor on top of the fryer kettle, using the two pieces of wood as shown in Figure 2 below.

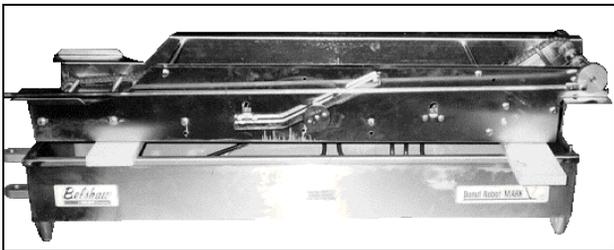


Figure 2: Rest the conveyor on the fryer.

Step 6: Dry all parts

WARNING

All parts must be dried thoroughly. Failure to dry the kettle, conveyor, and all parts of the Donut Robot completely will cause Shortening to spatter or overflow the fryer and may result in fire, injury, or death.

Thoroughly dry all parts, including the conveyor, the heating element(s), the inside of the kettle, and the drain.

1. There should be no water drops anywhere on the Donut Robot.
2. If your kettle has the optional drain assembly, make sure no water is in the drain or drain tube.
3. After cleaning, return the conveyor to the fryer and cover with shortening. Water trapped in the chain may cause staining.

Step 7: Cleaning the turner, heating element, and kettle

1. If the turner requires extra cleaning, remove and clean it as follows.
2. Set the conveyor on a clean surface.
 - a. Use the same pieces of wood as in Step 6 to raise the conveyor 1" (25 mm) from the surface. This will enable the turner to turn freely.
3. Move the flight bars of the conveyor until the turner is in the middle of a flight pocket. Do this by turning the round motor coupling on the outfeed end of the conveyor.
4. Swing the turner cam weight up out of position. (See Figure 3).
5. Holding the turner in one hand, lift up and pull out the turner cam with the other hand.



Figure 3 Removing the Turner Cam

6. Lift out the turner. See Figure 4.

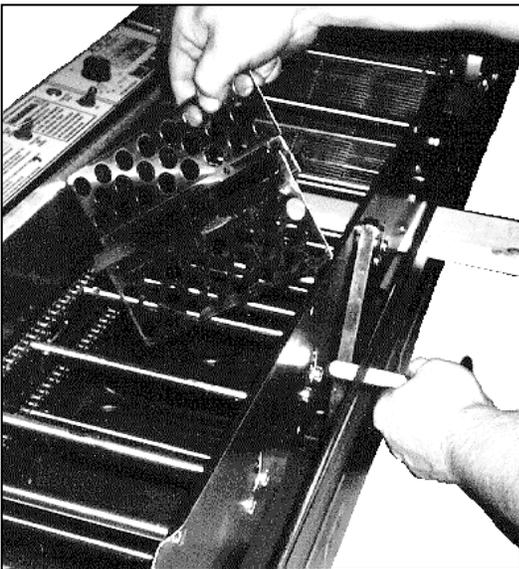


Figure 4 Removing the Turner

7. Wash the turner cam and turner using mild detergent and warm water.
12. Rinse the turner cam and turner in clear water.
13. Dry thoroughly.

WARNING

All parts must be dried thoroughly. Moisture causes hot shortening to spatter, which may cause serious injury.

14. To clean the drop plate, remove it by lifting its forward end and sliding it toward the rear of the conveyor. (See Figure 5) Wipe the drop plate with a damp cloth.

CAUTION

If the drop plate is scratched, donuts will stick to it. To prevent this from happening, always wipe the drop plate in the direction of the grain in the metal, which runs parallel to the length of the conveyor, and never use abrasive cleaners.

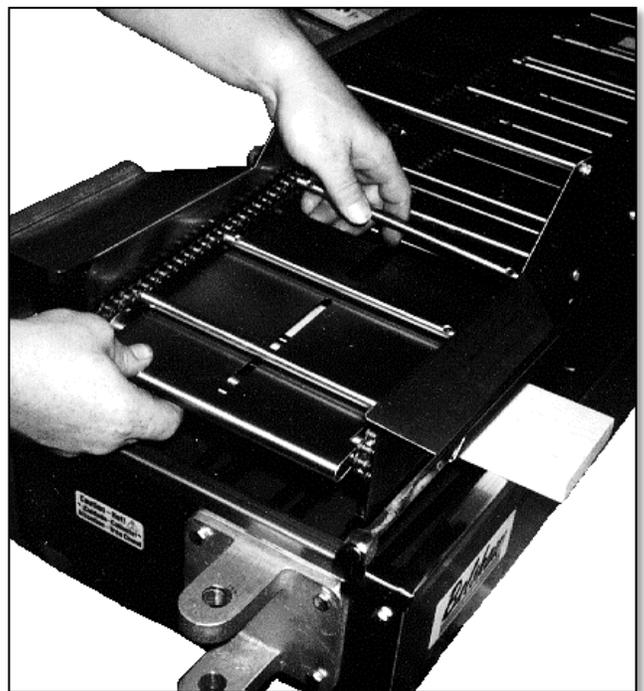


Figure 5 Removing the Drop Plate

15. Brush off any carbon that has accumulated on the Donut Robot's heating element. Accumulated carbon can cause corrosion and ineffective heating.

16. Tilt the heater head assembly back, raising the heating element out of the kettle.
17. Lift the kettle out of the fryer case.
18. Clean all parts of the kettle if needed, inside and out.
19. Ensure all parts are dry
20. Replace the kettle and lower the heater head.
21. Put the drop plate, turner cam, and turner back on the conveyor.
22. Replace the conveyor
 - a. When you replace the conveyor, line up the notch in the drive coupling with the large bolt in the motor drive (at the right end of the heater head).

WARNING

To avoid being burned, electrocuted, or otherwise injured, always unplug the machine and allow it to cool down before making adjustments, clearing obstructions, lubricating, cleaning, or disassembling.

Taking Care of the Plunger, Hopper, and Cylinder

The plunger, hopper, and cylinder of your Donut Robot are precision instruments. With proper care, they will perform well for years. Follow these guidelines:

- * Clean these parts only in the manner explained in this manual.
- * Handle these parts with care. Avoid dropping them on hard surfaces.
- * Do not force the machine if it becomes jammed. To avoid damaging the plunger, disassemble the machine and remove any obstructions.

Lubrication

Daily

Before using the machine each day, apply Food Grade mineral oil to the plunger connecting rod. The oil should penetrate the ball lock and the spring socket. See Figure 6.



Figure 6 Lubricating the Connecting Rod.

Weekly

Apply a few drops of Food Grade mineral oil to the swing column where it contacts the swing column bracket.

5

Accessories

This section contains information about accessories which can be used with your Donut Robot®:

- Feed Table
- Roto Cooler
- Filter Flo Siphon
- Shortening Reserve Tank

FT-42 Feed Table



Figure 7 FT-42 Feed Table with Feed Table cloth.

The FT-42 Feed Table is designed to supply proofed yeast-raised donuts to the Donut Robot. It produces less than 70 dB(A) of equivalent A-weighted sound pressure at work stations. This has been determined while running the machine, using a Bruel & Kjaer sound level meter, type 2236. The Feed Table is meant to be used on a flat, stationary table or countertop, positioned end-to-end with the Donut Robot. The operator is expected to read and follow these instructions.

Installation

1. Unplug the depositor power cord of your Donut Robot.
2. Release the plunger from the depositor.
3. Unscrew and lift off the hopper assembly.
4. Lift off the depositor and swing column.
5. Lift the outfeed end of the Feed Table and set the brace under the trip shelf over the edge of the kettle.

WARNING

To avoid injury, make sure that the Feed Table is turned off before proceeding.

6. Plug the Feed Table power cord into the outlet on the end of the heater head.
7. Set the switch on the control panel to “Feed Table”.

Operation

1. Test to make sure that the automatic timing for the Feed Table is working. To do this:
 - a. Turn on the Donut Robot’s conveyor drive.
 - b. Turn on the Feed Table’s conveyor drive.

The Feed Table should receive a signal from the Donut Robot, move forward the distance needed to supply one pocket of donuts, and then stop until it receives the next signal.

2. Proof your donuts on the proofing cloths from the Feed Table.
3. Put a proofing tray, with a proofing cloth on it, on the Feed Table.
4. Press the prime switch on the power head assembly. The hooks on the Feed Table will grab the proofing cloth off of the proofing board. Allow the cloth to advance to the front of the Feed Table.
5. Release the prime switch and turn on the main power. Remove the proofing board.

When the Feed Table is on, the Feed Table automatically advances donuts when the Donut Robot is ready to accept them. After the donuts go into the fryer, the proofing cloths are carried underneath the Feed Table and fall onto the work surface.

6. Continue putting proofing cloths on the Feed Table.

CAUTION

To avoid damaging the machine, never use force to assemble or operate the Feed Table.

Maintenance and Cleaning

After Each Use

Use a soft, damp cloth for cleaning.

WARNING

To avoid electrocuting yourself or damaging the machine, never allow any liquid to enter the power head.

As Needed

If you ever need to adjust the tension of the conveyor chains, follow these steps:

1. Loosen the hex head bolts that hold the roller shaft at the outfeed end of the conveyor.
2. Pull the shaft until the chains reach the correct tension. The tension is correct when you can lift the chains about 1”/2.5 cm above the surface of the Feed Table. Each chain should have the same tension.
3. Tighten the hex head bolts that hold the roller shaft.

Roto Cooler

SPECIFICATIONS				
Dimensions	Shipping Weight	Electrical Data	Construction	Standard Equipment
Dia.=24"/61 cm H=6-5/8"/17 cm	16 lb/7.3 kg	120 V 1 Phase 50 Hz	Basket: High-density polyethylene. Base: Spun, polished, heavy-gauge aluminum.	Basket and turntable base with power cord and motor.

Figure 8 Roto Cooler.



The Roto Cooler is designed to catch and cool donuts as they drop from the outfeed end of the Donut Robot.

The Roto Cooler produces less than 70 dB(A) of equivalent A-weighted sound pressure at work stations. This has been determined while running the machine, using a Bruel & Kjaer sound level meter, type 2236.

The Roto Cooler is meant to be used on a flat, stationary table or countertop. The operator is expected to read and follow these instructions.

To use the Roto Cooler:

1. Place the Roto Cooler near the outfeed end of the Donut Robot so donuts will fall into it.

2. Connect the Roto Cooler power cord to the 120 V outlet on back of the Donut Robot's heater head.
3. Turn on the Roto Cooler. It will rotate and receive donuts. Remove cooled donuts from the Roto Cooler as needed.
4. When you are finished using the Roto Cooler, turn it off and unplug it.

WARNING

To avoid electrocuting yourself or damaging the machine, never submerge the base of the Roto Cooler.

5. Clean the Roto Cooler using soap and water and a non-abrasive cloth or scrubber.

Filter Flo Siphon

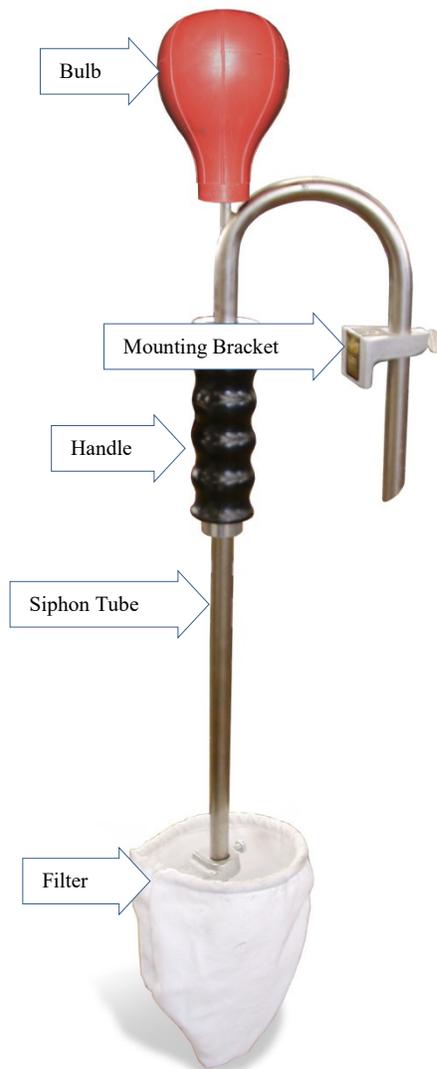


Figure 9 Filter Flo Siphon.

The Filter Flo Siphon is designed to drain and filter shortening from the kettle of the Donut Robot. The operator is expected to read and follow these instructions.

Installation

1. Let the shortening cool to 100°F/38°C.

WARNING

Hot shortening can cause serious burns. Never touch hot shortening. Never wear shorts while using the Filter Flo Siphon.

2. Place the mounting bracket, with the siphon tube in it, on the lip of the kettle. You may place it on the infeed end of the kettle, or on the front side of the kettle. If you place it on the front side, you must disconnect the swing connecting rod from the throw arm and move it out of the way.
3. Position the opening of the siphon tube near the bottom of the kettle.
4. Tighten the thumb screw in the mounting bracket.
5. Attach the filter assembly to the lower part of the siphon tube, as shown in Figure 11. To do this:
 - a. Slide the opening in the filter mounting bracket around the siphon tube.
 - b. Adjust the filter mounting bracket vertically to ensure that the filter does not touch the valve assembly.
 - c. Tighten the screw that holds the filter mounting bracket to the siphon tube.
 - d. Tighten the screw that holds the filter retaining ring to the filter mounting bracket.

WARNING

Make sure that both screw in the filter assembly are tight. If they are not, the filter assembly might slide off of the siphon tube during operation, causing shortening to splatter.

6. Place a five-gallon metal container under the filter.

WARNING

Do not use a plastic container. Hot shortening could melt the container.

Operation

1. Compress the bulb quickly and release it quickly. Do this only once. Shortening should flow into the container.

CAUTION

Do not compress the bulb more than once. Doing so could allow hot shortening to get into the bulb, damaging your equipment.

2. Watch the container as the shortening flows into it. If the shortening rises to within 2”/ 5 cm of the top of the container, do the following:
 - a. With one hand, hold the siphon by the handle. With the other hand, loosen the thumb screw that holds the siphon assembly to the mounting bracket on the lip of the kettle.
 - b. Slowly lift the siphon assembly so its opening is above the shortening. Do not remove it from the mounting bracket.
 - c. Tighten the thumb screw.
 - d. When the shortening stops flowing and the valve closes, move the container out from under the filter.
 - e. Place another five-gallon metal container under the filter.
 - f. With one hand, hold the siphon by the handle. With the other hand, loosen the thumb screw that holds the siphon assembly to the mounting bracket on the lip of the kettle.
 - g. Slowly lower the siphon assembly so its opening is near the bottom of the kettle.
 - h. Tighten the thumb screw.

- i. Restart the siphon, as explained in step 1.
- j. Continue watching the container and repeat the above procedure as needed.

WARNING

If you allow shortening to overflow the container, the shortening could burn you, and it will get on the floor, possibly causing slips, falls, injury, or even death. If shortening does get on the floor, thoroughly clean and dry the floor right away.

3. When the shortening stops flowing, tilt up the side of the kettle opposite the siphon. Place a wedge under the side of the kettle to hold it up. The remaining shortening will now flow toward the siphon.
4. Set aside the container of shortening.
5. Remove the filter assembly.
6. Place a different container under the valve assembly and start the siphon again. Drain the remaining shortening and discard it; it will be full of sediment.

Cleaning

1. Remove the siphon from the Donut Robot.
2. Squeeze the bulb several times to expel shortening from the siphon.
3. Wipe the siphon clean and hang it with the bulb side up so any remaining shortening will drain. Place a pan under the siphon to collect the shortening.
4. Rinse the filter bag and hang it to dry. You may launder it as needed.

WARNING

After washing, be sure the Filter Flo Siphon is completely dry before using it again. Moisture will cause hot shortening to spatter, which may cause serious injury.

Shortening Reserve Tank

SPECIFICATIONS				
Dimensions	Shipping Weight	Capacity	Construction	Standard Equipment
L=11"/28 cm W=5-1/2"/14 cm D=4"/10 cm	4 lb/2 kg	4 lb/2 kg shortening	Nickel-plated steel tank and non-corrosive self-closing valve.	Shortening reserve tank and valve assembly.

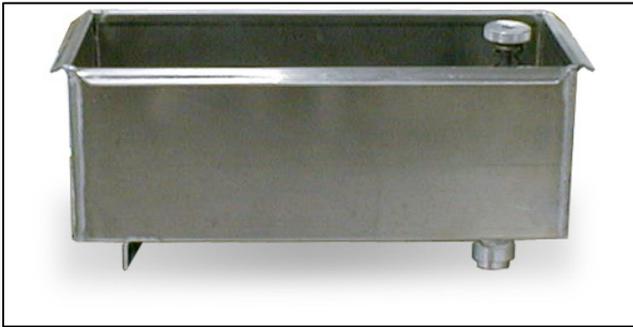


Figure 10 Shortening reserve Tank
The Shortening Reserve Tank is designed to supply melted shortening to the kettle of the Donut Robot. The operator is expected to read and follow these instructions.

To use the Shortening Reserve Tank:

1. Position the Shortening Reserve Tank on the conveyor side panels. Make sure that you do not position it above the donut turner.

WARNING

Be careful if you put hot shortening into the tank. Hot shortening can cause serious burns.

2. Place shortening in the tank.
3. Turn on the Donut Robot. The heat of the fryer will melt the shortening in the tank.
4. To supply shortening to the fryer, open the valve by pushing down on the valve assembly.
5. When you are done making donuts, drain the remaining shortening into the fryer.
6. When the shortening and equipment have cooled completely, remove the Shortening Reserve Tank and wash it.

6

Donut-Making Helps

Tips on Making Quality Cake Donuts

- Use the correct batter temperature.
In general, the correct batter temperature is 75°-80°F/24°-27°C. Check the mix manufacturer's instructions, as the recommended temperature range may vary.
If the batter is too warm, the donuts will lack volume and may "ring out" or be misshapen. If the batter is too cold, the donuts will stay under the shortening too long, fry too slowly, and crack open or ball up. They may also absorb excess shortening and lose volume.
- Use the correct floor time.
A floor time of 10 minutes between mixing and cutting allows the baking powder to react with the water. This helps the donuts attain the proper volume and absorb the proper amount of shortening.
If the floor time exceeds 30 minutes, the mix will gas off, the donuts will lose volume and shape and will absorb too much shortening.
- Use the correct frying temperature.
The correct shortening temperature for frying is 370°-380°F/188°-193°C.
If the shortening is too hot, the donuts will fry too quickly on the outside and will lose volume. The donuts may also become dense inside.

If the shortening is too cold, the donuts will spread too rapidly, will form large rings, will tend to crack open, will be too light in appearance, and will absorb too much shortening.

- Maintain the proper shortening level. We recommend a distance of 1 1/4" between the depositor and the shortening.
If the shortening is too deep, the donuts may not turn over when they reach the turner, causing them to cook unevenly.

If the shortening is too shallow (too far below the depositor), the donuts may not drop flat, may turn over while submerging and surfacing, and may become irregular, cracked, or rough-cruste.

- Ensure that the donuts absorb the right amount of shortening.
Donuts should absorb 1-1/2 to 3 oz/42 to 85 g of shortening per dozen, depending on their weight. You can achieve proper absorption by following tips 1-3.
- If the donuts do not absorb enough shortening, they will not keep well. If they absorb too much shortening, they will lose volume and may become misshapen. If this happens, follow tips 1-3, mix the batter a little longer than usual, turn the donuts as soon as they become golden brown, and turn the donuts only once.

Calculating Correct Water Temperature

The following is an example of how to calculate the correct water temperature to use.

You must use your own room temperature, dry mix temperature and target batter temperature. If you are making yeast-raised donuts, also estimate the temperature increase during mixing.

	Cake Donuts		Yeast-Raised Donuts	
	°F	°C	°F	°C
Room temperature	72	22.2	72	22.2
Dry mix temperature	<u>+70</u>	<u>+21.1</u>	<u>+70</u>	<u>+21.1</u>
Total A	142	43.3	142	43.3
Desired batter temperature	75	23.9	80	26.7
	<u>x3</u>	<u>x3</u>	<u>x3</u>	<u>x3</u>
Total B	225	71.7	240	80.1
Total B	225	71.7	240	80.1
-Total A	<u>-142</u>	<u>-43.3</u>	<u>-142</u>	<u>-43.3</u>
Desired water temp. for cake donuts	83°F	28.4°C	98	36.8
			↓	↓
			Figure from above	
			98	36.8
Temperature increase during mixing (average: 30°F/17°C)			<u>-30</u>	<u>-17</u>
Desired water temperature for yeast-raised donuts			68°F	19.8°C

Belshaw[®]

Donut Robot[®]

Mark II, & Mark II GP

Mark V & Mark V GP



Technical Supplement

MN-0112EN 05-20-2022

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Operator's Manual – located before Technical Supplement**

- Printed separately for CE / European Union manuals

1 About the Technical Supplement

This technical supplement to the Donut Robot® Mark II / Mark V Operator's Manual contains much information that users and service persons may find helpful:

- Detailed maintenance procedures
- Detailed troubleshooting guides
- Parts lists and assembly drawings
- Instructions for changing parameters of the electronic temperature controller

This is a technical supplement, not the official operator's manual. You use this supplement at your own risk. While very effort is made to inform you of how to install and maintain the Donut Robot® safely, Belshaw disclaims any liability for the use of the information contained herein.

2

Installation

The photos below show the major visible components of a Donut Robot® Mark II. The Donut Robot® Mark V is 50% longer. All components apply to Mark II and Mark V, both standard and GP models.

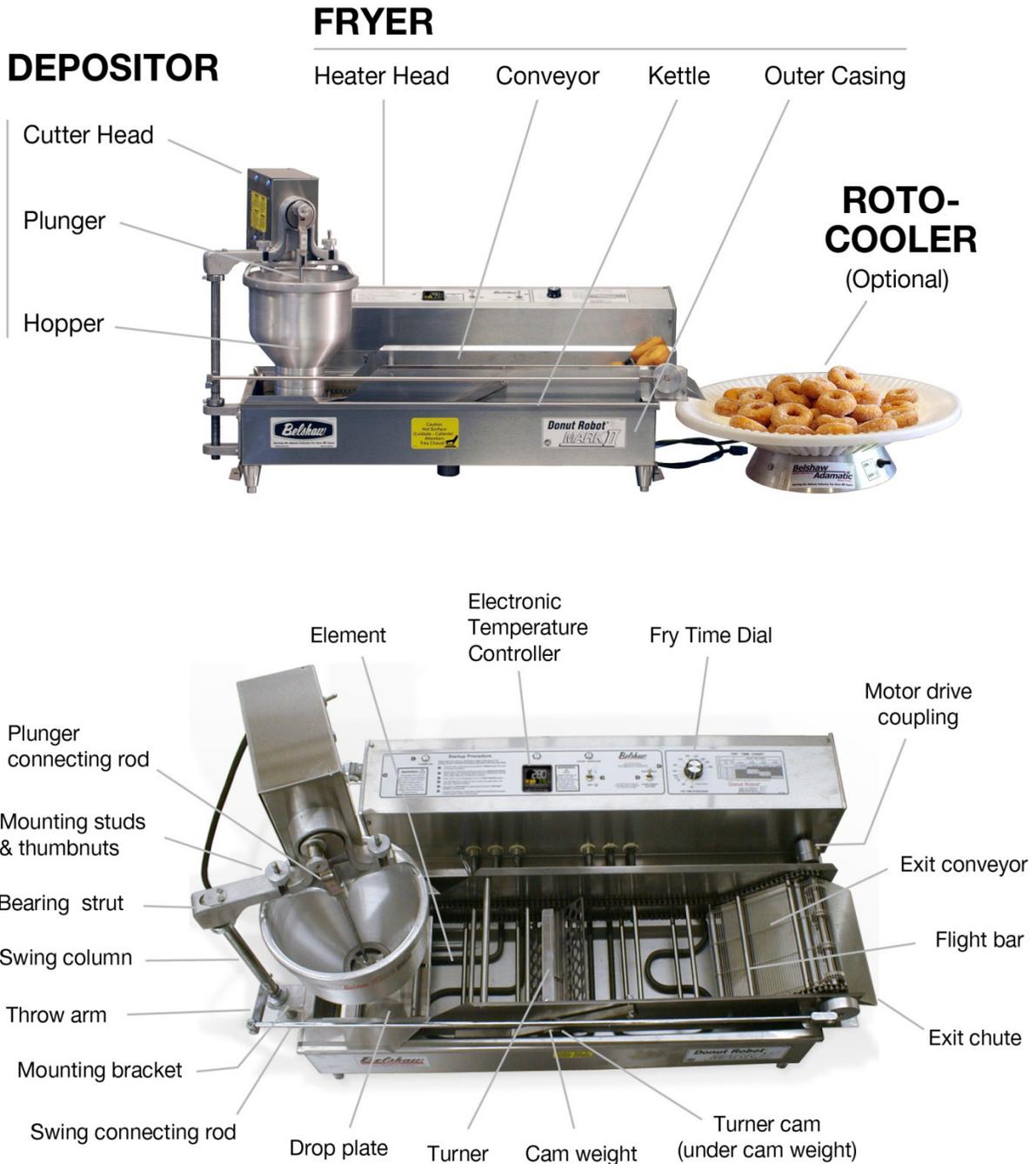


Figure 1.1. Above: Donut Robot Mark II. (components apply also to Donut Robot Mark V)

Unpacking the Fryer

1. Remove the foam and other packing materials from the two boxes.
2. Remove the fryer and move it onto its supporting surface. Two people are required to move the fryer. If you must move the fryer by yourself, perform these steps:
3. Remove the conveyor from the fryer.
4. Remove the retaining pins that hold the heater head in place, and lift the heater head out of the fryer. Set the heater head gently in a secure place.
5. Remove the fryer case and kettle, and move them to the work location. Take care not to drag the electrical cord along the floor, in case you may trip.
6. Remove the cutter head of the depositor. Take care not to drag the electrical cord along the floor, in case you may trip.
7. Remove the hopper, plunger, and column.

Initial Cleaning

Thoroughly clean your Donut Robot before using it. Remove all packing materials. Use household dishwashing detergent. **Do not use strong alkali cleaners such as lye, soda ash, or trisodium phosphate.** Thoroughly dry and lubricate parts to prevent rusting.

Refer to the 'Cleaning' section in the Operator's Manual for cleaning instructions.

WARNING

To avoid electrocution or damaging the machine, never allow water, steam, cleaning solution, or other liquid to enter the cutter head or fryer heater head compartments.

WARNING

Never let water and hot shortening come in contact. Moisture causes hot shortening to spatter, which may cause serious injury. Prior to use, make sure any parts you have washed are dry.

After cleaning, assemble the fryer and depositor as explained below.

Assembling the Fryer

1. Place the fryer case on a flat, stationary surface.
2. Screw the fryer's legs in as far as they will go.
3. Set the kettle into the fryer case. The end of the kettle that has the locating pin must be placed at the outfeed end of the fryer case. The lip of the kettle should fit securely over the edge of the case.
4. Install the heater head assembly as follows:
 - a. Align the holes in the heater head end caps with the holes in the heater head mounting brackets.
 - b. Slide the retaining pins through the holes so that the pinheads are on the outside.
 - c. Insert the hairpin clips into the holes in the retaining pins.
5. Lower the heater head assembly into position. The thermostat bulb bracket should rest on or very near the bottom of the kettle.
6. Install the conveyor assembly as follows:
 - a. Hold the conveyor at the angle shown in Figure 1-2 and slide the conveyor drive coupling over the main drive shaft coupling. The conveyor coupling has a notch in it. Turn the conveyor coupling so that the head of the socket head screw in the motor drive coupling can slide into this notch. (See Figure 1-2.)

- b. Lower the front side of the conveyor assembly so the hole in the conveyor flange fits over the locating pin on the lip of the kettle.

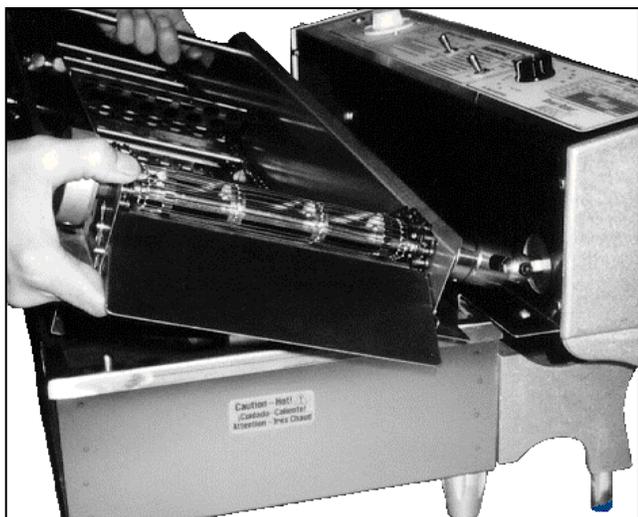


Figure 1-2. Joining the Couplings.



Figure 1-3. Inserting the Swing Column.

If you are preparing to make yeast-raised donuts, skip steps 7 and 8 and proceed to step 9.

7. Insert the swing column into the swing column-mounting bracket. Make sure the

plastic spacer washer is on the swing column between the set collar and the swing column-mounting bracket. (See Figure 1-3.)

8. Connect the swing connecting rod to the throw arm of the swing column. A locating pin on the swing connecting rod rests in a hole in the throw arm. (See Figure 1-4.)

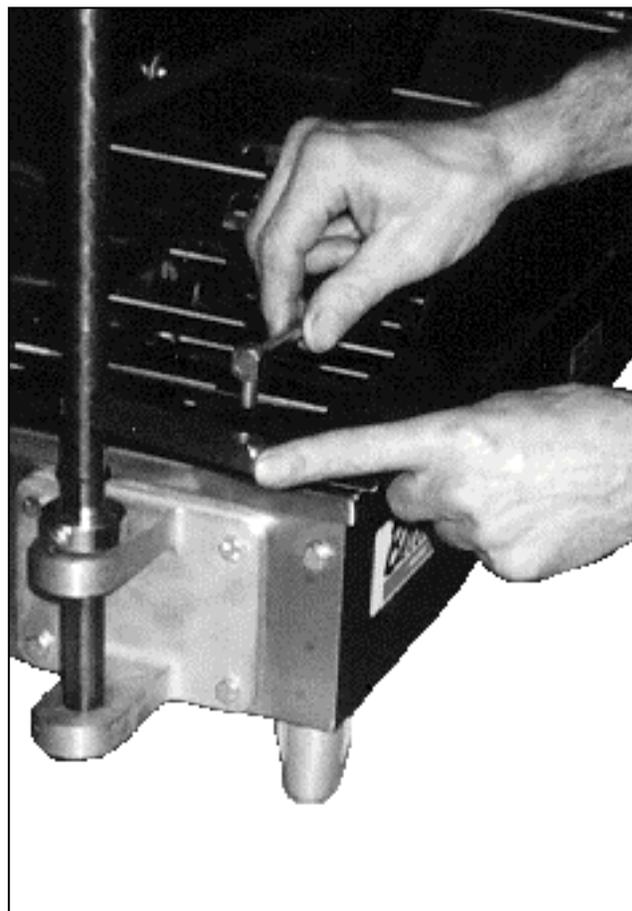


Figure 1-4. Connecting the Swing Connecting Rod.

9. Be sure your power source matches the specifications on the data plate. Connect the machine to the power source.
10. Turn on the conveyor only and check to see that it operates smoothly. The power switch for the conveyor drive is on the heater head.

Assembling the Depositor

Read this section only if you are preparing to make cake donuts.

1. Set the cutter head onto the swing column.
(See Figure 1-5.)

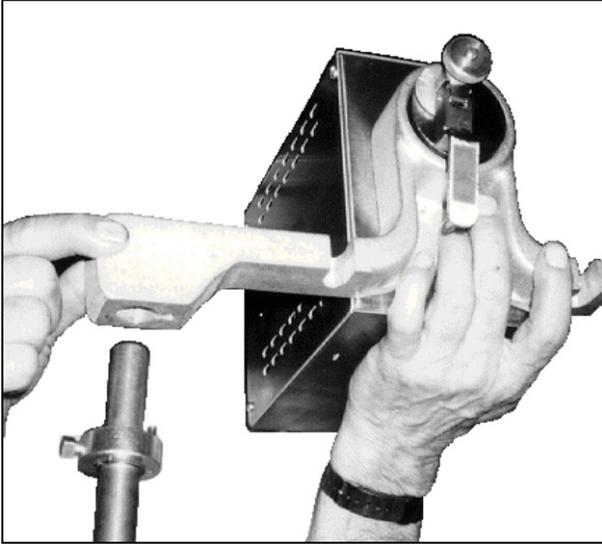


Figure 1-5. Mounting the cutter head.

2. Mount the hopper by sliding the two mounting studs on the hopper arch into the notches on the bearing strut. Secure the hopper with the thumbnuts. (See Figure 1-6.)



Figure 1-6. Mounting the Hopper.

3. Install the plunger as follows:

- a. Pull the plunger connecting rod up and out of the way.
- b. Put the narrow part of the plunger's center rod through the slot in the center of the hopper arch.
- c. Lower the plunger until the wider part at the top of the center rod enters the round opening in the hopper arch and the plunger's piston just enters the hopper cylinder.
- d. Lower the connecting rod and insert the pin into the hole near the top of the plunger center rod. (See Figure 1-7.)



Figure 1-7. Installing the Plunger.

4. Plug the power cord from the depositor into the outlet on the back of the heater head.
5. Test the depositor to ensure that it is operating properly. Turn it on using the prime switch on the depositor. The depositor should run continuously. Turn off the depositor.

Adjusting the Hopper

Read this section only if you are preparing to make cake donuts.

WARNING

To avoid injury, always disconnect the machine from the power source before making adjustments.

1. The bottom of the hopper should be 1”/ 2.5 cm above the flight bars. To set the height of the hopper:
 - a. Hold the depositor from below to prevent from dropping suddenly.
 - b. Loosen the set screw in the lower set collar on the swing column.
 - c. Raise or lower the swing column as needed.
 - d. Tighten the setscrew. (See Figure 1-8.)



Figure 1-8. Adjusting the Height of the Hopper.

2. As the hopper swings back and forth over the kettle, the hopper cylinder should stop the same distance away from either side of the kettle at each end of the swing.

To check the swing of the hopper, turn on the conveyor. If you need to center the swing of the hopper, follow these steps:

- a. Turn off the conveyor.
- b. Loosen the setscrews in the upper set collar.
- c. Swivel the depositor as needed.
- d. Tighten the setscrews. See Figure 1-9.

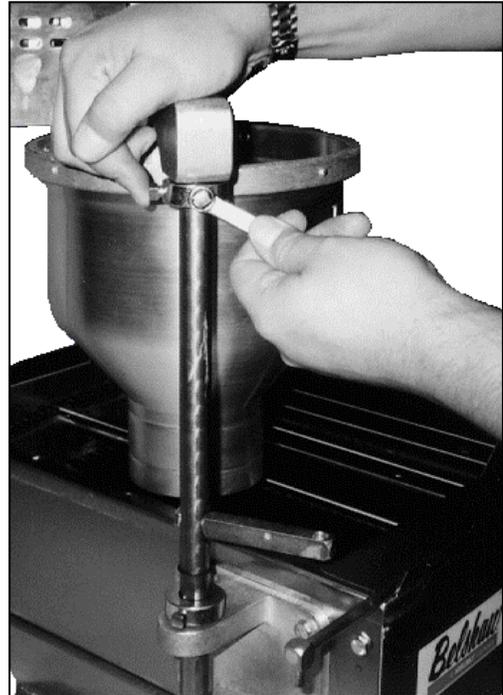


Figure 1-9. Adjusting the Swing of the Hopper.

- e. Double-check the swing of the hopper by turning on the conveyor. Then turn off the conveyor.

Leveling and Securing the Fryer

Check to see if the fryer is level. If it is not, adjust the heights of the legs. Be sure that all six legs rest on the work surface when the fryer is level.

Bolt the fryer to the work surface as follows:

1. There are brackets on the ends of the fryer case. Each has a hole in it. Mark the locations of the holes on the work surface.
2. Drill holes through the work surface.
3. Insert bolts through the holes.
4. Tighten nuts onto the bolts to ensure that the Donut Robot will not move.

Moving the Fryer

If you ever want to move the fryer to a different workstation, follow this procedure:

1. Turn off the machine and disconnect it from the power source. Unplug the depositor power cord.
2. Allow the machine and the shortening to cool.

WARNING

Do not touch hot shortening. It can cause serious burns.

3. Remove and set aside the plunger, the hopper, and the cutter head, in that order.
4. Disconnect the swing connecting rod.
5. Remove the shortening from the fryer as explained in “Removing the Shortening” in Section 3.
6. To avoid dropping the machine or getting shortening on the floor wipe excess shortening off of the fryer and the conveyor.

WARNING

Thoroughly clean and dry the floor if shortening is spilled. Materials on the floor can cause people to slip or fall, resulting in serious injury or loss of life.

7. Set aside the conveyor.
8. Remove the clevis pins that hold the heater head in place. Remove the heater head from the fryer.
9. To prevent tripping, coil the power cord. Move the heater head to the new workstation.
10. Move the fryer to its new location.
11. Install the heater head.
12. Move and install the conveyor.
13. Move and install the swing column. Connect the swing connecting rod.
14. Move and install the depositor’s cutter head (the motor and electrical compartment).
15. Move and install the hopper and the plunger.
16. Level and secure the fryer.

3

Maintenance

WARNING

To avoid being burned, electrocuted, or otherwise injured, always unplug the machine and allow it to cool down before making adjustments, clearing obstructions, lubricating, cleaning, or disassembling.

Lubricating

Daily

Before using the machine each day, apply food grade lubricating oil to the plunger connecting rod. The oil should penetrate the ball lock and the spring socket. See Figure 2-1.



Figure 2-1. Lubricating the Connecting Rod.

Weekly

1. Apply a few drops of food grade lubricating oil to the swing column where it contacts the

swing column bracket. See arrow on Figure 2-2.



Figure 2-2. Lubricating the swing column.

Yearly

Lubricate the conveyor drive gears, as explained below.

1. Disconnect the machine from the power source.
2. Remove the back cover of the heater head.
3. Lightly coat the gear teeth with food grade grease. See Figure 2-3.

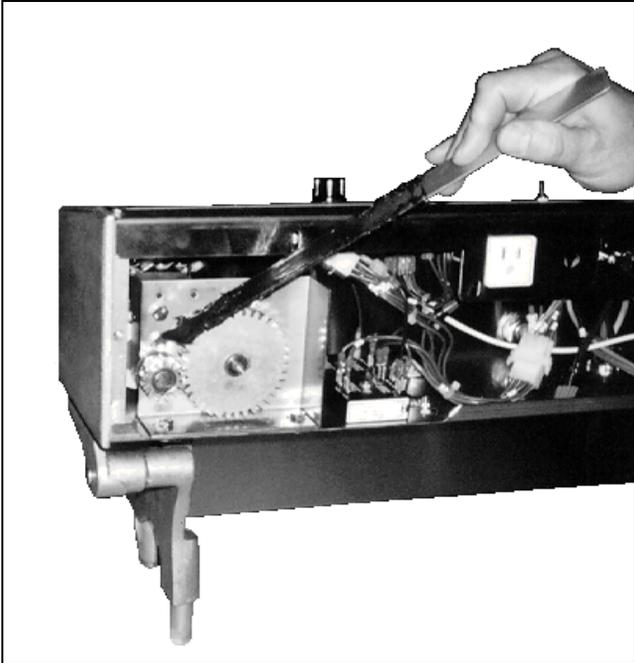


Figure 2-3. Lubricating the Drive Gears.

6. Replace the back cover of the heater head.

Taking Care of the Plunger, Hopper, and Cylinder

The plunger, hopper, and cylinder of your Donut Robot are precision instruments. If you take good care of them, they will perform well for years. Follow these guidelines:

- Clean these parts only in the manner explained in this manual.
- Handle these parts with care. Avoid dropping them on hard surfaces.
- Do not force the machine if it becomes jammed. To avoid damaging the plunger, disassemble the machine and remove any obstructions.

4

Troubleshooting

CAUTION

If you perform repairs yourself or have them performed by anyone other than a service technician authorized by BELSHAW, you do so at your own risk.

This section is designed as an aid in troubleshooting with the Donut Robot® Mark II / Mark V and with the FT-42 Feed Table. It is not a substitute for a qualified technician. You may encounter a problem with your machine that is not covered in this section, or you may try the remedies suggested here and find that they do not solve the problem. If this happens, call your dealer or another qualified technician. Also, call your dealer if you need a replacement part.

If you need assistance in identifying a part, you can contact Belshaw Adamatic Service Dept at 800-578-2547 or email service@belshaw.com. You will need to state:

- The model name of the machine.
- The serial number of the machine.
- The voltage, phase, and cycle of the machine.

Following is a troubleshooting chart to help identify and solve problems with the Mark II / Mark V. See also “Donut-Making Helps.”

WARNING

To avoid being burned, electrocuted, or otherwise injured, unplug the machine and allow it to cool before disassembling, repairing, or wiring.

Mark II and Mark V

THE DONUTS BALL OR BLISTER.	
Possible Causes	What To Do
The dough is too cold.	See “Donut-Making Helps” section.
The shortening is too hot.	Decrease the temperature setting.
The dough is overmixed.	Review the mixing procedure.
The donuts are too large.	Adjust the dial on the depositor to produce smaller donuts.
The shortening is old or contaminated.	WARNING
	To avoid being burned, turn off the machine and allow the shortening to cool.
	Replace the bad shortening with fresh shortening.
THE DONUTS ARE SHAPED IMPERFECTLY.	
Possible Causes	What To Do
The shortening level is too low.	Add shortening to reach the proper level.
The drop plate is out of position.	WARNING
	To avoid being burned or otherwise injured, turn off the machine and allow the shortening to cool.
	Reposition the drop plate.
The tip of the cylinder is dirty.	WARNING
	To avoid injury, turn off the machine and remove the hopper.
	Clean the cylinder.
The tip of the cylinder is nicked.	Replace the hopper.
The size-selection dial is not tightened.	Tighten the thumb nut.
The dough is overmixed.	Review the mixing procedure.

THE DONUTS ARE UNDERCOOKED.	
Possible Causes	What To Do
The shortening is not hot enough.	Increase the temperature setting.
The conveyor is moving too quickly.	Decrease the speed of the conveyor, using the knob labeled “Fry Time in Seconds.”
The dough is too cold.	See “Donut-Making Helps.”
The dough has not had enough floor time.	See “Donut-Making Helps.”
The thermostat reads inaccurately.	Calibrate the thermostat.
THE DONUTS ARE OVERCOOKED.	
Possible Causes	What To Do
The shortening is too hot.	Decrease the temperature setting. The temperature setting should never exceed 375°F/191°C.
The conveyor is moving too slowly.	Increase the speed of the conveyor, using the knob labeled “Fry Time in Seconds.”
The thermostat reads inaccurately.	Calibrate the thermostat.
THE DEPOSITOR SWING COLUMN CHATTERS.	
Possible Causes	What To Do
	WARNING
	To avoid injury, before doing either of the following, turn off the machine.
The nylon thrust washer is missing.	Install the nylon thrust washer between the swing column bracket and the set collar.
There is not enough lubrication between the swing column and the swing column mounting bracket.	Lubricate the upper and lower legs of the bracket with SAE 30 machine oil.

THE CONVEYOR BITES THE DONUTS.

Possible Causes	What To Do
The donuts are not cooking enough.	See “The donuts are undercooked” below.
The shortening level is too low.	Add shortening to reach the proper level.
	WARNING
	Before doing any of the following, turn off the machine and allow the shortening to cool.
The turner is bent or packed with cooked food particles.	Straighten and/or clean the turner.
The cam weight is sticking due to the accumulation of varnish.	Clean to remove the cooked-on varnish.
The fryer is not level.	Level the fryer.

THE DEPOSITOR OPERATES CONTINUOUSLY.

Possible Causes	What To Do
	WARNING
	To avoid being burned, electrocuted, or otherwise injured, before doing any of the following, turn off the machine, allow the shortening to cool, and disconnect the machine from the power source.
One of the microswitches is defective. (There are three microswitches in the conveyor drive assembly and one microswitch in the depositor.)	For help in testing the microswitches, refer to the section “Electrical Components.” Replace any defective microswitches.
Something is interfering with the nylon brake dog in the depositor.	Clear away the cause of the interference.
The brake spring in the depositor is weak or broken.	Replace the spring.

THE DONUTS DROP AT THE WRONG TIME.	
Possible Cause	What To Do
The hopper swing is adjusted incorrectly.	WARNING
	To avoid injury, turn off the machine.
	Adjust the hopper swing. See “Adjusting the Hopper” in the “Installation” section.
THE HEATING ELEMENT FAILS TO MAINTAIN THE PROPER TEMPERATURE.	
Possible Causes	What To Do
The input voltage is incorrect.	Supply the correct power as specified on the data plate.
Sediment has accumulated around the thermostat bulb.	WARNING
	To avoid being burned or otherwise injured, turn off the machine and allow the shortening to cool.
	Clean to remove the sediment. (Clean the Donut Robot regularly and thoroughly.)
The thermostat has been calibrated incorrectly.	Recalibrate the thermostat.
The thermostat is defective.	WARNING
	To avoid being burned, electrocuted, or otherwise injured, turn off the machine, allow the shortening to cool, and disconnect the machine from the power source.
	Replace the thermostat.

THE CONVEYOR IS JAMMED.	
Possible Causes	What To Do
	WARNING
	To avoid being burned or otherwise injured, before doing any of the following, turn off the machine and allow the shortening to cool.
Cooked food particles are wedged between a chain opening and a sprocket tooth.	Clean to remove the food particles. Clean the Donut Robot regularly and thoroughly.
The turner slot is packed with cooked food particles.	Clean to remove the food particles.
The drop plate is out of position and is interfering with the conveyor.	Reposition the drop plate.
Something is interfering with the free movement of the turner cam and cam weight.	Remove the obstruction.
The heating element is bent and is interfering with the turner.	Straighten the heating element.
The turner is out of position and is catching on a flight bar below.	Lift and move the outfeed end of the conveyor to disengage the conveyor coupling from the conveyor drive shaft. Turn the conveyor back 2-3 pockets. The turner will return to the correct position.
The conveyor drive shaft and the drive motor shaft are out of alignment.	Remove the cover of the drive assembly. Loosen the four mounting spacers so the drive assembly can be moved. Align the motor shaft with the conveyor shaft. When they are aligned, tighten the mounting spacers. Replace the cover.

THE MOTOR OVERHEATS.	
Possible Causes	What To Do
The power requirements of the machine do not match the power source.	Supply the correct power as specified on the data plate.
	WARNING
	To avoid being burned, electrocuted, or otherwise injured, before doing the following, turn off the machine, allow the shortening to cool, and disconnect the machine from the power source.
The motor is binding.	Repair or replace the motor.
The motor is defective.	Repair or replace the motor.
THE DEPOSITOR CUTS DOUBLE WHEN YOU HAVE SELECTED ONE CUT PER POCKET.	
Possible Causes	What To Do
	WARNING
	To avoid being burned, electrocuted, or otherwise injured, before doing any of the following, turn off the machine, allow the shortening to cool, and disconnect the machine from the power source.
The nylon brake dog is binding on the depositor brake motor.	Loosen the brake dog. If the spring is missing or weak, replace it. If the brake dog is worn, replace it.
An internal wire is interfering with the nylon brake dog.	Move the wire.
The arm on the depositor microswitch is bent.	Bend the arm back into position or replace the microswitch.
The wires on the depositor microswitch are reversed.	Make the correct connections.

THE DEPOSITOR WILL NOT OPERATE, BUT THE CONVEYOR RUNS.	
Possible Causes	What To Do
The depositor power cord is not plugged in to the outlet on the back of the heater head.	Connect the depositor power cord to the correct outlet.
	WARNING
	To avoid being burned, electrocuted, or otherwise injured, before doing any of the following, turn off the machine, allow the shortening to cool, and disconnect the machine from the power source.
The set screws in the depositor cam are loose.	Tighten the set screws.
The depositor power cord is broken.	Repair or replace the depositor power cord.
The depositor motor is defective.	Replace the depositor motor.
One of the microswitches is defective. (There are three microswitches in the conveyor drive assembly and one microswitch in the depositor.)	For help in testing the microswitches, refer to Section 5, “Electrical Components.” Replace any defective microswitches.
The depositor power switch is defective.	Replace the depositor power switch.
The circuit breaker on the back of the heater head is defective.	Replace the circuit breaker.
The depositor’s wiring harness is not connected.	Check the connection between the pin housing in the conveyor drive assembly and the socket housing in the fryer’s heater head. Also, make sure that the pins are securely seated in the pin housing.
The Feed Table / Cake Donuts switch is defective.	Replace the switch.

THE ELEMENT WILL NOT HEAT, AND THE CONVEYOR WILL NOT RUN.	
Possible Causes	What To Do
The power cord is not plugged in, or the outlet has no power.	Connect the machine to a good power source.
	WARNING
	To avoid being burned, electrocuted, or otherwise injured, before doing any of the following, turn off the machine, allow the shortening to cool, and disconnect the machine from the power source.
The power cord is defective.	Replace the power cord.
The transformer is defective.	Replace the transformer.
The connections to the transformer are bad.	Rewire the connections to the transformer.
THE ELEMENT WILL NOT HEAT, BUT THE CONVEYOR RUNS.	
Possible Causes	What To Do
The high temperature limit control switch has been tripped.	Push the red reset button on the back panel of the heater head.
The temperature controller is displaying the wrong temperature.	Recalibrate the temperature controller.
	WARNING
	To avoid being burned, electrocuted, or otherwise injured, before doing any of the following, turn off the machine, allow the shortening to cool, and disconnect the machine from the power source.
The high temperature limit control is defective.	Replace the high temperature limit control.
The temperature controller is defective.	Replace the temperature controller.
The contactor for the transistor is defective.	Replace the contactor.
The connections to the contactor are bad.	Rewire the connections to the contactor.

THE ELEMENT HEATS, BUT THE CONVEYOR WILL NOT RUN.	
Possible Causes	What To Do
The input voltage is incorrect.	Supply the correct power as specified on the data plate.
The circuit breaker has been tripped.	Reset it by moving the white switch on the back of the heater head to “off” and then to “on.” If the conveyor still will not run, see that the power source agrees with the specifications on the data plate. If the problem persists, see below.
	WARNING
	To avoid being burned, electrocuted, or otherwise injured, before doing any of the following, turn off the machine, allow the shortening to cool, and disconnect the machine from the power source.
There is a short circuit.	Find it and repair it. (First see “The circuit breaker has been tripped” above.)
The wiring harness in the conveyor drive assembly is not connected.	Check the connection of the pin connector from the conveyor drive assembly to the socket connector in the heater head enclosure. Make sure the pins in the pin housing are securely seated in the housing.
The conveyor drive power switch is defective.	Replace the switch.
The nylon brake dog is binding on the conveyor brake motor.	If the brake dog is worn, replace it. If it is too tight, loosen it. If the spring is weak or missing, replace it.
The brake motor is defective.	Replace the brake motor.
An internal wire is interfering with the nylon brake dog.	Move the wire.
A fan blade is caught on a wire.	Move the wire.
The conveyor is jammed.	Clear the obstruction.
The couplings are not engaged.	Engage the couplings.
The conveyor drive coupling is slipping.	Tighten the two set screws.

FT-42 Feed Table

Following is a troubleshooting chart to help identify and solve problems with the FT-42 Feed Table.

WARNING
To avoid being burned, electrocuted, or otherwise injured, unplug the machine and allow it to cool before disassembling, repairing, or wiring.

THE CONVEYOR CHAINS DO NOT ADVANCE WHEN THE MAIN POWER IS ON OR WHEN THE PRIME SWITCH IS PRESSED, AND THE PILOT LIGHT DOES NOT COME ON.	
Possible Causes	What To Do
The power cord is not connected.	Plug in the power cord.
The circuit breaker for the gear box outlet on the Donut Robot's heater head is tripped.	Push the white reset button near the outlet.
	WARNING
	To avoid electric shock or other injury, before doing any of the following, unplug the machine.
The black or white wire in the power cord is broken or poorly connected.	Repair the cord and/or make the proper connection.
The fuse on the Feed Table is blown.	Replace the fuse.
The fuse for the Donut Robot's conveyor is blown.	Replace the fuse.

THE CONVEYOR CHAINS DO NOT ADVANCE WHEN THE MAIN POWER IS ON, BUT THEY DO ADVANCE WHEN THE PRIME SWITCH IS PRESSED.	
Possible Causes	What To Do
	WARNING
	To avoid electric shock or other injury, before doing any of the following, unplug the machine.
The red wire in the power cord is broken or poorly connected.	Repair the cord and/or make the proper connection.
The microswitch in the power head is defective.	Replace the microswitch.
The microswitch in the Donut Robot's signal circuit is defective.	Replace the microswitch.
THE CONVEYOR CHAINS DO NOT ADVANCE AT ALL, DO NOT ADVANCE FAR ENOUGH, OR DO NOT ADVANCE THE SAME DISTANCE DURING EACH CYCLE, BUT THE PILOT LIGHT DOES COME ON.	
Possible Cause	What To Do
	WARNING
	To avoid electric shock or other injury, before doing the following, unplug the machine.
The cam in the power head is loose.	Tighten the cam set screw.

THE CONVEYOR CHAINS ADVANCE CONTINUOUSLY WHEN THE MAIN POWER IS ON.

Possible Causes	What To Do
	WARNING
	To avoid electric shock or other injury, before doing any of the following, unplug the machine.
The brake is defective.	Repair or replace the brake.
The cam in the power head is loose.	Tighten the cam set screw.
The microswitch in the power head is defective.	Replace the microswitch.
The microswitch in the Donut Robot’s signal circuit is defective.	Replace the microswitch.

TWO ROWS OF DONUTS ARE ADVANCED DURING EACH CYCLE.

Possible Causes	What To Do
	WARNING
	To avoid electric shock or other injury, before doing either of the following, unplug the machine.
The brake is defective.	Repair or replace the brake.
The cam in the power head is loose.	Tighten the cam set screw.

5 OMRON Temperature Controller

Changing Parameters on the Electronic Temperature Controller

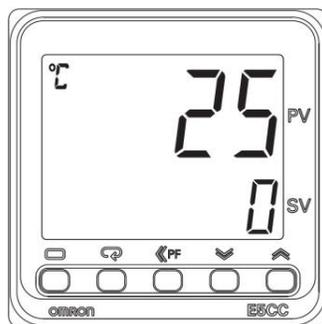
To change parameters on the temperature controller, see the Service Bulletin SB-0446 on the following pages.

MKII Temperature Controller Programming procedure

This service bulletin covers the procedure for programming the TJ-0184D-3 or 4 (Omron E5CC-RX3DM-000) temperature controller used in a Mark II, Mark V or Mark VI.

The TJ-0184D-2 controller comes per-programmed and protected so the operator cannot change the setup parameters. To change any setting you must first unlock the controller.

Note: Only the settings that are changed from the Factory settings are listed below.



To unlock the controller:

1. Press the + keys for more than 3 seconds
2. Press the key to move to the next parameter
3. Press the or to change the parameter $\bar{\Delta}PPL$ and $\bar{\Delta}CPL$ from 2 to 0
4. Press the + keys for more than 1 second to return to operator screen

Parameter	Factory default setting	Present setting	Unit	Front panel	Explanation of present setting
Protection parameters					
Operation/Adjustment Protect	0	2	.	$\bar{\Delta}PPL$	2:Display and change of only "PV" and "PV/SP" parameters is allowed. [2]
Initial Setting/Communications Protect	1	2	.	$\bar{\Delta}CPL$	2:Prohibited [2]

To change operator set points: (Must be unlocked to change Alarm Value 1)

1. Press the key to move to the next parameter
2. Press the or to change the parameter
3. Press the key to return to operator screen

Operator set points					
Set Point	0	375/190	°F/°C	.	.
Alarm Value 1	0	-1	°F/°C	AL - 1	Latches Aux 1, conveyor auto start

To change operator level parameters: (Must be unlocked)

1. Press the  key for less than 1 second
2. Press the  key to move to the next parameter
3. Press the  or  to change the parameter
4. Press the  key to return to operator screen

Operator level parameters					
Process Value Input Shift	0.0	0.0	°F/°C	2N5	This is the offset setting for calibration
Hysteresis (Heating)	1.0	1.0	°F/°C	HYS	.

To change initial level parameters: (Must be unlocked)

1. Press the  key for more than 1 second to adjust initial parameters
2. Press the  key to move to the next parameter
3. Press the  or  to change the parameter
4. Press the  key for more than 1 second return to operator screen

Initial level parameters					
Input Type	5	7	.	2N-2	7:Thermocouple[J] (-100 to 850°C or -100 to 1500°F) [7]
Temperature Unit	0	1	.	d-U	°F [F]
SP Upper Limit	130	400/200	°F/°C	SL-H	.
SP Lower Limit	-20	0	°F/°C	SL-L	.
Alarm 2 Type	2	0	.	AL2	0:Alarm function OFF [0]
Alarm 3 Type	2	0	.	AL3	0:Alarm function OFF [0]
Alarm 4 Type	2	0	.	AL4	0:Alarm function OFF [0]

To change advanced level parameters: (Must be unlocked)

1. Unlock the controller
2. Press the  key for more than 1 second to adjust initial parameters
3. Press the  key until you get to parameter *AMOV*
4. Press the  or  to change *AMOV* parameter to -169

Advanced level parameters					
Alarm 1 Latch	0	1	.	AL1	Enabled [ON]
PV/SP No. 1 Display Selection	4	1	.	SPd1	1:"PV/SP/No display" [1]
PV Decimal Point Display	1	0	.	PVdP	OFF [OFF]

After programming: To lock the controller:

1. Press the  +  keys for more than 3 seconds
2. Press the  key to move to the next parameter
3. Press the  or  to change the parameter $\bar{\alpha}RPL$ and $\bar{L}LPL$ from 0 to 2
4. Press the  +  keys for more than 1 second to return to operator screen

To set the controller back to factory default settings: (Must be unlocked, see page 1)

1. Press the  key for more than 1 second to adjust initial parameters
2. Press the  key until you get to parameter $RM\bar{\alpha}'$
3. Press the  or  to change $RM\bar{\alpha}'$ parameter to -169
4. Change parameter $\bar{L}N\bar{L}L$ from $\bar{\alpha}FF$ to FRL
5. Press the  key for more than 1 second return to initial screen
6. Press the  key for more than 1 second return to operator screen

Please do not hesitate to contact Belshaw Adamatic Bakery Group for additional assistance at (206) 322-5474, (800) 578-2547 or e-mail at service@belshaw.com.

6 Diagrams and Parts Lists

See the following pages for diagrams and parts lists for your Donut Robot.

Parts Diagrams For Mark II, Mark II GP

The mechanical and electrical diagrams for Donut Robot® Mark II models with Item Numbers listed below are included in the following pages.

ABOUT ITEM NUMBERS:

All machines are identified by an Item Number. The Item Number is located on a data tag attached to the back of the control panel. You need the Item Number to identify correct parts diagrams for the fryer. When the item number is known, it should be checked off on the front cover of this manual, and also immediately below.

RECORD YOUR ITEM NUMBER BELOW:

MARK FOR YOUR FRYER	ITEM NUMBER	MODEL	PLUNGER	VOLTS	HERTZ	PHASE
<input type="checkbox"/>	22600	DONUT ROBOT® MARK II	NONE	208-240V	60 hz	1 ø
<input type="checkbox"/>	22601	DONUT ROBOT® MARK II	STAR 1 ⁹ / ₁₆ "	208-240V	60 hz	1 ø
<input type="checkbox"/>	22602	DONUT ROBOT® MARK II	PLAIN 1 ⁹ / ₁₆ "	208-240V	60 hz	1 ø
<input type="checkbox"/>	22604	DONUT ROBOT® MARK II GP	MINI 1"(x2)	208-240V	60 hz	1 ø
<input type="checkbox"/>	22618	DONUT ROBOT® MARK II	NONE	208-220V	60 hz	3 ø
<input type="checkbox"/>	22619	DONUT ROBOT® MARK II	STAR 1 ⁹ / ₁₆ "	208-220V	60 hz	3 ø
<input type="checkbox"/>	22620	DONUT ROBOT® MARK II	PLAIN 1 ⁹ / ₁₆ "	208-220V	60 hz	3 ø
<input type="checkbox"/>	22621	DONUT ROBOT® MARK II GP	MINI 1"(x2)	208-220V	60 hz	3 ø
<input type="checkbox"/>	22618-1	DONUT ROBOT® MARK II	NONE	230-240V	60 hz	3 ø
<input type="checkbox"/>	22619-1	DONUT ROBOT® MARK II	STAR 1 ⁹ / ₁₆ "	230-240V	60 hz	3 ø
<input type="checkbox"/>	22620-1	DONUT ROBOT® MARK II	PLAIN 1 ⁹ / ₁₆ "	230-240V	60 hz	3 ø
<input type="checkbox"/>	22621-1	DONUT ROBOT® MARK II GP	MINI 1"(x2)	230-240V	60 hz	3 ø
<input type="checkbox"/>	22635	DONUT ROBOT® MARK II	PLAIN 1 ¹³ / ₁₆ "	208-240V	60 hz	1 ø
<input type="checkbox"/>	22637	DONUT ROBOT® MARK II	STAR 1 ¹³ / ₁₆ "	208-240V	60 hz	1 ø

DIAGRAM: MK-2005

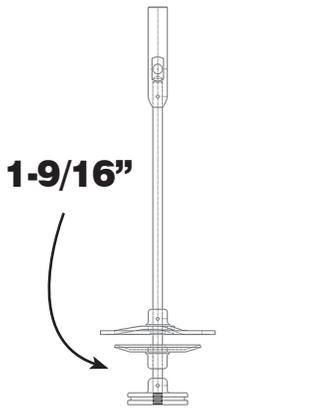
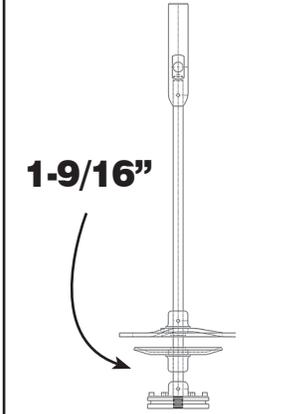
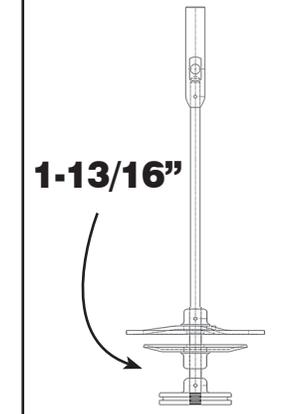
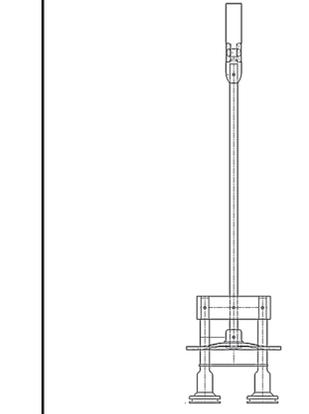
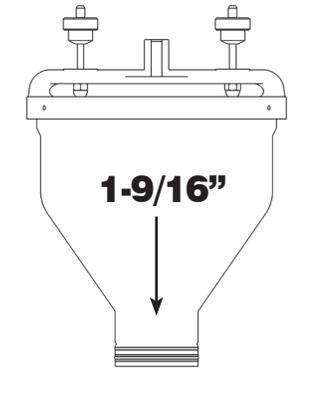
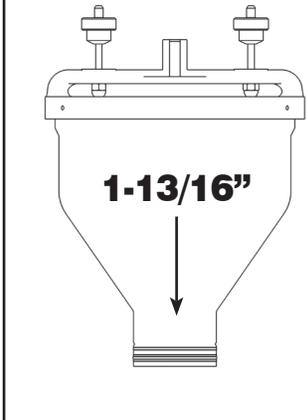
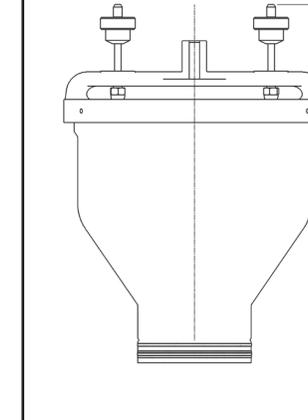
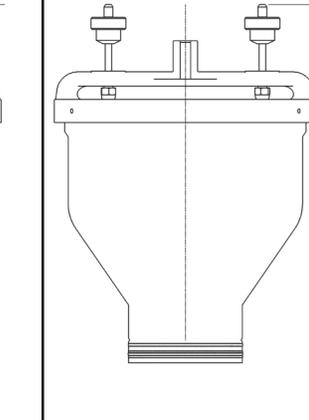
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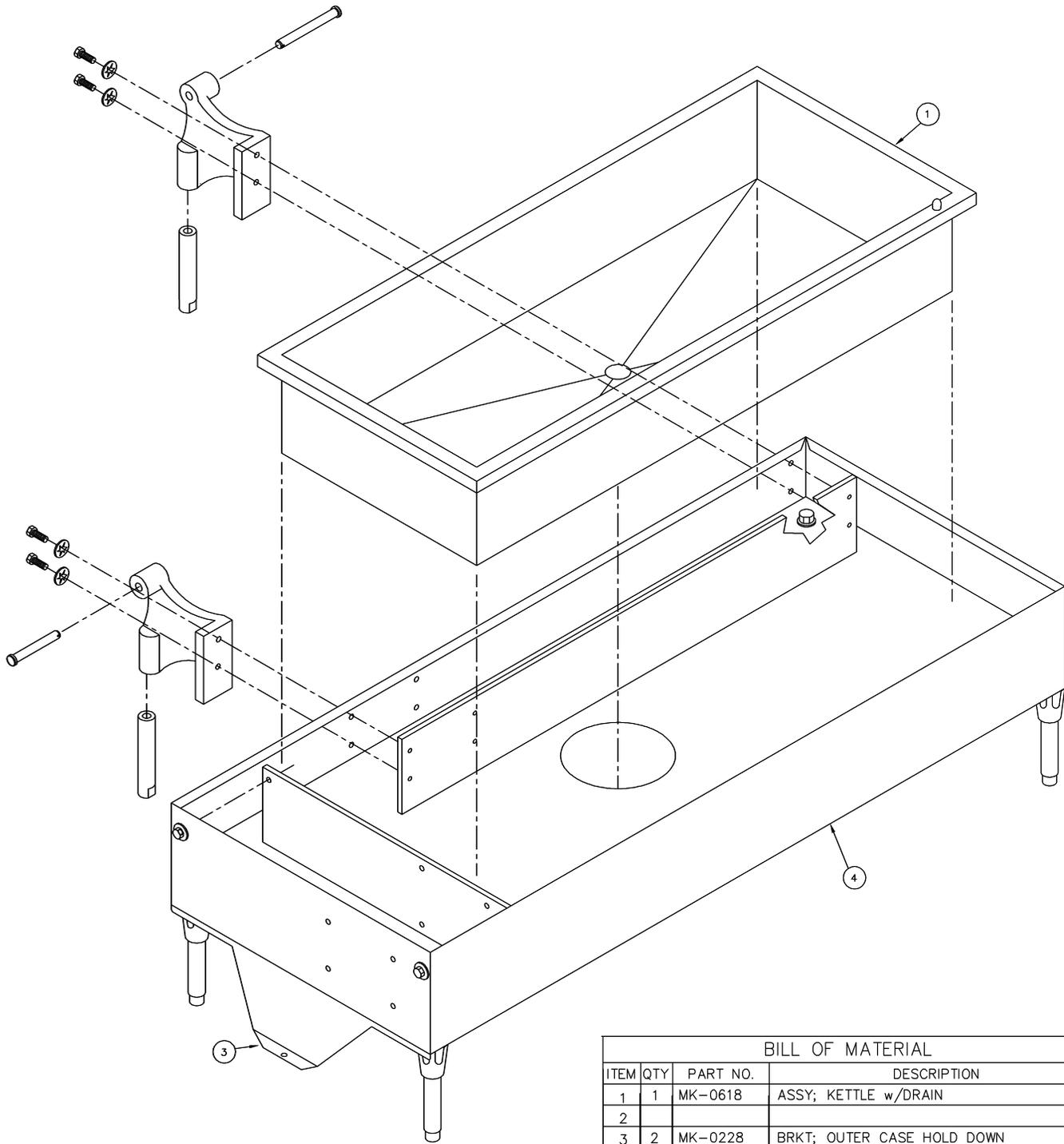
MODEL: Mark II, Mark II GP

ALL ITEM NUMBERS

TO IDENTIFY MODEL AND ITEM NUMBER, SEE
DATA TAG ON CONTROL PANEL

HOPPERS AND PLUNGERS

			
1-9/16" PLUNGER 1-9/16" diameter (40mm) Part# U-1001	1-9/16" STAR PLUNGER 1-9/16" diameter (40mm) Part# U-1001S	1-13/16" PLUNGER 1-13/16" diameter (40mm) Part# DR42-1136 <i>(limited availability)</i>	DOUBLE MINI PLUNGER 1" diameter (25.4mm) Part# MK-1023X1
			
1-9/16" HOPPER For Plain or Star Plunger 1-9/16" diameter (40mm) Part# MK-1025X1-9/16	1-13/16" HOPPER For Plain or Star Plunger 1-13/16" diameter (46mm) Part# MK-1025X1-13/16	DOUBLE MINI HOPPER For Double Mini Plunger 1" diameter (25.4mm) Part# MK-1024X1	MINI DONUT CONVERSION KIT Part# MK-1502-1 (kit) Includes: Part# MK-1024X1 (Double Mini Hopper) +Part# MK-1023X1 (Double Mini Plunger)



BILL OF MATERIAL			
ITEM	QTY	PART NO.	DESCRIPTION
1	1	MK-0618	ASSY; KETTLE w/ DRAIN
2			
3	2	MK-0228	BRKT; OUTER CASE HOLD DOWN
4	1	MK-1200	ASSY; FRYER CASE
5	1	959-0016-G	DRAIN CAP (NOT SHOWN)

USE THIS DIAGRAM ONLY FOR

DIAGRAM: MK-1202

MODEL: Mark II, Mark II GP

ALL ITEM NUMBERS

TO IDENTIFY MODEL AND ITEM NUMBER, SEE DATA TAG ON CONTROL PANEL

DIAGRAM: MK-1000-3.75

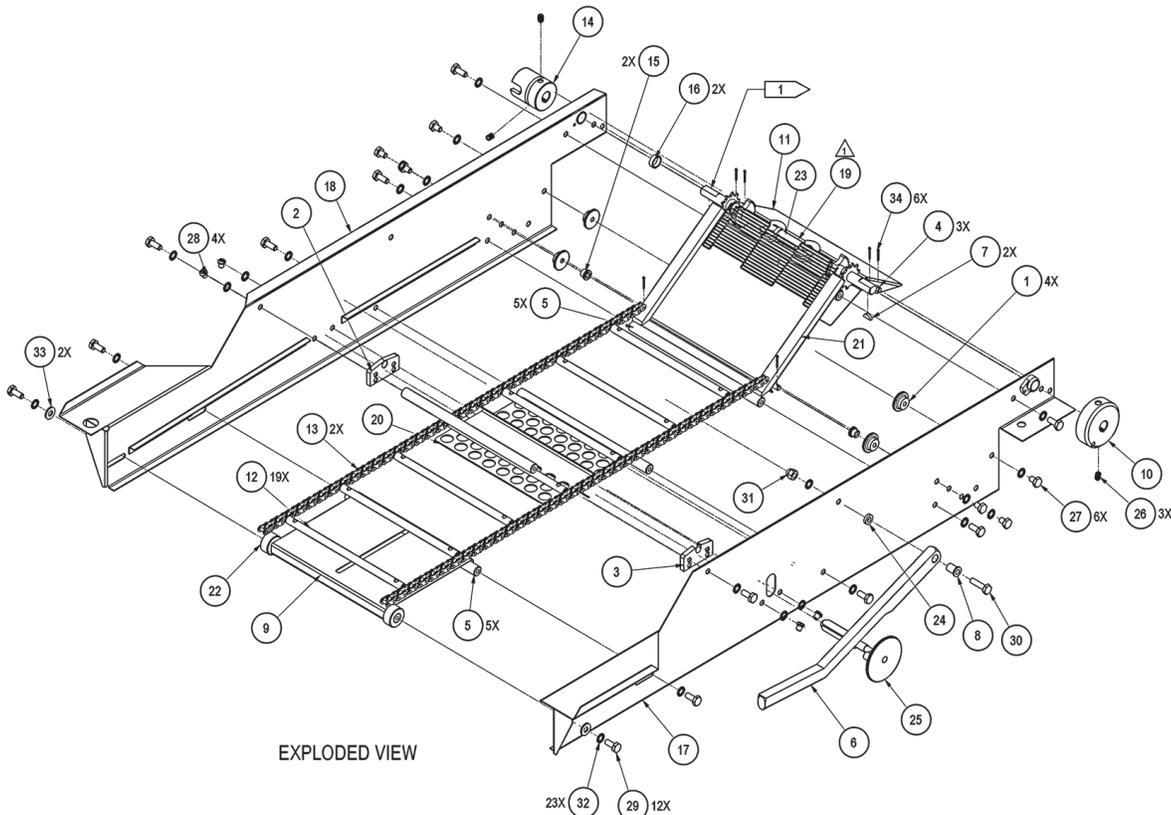
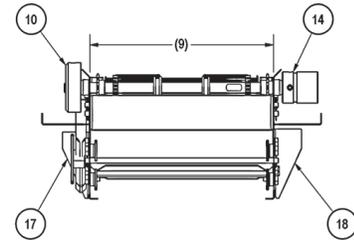
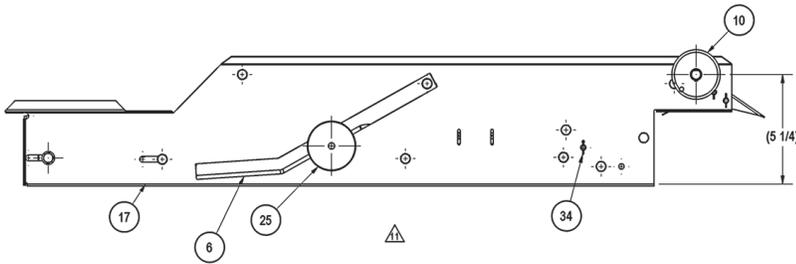
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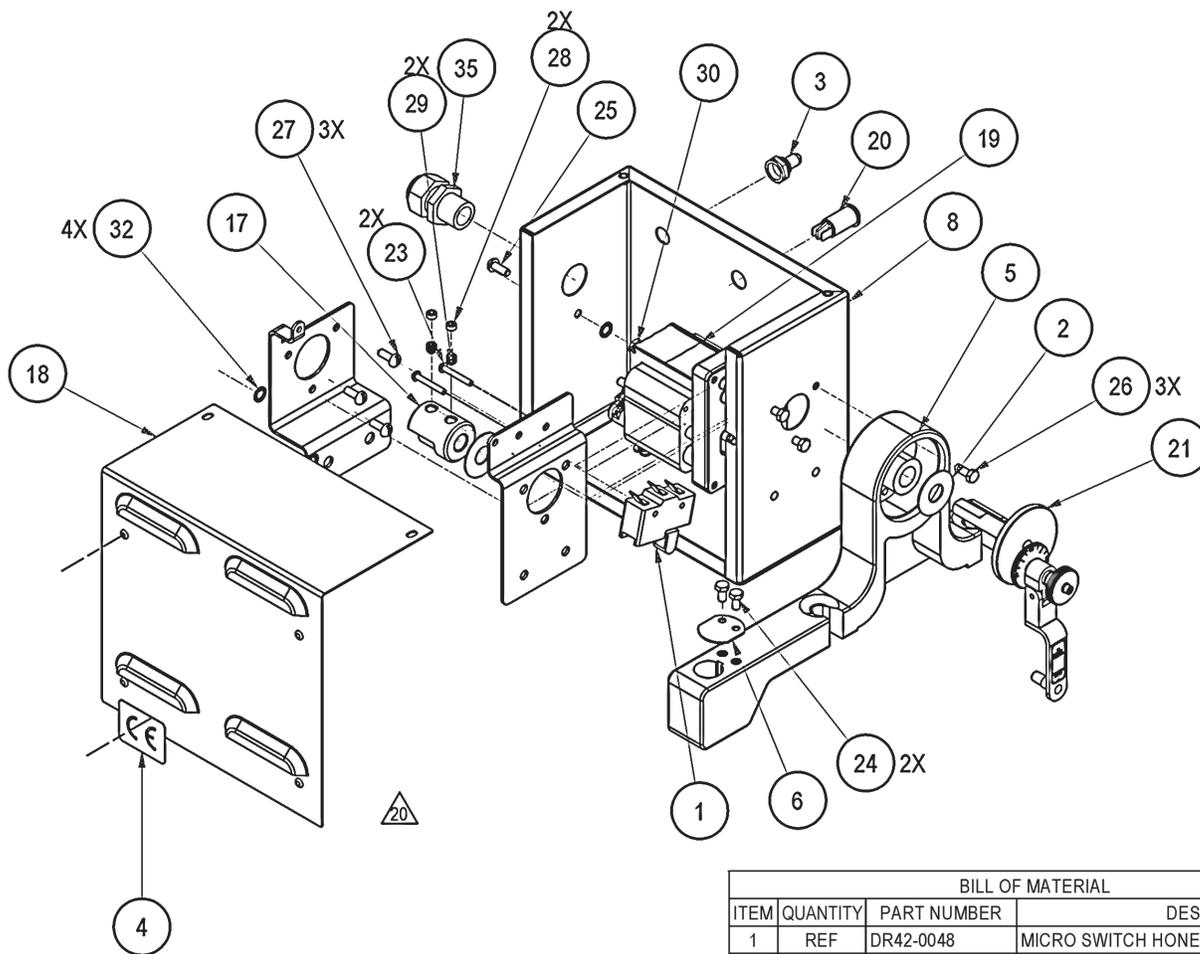
MODEL: Mark II

ITEM NUMBER: 22600, 22601, 22602, 22618, 22618-1, 22619, 22619-1, 22620, 22620-1, 22635, 22637

TO IDENTIFY MODEL AND ITEM NUMBER, SEE DATA TAG ON CONTROL PANEL

BILL OF MATERIAL			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	4	C100-0501	HOLD DOWN BUTTON
2	1	DMM-0135	TURNER SUPPORT SADDLE
3	1	DMM-0136	TURNER CAM SUPPORT SADDLE
4	3	DR42-0009	CONVEYOR SUPPORT ROD; Ø 1/4"
5	5	DR42-0010	SUPPORT SHAFT - 1/2" DIA.
6	1	DR42-0028	TURNER CAM WEIGHT
7	2	DR42-0116-1	WOODRUFF KEY, #404, GROUND
8	1	DR42-0240	TURNER WEIGHT THRUST BEARING
9	1	MK-0011	DROP PLATE
10	1	MK-0013	SWING CONNECTOR COUPLING
11	1	MK-0046	EXIT CHUTE
12	19	MK-0059	FLIGHT BAR
13	2	MK-0060	CONVEYOR CHAIN 3.75
14	1	MK-0092	CONVEYOR DRIVE COUPLING (SERIAL #20028-ON)
15	2	MK-0095	HOLD DOWN BUTTON
16	2	MK-0103	CONVEYOR DRIVE SHAFT SPACER
17	1	MK-0500	CONV SIDE PANEL ASSY FRONT
18	1	MK-0501	CONVEYOR SIDE PANEL ASSY - BACK
19	1	MK-0502-3.75	CONV DRIVE SHAFT ASSY 3.75
20	1	MK-0504	TURNER ASSEMBLY-3 3/4" SPACING
21	1	MK-0518	OUTFEED BELTING SUPPORT PLATE
22	1	MK-0521	DROP PLATE SHAFT ASSY
23	1	MKVI-0193	WIRE BELT, 7.5 X .125 X .050
24	1	U-0008	DIAL SCREW COLLAR
25	1	634-0673	ASSY, TURNER CAM
26	3	903-0957.A	1/4-20X3/8 SS SOC SETSCREW, CUP POINT
27	6	903-0961SS	SST, 1/4-20 X 0.375 HEX HEAD MACHINE SCREW
28	4	903-0962	1/4-20X3/8 PAN HD SLOT SCW ZP
29	12	903-0973SS	1/4-20X5/8 SS HEX CAP SCREW
30	1	903-1004	SST, 1/4-20 X 1.00 HEX HEAD MACHINE SCREW
31	1	903-5201.A	ACORN NUT, 1/4-20, PLATED
32	23	903-7529	1/4 SS INT TOOTH LOCK WASHER
33	2	903-7530SS	1/4 SAE SS FLAT WASHER
34	6	905-0180	COTTER PIN, 1/16X1/2 SS





CUTTERHEAD (DEPOSITOR)

DIAGRAM: MK-1044-A
 USE THIS DIAGRAM ONLY FOR
MODEL: Mark II, Mark II GP
ALL ITEM NUMBERS
 TO IDENTIFY MODEL AND ITEM NUMBER, SEE
 DATA TAG ON CONTROL PANEL

BILL OF MATERIAL			
ITEM	QUANTITY	PART NUMBER	DESCRIPTION
1	REF	DR42-0048	MICRO SWITCH HONEYWELL
2	1	DR42-0157	FIBRE WASHER
3	--	DR42-0339	MULTIFLEX SEAL (TOGGLE SWITCH)
4	--	LBL-0002	LABEL, CE
5	1	MK-0025	BEARING STRUT
6	1	MK-0071	COLUMN COVER PLATE
7	--	MK-0187	LABEL - DANGER OF ELECTRIC SHOCK
8	1	MK-0616	ASSY; CUTTER HEAD ENCLOSURE
9	-	MK-1044	TAB DWG, CUTTER HEAD
10	1	MK-1700	ELEC. COMP. CUTTER HEAD DOM. MKII & MKV
11	--	MK-1700-1	ELEC. COMP. CUTTER HEADAZ/NZ. MKII & MKV
12	--	MK-1700CE-1	ELEC. COMP. CUTTER HEAD MKIIG EXP.
13	--	MK-1700DMM	ELEC. COMP. CUTTER HEAD MKI DOM/EXP/CE
14	--	MK-1704	ELEC. COMP. CUTTER HEADAZ/NZ. MKII & MKV
15	1	MK-7007	MOTOR MOUNTING PLATE
16	1	MK-7008	MOTOR MOUNTING PLATE
17	1	MKV-0103	CAM
18	1	MKV-1018	ASSEMBLY ENCLOSURE COVER
19	REF	MTR-0010	MOTOR 115V, 50/60, 50 RPM MERKLE-KORFF
20	REF	PLT-0002	PILOT LIGHT, 120V CE
21	1	U-1013	POWER CRANK ASSY
22	1	903-0302.A	SCREW,MS,PN,PH,6-32X1/4 SS
23	2	903-0380	6-32X1 SLT RND MS SS
24	2	903-0501SS	10-24 X 3/8 SS HEX HD MACH SCREW
25	1	903-0504	10-24 X 3/8 ONE WAY RH MACH SCW
26	3	903-0519SS	10-24X1/2 HEX HEAD M/S SS
27	3	903-0710	10-32X1/2 SS SLOT RD HD M/S
28	2	903-0950	1/4-20 UNC x 0.1875 SET SCREW, FLAT POINT
29	2	903-0951.CP	1/4-20X1/4 SKT SET SCR CP LP
30	1	903-5100	10-24, HEX NUT
31	2	903-5201SS	NYLOCK NUT, SS, 1/4-20 UNC
32	4	903-7514	#10 SS INTERNAL TOOTH LOCKWASR
33	1	904-0520	LABEL, CUTTER HD KIT, DOM, MK
34	--	904-0521	LABEL, CUTTER HD KIT, EXP/CE, MK
35	1	992-0052	CORD CLAMP, NYLON, .170-.450

DIAGRAM: MK-1203TAB (MK-1203A & MK-1203E)

USE THIS DIAGRAM ONLY FOR

MODEL: Mark II, Mark II GP
ALL ITEM NUMBERS

TO IDENTIFY MODEL AND ITEM NUMBER,
 SEE DATA TAG ON CONTROL PANEL

ITEM	PART NUMBER	DESCRIPTION
1	DR42-0240	TURNER WEIGHT THRUST BEARING
2	DR42-0511	SWING CONNECTING ROD ASSEMBLY (MKII, MKIV)
3	MK-0047	COLUMN MOUNTING BRACKET ASSEMBLY
4	MK-0522	SWING COLUMN ASSEMBLY
5	MK-1044A	CUTTER HEAD ASSY DOMESTIC
6	MK-1044B	CUTTER HEAD ASSY EXPORT/CE
7	MKV-0500	SWING CONNECTING ROD ASSY (MKV, MKVI, MKVID)
8	MKIIIG-0121	BRACKET - BEARING ASSEMBLY
9	U-0008	DIAL SCREW COLLAR
10	903-1007	SST, 1/4-20 X 1.25 HEX HEAD MACHINE SCREW
11	903-7529	WASHER, INTERNAL TOOTH LOCK, 1/4 SST
12	903-0979	SST, 1/4-20 X 0.75 HEX HEAD MACHINE SCREW

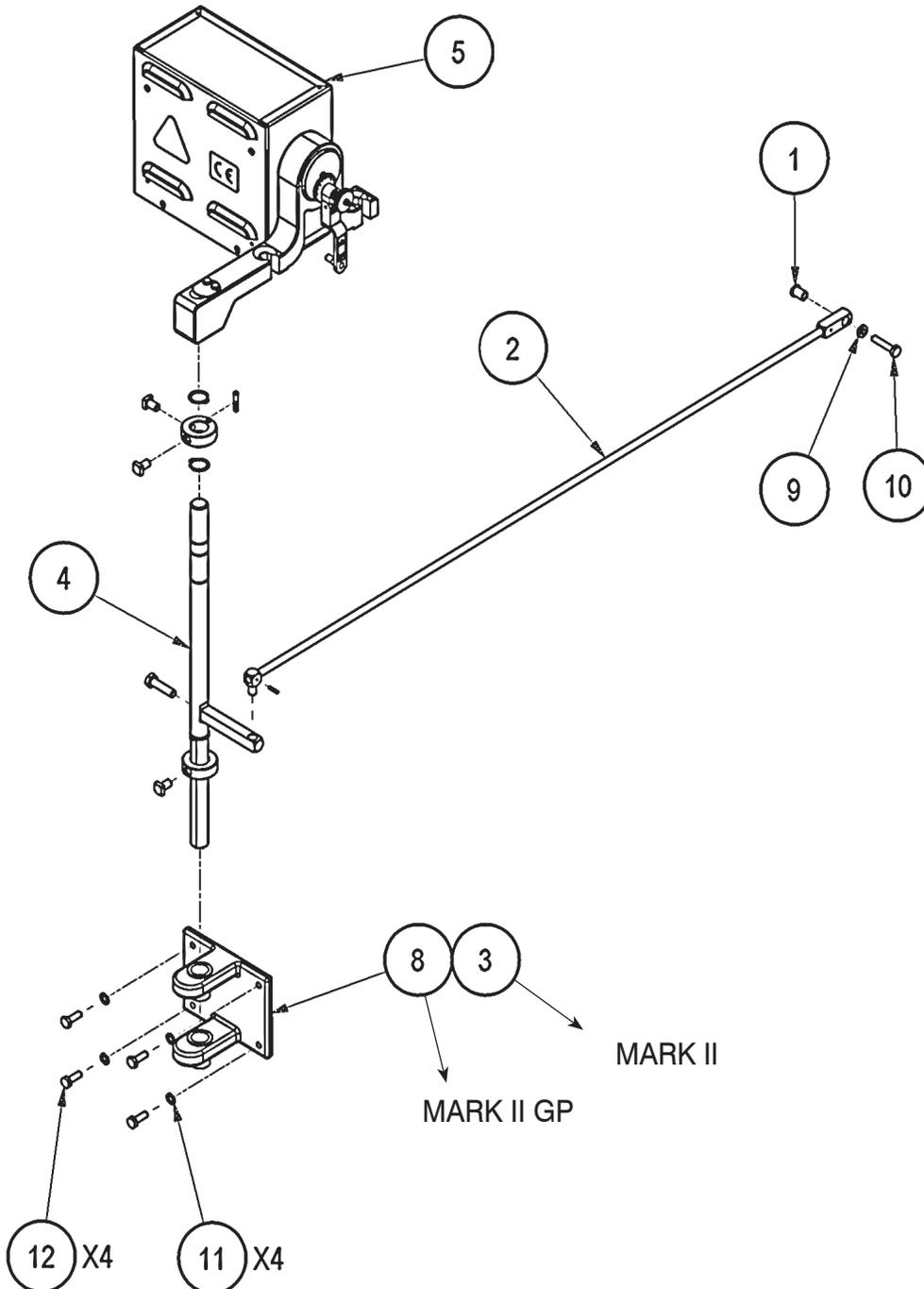
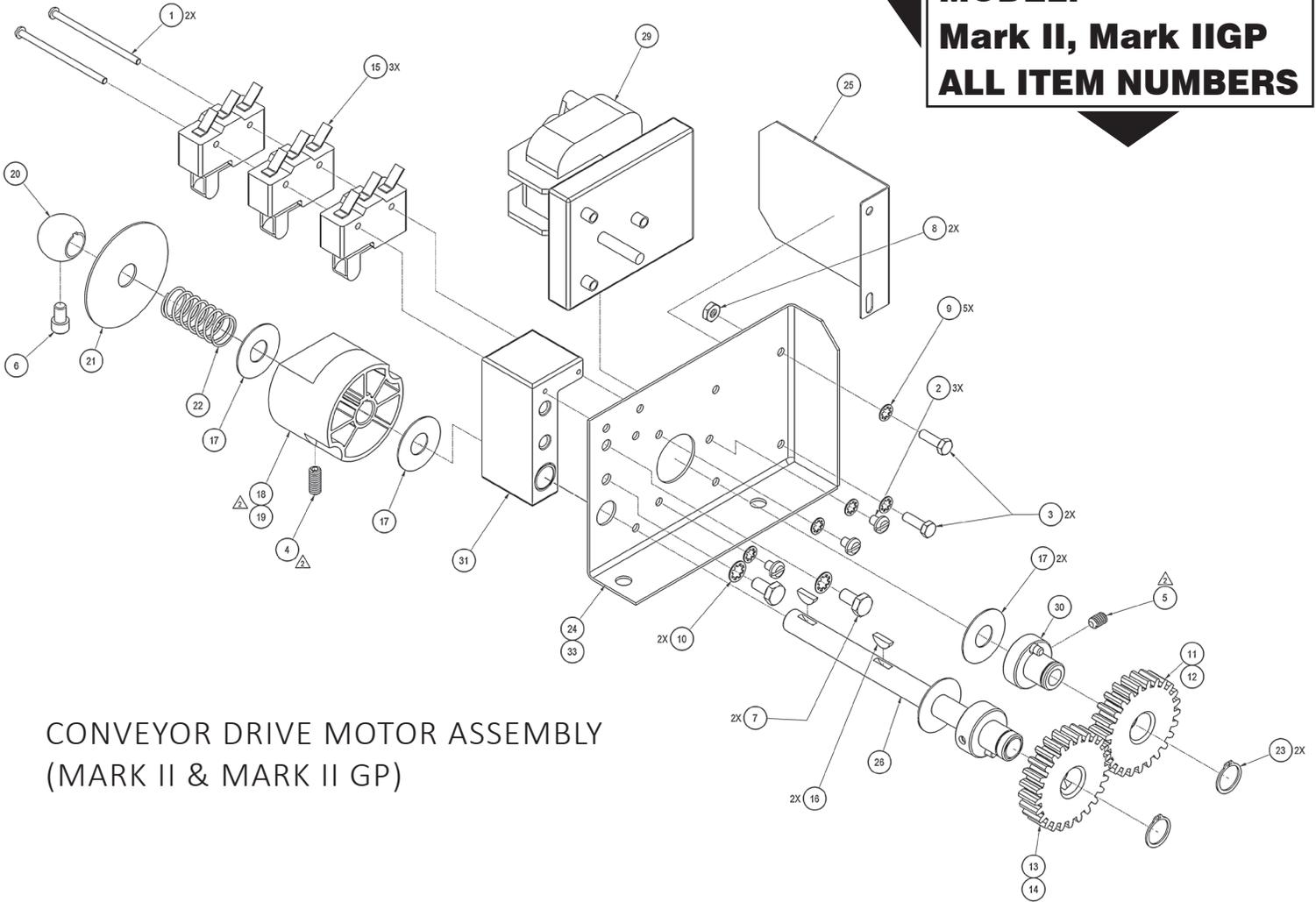
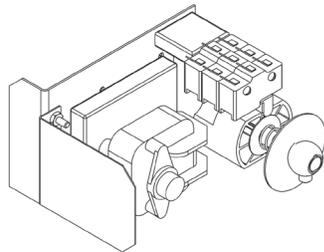
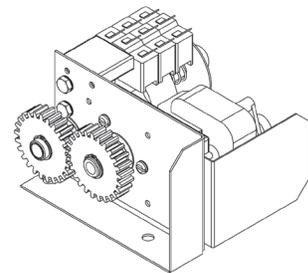


DIAGRAM: MKVI-1120TAB R02
 USE THIS DIAGRAM FOR

MODEL:
Mark II, Mark IIGP
ALL ITEM NUMBERS



CONVEYOR DRIVE MOTOR ASSEMBLY
 (MARK II & MARK II GP)



ITEM	PART NUMBER	MARK V	MARK VGP	DESCRIPTION
1	903-0365	2	2	6-32X2-1/2 SS SLOT ROUND M/S
2	903-0492	3	3	10-24X1/4 SS PAN HD SLOT M/S
3	903-0528	2	2	SST, #10-24 X 0.625 HEX HEAD MACHINE SCREW
4	903-0930	1	1	SCREW, SET, SC, CUP, 1/4-20X5/8 STL
5	903-0957.LRP	1	1	1/4-20X3/8 SS SOC SETSCREW, CUP POINT
6	903-0963	1	1	1/4-20X3/8 SS SKT HD CAP SCREW
7	903-0970SS	2	2	SST, 1/4-20 X 0.5 HEX HEAD MACHINE SCREW
8	903-5105.A	2	2	10-24 SS MACHINE SCREW NUT
9	903-7514	5	5	#10 SS INT TOOTH LOCK WASHER
10	903-7529	2	2	1/4 SS INT TOOTH LOCK WASHER
11	DR42-0045-13S	--	1	CRS CHANGE GEAR 13T 5/8 HOLE
12	DR42-0045-20S	1	--	CRS CHANGE GEAR 20T 5/8 HOLE
13	DR42-0045-30S	1	--	CRS CHANGE GEAR 30T 5/8 HOLE
14	DR42-0045-37S	--	1	CRS CHANGE GEAR 37T 5/8 HOLE
15	DR42-0048	REF	REF	SWITCH, MICRO
16	DR42-0116-1	2	2	WOODRUFF KEY, #404, GROUND
17	DR42-0157	4	4	FIBRE WASHER
18	MK-0019	1	1	SIGNAL CAM, 2 SIGNAL
19	MK-0019R	--	--	SIGNAL CAM, 2 SIGNAL RVS
20	MK-0045	1	1	DRIVE COUPLING
21	MK-0087	1	1	SEALING PLATE
22	MK-0088	1	1	SEALING PLATE PRESSURE SPRING
23	MK-0105	2	2	EXTERNAL SNAP RING 5/8
24	MK-0205	1	1	CONVEYOR DRIVE MOTOR MTG PLATE
25	MK-0238	1	1	FAN STOP GUARD
26	MK-0607	1	1	MAIN DRIVE SHAFT ASSEMBLY
27	MK-1720 (NOT SHOWN)	1	1	ELEC MK CONV DRV FWD STD
28	MK-1722 (NOT SHOWN)	--	--	ELEC MK CONV DRV REV STD
29	MKDW-0009	REF	REF	BRAKE MTR 115 50/80 8RPM CE
30	MKDW-0508	1	1	CHANGE GEAR COLLAR ASSEMBLY
31	MKVI-0019	1	1	DRIVE SHAFT BEARING BLOCK
32	MKVID-0012	--	--	DRIVE SHAFT BEARING BLOCK REVERSE FLOW
33	MKVID-0013	--	--	CONVEYOR DRIVE MOUNTING PLATE REVERSE FLOW

HEATERHEAD COMPONENTS
FOR ITEM NUMBERS 22618-1, 22619-1, 22620-1 AND 22621-1 ONLY
(230/240V-60-3 MODELS)

BOM FOR: MK-1632-1 and MK-1632GP-1 (COMBINED)

USE THIS DIAGRAM ONLY FOR

MODEL: Mark II, Mark II GP

ITEM NUMBER:

22618-1, 22619-1, 22620-1,

22621-1

TO IDENTIFY MODEL AND ITEM NUMBER, SEE
DATA TAG ON CONTROL PANEL

BILL OF MATERIAL

PART NUMBER MK-1632-1 and MK-1632GP-1

Quantity	Component Part	Component Name
1	158	LABEL; DATA PLATE
1	634-0234	KNOB TYCO/ALCOSWITCH
1	904-0035	LABEL,ETL LISTED,NSF STD 4
1	904-0040	LABEL; ETL LISTED, UL STD 197 STD C22.2
1	992-0023	CORD CLAMP, AL, .500-.625", 1" NPT, BRN
1	DR42-0216	HTR HD ROTOCOOLER OUTLET LABEL
1	FM200-0066	LABEL,TEMP CUTOUT
1	FM200-0105	LABEL ON-OFF O NO HOLE
1	MDD-0459	LABEL,WARNING HAZ VOLTAGE
1	MK-0189	LABEL (FOR MARK II, ITEM# 22619-1 AND 22620-1)
1	MK-0166	LABEL (FOR MARK II GP ITEM# 22621-1)
1	MK-0270D	BREAKER MOUNTING GUARD DOMES
1	MK-0272	HEATER HEAD END CAP LH MAZAK
1	MK-0273	HEATER HEAD END CAP RH MAZAK
1	MK-0275 R02	BULB CLAMP TOP
1	MK-0276	CAPILLARY TUBE COVER
1	MK-0730-3	HEATER HEAD BOTTOM SUB 3PH
1	MK-1736-1	ELEC MKII 208-240/50/60/3 DOM WITH OMRON DIGITAL TEMP CONTROLS
1	MK-6001 R01	BULB BRACKET CLAMP, UNIVERSAL FOR USE WITH #TCPL-0005 & OMRON CNTLR
1	MK-7003	HEATER HEAD ENCLOSURE HEATER HEAD FOR USE W/ OMRON CONTROLLER
1	MK-9002	LABEL; STARTUP PROCEDURE LABEL FOR MK UNITS WITH OMRON TEMP CNTRL
1	MKVI-1120 R06	CONV DRIVE ASSY DOM/EXP (FOR MARK II, ITEM# 22619-1 AND 22620-1)
1	MKVI-1120GP R04	CONV DRIVE ASSY GP MKVI (FOR MARK II GP ITEM# 22621-1)
2	903-0245X3/8	4-40X3/8 SS SLOT RD HD M/S
2	903-0504	10-24X3/8 ONE WAY RH MACH SCRW
2	903-0625	10-24X1-1/2 RD HD SLOT M/S SS
2	903-0961SS	1/4-20X3/8 SS HEX CAP SCREW
2	903-7502	#6 SS INTERNAL TH LOCKWASHER
2	903-7529	1/4 SS INT TOOTH LOCK WASHER
2	903-7530SS	1/4 SAE SS FLAT WASHER
3	903-0604	10-24X1SS SLOT RND M/S
3	DR42-0339	MULTIFLEX SEAL (TOGGLE SWITCH) ARCOLECTRIC
4	903-0302	6-32X1/4 SS SLOT PAN M/S
4	903-0515	10-24X3/8 SS SLOT PAN M/S
4	903-5105.A	10-24 SS MACHINE SCREW NUT
6	MK-0282-2	ELEM TERMINAL INSULATOR,3 PH
11	903-7514	#10 SS INTERNAL TOOTH LOCKWASR
12	903-7513	#10 FLAT WASHER SAE SS
17	903-0501SS	10-24X3/8 SS HEX MACH SCREW

DIAGRAM: MK-1613TAB

USE THIS DIAGRAM ONLY FOR

MODEL:

Mark II, Mark II GP

ITEM NUMBER:

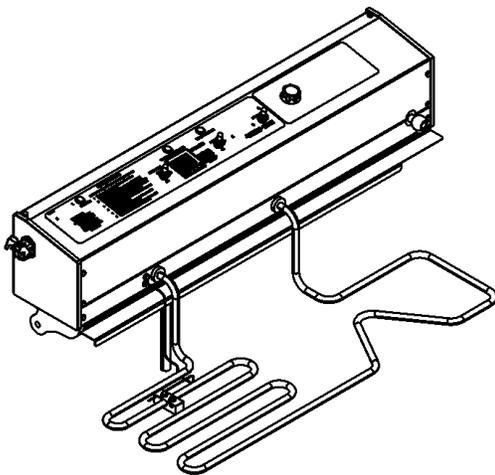
**22600, 22601, 22602,
22604, 22635, 22637**

TO IDENTIFY MODEL AND ITEM
NUMBER, SEE DATA TAG ON
CONTROL PANEL

NOTE:

**PARTS LIST REFERS TO
DIAGRAMS ON PAGES 11-13**

HEATERHEAD COMPONENTS
(PAGE 10-13)



BILL OF MATERIAL

ITEM	MK-1613 QTY	MK-1613GP QTY	PART NUMBER	DESCRIPTION
1	1	1	0158	DATA PLATE
2	1	1	634-0234	KNOB
3	(REF)	(REF)	(634-0383)	TERMINAL BLOCK
4	(REF)	(REF)	(CBR-0001A)	BREAKER 5A
5	(REF)	(REF)	(CTR-0002)	CONTACTOR, 120V, 40A, 2 POLE
6	(REF)	(REF)	(DR42-0001D)	HTR ELEM 200V/3800W, 236V/5320W
7	(REF)	(REF)	(DR42-0050)	TOGGLE SWITCH SPST
8	1	1	DR42-0216	HEATER HEAD ROTO COOLER OUTLET LABEL
9	3	3	DR42-0339	MULTIFLEX SEAL (TOGGLE SWITCH)
10	(REF)	(REF)	(DR42-0612)	POWER CORD ASSY, 4 WIRE
11	(REF)	(REF)	(FM200-0065M)	HI LIMIT, PANEL MOUNT
12	1	1	FM200-0066	LABEL; TEMPERATURE CUT OUT
13	1	1	FM200-0105	LABEL; ON/OFF (NO HOLE)
14	1	1	MDD-0459	LABEL; WARNING; HAZ VOLTAGE
15	(REF)	(REF)	(MK-0054)	TIMER, 60 SEC
16	(REF)	(REF)	(MK-0066)	TRANSIENT VOLTAGE SUPPRESSOR
17	--	1	MK-0166	LABEL-MKII GP
18	1	--	MK-0189	LABEL, FRY TIME
19	1	1	MK-0270D	BREAKER MOUNTING GUARD, DOMESTIC
20	1	1	MK-0272	HEATER HEAD END CAP L.H.
21	1	1	MK-0273	HEATER HEAD END CAP R.H.
22	1	1	MK-0275	BULB CLAMP TOP
23	1	1	MK-0276	CAPILLARY TUBE COVER
24	2	2	MK-0282-1	INSULATOR, ELEMENT TERMINAL
25	1	1	MK-0730-1	HEATER HEAD BOTTOM SUB, 1 PHASE
26	(REF)	(REF)	(MK-0790)	POTENTIOMETER ASSEMBLY
27	1	1	MK-1731-1	ELEC MKII 208-240 50/60 1 DOM (NOT SHOWN)
28	1	1	MK-6001	BULB BRACKET CLAMP, UNIVERSAL
29	1	1	MK-7003	HEATER HEAD ENCLOSURE
30	1	1	MK-9002	LABEL, FRY TIME
31	1	--	MKVI-1120	CONV DRIVE ASSY DOM/EXP
32	--	1	MKVI-1120GP	CONV DRIVE ASSY GP. MKVI
33	(REF)	(REF)	(PLT-0002)	PILOT LIGHT, 120V CE
34	(REF)	(REF)	(SKT-0003)	OUTLET, HEATER HEAD
35	(REF)	(REF)	(SKT-0700)	SOCKET
36	(REF)	(REF)	(SWT-0042)	SWITCH, TOGGLE, SPDT, ON/OFF/ON
37	(REF)	(REF)	(TCPL-0005)	THERMOCOUPLE, TYPE J, .063X18
38	(REF)	(REF)	(TCPL-0005-TOOL)	TOOL; THERMOCOUPLE SHAPE/FORMING (NOT SHOWN)
39	(REF)	(REF)	(TDR-0013)	BUZZER 40 SEC DELAY
40	(REF)	(REF)	(TDR-0014)	SOLID STATE OFF DELAY TIMER
41	(REF)	(REF)	(TJ-0184D-3)	TEMP CTRL; 100-240 VAC; MKII F
42	(REF)	(REF)	(TM200-0120)	TOGGLE SWITCH, SPDT ON-ON
43	2	2	903-0245X3/8	4-40X3/8 SS SLOT RD HD M/S
44	4	4	903-0302	6-32X1/4 SS SLOT PAN M/S
45	17	17	903-0501SS	10-24 X 3/8 SS HEX HD MACH SCREW
46	2	2	903-0504	10-24 X 3/8 ONE WAY RH MACH SCW
47	4	4	903-0515	10-24X3/8 SS SLOT PAN M/S
48	3	3	903-0604	10-24 X 1 SS SLOT RND M/S
49	2	2	903-0625	10-24 X 1.5 SS SLOT RND M/S
50	2	2	903-0961SS	SST, 1/4-20 X 0.375 HEX HEAD MACHINE SCREW
51	4	4	903-5105.A	10-24 SS MACHINE SCREW NUT
52	2	2	903-5320	NUT, 5/8-11 HEX SS
53	2	2	903-7502	WASHER, INTERNAL TOOTH LOCK, #6 SST
54	12	12	903-7513	#10 SS FLAT WASHER
55	11	11	903-7514	#10 SS INT TOOTH LOCK WASHER
56	2	2	903-7529	1/4 SS INT TOOTH LOCK WASHER
57	2	2	903-7530SS	1/4 SAE SS FLAT WASHER
58	2	2	903-7600	5/8 SST FLAT WASHER, SAE
59	1	1	904-0035	LABEL; ETL LISTED; NSF STD 4
60	1	1	904-0040	LABEL; ETL LISTED; UL STD 197
61	1	1	992-0024	SHC-1041 CORD CLAMP, .625-.750

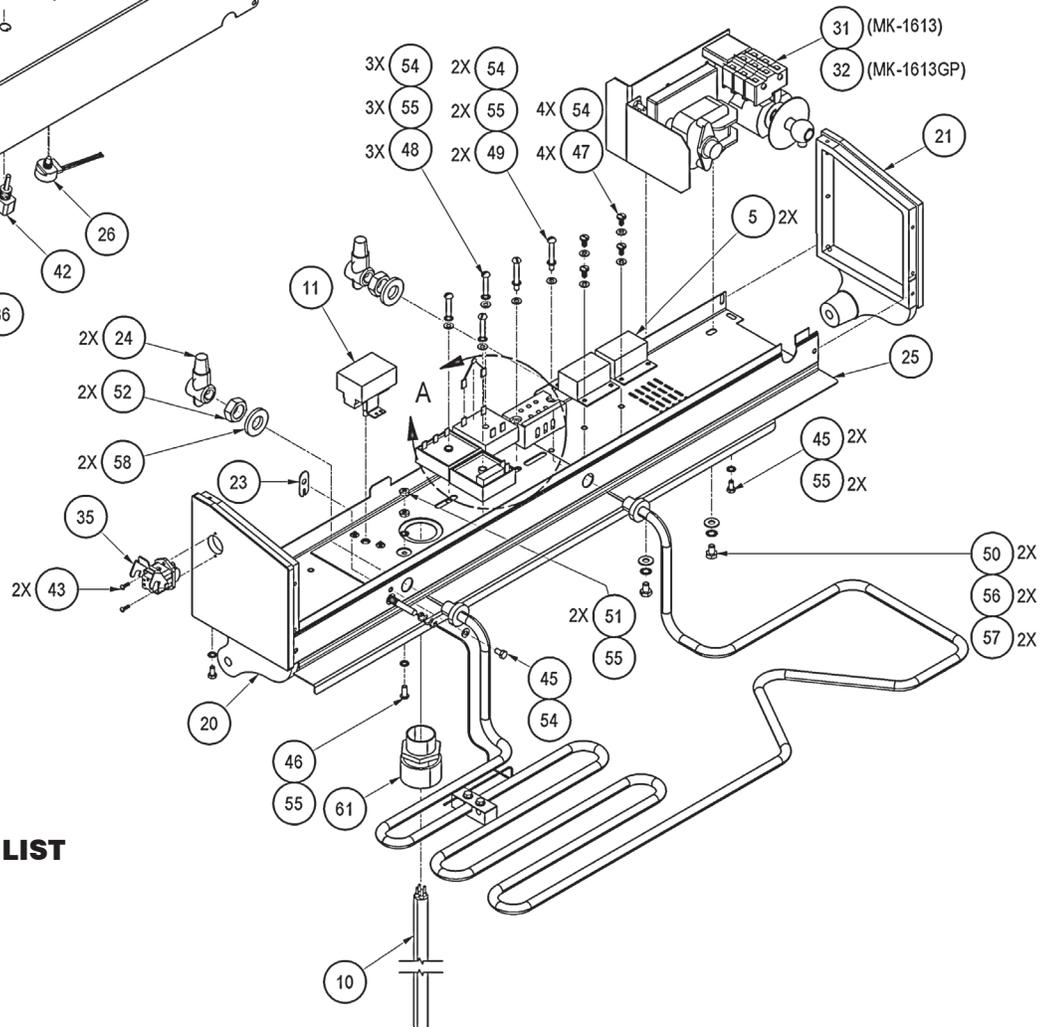
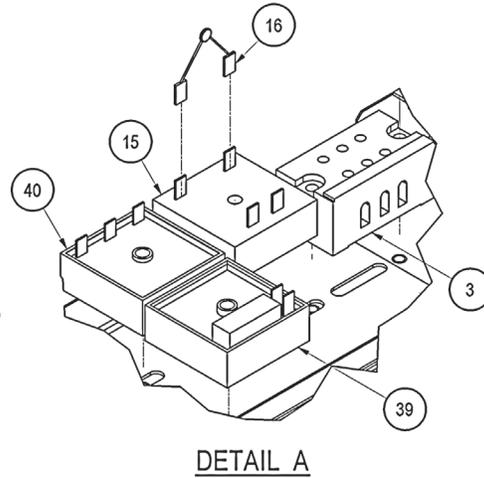
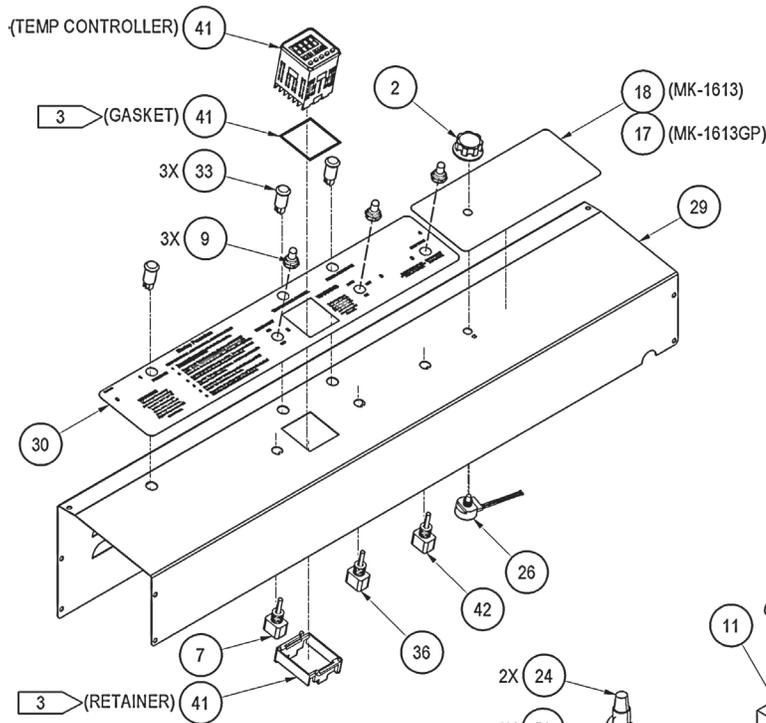
DIAGRAM: MK-1613TAB

USE THIS DIAGRAM ONLY FOR

MODEL: Mark II, Mark II GP
ITEM NUMBER: 22600, 22601,
22602, 22604, 22635, 22637

TO IDENTIFY MODEL AND ITEM NUMBER, SEE DATA
TAG ON CONTROL PANEL

SEE PAGE 10 FOR PARTS LIST



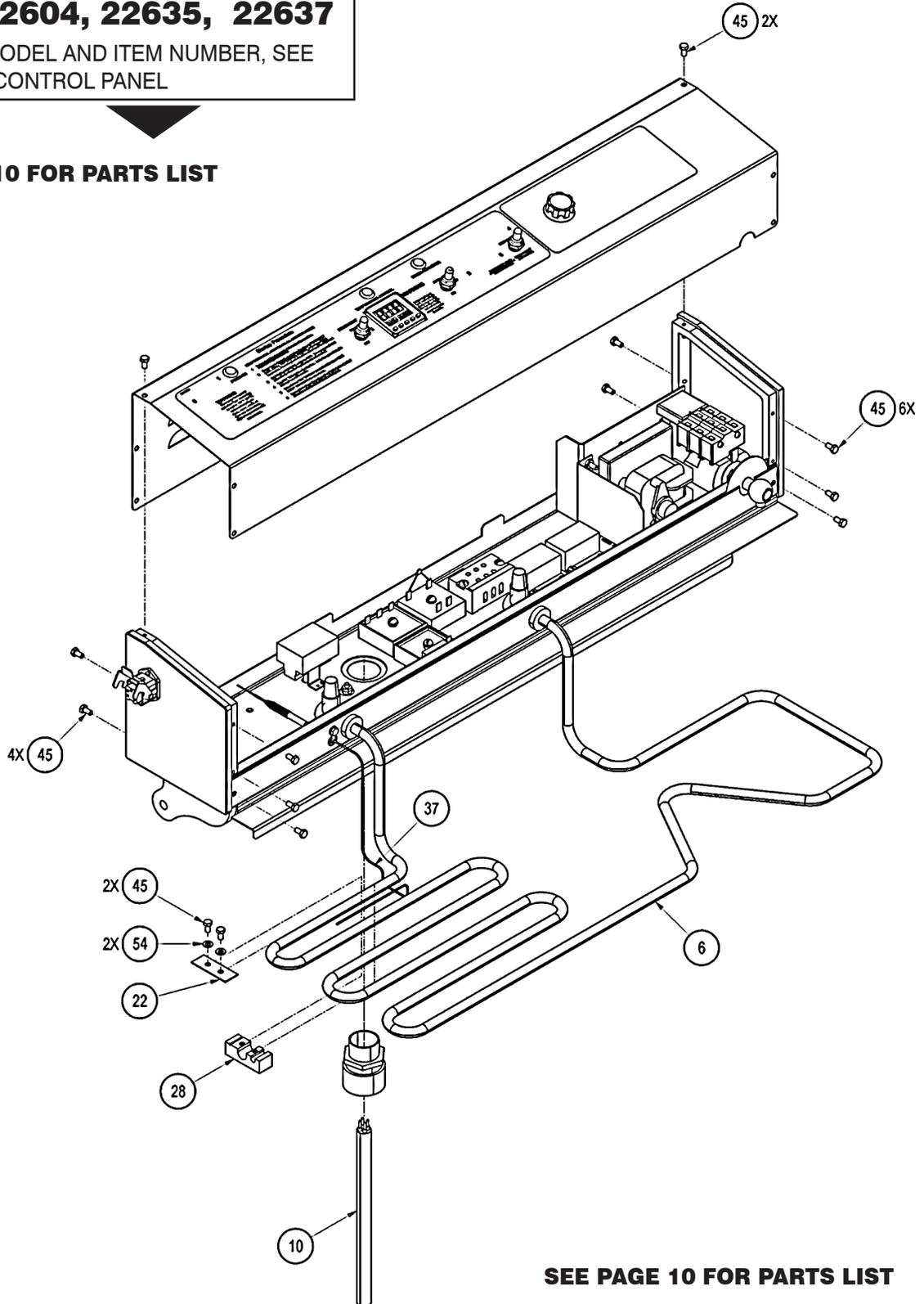
SEE PAGE 10 FOR PARTS LIST

DIAGRAM: MK-1613TAB
USE THIS DIAGRAM ONLY FOR

MODEL: Mark II
ITEM NUMBER: 22600, 22601,
22602, 22604, 22635, 22637

TO IDENTIFY MODEL AND ITEM NUMBER, SEE
DATA TAG ON CONTROL PANEL

SEE PAGE 10 FOR PARTS LIST



SEE PAGE 10 FOR PARTS LIST

DIAGRAM: MK-1613TAB

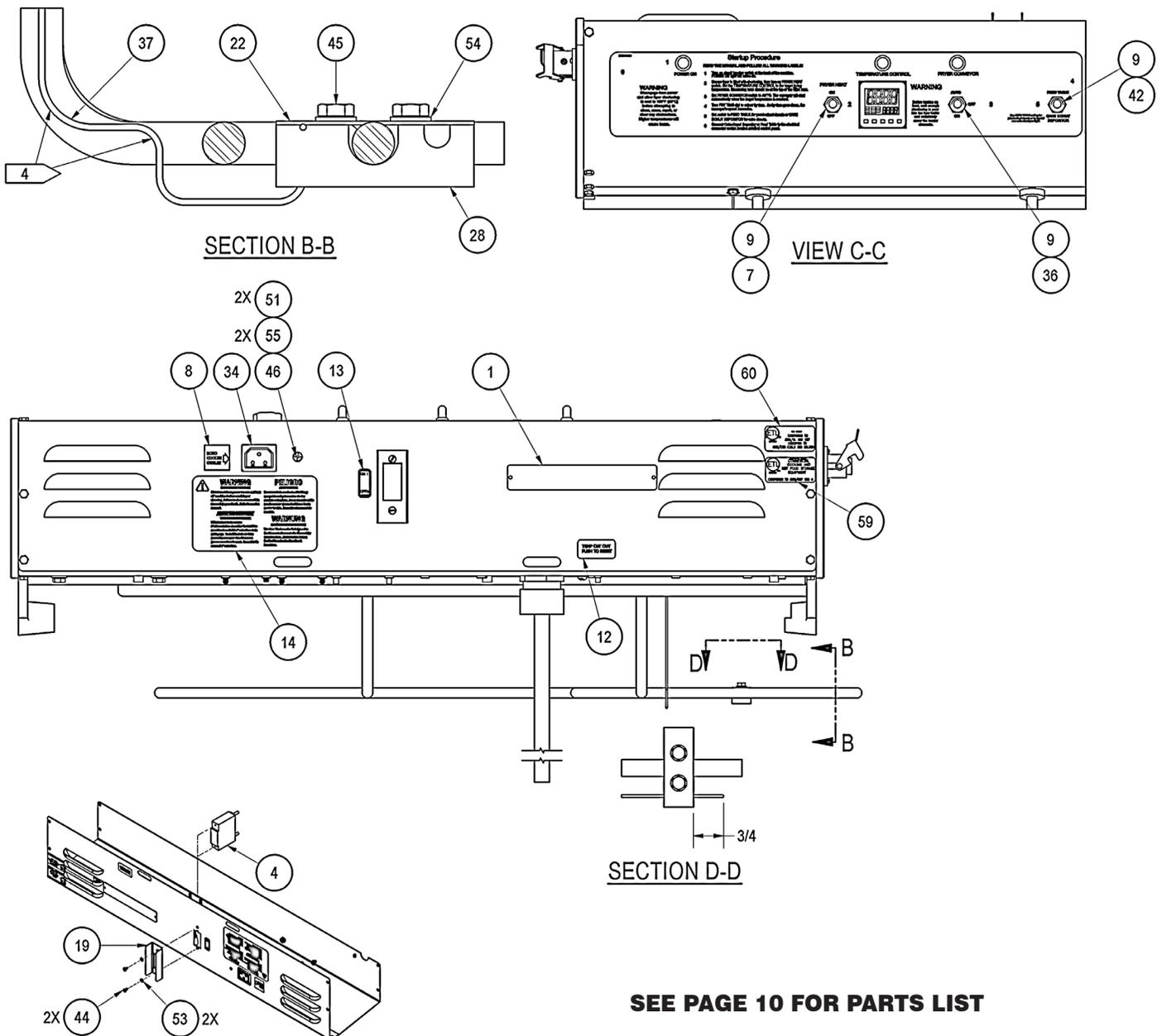
USE THIS DIAGRAM ONLY FOR

MODEL: Mark II

**ITEM NUMBER: 22600, 22601, 22602,
22604, 22635, 22637**

TO IDENTIFY MODEL AND ITEM NUMBER, SEE DATA TAG ON
CONTROL PANEL

SEE PAGE 10 FOR PARTS LIST



SEE PAGE 10 FOR PARTS LIST

DIAGRAM: MK-1632TAB

USE THIS DIAGRAM ONLY FOR

MODEL:

Mark II, Mark II GP

ITEM NUMBER:

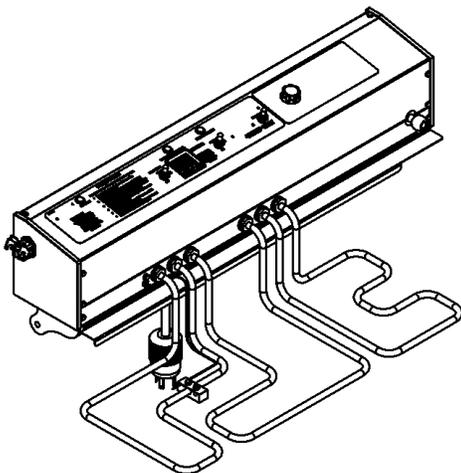
**22618, 22619, 22620,
22621**

TO IDENTIFY MODEL AND ITEM
NUMBER, SEE DATA TAG ON
CONTROL PANEL

NOTE:

**PARTS LIST REFERS TO
DIAGRAMS ON PAGES 15-17**

HEATERHEAD
COMPONENTS
(PAGE 14-17)



BILL OF MATERIAL				
ITEM	MK-1632 QTY	MK-1632GP QTY	PART NUMBER	DESCRIPTION
1	1	1	0158	DATA PLATE
2	1	1	634-0234	KNOB
3	(REF)	(REF)	(634-0383)	TERMINAL BLOCK
4	(REF)	(REF)	(CBR-0001A)	BREAKER 5A
5	(REF)	(REF)	(CTR-0030)	CONTACTOR, 110V, 50A, 3 POLE
6	(REF)	(REF)	(DR42-0050)	TOGGLE SWITCH SPST
7	1	1	DR42-0216	HEATER HEAD ROTO COOLER OUTLET LABEL
8	3	3	DR42-0339	MULTIFLEX SEAL (TOGGLE SWITCH)
9	(REF)	(REF)	(DR42-1098-1)	INFD ELEM 200V/1320W,240V/1900
10	(REF)	(REF)	(DR42-1098-2)	CTR ELEM 200V/1320W,240V/1900
11	(REF)	(REF)	(DR42-1098-3)	OUTFD ELEM 200V/1320W,240V/1900
12	(REF)	(REF)	(FM200-0065M)	HI LIMIT, PANEL MOUNT
13	1	1	FM200-0066	LABEL; TEMPERATURE CUT OUT
14	1	1	FM200-0105	LABEL; ON/OFF (NO HOLE)
15	1	1	MDD-0459	LABEL; WARNING; HAZ VOLTAGE
16	(REF)	(REF)	(MK-0054)	TIMER, 60 SEC
17	(REF)	(REF)	(MK-0066)	TRANSIENT VOLTAGE SUPPRESSOR
18	--	1	MK-0166	LABEL-MKII GP
19	1	--	MK-0189	LABEL, FRY TIME
20	1	1	MK-0270D	BREAKER MOUNTING GUARD, DOMESTIC
21	1	1	MK-0272	HEATER HEAD END CAP L.H.
22	1	1	MK-0273	HEATER HEAD END CAP R.H.
23	1	1	MK-0275	BULB CLAMP TOP
24	1	1	MK-0276	CAPILLARY TUBE COVER
25	6	6	MK-0282-2	INSULATOR, ELEMENT TERMINAL, 3PH
26	1	1	MK-0730-3	HEATER HEAD BOTTOM SUB, 3 PH
27	(REF)	(REF)	(MK-0790)	POTENTIOMETER ASSEMBLY
28	1	1	MK-1736-1	ELEC MKII 208/240 50/60 3 DOM (NOT SHOWN)
29	1	1	MK-6001	BULB BRACKET CLAMP, UNIVERSAL
30	1	1	MK-7003	HEATER HEAD ENCLOSURE
31	1	1	MK-9002	LABEL, FRY TIME
32	(REF)	(REF)	(MKV-0515)	POWER CORD
33	1	--	MKVI-1120	CONV DRIVE ASSY DOM/EXP
34	--	1	MKVI-1120GP	CONV DRIVE ASSY GP. MKVI
35	(REF)	(REF)	(PLT-0002)	PILOT LIGHT, 120V CE
36	(REF)	(REF)	(SKT-0003)	OUTLET, HEATER HEAD
37	(REF)	(REF)	(SKT-0700)	SOCKET
38	(REF)	(REF)	(SWT-0042)	SWITCH, TOGGLE, SPDT, ON/OFF/ON
39	(REF)	(REF)	(TCPL-0005)	THERMOCOUPLE, TYPE J, .063X18
40	(REF)	(REF)	(TCPL-0005-TOOL)	TOOL; THERMOCOUPLE SHAPE/FORMING (NOT SHOWN)
41	(REF)	(REF)	(TDR-0013)	BUZZER 40 SEC DELAY
42	(REF)	(REF)	(TDR-0014)	SOLID STATE OFF DELAY TIMER
43	(REF)	(REF)	(TJ-0184D-3)	TEMP CTRL; 100-240 VAC; MKII F
44	(REF)	(REF)	(TM200-0120)	TOGGLE SWITCH, SPDT ON-ON
45	(REF)	(REF)	(XFM-0052)	XFMR 250A (W/ FINGER GUARD)
46	(REF)	(REF)	(XFS-0005)	FINGER SAFE KIT (TRANSFORMER, 2 PER KIT)
47	2	2	903-0245X3/8	4-40X3/8 SS SLOT RD HD M/S
48	4	4	903-0302	6-32X1/4 SS SLOT PAN M/S
49	8	8	903-0492	10-24X1/4 SS PAN HD SLOT M/S
50	17	17	903-0501SS	10-24 X 3/8 SS HEX HD MACH SCREW
51	2	2	903-0504	10-24 X 3/8 ONE WAY RH MACH SCW
52	3	3	903-0604	10-24 X 1 SS SLOT RND M/S
53	2	2	903-0625	10-24 X 1.5 SS SLOT RND M/S
54	2	2	903-0961SS	SST, 1/4-20 X 0.375 HEX HEAD MACHINE SCREW
55	4	4	903-5105.A	10-24 SS MACHINE SCREW NUT
56	2	2	903-7502	WASHER, INTERNAL TOOTH LOCK, #6 SST
57	8	12	903-7513	#10 SS FLAT WASHER
58	11	11	903-7514	#10 SS INT TOOTH LOCK WASHER
59	2	2	903-7529	1/4 SS INT TOOTH LOCK WASHER
60	2	2	903-7530SS	1/4 SAE SS FLAT WASHER
61	1	1	904-0035	LABEL; ETL LISTED; NSF STD 4
62	1	1	904-0040	LABEL; ETL LISTED; UL STD 197
63	1	1	992-0023	SHC-1040 CORD CLAMP, .500-.625

DIAGRAM: MK-1632TAB

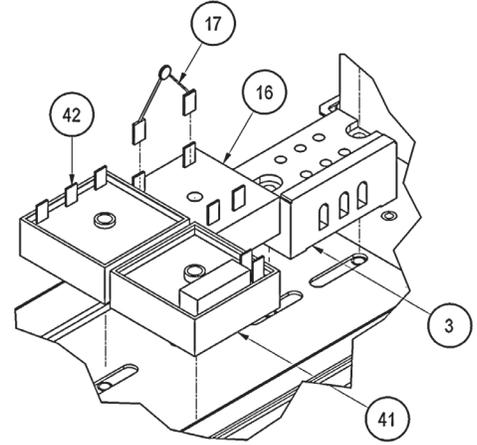
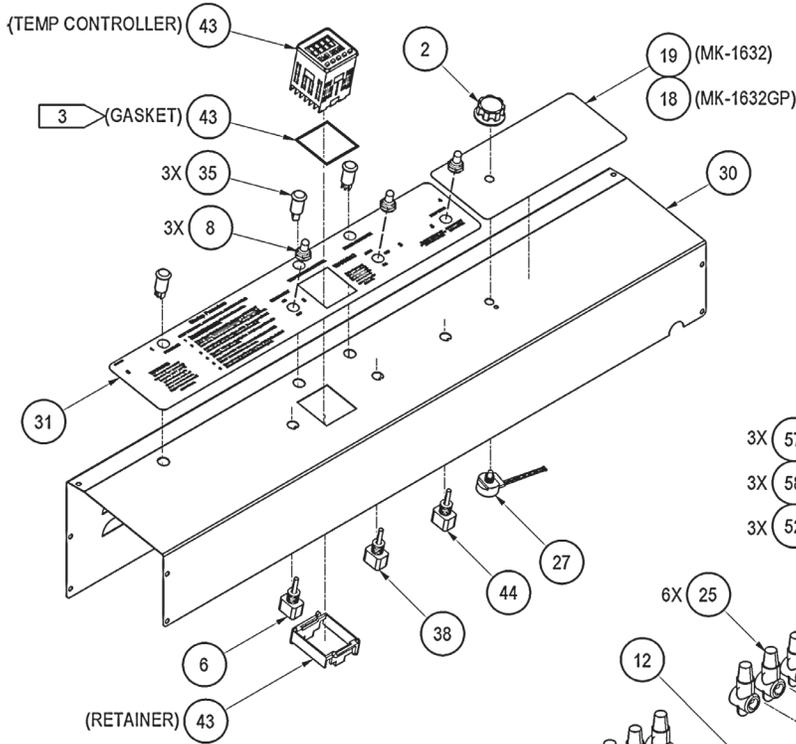
USE THIS DIAGRAM ONLY FOR

MODEL: Mark II, Mark II GP

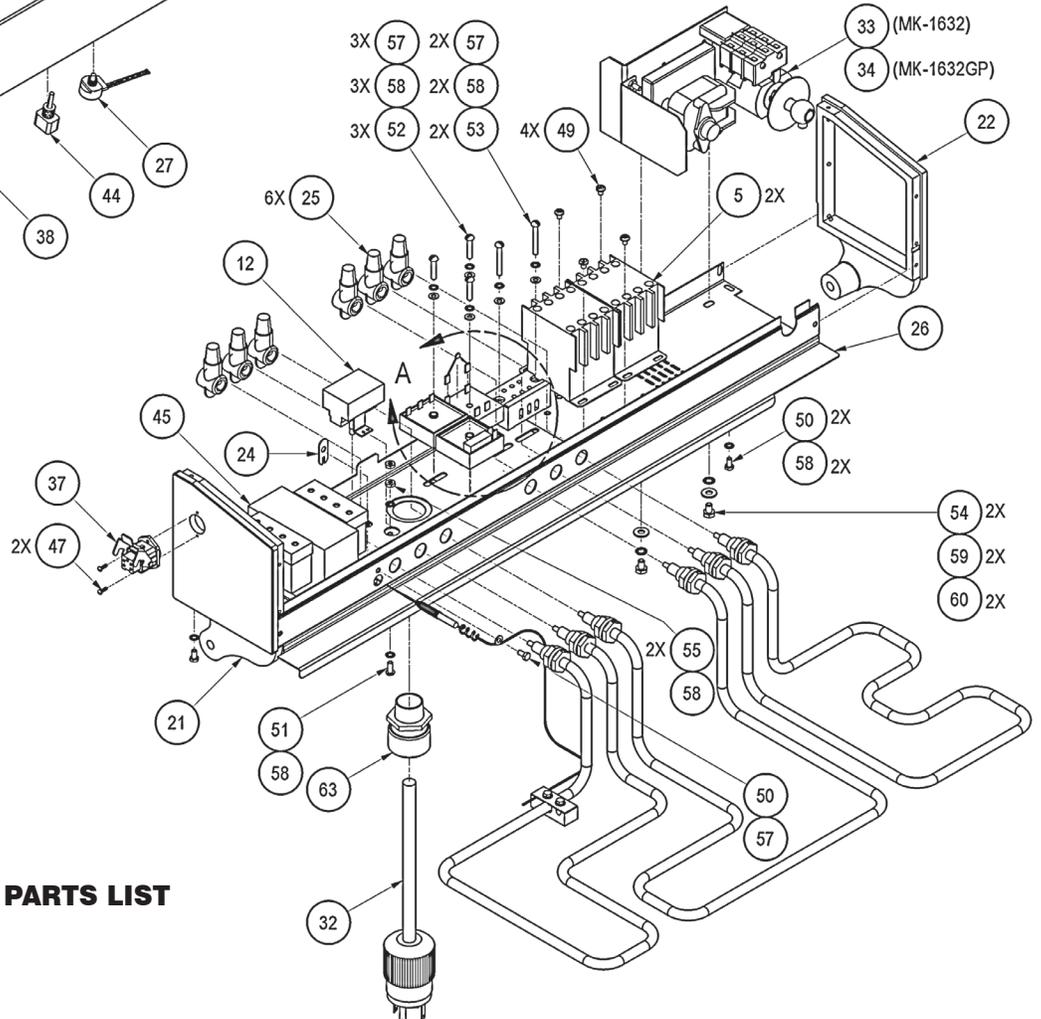
**ITEM NUMBER: 22618, 22619,
22620, 22621**

TO IDENTIFY MODEL AND ITEM NUMBER, SEE DATA
TAG ON CONTROL PANEL

NOTE: SEE PAGE 14 FOR PARTS LIST



DETAIL A



NOTE: SEE PAGE 14 FOR PARTS LIST

DIAGRAM: MK-1632TAB

USE THIS DIAGRAM ONLY FOR

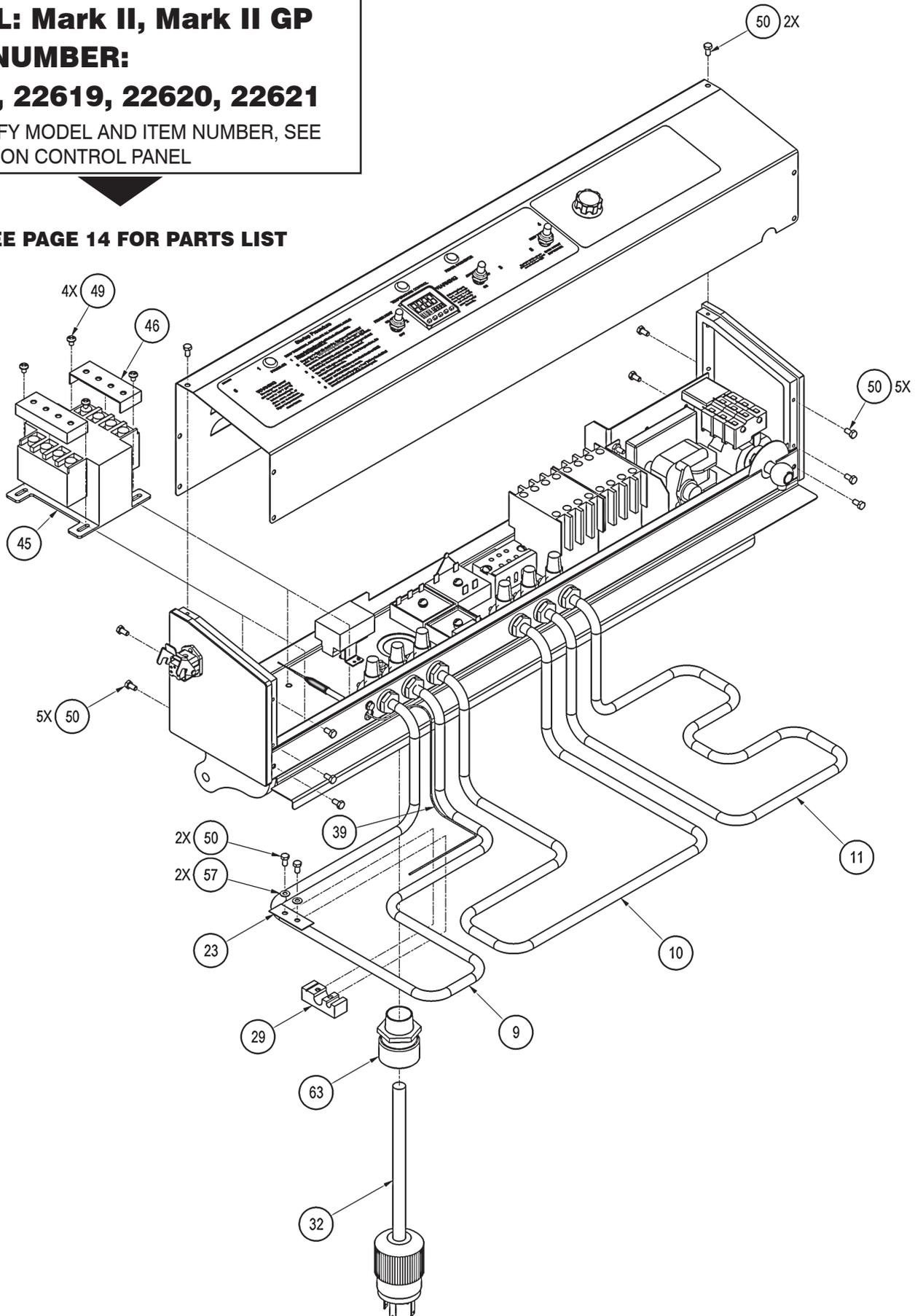
MODEL: Mark II, Mark II GP

ITEM NUMBER:

22618, 22619, 22620, 22621

TO IDENTIFY MODEL AND ITEM NUMBER, SEE
DATA TAG ON CONTROL PANEL

NOTE: SEE PAGE 14 FOR PARTS LIST



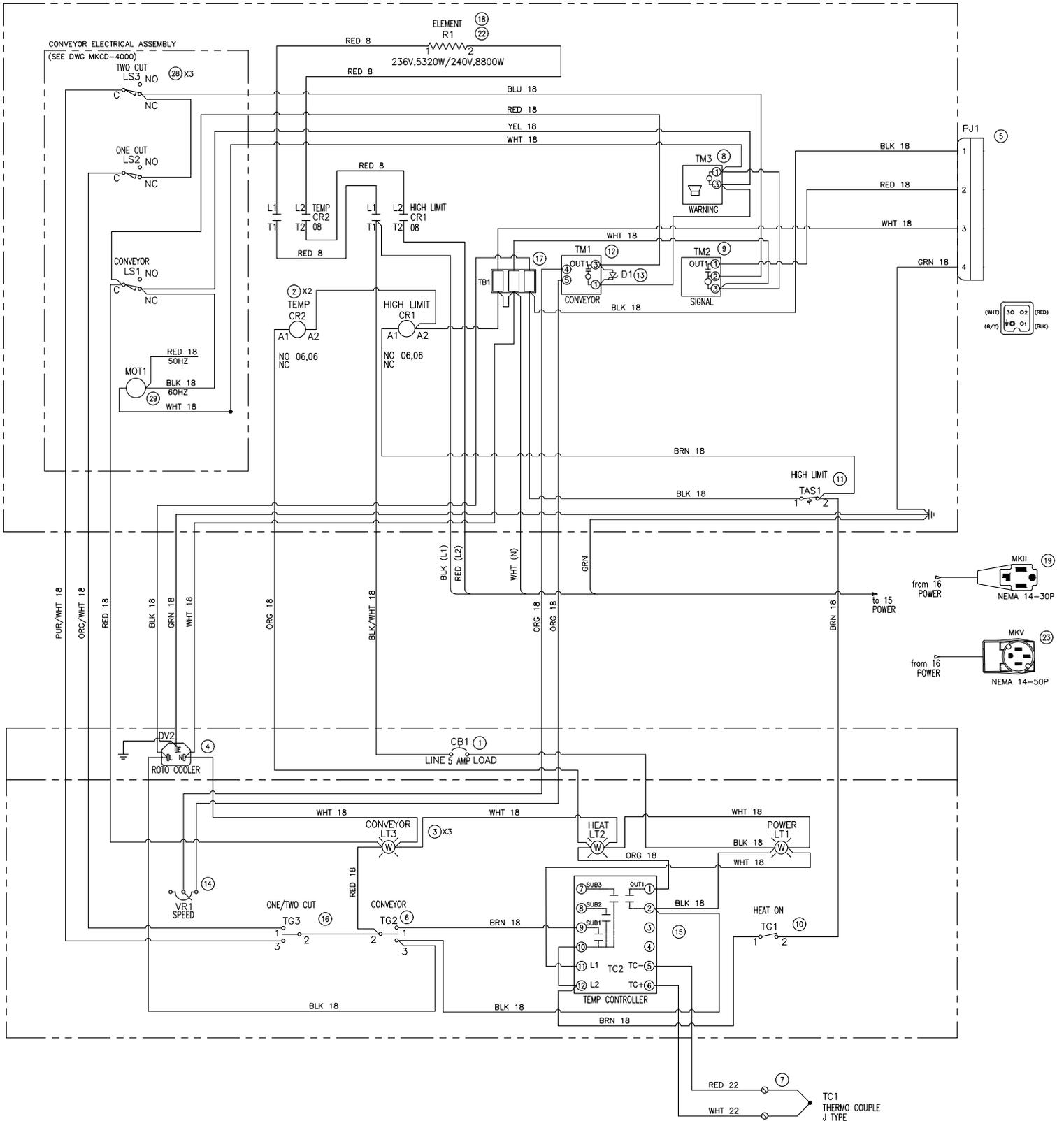


DIAGRAM: MK-1731_R0_CV
 USE THIS DIAGRAM ONLY FOR

MODEL: Mark II, Mark II GP
ITEM NUMBER:
22600, 22601, 22602,
22604, 22635, 22637

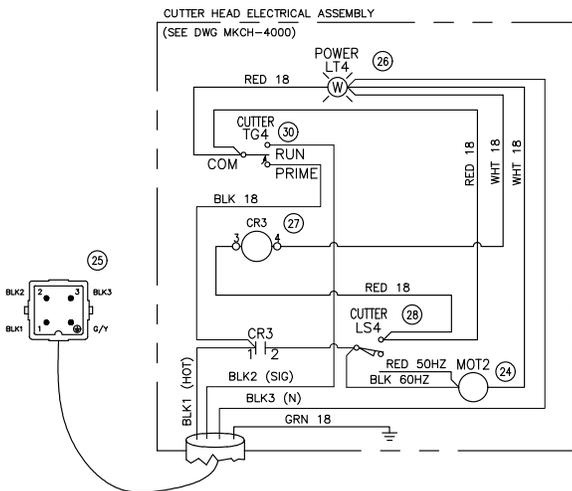
TO IDENTIFY MODEL AND ITEM NUMBER, SEE
 DATA TAG ON CONTROL PANEL

BOM: MK-1731 MKII/MKV 200-240 50/60/1D COM				
ITEM #	DESCRIPTION	QTY	UNIT	BELSHAW PART NO.
1	BREAKER 5A	1	EA	#CBR-0001A
2	CTR, 2P, 40A, 120VAC COIL	2	EA	#CTR-0002
3	CLEAR NEON PILOT LIGHT 125V	3	EA	#PLT-0002
4	OUTLET, HEATER HEAD	1	EA	#SKT-0003
5	PANEL MOUNT SOCKET ASSY	1	EA	#SKT-0700
6	SWITCH, TOGGLE, SPDT,ON/OFF/ON	1	EA	#SWT-0042
7	THERMOCOUPLE, TYPE J, .063X14	1	EA	#TCPL-0005
8	BUZZER 40 SECOND DELAY	1	EA	#TDR-0013
9	SOLID STATE DELAY OFF TIMER	1	EA	#TDR-0014
10	TOGGLE SWITCH SPST	1	EA	DR42-0050
11	SWT,HILIM(5.75) USE SK-1204,	1	EA	FM200-0065M
12	TIMER-60 SEC.	1	EA	MK-0054
13	TRANSIENT VOLTAGE SUPPRESSOR	1	EA	MK-0066
14	POTENTIOMETER ASY 1.5MEG 20K	1	EA	MK-0790
15	TEMP CRTL, 1/16 DIN, MKII F	1	EA	TJ-0184D-3
16	TOGGLE SWITCH, SPDT ON-ON	1	EA	TM200-0120
17	TERMINAL BLOCK	1	EA	634-0383

BOM: MK-1731-1 ELEC MKII 208-240 50/60 1 DOM				
ITEM #	DESCRIPTION	QTY	UNIT	BELSHAW PART NO.
18	HTR ELEM 200/236V 3800/5320W	1	EA	DR42-0001D
19	POWER CORD ASSY 4 WIRE	1	EA	DR42-0612
20	MKII/MKV 200-240 50/60/1 COM	1	EA	MK-1731

BOM: MK-1731-2 ELEC MKV 208-240 50/60 1 DOM				
ITEM #	DESCRIPTION	QTY	UNIT	BELSHAW PART NO.
21	MKII/MKV 200-240 50/60/1 COM	1	EA	MK-1731
22	ELEMENT 1 PHASE, 240/8800	1	EA	MKV-0004
23	POWER CORD ASSY 4 WIRE	1	EA	MKV-0514

MK-1731 REFERENCE PARTS				
ITEM #	DESCRIPTION	QTY	UNIT	BELSHAW PART NO.
24	MOTOR 115V, 50/60, 50 RPM	1	EA	#MTR-0010
25	SIGNAL CORD ASSY DOM/CE 54	1	EA	#PLG-0500-4
26	CLEAR NEON PILOT LIGHT 125V	1	EA	#PLT-0002
27	RELAY SSR 100-240VAC 25A	1	EA	#RLY-0020
28	MICRO SWITCH	4	EA	DR42-0048
29	BRAKE MTR 115 50/60 8RPM CE	1	EA	MKDW-0009
30	TOGGLE SWITCH DPDT 15A 125V	1	EA	MKV-0010



DATA TAG

MKII		MKV	
VOLTS	208/220/230/240	VOLTS	208/220/230/240
HERTZ	60	HERTZ	60
PHASE	1	PHASE	1
KW	4.4/4.9/5.3/5.8	KW	6.9/7.6/8.3/9.1
AMPS	21/22.1/23/24	AMPS	33/34.8/36.2/37.7

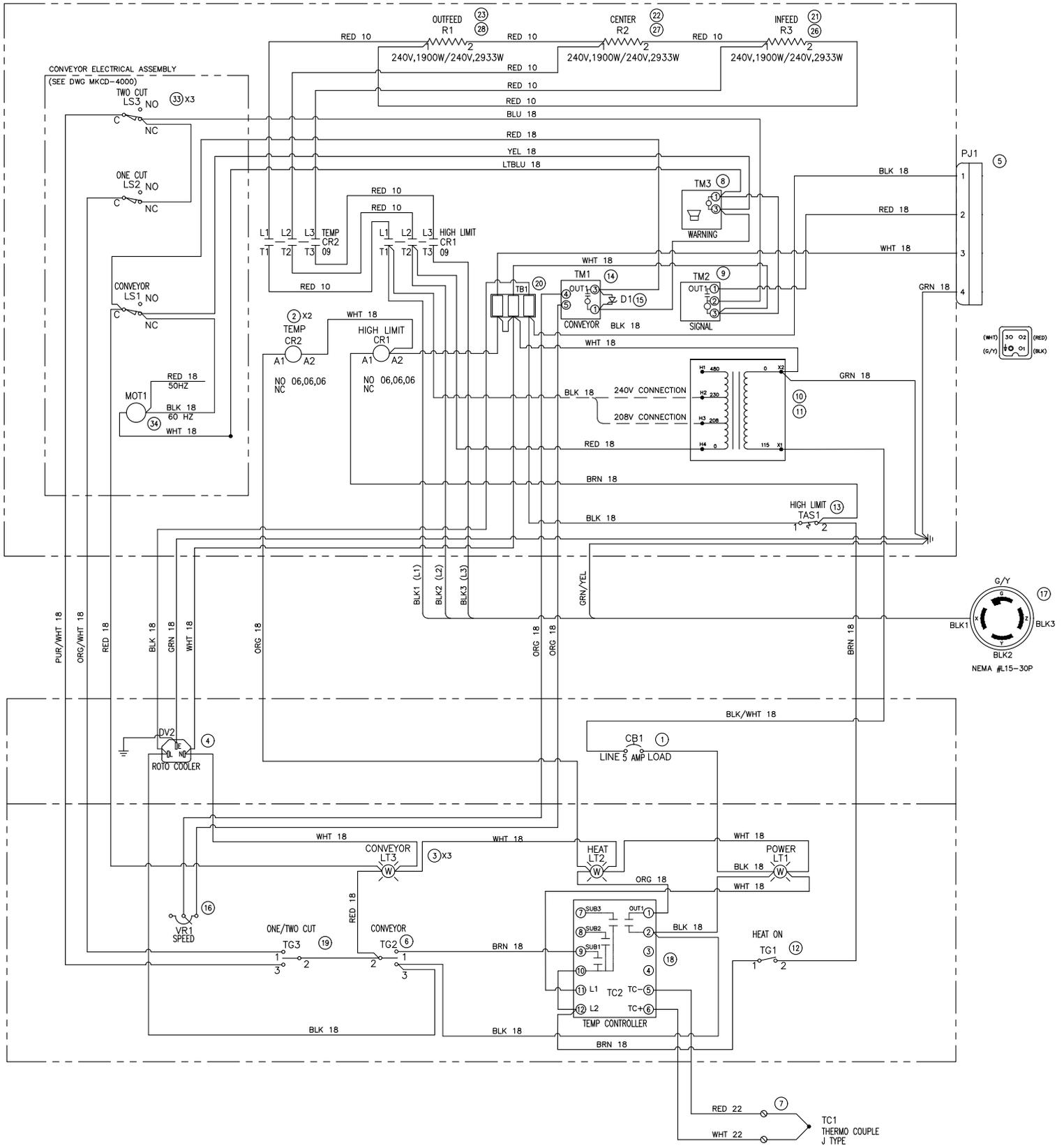


DIAGRAM: MK-1736_R0_CV

USE THIS DIAGRAM ONLY FOR

MODEL: Mark II, Mark II GP
ITEM NUMBER: 22618, 22618-1,
22619, 22619-1, 22620, 22620-1,
22621, 22621-1

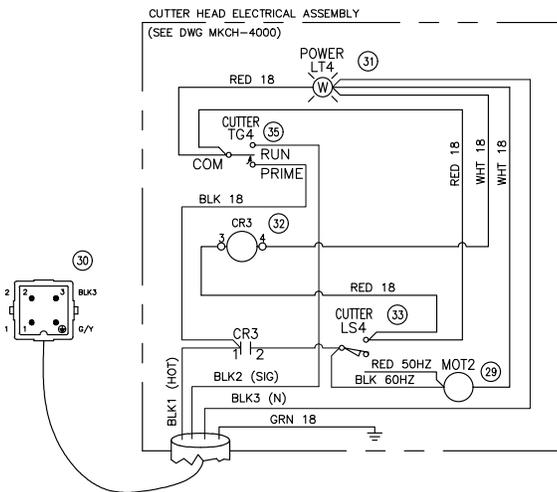
TO IDENTIFY MODEL AND ITEM NUMBER, SEE DATA TAG ON CONTROL PANEL

BOM: MK-1736 MKII/MKV 208-240/50/60/3D COM				
ITEM #	DESCRIPTION	QTY	UNIT	BELSHAW PART NO.
1	BREAKER 5A	1	EA	#CBR-0001A
2	CTR, 3P, 50A, 110V COIL	2	EA	#CTR-0030
3	CLEAR NEON PILOT LIGHT 125V	3	EA	#PLT-0002
4	OUTLET, HEATER HEAD	1	EA	#SKT-0003
5	PANEL MOUNT SOCKET ASSY	1	EA	#SKT-0700
6	SWITCH, TOGGLE, SPDT,ON/OFF/ON	1	EA	#SWT-0042
7	THERMOCOUPLE, TYPE J, .063X14	1	EA	#TCPL-0005
8	BUZZER 40 SECOND DELAY	1	EA	#TDR-0013
9	SOLID STATE DELAY OFF TIMER	1	EA	#TDR-0014
10	XFMR 208/230/460-115	1	EA	#XFM-0052
11	FINGER SAFE KIT, TRANSFORMER	1	EA	#XFS-0005
12	TOGGLE SWITCH SPST	1	EA	DR42-0050
13	SWT,HILIM(5.75) USE SK-1204,	1	EA	FM200-0065M
14	TIMER-60 SEC.	1	EA	MK-0054
15	TRANSIENT VOLTAGE SUPPRESSOR	1	EA	MK-0066
16	POTENTIOMETER ASY 1.5MEG 20K	1	EA	MK-0790
17	POWER CORD ASSY 200/240/3	1	EA	MKV-0515
18	TEMP CRTL, 1/16 DIN, MKII F	1	EA	TJ-0184D-3
19	TOGGLE SWITCH, SPDT ON-ON	1	EA	TM200-0120
20	TERMINAL BLOCK	1	EA	634-0383

BOM: MK-1736-1 ELEC MKII 208-240 5/6 3 DOM				
ITEM #	DESCRIPTION	QTY	UNIT	BELSHAW PART NO.
21	INFD ELEM 200V/1320W,240V/1900	1	EA	DR42-1098-1
22	CTR ELEM 200V/1320W,240V/1900W	1	EA	DR42-1098-2
23	OUTFD ELEM 200V/1320W,240/1900	1	EA	DR42-1098-3
24	MKII/MKV 208-240 50/60/3D COM	1	EA	MK-1736

BOM: MK-1736-2 ELEC MKV 208-240 5/6 3 DOM				
ITEM #	DESCRIPTION	QTY	UNIT	BELSHAW PART NO.
25	MKII/MKV 208-240 50/60/3D COM	1	EA	MK-1736
26	ELEMENT,INFD BK 208/240/3P	1	EA	MKV-0005-1
27	ELEMENT,INFD FRONT 208/240/3P	1	EA	MKV-0005-2
28	ELEMENT,OUTFEED 208/240/3P	1	EA	MKV-0005-3

MK-1736 REFERENCE PARTS				
ITEM #	DESCRIPTION	QTY	UNIT	BELSHAW PART NO.
29	MOTOR 115V, 50/60, 50 RPM	1	EA	#MTR-0010
30	SIGNAL CORD ASSY DOW/CE 54	1	EA	#PLG-0500-4
31	CLEAR NEON PILOT LIGHT 125V	1	EA	#PLT-0002
32	RELAY SSR 100-240VAC 25A	1	EA	#RLY-0020
33	MICRO SWITCH	4	EA	DR42-0048
34	BRAKE MTR 115 50/60 8RPM CE	1	EA	MKDW-0009
35	TOGGLE SWITCH DPDT 15A 125V	1	EA	MKV-0010



DATA TAG

MKII		MKV/MKII	
VOLTS	208/220/230/240	VOLTS	208/220/230/240
HERTZ	50/60	HERTZ	50/60
PHASE	3	PHASE	3
KW	4.5/5/5.5/5.9	KW	6.9/7.6/8.3/9
AMPS	12.7/13.4/14/14.7	AMPS	19.2/20.3/21.2/22.1

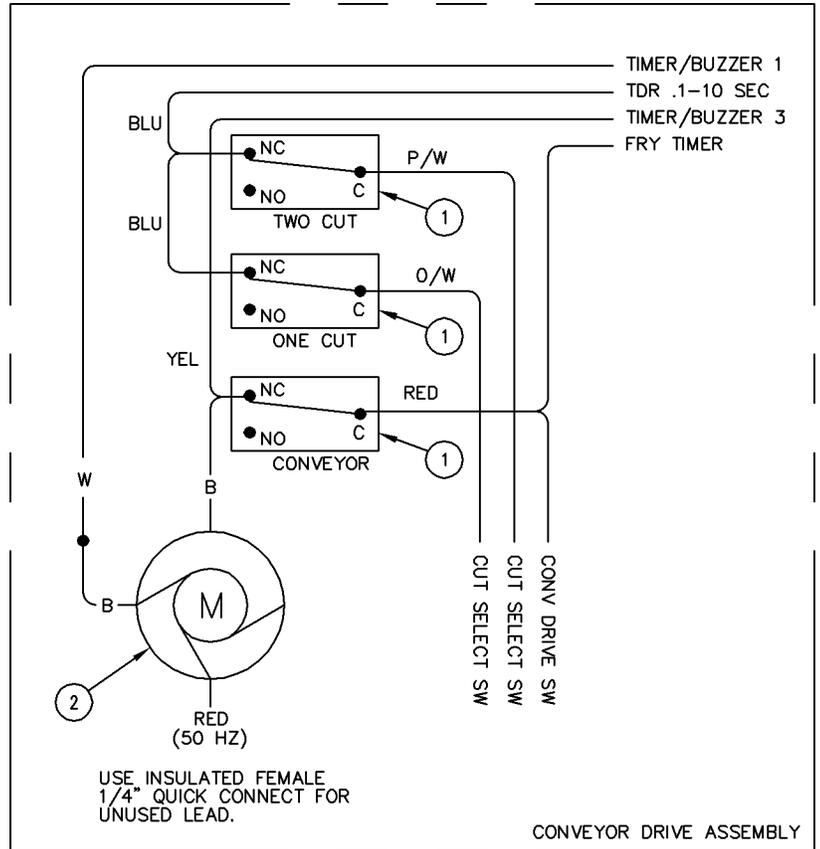
DIAGRAM: MKCD-4000

USE THIS DIAGRAM ONLY FOR

**MODEL: Mark II, Mark II GP
ALL ITEM NUMBERS**

TO IDENTIFY MODEL AND ITEM NUMBER,
SEE DATA TAG ON CONTROL PANEL

CONVEYOR DRIVE



NOTES:

1. USE 18 GA. 105°C MACHINE WIRE
2. FOR MOTOR UPGRADE ONLY, SEE SK-1236

BOM - MK-1720, -1721, -1722, -1723						DESCRIPTION
ITEM	PART NO.	FWD		REV		
		1720 STD (QTY)	1721 FP (QTY)	1722 STD (QTY)	1723 FP (QTY)	
1	DR42-0048	3	2	3	2	MICROSWITCH
2	MKDW-0009	1	1			GEAR MOTOR, FORWARD
	MKVID-0046			1	1	GEAR MOTOR, REVERSE

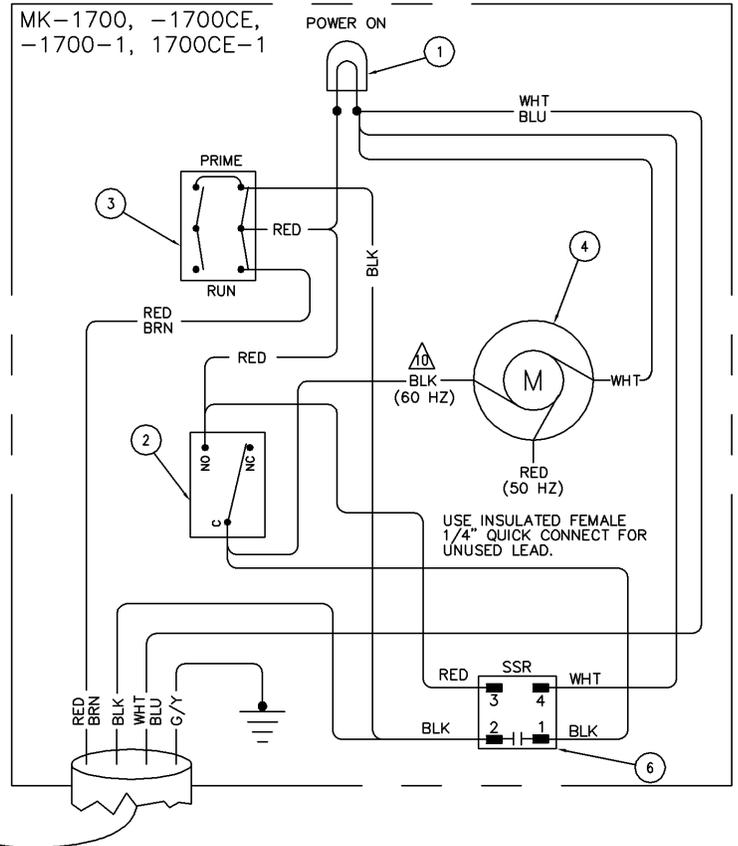
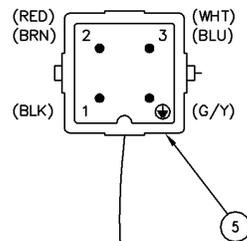
DIAGRAM: MKCD-4000

USE THIS DIAGRAM ONLY FOR

**MODEL: Mark II, Mark II GP
ALL ITEM NUMBERS**

TO IDENTIFY MODEL AND ITEM NUMBER,
SEE DATA TAG ON CONTROL PANEL

CUTTERHEAD (DEPOSITOR)



BOM - MK-1700, -1700CE, -1700-1, 1700CE-1, -1700DMM

ITEM	PART NO.	MKI	MKII & MKV	MKIIG		DESCRIPTION	
		1700DMM	1700	1700CE	1700-1		1700CE-1
		DOM/EXP/CE (QTY)	DOM (QTY)	EXP/CE (QTY)	DOM (QTY)	EXP/CE (QTY)	
1	PLT-0002	1	1	1	1	1	PILOT LIGHT, 125V, WHITE
2	DR42-0048	1	1	1	1	1	MICROSWITCH
3	MKV-0010	1	1	1	1	1	TOGGLE SWITCH DPDT 15A 125V
4	MTR-0010		1	1	1	1	BRAKE MOTOR, 115V, 50/60HZ, 50 RPM
	MTR-0009	1					BRAKE MOTOR 21/26 RPM 115V
5	PLG-0500-4		1				SIGNAL CORD ASSEMBLY DOM/CE 54
	PLG-0500-4	1		1			SIGNAL CORD ASSEMBLY
	PLG-0500-5				1		SIGNAL CORD ASSEMBLY DOM/CE 84
	PLG-0500-5					1	SIGNAL CORD ASSEMBLY
6	RLY-0020		1	1	1	1	SOLID STATE RELAY
7	TDR-0018	1					RELAY ON DELAY .1-10S 120V

Belshaw Adamatic Bakery Group

Limited Warranty / Return Policy

Subject to the terms and limitations set forth in this limited warranty ("Limited Warranty"), Belshaw Adamatic Bakery Group (also referred to as "the Manufacturer") warrants to the original purchaser ("Purchaser") of Manufacturer's equipment and parts ("Products"), Belshaw Adamatic Bakery Group's manufacture and assembly of Products to be free from defects in workmanship and material which would result in product failure under normal use and service. Belshaw Adamatic Bakery Group's entire liability under this Limited Warranty is limited to either repairing or replacing at Manufacturer's factory or on Purchaser's premises, at Belshaw Adamatic Bakery Group's option, any Products purchased by Purchaser which shall be determined by the Manufacturer to be defective. If necessary to return Products to Manufacturer's factory, Products must be shipped by Purchaser with transportation charges prepaid by Purchaser.

Belshaw Adamatic Bakery Group reserves the right to make changes in design or add any improvement to its Products at any time without incurring any obligations to install the same on Products previously sold.

Possession, use or operation of Products sold hereunder for any other than their designed purpose, or use of Products which are in poor repair, modified, improperly operated, or neglected, is done at the Purchaser's risk. Belshaw Adamatic Bakery Group hereby disclaims any liability for these actions and shall not be liable for defects in or for any damages or loss to any property which is attributable to such actions.

Under no circumstances shall Belshaw Adamatic Bakery Group be liable for any indirect, special, incidental, or consequential damages arising out of, or from the use of its Products by Purchaser, its assignees, employees, agents or customers.

THIS LIMITED WARRANTY SHALL BE PURCHASER'S SOLE AND EXCLUSIVE REMEDY WITH RESPECT TO DEFECTIVE PRODUCTS.

Warranty Period

This Limited Warranty covers Products manufactured by Belshaw Adamatic Bakery Group and sold by Belshaw Adamatic Bakery Group or its authorized distributor ("Distributor") or authorized dealer ("Dealer"), and this Limited Warranty shall extend for a period of one (1) year from date of shipment to Purchaser, and to the original Purchaser only.

Limited Warranty

With respect to products not manufactured by Belshaw Adamatic Bakery Group, warranty coverage shall be limited to the warranty of the original manufacturer of the product, or the Belshaw Adamatic Bakery Group Limited Warranty, whichever is the lesser coverage period.

Replacement Products provided under the terms of this Limited Warranty are warranted for the remainder of the original warranty period applicable to the Product.

Exclusions

This Limited Warranty excludes from its coverage and does not apply to: (a) solenoid and relay coils; (b) lamps; (c) "O" rings; (d) belts; and (e) impellers. This Limited Warranty also excludes the cost of labor for removing and replacing Products subject to a warranty claim, other than the labor incurred directly by the Manufacturer when, in Belshaw Adamatic Bakery Group's opinion, a repair of the Product by the Manufacturer is justified.

Warranty Claims

In case of warranty claims relating to your Product, you must follow the instructions below.

Report Claims to Your Authorized Distributor or Dealer or to Belshaw Adamatic Bakery Group

As soon as you discover a problem, contact the Distributor or Dealer from whom you purchased the Product or Belshaw Adamatic Bakery Group. Your Distributor or Dealer will notify Belshaw Adamatic Bakery Group for you. **Only Belshaw Adamatic Customer Service can approve or authorize warranty claims.**

You must state the following:

1. Your name, company name, and telephone number
2. The location, phone number, and contact name where the Product is located
3. The invoice number and date of purchase of the Product
4. The Model and Serial Number of the Product, as written on the data tag attached to the Product
5. A description of the problem and how it occurred

Shipping Damage and Missing Items

Damage to the Packaging or Crate. On delivery, promptly check all packages thoroughly for any sign of damage. In cases of visible damage, **always note the damage on the Delivery Receipt.** Failure to note damage is taken by the Freight Carrier to mean that the package is in good condition at time of receipt, and can result in denial of a Freight Claim. Take photographs that clearly show the damage.

Damage to Products. If you find any damaged Product inside the shipment, photograph the damage both inside and outside of the package. Do not throw the packaging away. Photos of the package and contents are needed to show the condition of the Product at the time it was received.

Missing Items. As soon as you believe any items to be missing from a shipment, promptly report this to the Distributor or Dealer from whom the Product was purchased or to Belshaw Adamatic Bakery Group. If possible, photograph the entire contents of the delivery and email this to your Distributor or Dealer, or to Belshaw Adamatic Customer Service at service@belshaw.com.

Returning Products to Belshaw Adamatic Bakery Group

Under the terms of the Limited Warranty, you may be asked to return to Belshaw Adamatic Bakery Group any Product that is the subject of a warranty claim. These Products must be clearly labeled with a Return Goods Authorization Number ("RGA Number") given to you by your Distributor or Dealer, or by Belshaw Adamatic Customer Service. Products received without an RGA Number will not be processed. All Products must be shipped freight prepaid by the Purchaser to Belshaw Adamatic Bakery Group at the address below.

Contacting Belshaw Adamatic Bakery Group

At any time, you can contact Belshaw Adamatic Bakery Group customer service for assistance:

Belshaw Adamatic Bakery Group Customer Service
814 44th St. NW, Suite 103,
Auburn WA 98001, USA
Phone: 800-578-2547 (USA/ Canada) or (+1)253-886-5340
(Worldwide)
Email: service@belshaw.com
Office Hours: Monday – Friday, 6am to 4pm, USA Pacific Time

Belshaw

www.belshaw.com

814 44th Street NW, Suite 103
Auburn, WA 98001 USA

1-800-BELSHAW
1-800-578-2547 (USA/Canada)
(+1) 206-322-5474 (Worldwide)

service@belshaw.com

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The Spirit of Excellence