

**OPERATOR'S MANUAL
TECHNICAL SUPPLEMENT
PARTS AND ELECTRICAL DIAGRAMS**



Donut Icer

Model: HI18F • HI24F

ITEM NUMBER

20024 HI18F, 120V-60-1

20025-3 HI18F, 208/240V-60-1

(Other)

20022 HI24F, 120V-60-1

20023-3 HI24F, 208/240V-60-1

SERIAL NUMBER

*Item Number / 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.*



Belshaw®

belshaw-adamatic.com

Adamatic

Bakery Group



Econo-Icer HI18/HI24

Operator's Manual

Belshaw Bros., Inc.

814 44TH ST NW, Suite 103

Auburn, WA 98001 USA

Phone: (206) 322-5474 ■ Fax: (206) 322-5425

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BELSHAW FREIGHT DAMAGE POLICY

Belshaw has made every effort to insure that your equipment arrives in excellent condition. **For your protection**, please inspect your shipment for any signs of damage that may have occurred during transport. Please note any damage that is found during inspection and file a freight claim with the shipping company immediately. Acceptance of damaged equipment may become the responsibility of the acceptor.

IMPORTANT
Keep This Manual For Future Reference.



EQUIPMENT RECORD

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

Purchased by _____

Installed by _____

Date of installation _____ Model number _____

Serial number _____

040618

MN-1747EN

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CERTIFICATE OF COMPLIANCE

Certificate Number 20151109-E30669
Report Reference E30669-20151106
Issue Date 2015-NOVEMBER-09

Issued to: BELSHAW BROS INC
Suite 103
814 44Th St Nw
Auburn WA 98001

**This is to certify that
representative samples of**

COMMERCIAL COOKING APPLIANCES
Commercial Electric Donut Icers - HI18C, HI18F, HI24C,
HI24F

Have been investigated by UL in accordance with the
Standard(s) indicated on this Certificate.

Standard(s) for Safety:

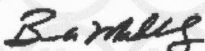
UL 197, Standard for Commercial Electric Cooking
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CAN/CSA C22.2 No. 109-M1981, Standard for Commercial
Cooking Appliances

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Bruce Mahrenholz, Director North American Certification Program

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Preface

The **HI18/HI24 Econo-Icer** is designed for quickly and easily icing donuts and a variety of baking products.


The **HI18/HI24 Econo-Icer** is meant to be used on a flat, stationary surface, with the operator standing on the handled side. The operator must work safely at all times and follow the instructions and warnings in this manual.

The **HI18/HI24 Econo-Icer** uses electrical elements to heat frosting in its kettle. The machine is available with the following electrical configurations:


- ✓ 120 volts, 1 phase, 60 hertz
- ✓ 220 volts, 1 phase, 60 hertz


The **HI18/HI24 Econo-Icer** produces less than 70 dB(A) of equivalent continuous A-weighted sound pressure at work stations. This has been determined during a run of the machine with shortening in the kettle, using a Bruel & Kjaer sound level meter, type 2236.


To use the **HI18/HI24 Econo-Icer** safely, heed the following warnings:


 UNPLUG the machine before attempting any adjustment, repair, disassembly, or cleaning to


avoid electrocution or other injury.


 NEVER USE force to assemble, disassemble, operate, clean, or maintain the machine.

 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.


 MAKE SURE that all electrical cords are routed so that no one will trip over them.


 To avoid electrocution, MAKE SURE that no electrical cords are frayed or cracked and that they do not pass through any water or icing.

 NEVER TOUCH the icing pan once the machine is on. The pan gets very hot, which may cause serious burns.

 DO NOT OVERFILL the icing pan with icing. If shortening overflows the

icing pan, it could cause serious burns or could cause someone to slip on the floor and be seriously injured.

 **MAKE SURE** that the machine and the icing are cool before attempting any adjustment, repair, disassembly, or cleaning. Hot icing can cause serious burns.

 **BE CAREFUL** never to get icing, water, or other materials on the floor. If anything does get spilled on the floor, mop it up immediately. Materials on the floor can cause people to slip or fall, resulting in serious injury or loss of life.

1

Operation

Operation

1. FILL **Icing Pan** with icing approximately 1/2" from the top of the pan.



2. TURN ON **Heater**.
3. ALLOW icing to heat for 45 minutes to reach desired icing temperature. The **Heating Indicator Light** will turn off, and the **Temperature Controller** will display the icing temperature.

NOTE: Periodic stirring of the icing is necessary to ensure constant, even heating of the icing.



4. ROTATE **Wire / Frame** over icing.
5. SLIDE the rack of donuts into the **Rack Holder**.



6. ROTATE the **Wire / Frame** over the rack of donuts to be iced.
7. FIRMLY GRIP the two (2) handles and rotate the **Wire / Frame** and rack of donuts to be iced.



10. LOWER the **Icing Pan**.



8. RETURN the empty donut rack to the original position.



11. ROTATE the empty donut rack over the iced donuts.



9. PUSH DOWN on the **Icing Lift Handle** to raise the **Icing Pan** until it reaches desired height.



12. FIRMLY GRIP the two (2) handles and rotate the **Wire / Frame** and donut rack to the original position.



13. ROTATE the **Wire / Frame** over the icing, remove iced donuts, and repeat steps 1-13.

2 Installing HI18/HI24 Digital Temperature Retrofit Kit

Parts Needed

1. Heater Control Box Assembly (HI24-1017) + Hardware:
 - ✓ 4X .” Bolts
 - ✓ 8X .” Washers
 - ✓ 2X 6” High Temperature Wire Sleeves
2. 6X Wire Ties (990-0150)
3. Thermocouple Mounting Bracket (HI24-7008)
4. Heating Element Mounting Hardware:
 - ✓ 4X #10 Washers
 - ✓ 2X #10 Nuts

Installation Instructions

1. UNPLUG HI Unit from power source.
2. REMOVE existing **Heater Control Box**:
 - ✓ Remove Icing Pan.
 - ✓ Remove Top Cover from

Heating Panel (4X Bolts).

- ✓ Remove wires from Heating Element.
 - ✓ Remove old Heating Control Box Front Cover (4X Bolts).
 - ✓ Remove 4X bolts connecting the old Heating Control Box to Heating Panel.
 - ✓ Remove old Heating Control Box, including wire for connecting to Heating Elements, and Wire Sleeves.
3. ATTACH **Retrofit Heating Control Box**:
 - ✓ Remove 5X bolts securing the Front Cover of the new Heating Control Box Assembly and remove the cover.
 - ✓ Place Wire Sleeves on 12 GA white wires sticking out of the backside of the new Heater Control Box. (See Figure 1.)
 - ✓ Insert the wires and sleeves through heating box holes. (See Figure 1.)
 - ✓ Ensure sleeves are located as shown below. (See Figure 1.)
 - ✓ NOTE: Grommets located in

the new Heating Control Box pop off easily. **Use care when moving wire through grommets.**

- ✓ Remove Front Cover of the new Heating Control Box Assembly.
 - ✓ Remove 4X nuts and 4X washers from long bolts on **back** of new Heater Control Box.
 - ✓ Install the new Heating Control Panel onto the Heating Box using corresponding holes and hardware provided in this kit.
 - ✓ Replace Heating Control Box Front Cover (5X Bolts), making sure not to pinch any wires under the cover. **DO NOT over-tighten Front Cover bolts. Doing so could lead to gasket leakage.**
4. Reinstall the Top Cover of Heating Panel (5X Bolts).
 5. Replace Icing Pan.
 6. Route Female Thermocouple wire under the unit. (See Figures 3 and 4.)
 - ✓ Attach shielded thermocouple wire to Frame using supplied wire ties. (See Figure 4.)
 7. Place Thermocouple into indicated alignment hole on Thermocouple Bracket. (See Figure 5.)
 8. PLACE Thermocouple Bracket on Icing Pan. (See Figure 6, 7, and 8.)
 9. PLUG in unit and verify all functions work properly.
 - ✓ Rotate Green ON/OFF Switch (located furthest to the left of the unit) to the ON position. The green light in the switch should illuminate. (See Figure 9.)
 - ✓ Omron Controller (far right) should power up and display Current Temperature (PV, large number) and Set Point temperature (SV, small number). (See Figure 10.)
 - ✓ To test digital temperature controller, wrap hand around Thermocouple, and ensure the indicated temperature (PV, displayed in large text) rises.
 - ✓ The Set Point (SV) can be changed by pushing the D or U arrows. (See Figure 10.)
 - ✓ Heat Cycle light should turn on after approximately 5 seconds.

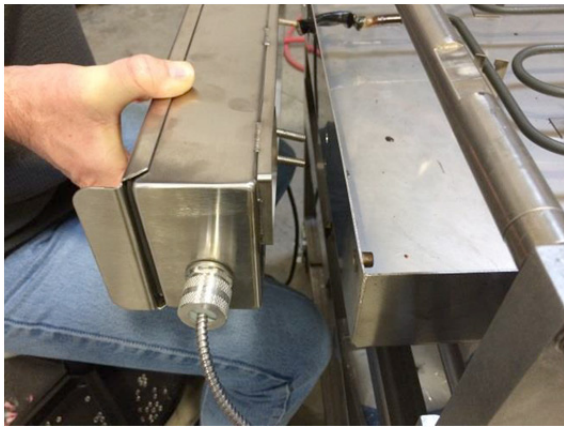


Figure 1, Installing New Control Panel



Figure 4, Thermocouple Routing 2



Figure 2, Element Connections on Relay



Figure 5, Installation of Thermocouple Bracket



Figure 3, Thermocouple Routing 1



Figure 6, Installation of Thermocouple



Figure 7, Installation of Thermocouple



Figure 9, Controls

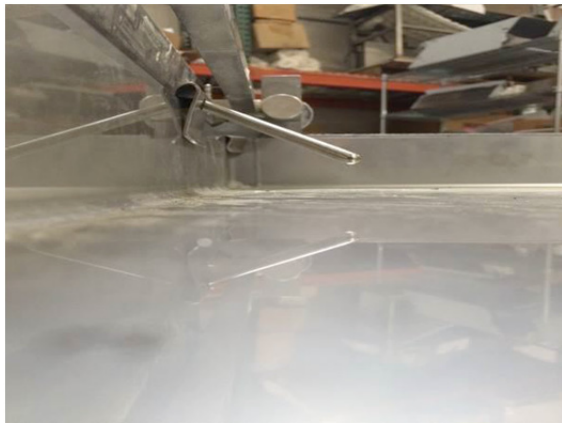


Figure 8, Installation of Thermocouple

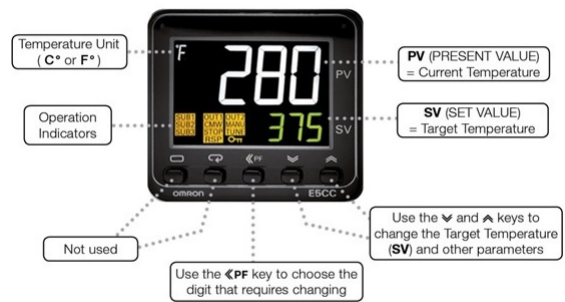


Figure 10, Temperature Controller

TROUBLESHOOTING

Potential Issue	What To Do
Error or Alarm present on Digital Temperature Control	<ul style="list-style-type: none"> Ensure Thermocouple is connected and functioning properly Cycle power (Green Power Switch, or unplug unit for 10 seconds, and plug back in)
Thermocouple becomes disconnected, Digital Temperature Control is flashing S.ERR	<ul style="list-style-type: none"> Reconnect Thermocouple. S.ERR on temperature controller will disappear after a brief moment. Cycle power if necessary to clear controller error/alarm warning
Device on, indicated temperature not rising	<ul style="list-style-type: none"> Ensure Thermocouple is connected, located in the Thermocouple Bracket and connected to the Icing Pan

3

Cleaning

Once a day, clean the **HI18/HI24 Econo-Icer** as explained below:

1. REMOVE any debris from the work area before disassembling the **HI18/HI24 Econo-Icer**.
2. UNPLUG and REMOVE **Thermocouple** and **Bracket** from **Icing Pan**.
3. To avoid being burned, WAIT for **Icing Pan** to cool before removing; REMOVE **Icing Pan**.
4. UNPLUG AND REMOVE heating panel assembly from unit.
5. CLEAN the **HI18/HI24 Econo-Icer** with warm water and mild cleaner.
6. LIFT the **Tray Holder** over to the right side rest position, wash with warm soapy water, rinse, and wipe dry.
7. REMOVE **Retainer Knob** (HI24-0041, see parts list) that holds the **Wire / Frame** in place and lift out the **Wire / Frame**. Place **Wire / Frame** in automatic dishwasher. Use caution so that the wires do not get damaged.

8. RETURN the **Tray Holder** to the left side rest position.

For your safety, observe the following warnings throughout the entire cleaning process.

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



- ✓ To avoid the possibility of shock, unplug the unit before cleaning.



- ✓ To avoid damage to the **Wire / Frame**, use caution when removing and transporting.



4

Maintenance

Lubrication

1. USE several drops of Lubriplate FMO-900-AW gear oil on the **Lift Handle Axle**, located under the heating panel assembly.
LUBRICATE EVERY TWO WEEKS.
2. USE Lubriplate FMO-900-AW gear oil to lubricate the tray **Holder** and **Wire Holder Pivot Pins**.
LUBRICATE EVERY WEEK.



WARNING

To avoid serious burns or other injury, always disconnect the machine from the power source before lubricating.



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Econo-Icer HI18/HI24

Technical Supplement

Belshaw Adamatic Bakery Group

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Date of installation _____ Model number _____

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042615

MN-1748EN

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Preface

To transport the **HI18/HI24 Econo-Icer** to the workstation and unpack it, follow the steps listed below:

1. Use a fork lift or pallet jack to transport the shipping crate to workstation.
2. Break down the shipping crate.
3. Remove all packing materials, including foam, tape, brown paper, plastic, and white protective coating.

The **HI18/HI24 Econo-Icer** is designed for quickly and easily icing donuts and a variety of baking products.





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The **HI18/HI24 Econo-Icer** uses electrical elements to heat frosting in its kettle. The machine is available with the following electrical configurations:


- ✓ 220 volts, 1 phase, 50 hertz
- ✓ 240 volts, 1 phase, 50 hertz


The **HI18/HI24 Econo-Icer** produces less than 70 dB(A) of equivalent continuous A-weighted sound pressure at work stations. This has been determined during a run of the machine with shortening in the kettle, using a Bruel & Kjaer sound level meter, type 2236.


To use the **HI18/HI24 Econo-Icer** safely, heed the following warnings:


-  UNPLUG the machine before attempting any adjustment, repair, disassembly, or cleaning to avoid electrocution or other injury.
-  NEVER USE force to assemble, disassemble, operate, clean, or maintain the machine.
-  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.
-  MAKE SURE that all electrical cords are routed so that no one will trip over them.

 To avoid electrocution, **MAKE SURE** that all electrical cords are not frayed or cracked and that they do not pass through any water or icing.

 **NEVER TOUCH** the icing pan once the machine is on. The pan gets very hot, which may cause serious burns.

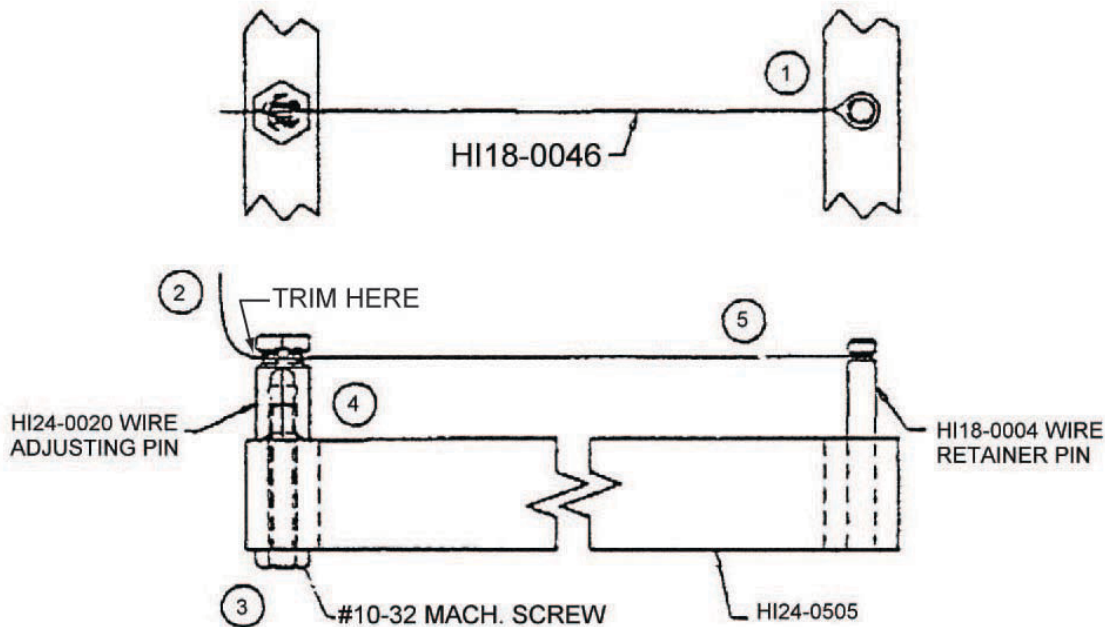
 **DO NOT OVERFILL** the icing pan with icing. If shortening overflows the icing pan, it could cause serious burns or could cause someone to slip on the floor and be seriously injured.

 **MAKE SURE** that the machine and the icing are cool before attempting any adjustment, repair, disassembly, or cleaning. Hot icing can cause serious burns.

 **BE CAREFUL** never to get icing, water, or other materials on the floor. If anything does get spilled on the floor, mop it up immediately. Materials on the floor can cause people to slip or fall, resulting in serious injury or loss of life.

1

Maintenance



Wire Tensioning and Replacement.

The following tools are required for wire tensioning and replacement:

- ✓ 5/16" Open-End Wrench
- ✓ Wire Cutter

IMPORTANT

Do not use a box wrench to tighten. This will cause too much torque, and frame may bend and bow.



1. PLACE looped end of wire over the **Wire Retainer Pin** (HI18-0004) placing it in the groove.
2. THREAD other end of wire through the hole in the **Wire Adjusting Pin** (HI24-0020) and BEND the end pointing up as shown.
3. With the 5/16" open-end wrench, LOOSEN the **#10-32X1" machine screw**.
4. With the 5/16" open-end wrench, TURN the **Wiring Adjusting Pin** to tighten the wire. Be sure the wire winds in the groove of the pin. (This will

also tighten the loop around the **Wire Retainer Pin.**)

5. TIGHTEN the wire until taut, removing all slack. **Do Not Over Tighten! Over Tightening Will Cause The Frame To Bend And Bow.**

6. TIGHTEN the **#10-32 machine screw** to hold pin in place.

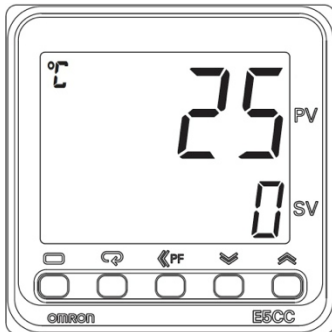
7. TRIM excess tail of the end of wire with wire cutters.

2

Programming the Temperature Controller

The **TJ-0184D-1 or 2 Controller** comes per-programmed and protected so the operator cannot change the setup parameters. To change any settings, you must first unlock the **Controller**.

Note: Only the settings that are changed from the factory settings are listed in this section.



Unlocking the Controller





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 $\bar{\Delta}PPt$ and $\bar{\Delta}SPt$ 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	.	0APt	2:Display and change of only "PV" and "PV/SP" parameters are allowed. [2]
Initial Setting/Communications Protect	1	2	.	1CPt	2:Prohibited. [2]

Changing Operator Set Points






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**  **key** to
change the parameter.
3. PRESS the  **key** to return to
operator screen.

PARAMETER	FACTORY DEFAULT SETTING	PRESENT SETTING	UNIT	FRONT PANEL	EXPLANATION OF PRESENT SETTING
Operator Set Points					
Set Point	0.0	125.0/50.0	°F/°C	.	.
Alarm Value 1	0.0	10.0/5.0	°F/°C	AL - 1	.

Changing Operator Level Parameters





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**  **key** to change the parameter.
4. PRESS the  **key** to return to operator screen.

PARAMETER	FACTORY DEFAULT SETTING	PRESENT SETTING	UNIT	FRONT PANEL	EXPLANATION OF PRESENT SETTING
Operator Level Parameters					
Process Value Input Shift	0.0	0.0	°F/°C	<i>2N5</i>	This is the offset setting for calibration.
Hysteresis (Heating)	1.0	0.5	°F/°C	<i>HYS</i>	.

Changing Initial Level Parameters

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**  **key** to change the parameter.

4. PRESS the  **key** for more than 1 second return to operator screen.

PARAMETER	FACTORY DEFAULT SETTING	PRESENT SETTING	UNIT	FRONT PANEL	EXPLANATION OF PRESENT SETTING
Initial Level Parameters					
Input Type	5	8	.	IN-T	8:Thermocouple [J] (-20.0 to 400.0°C or 0.0 to 750.0°F) [8]
Temperature Unit	0	1	.	d-U	°F [F]
SP Upper Limit	130.0	150.0/65.0	°F/°C	SL-H	.
SP Lower Limit	-20.0	0.0	°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]

Changing Advanced Level Parameters








To change advanced level parameters:
(Must be unlocked.)

- UNLOCK the controller.
- PRESS the  **key** for more than 1 second to adjust initial parameters.
- PRESS the  **key** until you get to parameter *AM0V*.
- PRESS the  **or**  key to change *AM0V* parameter to -169.

PARAMETER	FACTORY DEFAULT SETTING	PRESENT SETTING	UNIT	FRONT PANEL	EXPLANATION OF PRESENT SETTING
Advanced Level Parameters					
Alarm 1 Latch	0	1	.	<i>AlL</i>	Enabled [<i>oN</i>]
PV/SP No. 1 Display Selection	4	1	.	<i>SPd1</i>	1: "PV/SP/No display" [1]
PV Decimal Point Display	1	0	.	<i>PVdP</i>	OFF [<i>oFF</i>]







Locking the Controller

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**  **key** to change the parameter *oAPL* and *oPL* from 0 to 2.
4. PRESS the  +  **keys** for more than 1 second to return to operator screen.

Setting the Controller to Default Settings

To set the controller back to factory default settings: (Must be unlocked.)

1. PRESS the  **key** for more than 1 second to adjust initial parameters.
2. PRESS the  **key** until you get to **parameter** *AMoV*.
3. PRESS the  **or**  **key** to change *AMoV* **parameter** to - **169**.
4. CHANGE **parameter** *oNLE* from *oFF* to *FACt*.
5. PRESS the  **key** for more than 1 second to return to initial screen.
6. PRESS the  **key** for more than 1 second to return to operator screen.

3

Troubleshooting

If you have a problem with your **HI18/HI24 Econo-Icer** that you cannot solve, call your dealer or another qualified technician.

If your dealer cannot help you, please call Belshaw Adamatic at 800-578-2547. When you call, please specify the following:

- ✓ The MODEL NAME of the machine.
- ✓ The SERIAL NUMBER of the machine.
- ✓ The VOLTAGE, PHASE, and CYCLE of the machine.

CAUTION

IF YOU PERFORM REPAIRS YOURSELF, OR HAVE THEM PERFORMED BY ANYONE OTHER THAN A SERVICE TECHNICIAN AUTHORIZED BY BELSHAW ADAMATIC, YOU DO SO AT YOUR OWN RISK.



DISCONNECT THE MACHINE FROM THE POWER SOURCE BEFORE DISASSEMBLING, REPAIRING, OR WIRING.



Troubleshooting Specifics

NO HEAT AND ON/OFF SWITCH DOES NOT LIGHT UP	
Possible Causes	What To Do
Unit not plugged in or wall electrical breaker is tripped.	Plug unit in and/or check electrical outlet.
ON/OFF SWITCH ON AND LIT UP, HEATING LIGHT NOT ON	
Possible Causes	What To Do
Loose wire.	Check wires.
NO HEAT, ON/OFF SWITCH ON AND LIT UP, HEATING LIGHT ON	
Possible Causes	What To Do
Heating element failure.	Check heating element of open circuit.
Relay failure.	Check if relay turns on; replace if defective.
UNEVEN ICING TEMPERATURE.	
Possible Causes	What To Do
Icing needs stirring.	Stir icing.
WIRES ARE NOT EVENLY TAUT	
Possible Causes	What To Do
Wires are not evenly adjusted.	Tighten loose wires.
NO HEAT, ON/OFF SWITCH ON AND LIT UP, HEATING LIGHT NOT ON	
Possible Causes	What To Do
Loose wire.	Check wires.
High limit tripped.	Wait 10 minutes and recheck.
Temperature controller set too low.	Adjust set point higher.
Thermocouple not plugged in.	Plug thermocouple into connector.

Parts Diagrams for HI18F, HI24F

Mark the Item Number for your Icer below.

ABOUT ITEM NUMBERS:

Icer models are identified by an Item Number. You need your Icer's Item Number to find the correct parts diagrams for your glazer. The Item Number is located on a data tag on the icer. When the item number is known, it should be checked off on the cover page of this manual, and also in the table below.

<input checked="" type="checkbox"/>				
MARK YOUR ICER'S ITEM NUMBER BELOW	ITEM NUMBER	MODEL	VOLTS	HERTZ
<input type="checkbox"/>	20024	HI 18F	110-120 V	50/60 HZ
<input type="checkbox"/>	20025-3	HI 18F	208-240 V	50/60 HZ
<input type="checkbox"/>	20022	HI 24F	110-120 V	50/60 HZ
<input type="checkbox"/>	20023-3	HI 24F	208-240 V	50/60 HZ

DIAGRAM: HI18-2012TAB, OVERALL ASSEMBLY

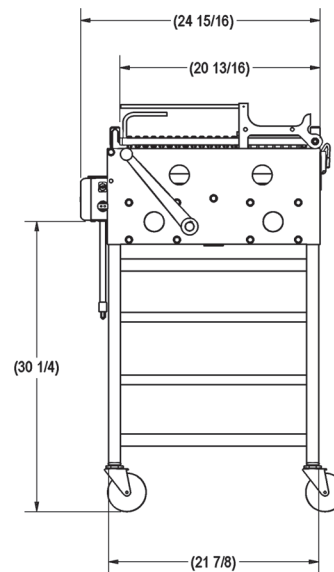
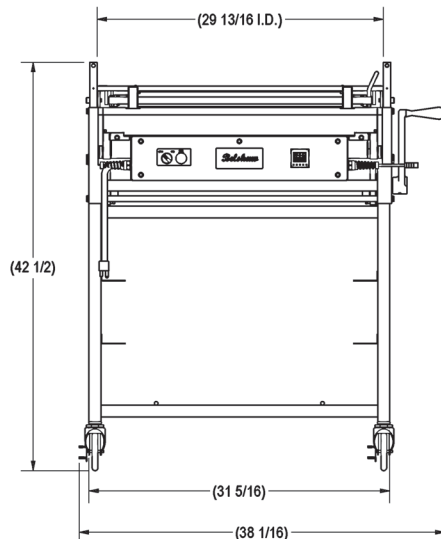
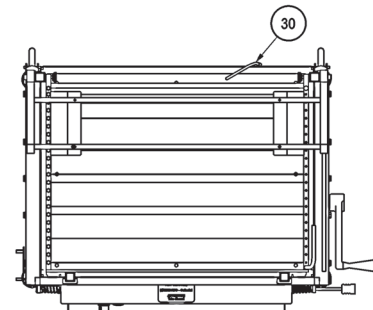
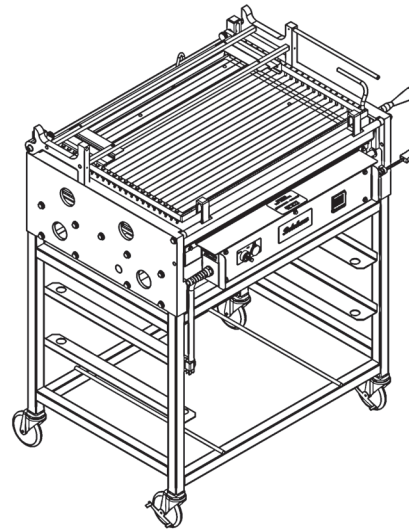
120V and 208-240V models

Model: HI18F

Item Numbers: 20024, 20025-3

TO IDENTIFY MODEL AND ITEM NUMBER, SEE DATA TAG ON ICER

BILL OF MATERIAL				
ITEM	HI18-2012 QTY	HI18-2012-240CE QTY	PART NUMBER	DESCRIPTION
1	2	2	HI24-0008-1	STAND-OFF; CONDUIT
2	4	4	FT6-0120	CASTER SOCKET; 18 GA, 1.25, RT-POLY
3	2	-	HG18-0031-4	SWIVEL CASTER, 4"
4	2	-	HG18-0031B-4	SWIVEL CASTER W/BRAKE, 4"
5	1	1	HI18-0001	ICING PAN
6	2	2	HI18-0008	LIFT SHAFT
7	2	2	HI18-0021	TRAY HOLDER (NOT SHOWN)
8	1	1	HI18-0030	SPACER SHAFT-SHORT
9	8	8	HI18-0031	SHAFT; SPACER-LONG
10	1	1	HI18-0032	SIDE PANEL-RIGHT (MACH)
11	1	1	HI18-0033	SIDE PANEL-LEFT (MACH)
12	1	1	HI18-0035	LIFT HANDLE
13	1	1	HI18-0037	TRAY STOP
14	4	4	HI18-0042	FOOT
15	2	2	HI18-0057	SCREEN HOLDER-FRONT
16	4	4	HI18-0084-1	SPACER FILLER
17	2	2	HI18-0502	LIFT BRACKET ASSEMBLY
18	1	1	HI18-0503	LIFT AXLE ASSEMBLY
19	1	-	HI18-0505	ASSY; POWER CORD; 120V, 15AMP
20	2	2	HI18-0506	HINGE BOLT ASSEMBLY
21	2	2	HI18-0521	ASSY; MOUNTING BRACKET; TRAY HOLDER
22	1	1	HI18-1002	ASSY_DONUT RETAINER FRAME
23	1	1	HI18-1003	ASSEMBLY, TRAY RETAINER
24	1	1	HI18-1010SS	WELDMENT; FRAME ASSEMBLY
25	1	-	HI18-1300	HEATING PANEL ASSY; 120V
26	-	1	HI18-1300-240CE	HEATING PANEL ASSY; 240V CE
27	1	1	HI24-7010L	RETAINING BRKT, HI TRAYS
28	1	1	HI24-7010	RETAINING BRKT, HI TRAYS
29	-	1	HI24-9002	POWER CORD; CEE 7/7
30	(REF)	(REF)	TCPL-0004A	THERMOCOUPLE, TYPE J, MALE
31	4	4	903-0973SS	1/4-20X5/8 SS HEX CAP SCREW
32	2	2	903-1319SS	5/16-18X1 UNC SS HEX HEAD MACHINE SCREW
33	4	4	903-1321	5/16-18X3/4 UNC SS HEX HEAD MACHINE SCREW
34	16	16	903-1330	5/16-18X1 UNC SS HEX HEAD MACHINE SCREW
35	2	2	903-1335SS	5/16-18X1-1/4 SS HEX CAP SCREW
36	2	2	903-1355SS	5/16-18X2 UNC SS HEX HEAD MACHINE SCREW
37	2	2	903-6103	5/16-18 UNC SS HEX NUT
38	4	4	903-7529	1/4 SS INT TOOTH LOCK WASHER
39	20	20	903-7540SS	SST, 5/16 FLAT WASHER, REGULAR



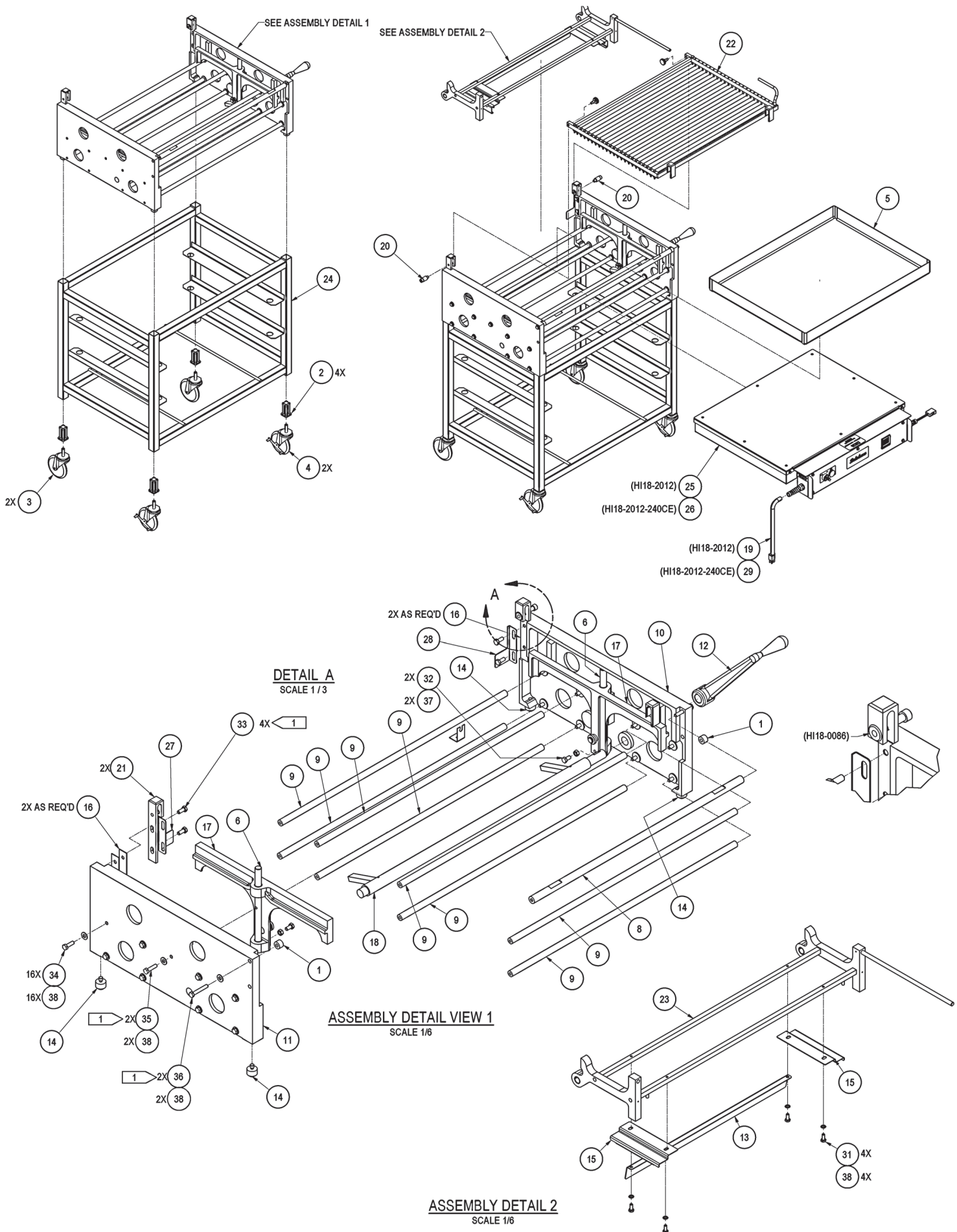


DIAGRAM: HI24-2005TAB, OVERALL ASSEMBLY

120V and 208-240V models

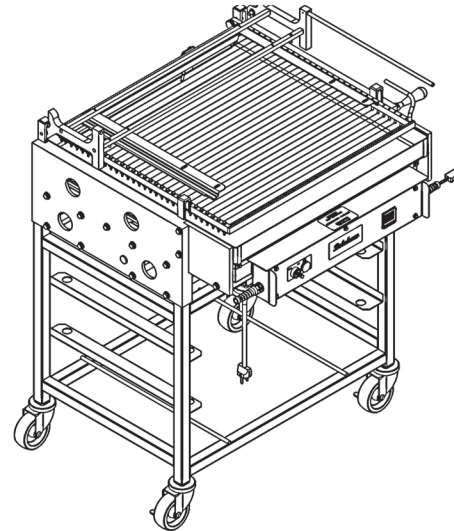
Model: HI24F

Item Numbers: 20022, 20023-3

TO IDENTIFY MODEL AND ITEM NUMBER, SEE DATA TAG ON ICER

BILL OF MATERIAL

ITEM	HI24-2005 QTY	HI24-2005-240CE QTY	PART NUMBER	DESCRIPTION
1	4	4	FT6-0120	CASTER SOCKET; 18 GA, 1.25, RT-POLY
2	2	2	HG18-0031-4	SWIVEL CASTER, 4"
3	2	2	HG18-0031B-4	SWIVEL CASTER W/BRAKE, 4"
4	2	2	HI18-0008	LIFT SHAFT
5	1	1	HI18-0030	SPACER SHAFT-SHORT
6	8	8	HI18-0031	SHAFT; SPACER-LONG
7	1	1	HI18-0032	SIDE PANEL-RIGHT (MACH)
8	1	1	HI18-0033	SIDE PANEL-LEFT (MACH)
9	1	1	HI18-0035	LIFT HANDLE
10	1	1	HI18-0037	TRAY STOP
11	4	4	HI18-0042	FOOT
12	2	2	HI18-0502	LIFT BRACKET ASSEMBLY
13	1	1	HI18-0503	LIFT AXLE ASSEMBLY
14	1	-	HI18-0505	ASSY; POWER CORD; 120V, 15AMP
15	2	2	HI18-0506	HINGE BOLT ASSEMBLY
16	2	2	HI18-0521	ASSY; MOUNTING BRACKET; TRAY HOLDER
17	1	1	HI18-1010SS	WELDMNT; FRAME ASSEMBLY
18	1	1	HI24-0006	ICING PAN
19	2	2	HI24-0008	PAN EXTENSION
20	2	2	HI24-0018	TRAY HOLDER
21	1	1	HI24-1001	DONUT RETAINER FRAME ASSY
22	1	1	HI24-1002	ASSEMBLY; TRAY RETAINER
23	1	-	HI24-1300	HEATING BOX ASSEMBLY, 120V
24	-	1	HI24-1300-240CE	HEATING BOX ASSY, 240V CE
25	-	1	HI24-9002	POWER CORD; CEE 7/7
26	1	1	HI24-7010	RETAINING BRKT, HI TRAYS
27	1	1	HI24-7010L	RETAINING BRKT, HI TRAYS
28	(REF)	(REF)	TCPL-0004A	THERMOCOUPLE, TYPE J, MALE
29	4	4	903-0973SS	1/4-20X5/8 SS HEX CAP SCREW
30	2	2	903-1319SS	5/16-18X1 UNC SS HEX HEAD MACHINE SCREW
31	4	4	903-1321	5/16-18X3/4 UNC SS HEX HEAD MACHINE SCREW
32	16	16	903-1330	5/16-18X1 UNC SS HEX HEAD MACHINE SCREW
33	4	4	903-1335SS	5/16-18X1-1/4 SS HEX CAP SCREW
34	4	4	903-1350	5/16-18X1-1/2 UNC SS HEX HEAD MACHINE SCREW
35	2	2	903-6103	5/16-18 UNC SS HEX NUT
36	4	4	903-7529	1/4 SS INT TOOTH LOCK WASHER
37	24	24	903-7540SS	SST, 5/16 FLAT WASHER, REGULAR



ASSEMBLED VIEW

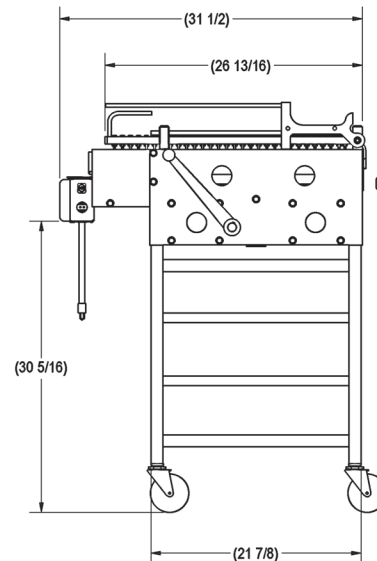
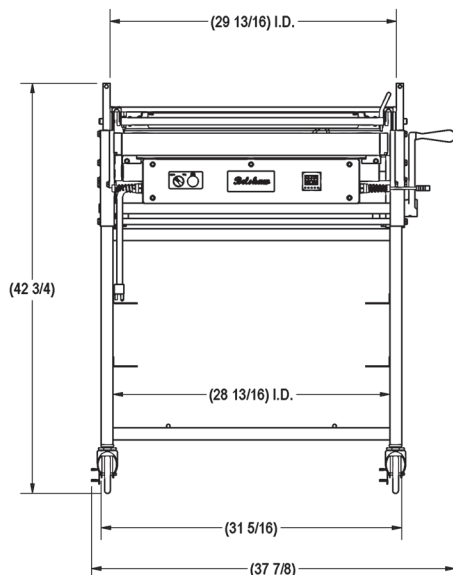
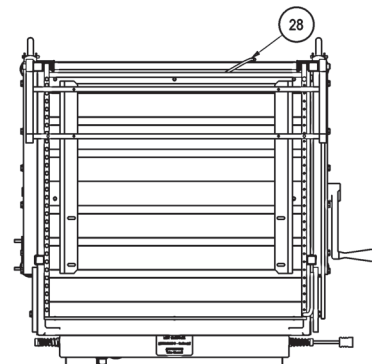


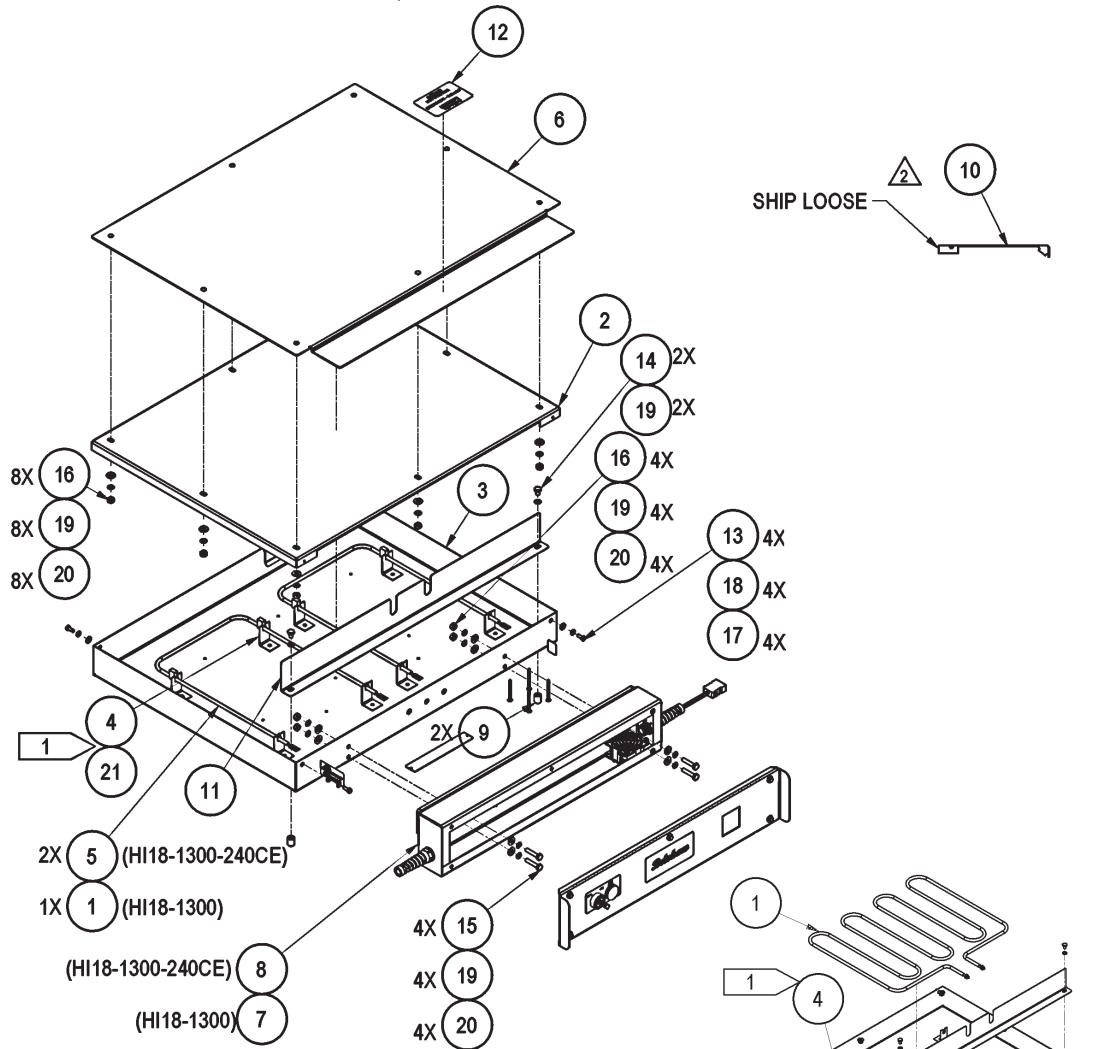
DIAGRAM: HI18-1300, HEATING PANEL ASSEMBLY

120V and 208-240V models

Model: HI18F

Item Numbers: 20024, 20025-3

TO IDENTIFY MODEL AND ITEM NUMBER, SEE DATA TAG ON ICER



BILL OF MATERIAL				
ITEM	HI18-1300 QTY	HI18-1300-240CE QTY	PART NUMBER	DESCRIPTION
1	1	-	HI18-0038	HEATER ELEMENT
2	1	1	HI18-0038	COVER, ELEMENT HOUSING
3	1	1	HI18-0039	ELEMENT HOUSING
4	7	8	HI18-0053	ELEMENT RETAINER BRACKET
5	-	2	HI18-0072	HEATER ELEMENT 250V/1500W
6	1	1	HI18-0089	PLATE; HEAT TRANSFER
7	1	-	HI24-1017	SWITCH BOX ASSY 120/60/1
8	-	1	HI24-1017-240CE	SWITCH BOX ASSY 240/60/1 CE
9	2	2	HI24-6000	SAFETY PIN
10	1	1	HI24-7008	BRACKET, THERMOCOUPLE
11	1	1	HI24-7009	BAFFLE; HEAT SHIELD
12	1	1	MK-0186	CAUTION HOT SURFACE LABEL
13	4	4	903-0519SS	10-24X1/2 HEX HEAD M/S SS
14	2	2	903-0961SS	SST, 1/4-20 X 0.375 HEX HEAD MACHINE SCREW
15	4	4	903-1007	SST, 1/4-20 X 1.25 HEX HEAD MACHINE SCREW
16	12	12	903-5200	1/4-20UNC SS HEX NUT
17	4	4	903-7513	#10 FLAT WASHER SAE SS
18	4	4	903-7514	#10 SS INTERNAL TOOTH LOCKWASR
19	18	18	903-7529	1/4 SS INT TOOTH LOCK WASHER
20	16	16	903-7531SS	1/4 SS WASHER STANDARD FLAT WASHER
21	7	8	905-0720	RIVET; 1/8 X 5/16 SS

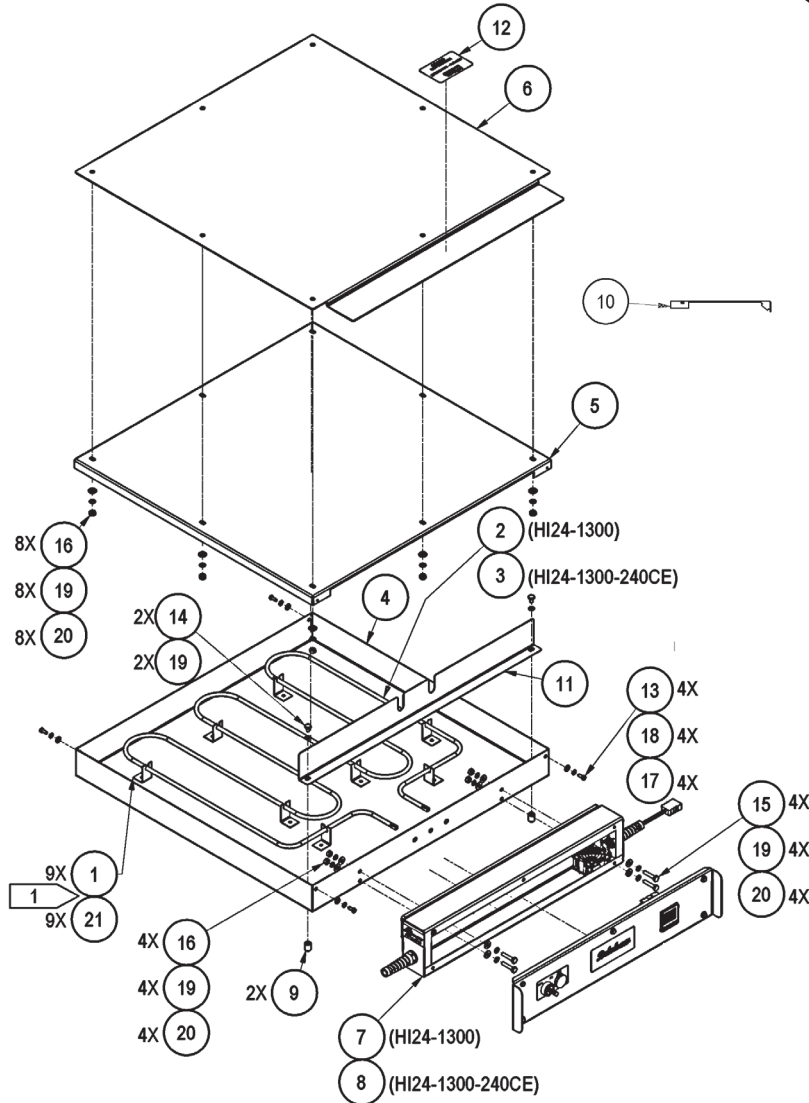
DIAGRAM: HI24-1300, HEATING PANEL ASSEMBLY

120V and 208-240V models

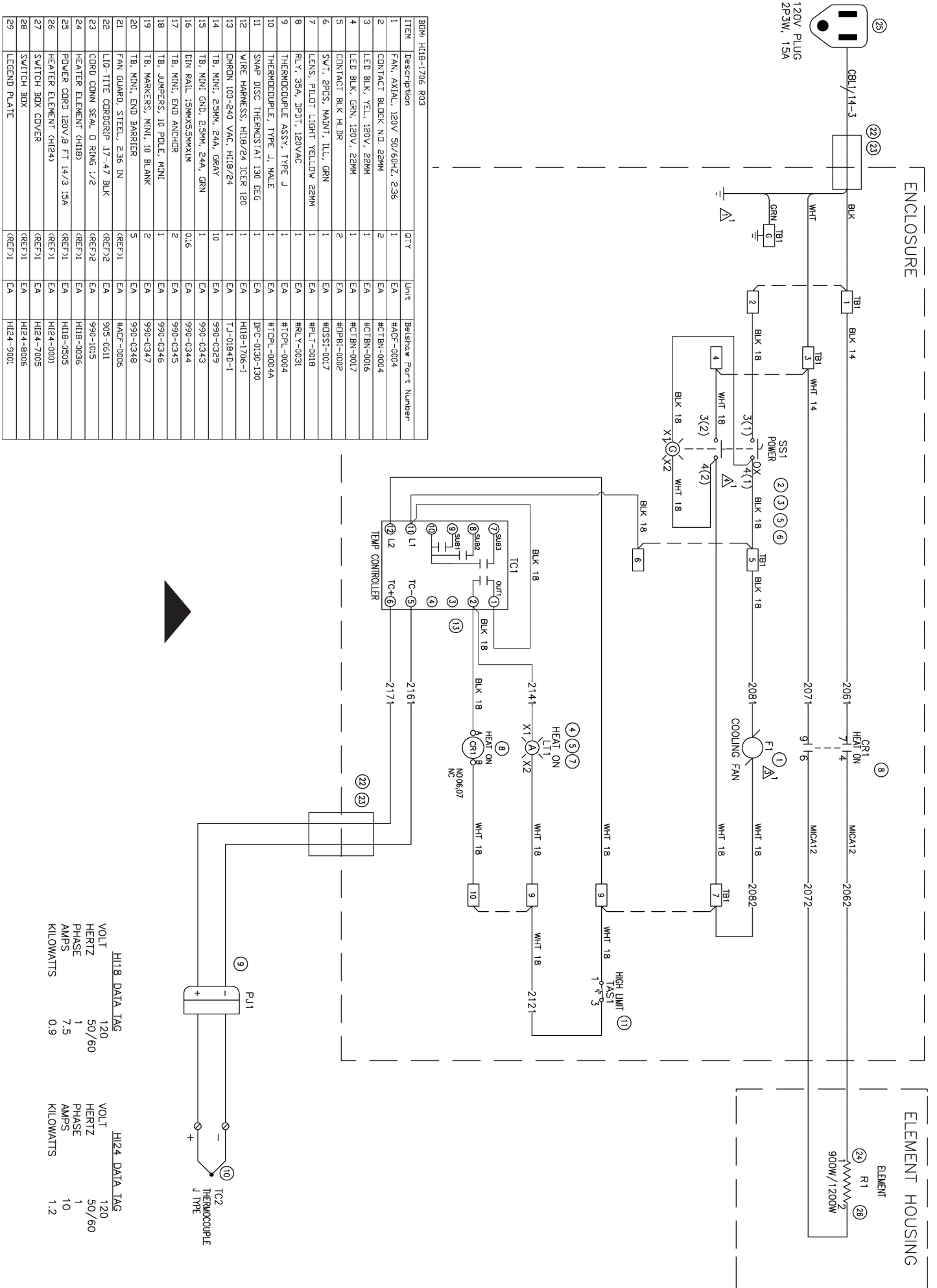
Model: HI24F

Item Numbers: 20022, 20023-3

TO IDENTIFY MODEL AND ITEM NUMBER, SEE DATA TAG ON ICER



BILL OF MATERIAL				
ITEM	HI24-1300 QTY	HI24-1300-240CE QTY	PART NUMBER	DESCRIPTION
1	8	9	HI18-0053	ELEMENT RETAINER BRACKET
2	1	-	HI24-0001	HEATING ELEMENT 120V/1200W
3	-	1	HI24-0001-240	HEATING ELEMENT 240V/1200W
4	1	1	HI24-0004	ELEMENT HOUSING
5	1	1	HI24-0005	ELEMENT HOUSING COVER
6	1	1	HI24-0011	HEAT TRANSFER PLATE
7	1	-	HI24-1017	SWITCH BOX ASSY 120/60/1
8	-	1	HI24-1017-240CE	SWITCH BOX ASSY 240/60/1 CE
9	2	2	HI24-6000	SAFETY PIN
10	1	1	HI24-7008	BRACKET, THERMOCOUPLE
11	1	1	HI24-7009	BAFFLE; HEAT SHIELD
12	1	1	MK-0186	CAUTION HOT SURFACE LABEL
13	4	4	903-0519SS	10-24X1/2 HEX HEAD M/S SS
14	2	2	903-0961SS	SST, 1/4-20 X 0.375 HEX HEAD MACHINE SCREW
15	4	4	903-1007	SST, 1/4-20 X 1.25 HEX HEAD MACHINE SCREW
16	12	12	903-5200	1/4-20UNC SS HEX NUT
17	4	4	903-7513	#10 FLAT WASHER SAE SS
18	4	4	903-7514	#10 SS INTERNAL TOOTH LOCKWASR
19	18	18	903-7529	1/4 SS INT TOOTH LOCK WASHER
20	16	16	903-7531SS	1/4 SS WASHER STANDARD FLAT WASHER
21	8	9	905-0720	RIVET; 1/8 X 5/16 SS



ITEM	Description	QTY	Unit	Belshaw Part Number
1	FAN, AXIAL, 120V 50/60HZ, 2.36	1	EA	#ACF-0004
2	CONTACT BLOCK, N.D., 22MM	2	EA	#CTBN-0004
3	LED BLK, YEL, 120V, 22MM	1	EA	#CTBN-0016
4	LED BLK, GRN, 120V, 22MM	1	EA	#CTBN-0017
5	CONTACT BLK HLDR	2	EA	#DDBI-0002
6	SWT, 2POS, MAINT, ILL, GRN	1	EA	#DSSI-0017
7	LENS, PILOT LIGHT YELLOW 22MM	1	EA	#PLT-0018
8	RLY, 35A, DPDT, 120VAC	1	EA	#RLY-0031
9	THERMOCOUPLE ASSY, TYPE J	1	EA	#TCPL-0004
10	THERMOCOUPLE, TYPE J, MALE	1	EA	#TCPL-0004A
11	SNAP DISC THERMUSTA 130 DEG	1	EA	#DPC-0130-130
12	WIRE HARNESS, HI18/24 ICER 120	1	EA	HI18-1706-1
13	DMRN 100-240 VAC, HI18/24	1	EA	TJ-0184D-1
14	TB, MINI, 2.5MM, 24A, GRAY	10	EA	990-0329
15	TB, MINI GND, 2.5MM, 24A, GRN	1	EA	990-0343
16	DIN RAIL, 15MMX35MMX1M	0.16	EA	990-0344
17	TB, MINI, END ANCHOR	2	EA	990-0345
18	TB, JUMPERS, 10 POLE, MINI	1	EA	990-0346
19	TB, MARKERS, MINI, 10 BLANK	2	EA	990-0347
20	TB, MINI, END BARRIER	5	EA	990-0348
21	FAN GUARD, STEEL, 2.36 IN	1	EA	#ACF-0006
22	LO-11E CORDGRP 17-.47 BLK	1	EA	905-0611
23	CORD CONN SEAL, O RING 1/2	1	EA	990-1015
24	HEATER ELEMENT GH18	1	EA	HI18-0036
25	POWER CORD 120V/18 FT 14/3 ISA	1	EA	HI18-0505
26	HEATER ELEMENT GH24	1	EA	HI24-0001
27	SWITCH BOX COVER	1	EA	HI24-7005
28	SWITCH BOX	1	EA	HI24-8006
29	LEGEND PLATE	1	EA	HI24-9001

HI18 DATA TAG	HI24 DATA TAG
VOLT	120
HERTZ	50/60
PHASE	1
AMPS	7.5
KILOWATTS	0.9

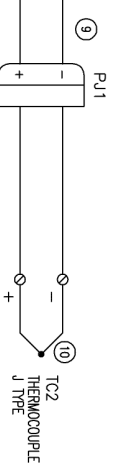
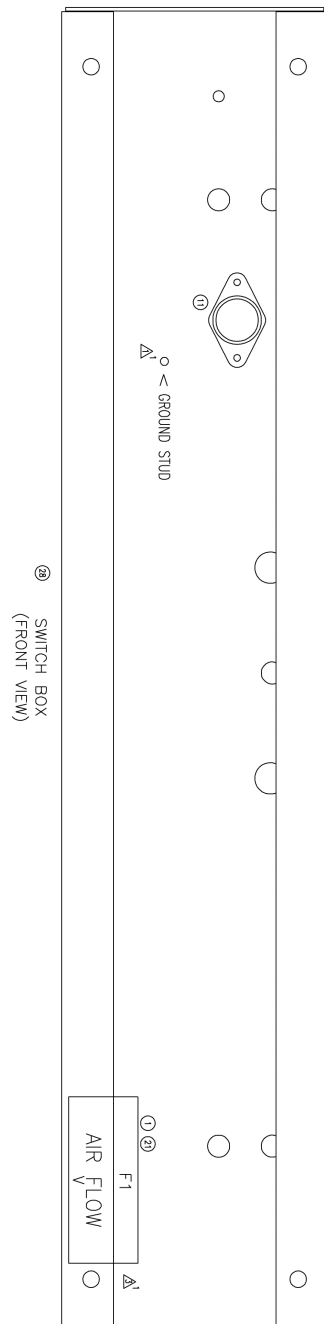
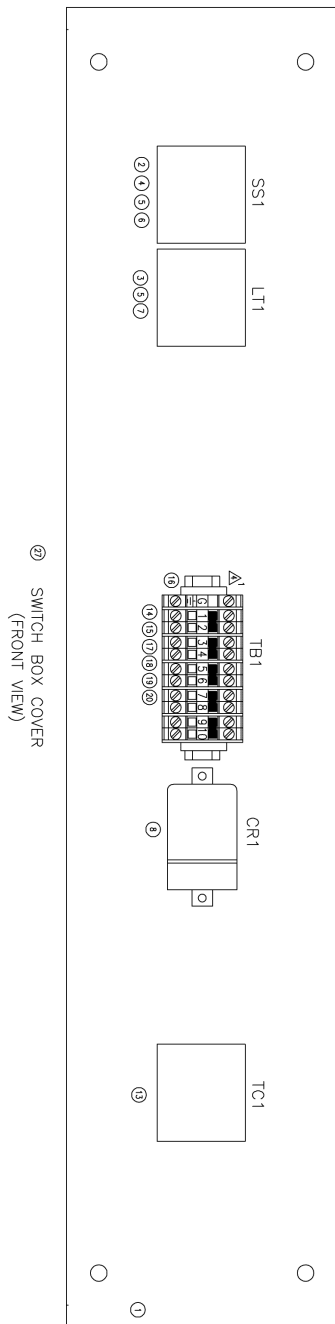
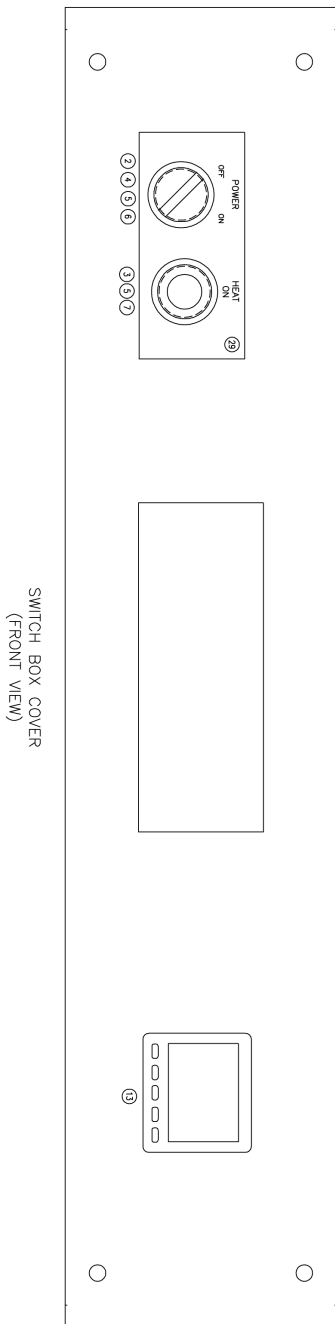
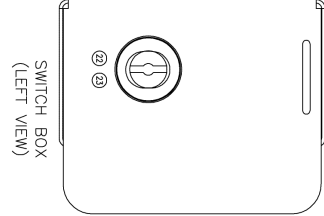
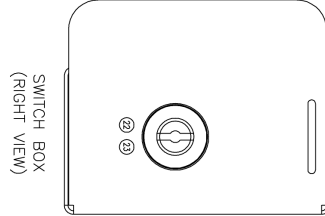


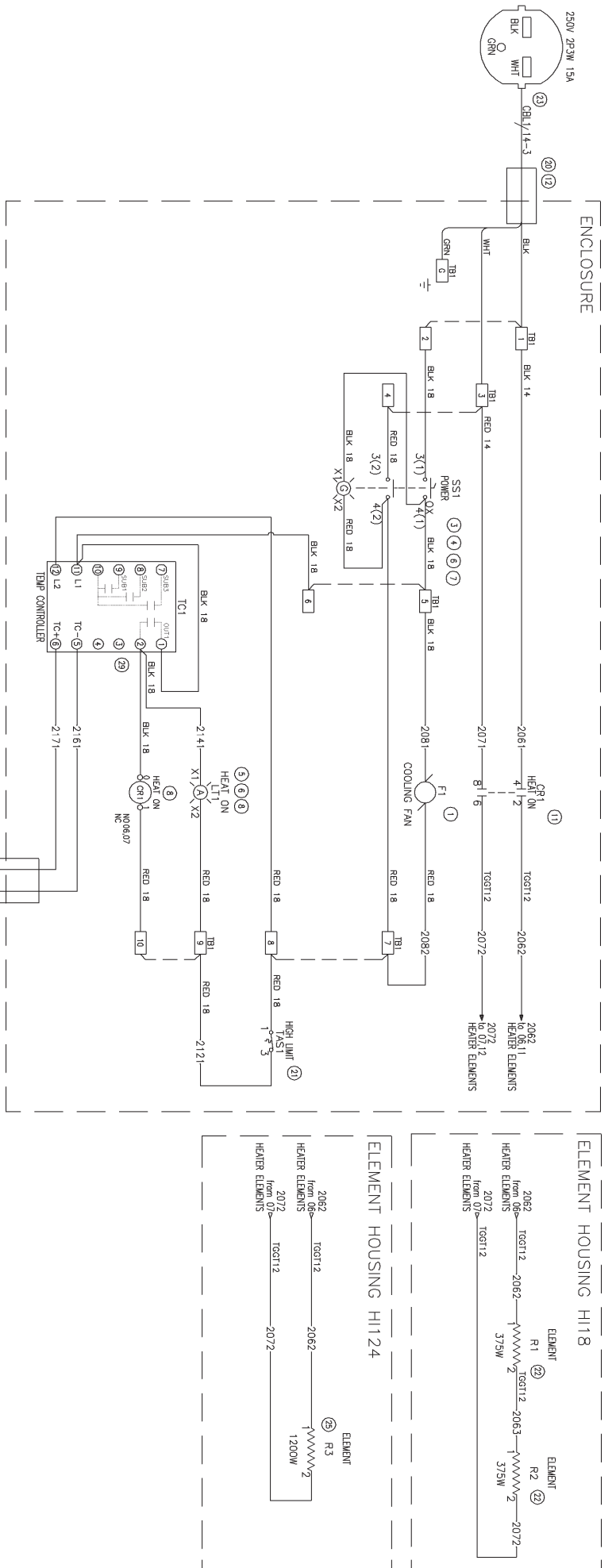
DIAGRAM: HI18-1706, ELECTRICAL ASSEMBLY/DIAGRAM

HI18F, HI24F (120-Volt models)

Item Numbers: 20024, 20022

TO IDENTIFY MODEL AND ITEM NUMBER, SEE DATA TAG ON ICER





ITEM	Description	Manufacturer Part Number	QTY	Belshaw Part Number
1	FAN, AXIAL, 230V 50/60HZ, 2.36	ORION FANS: OX60AP-22-1WB	1	#ACF-0006
2	FAN GUARD, STEEL, 2.36 IN	DAYTON: 38P19	0	#ACF-0006
3	CONTACT BLOCK, N.O. 22MM	SCHNEIDER: ZBE101	2	#CTBN-0004
4	LED BLK, GRN, 230V, 22MM	SCHNEIDER: ZBMA3	1	#CTBN-0018
5	LED BLK, YEL, 230V, 22MM	SCHNEIDER: ZBMA5	1	#CTBN-0019
6	CONTACT BLK, HLDR	SCHNEIDER: ZB4R2002	2	#OPBI-0002
7	SWT, 2POS, MANT, ILL, GRN	SCHNEIDER: ZB4R1233	1	#OSI-0017
8	LENS, PILOT LIGHT YELLOW 22MM	SCHNEIDER: ZB4R053	1	#PLI-0018
9	SQ D, RELAY, DPDT, 30A, 240V	SCHNEIDER: RPF28F7	1	#RLY-0035
10	THERMOCOUPLE ASST, TYPE J	EUSTIS: FEJ000X0245X	1	#TCI-0004
11	THERMOCOUPLE, TYPE J MALE	EUSTIS: ED-128-14	1	#TCI-0004A
12	LI-O-TITE CORDGRP, 17'-47' BLK	HEVCO: 3251	0	905-0611
13	TB, MINI, 2.5MM, 24A, GRAY	ALLEN-BRADLEY: 1492-LM3	9	990-0329
14	TB, MINI, 2.5MM, 24A, GRN	ALLEN-BRADLEY: 1492-LMG3	1	990-0343
15	DIN RAIL, 15MMX5MMX1M	ALLEN-BRADLEY: 1492-DR3	0.16	990-0344
16	TB, MINI, END ANCHOR	ALLEN-BRADLEY: 1492-EA15	2	990-0345
17	TB, JUMPERS, 10 POLE, MINI	ALLEN-BRADLEY: 1492-CJL5-10-BL	1	990-0346
18	TB, MARKERS, MINI, 10 BLANK	ALLEN-BRADLEY: 1492-M5X5	2	990-0347
19	TB, MINI, END BARRIER	ALLEN-BRADLEY: 1492-EBMA3	1	990-0348
20	CORD CONN, SEAL, 0 FRING, 1/2	HUBBELL: 20809001	0	990-1015
21	SNAP DISC, 130 DEG SPST	SUPCO: L130	1	DP-C-0130-130
22	HEATER ELEMENT 250V/1500W	EMERSON ELECTRIC: CH626-F83-004	0	H18-0072
23	WIRE HARNESS, H18/24, 240V UL	POWER FIRST: 3MY39	0	H18-0505-250
24	ELEMENT 240V/1200W	CHROMALOX: 333-877864-002	0	H18-1708-1
25	LABEL, ON/OFF SWT, HEAT LIGHT	:	0	H124-0001-240
26	CONGR. SWITCH BOX, ENCL, H18/H124	:	0	H124-7005
27	WLD.T. SWITCH BOX, ENCLOSURE	:	0	H124-8006 R005
28	TEMP CRTL.H18/24, 120-240V, DEG F	:	1	TJ-0184D-1
29	TEMP CRTL.H18/24, 120-240V, DEG F	:	1	TJ-0184D-1

H118 ELECTRICAL DATA		H124 ELECTRICAL DATA	
MODEL	H18-1708	MODEL	H124-1708
HERTZ	60	HERTZ	60
VOLTS	208	VOLTS	240
PHASE	1 PH	PHASE	1 PH
AMPS	2.52	AMPS	4.36
LARGEST MOTOR H.P.	0.125	LARGEST MOTOR H.P.	0.91
SHORT CIRCUIT RATING	-	SHORT CIRCUIT RATING	1.21
DIAGRAM NUMBERS	H18-1707	DIAGRAM NUMBERS	H18-1707

DIAGRAM: HI18-1708, ELECTRICAL ASSEMBLY/DIAGRAM

HI18F, HI24F (208-240 Volt models)

Item Numbers: 220025-3, 20023-3

TO IDENTIFY MODEL AND ITEM NUMBER, SEE DATA TAG ON ICER

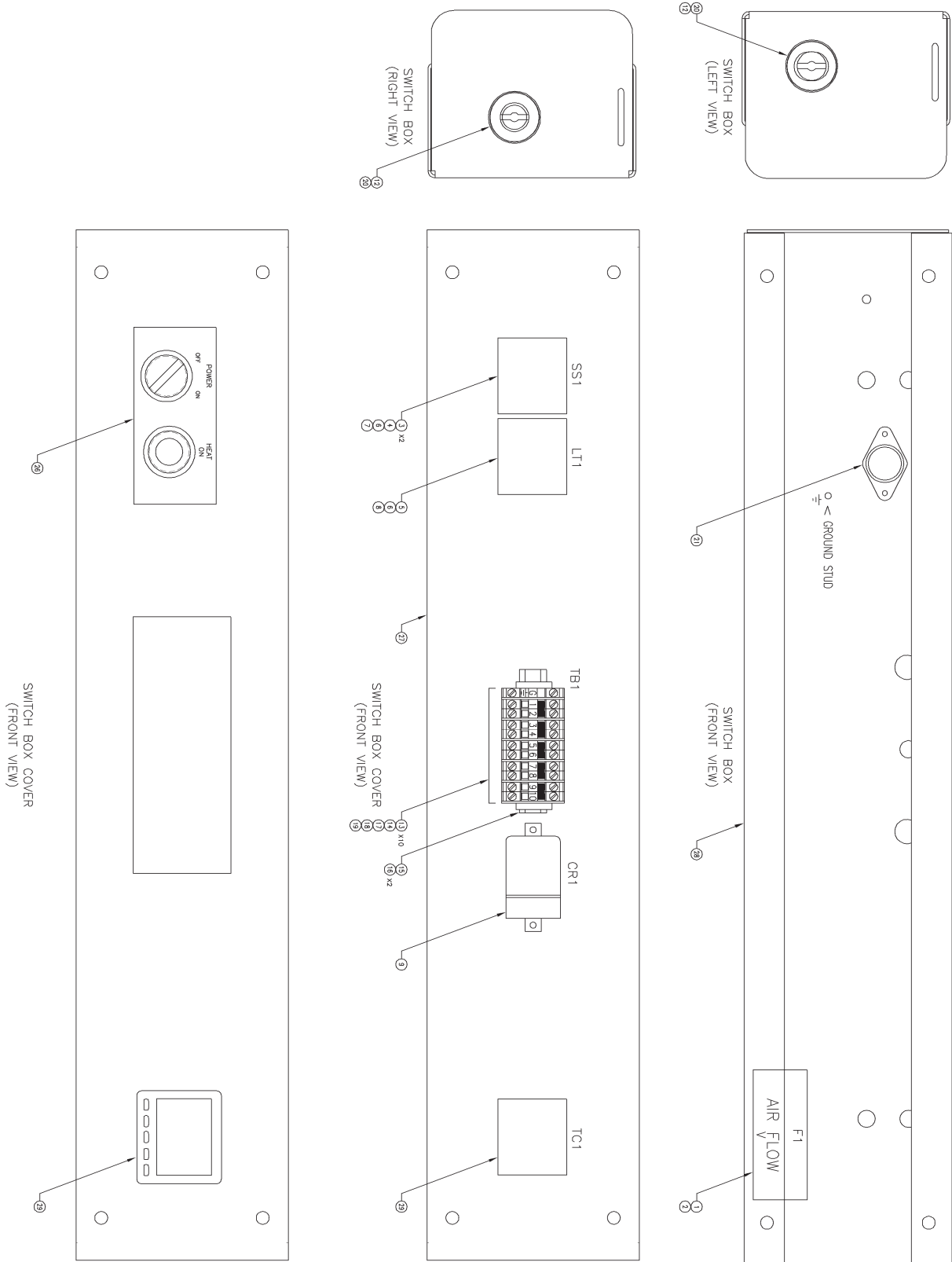
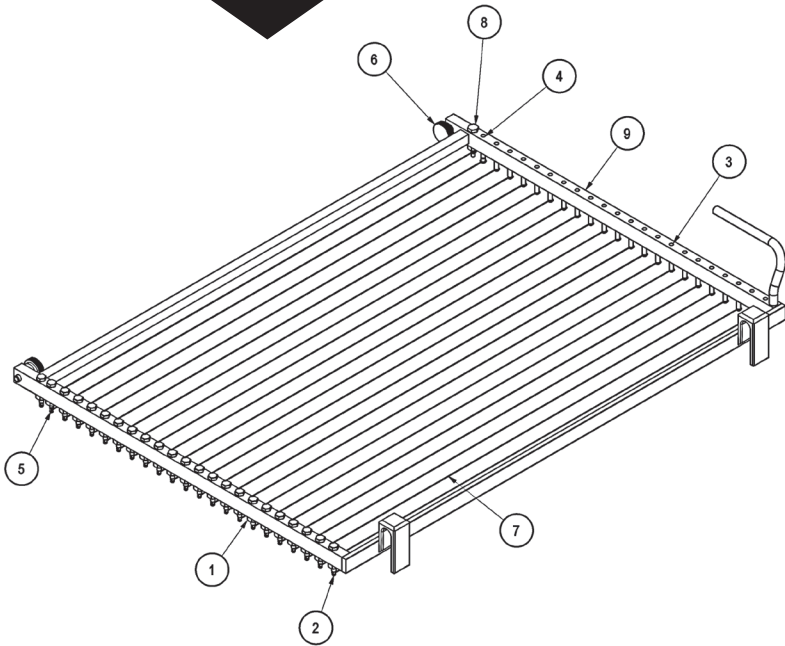


DIAGRAM: HI18-1002, DONUT RETAINER FRAME

Model: HI18F, Item Numbers 20024, 20025-3

TO IDENTIFY MODEL AND ITEM NUMBER, SEE DATA TAG ON ICER

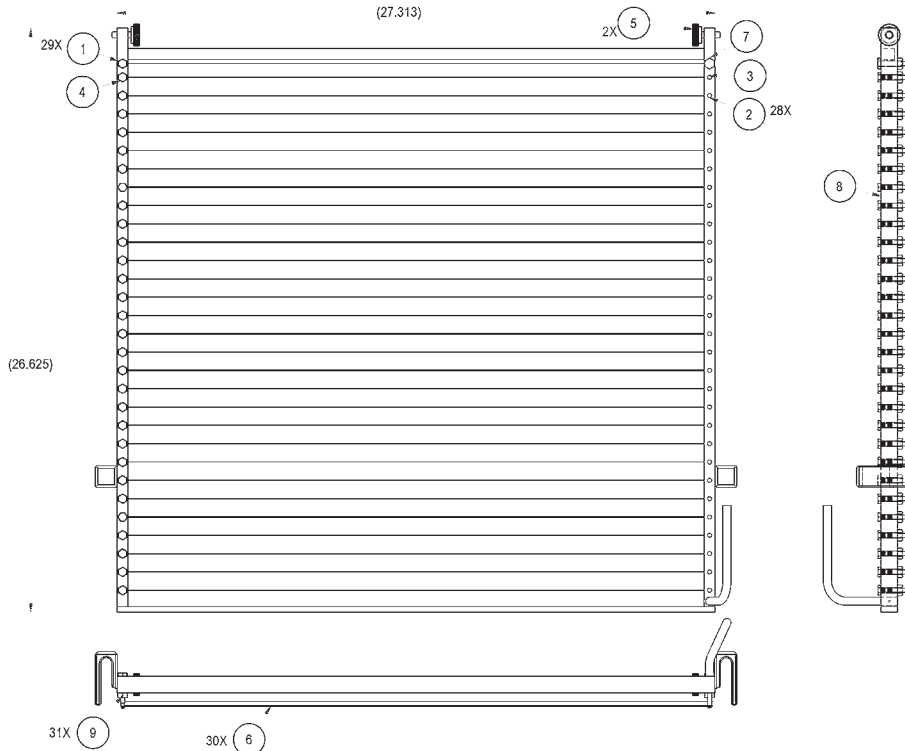


BILL OF MATERIAL			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	24	903-5205SS	1/4-28 SS HEX FINISH NUT
2	22	HI18-0002	TENSION BOLT WIRE
3	21	HI18-0004	WIRE RETAINER PIN
4	1	HI18-0019	WIRE RETAINER PIN - DUAL WIRE
5	1	HI18-0022	TENSION BOLT WIRE
6	2	HI18-0041	KNOB - DONUT RETAINER FRAME
7	23	HI18-0046	WIRE; S.S.
8	1	HI18-0051	TENSION BOLT WIRE (SAFETY, FRONT)
9	1	HI18-0504	SUB-ASSY; DONUT RETAINER FRAME

DIAGRAM: HI24-1002, DONUT RETAINER FRAME

Model: HI24F, Item Numbers 20022, 20023-3

TO IDENTIFY MODEL AND ITEM NUMBER, SEE DATA TAG ON ICER



BILL OF MATERIAL			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	29	HI18-0002	TENSION BOLT WIRE
2	28	HI18-0004	WIRE RETAINER PIN
3	1	HI18-0019	WIRE RETAINER PIN - DUAL WIRE
4	1	HI18-0022	TENSION BOLT WIRE
5	2	HI18-0041	KNOB - DONUT RETAINER FRAME
6	30	HI18-0046	WIRE; S.S.
7	1	HI18-0051	TENSION BOLT WIRE (SAFETY, FRONT)
8	1	HI24-0505	SUB-ASSY; DONUT RETAINER FRAME
9	31	903-5205SS	1/4-28 SS HEX FINISH NUT

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)206-322-5474 (Worldwide)

Email: service@belshaw.com

Office Hours: Monday – Friday, 6am to 4pm, USA Pacific Time



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The #1 Source for Donut and Bakery Equipment

www.belshaw.com

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