CADDY CORPORATION

Food Service Equipment Air Systems

Conveyor Models

BV, SV, MT, SM, TR, TM, CF, RCF and SWF

Operation and Maintenance Manual

509 Sharptown Road P.O. Box 345 Bridgeport, NJ 08014
Email: service@caddycorp.com Fax: 856-467-5511
Internet: http://caddycorp.com Phone: 856-467-4222

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509 Sharptown Road P.O. Box 345 Bridgeport, NJ 08014
Email: service@caddycorp.com Fax: 856-467-5511
Internet: http://caddycorp.com Phone: 856-467-4222

Introduction

The purpose of this manual is to acquaint you with the operation and proper maintenance of your Caddy Conveyor.

In order to obtain maximum efficiency it is important that you read this manual thoroughly and follow its recommendations.

In certain instances the manual makes reference to features which may or may not be part of your equipment. To determine whether such references apply to you, please consult your Submission Drawing.

Caddy Corporation thanks you for selecting its equipment and assures you that your continuing interest and satisfaction are paramount to us.

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Precautionary Steps

1. Chain guards, housing doors and skirting panels must be in place when conveyor is in operation in order to prevent bodily injury to operating personnel.

Conveyor must NOT be operated without chain guards, housing doors and skirting panels in place.

2. Turn conveyor circuit breaker **OFF** when performing maintenance on equipment. Since equipment acts as a conductor of electricity, respect all grounding and bonding codes.
3. When inspecting operation of conveyor, keep away from sprockets, chains, motors, etc.
4. Lubricate conveyor chain only when equipment is stopped but just prior to start-up. Lubrication is best applied at a point where the belt moves away from the nearest sprocket.
5. **A word to the wise!** Limit switches supplied with equipment are there for specific purposes: such as safety, tray control, wear prevention, etc. Circumventing the operation of these switches can cause personal injury and conveyor damage, and may void warranty and manufacturer's liability.
6. Conveyor wiring is water-tight but **will not withstand direct hosing down of electrical parts.** Such hosing is hazardous to operating personnel; it will cause severe damage to the equipment resulting in costly repairs and long periods of down time, and will void the warranty
7. When the conveyor is off, rotating the motor by hand can cause damage to electrical controls if the motor leads remain attached.
8. Failure to replace missing belt slats on the conveyor chain can cause the belt to fall out of the track with possible harm and damage to the equipment.
9. **Important:**
Detergent or disinfectants containing chlorine, ammonia or iodine must **not** be used on the Caddy non-steel components. Use of these chemicals will cause serious deterioration of plastic parts, and most importantly the belt itself.

CAUTION

- **Never place your hands where you cannot see them!**
- **Do not place your hands anywhere in the chain drive area!**
- **Do not spray water directly onto motor, wires or any electrical parts.**
- **Do not block limit switches with an object in order to stop conveyor! If trays are coming too fast, slow the conveyor down!**
- **Do not permit materials to clog drains!**

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Installation Instructions

This system must be installed and serviced by qualified electrical maintenance personnel familiar with electrical and mechanical systems. This manual is designed to give general information on the electrical and mechanical operation of this conveyor system. The system must be installed as per the applicable electrical codes."

The following Grounding Instructions are dependant upon the ratings and power connection of each system.

GROUNDING INSTRUCTIONS (Any permanently connected systems)
This appliance must be connected to a grounded, metal, permanent wiring system; or an equipment-grounding conductor must be run with the circuit conductors and connected to the equipment-grounding terminal or lead on the appliance.

GROUNDING INSTRUCTIONS (Systems rated 120 V, 15 A or less; cord connected)
This appliance must be grounded. In the event of malfunction or breakdown, grounding provides a path of least resistance for electric current to reduce the risk of electric shock. This appliance is equipped with a cord having an equipment-grounding conductor and a grounding plug. The plug must be plugged into an appropriate outlet that is properly installed and grounded in accordance with all local codes and ordinances.

DANGER - Improper connection of the equipment-grounding conductor can result in a risk of electric shock. The conductor with insulation having an outer surface that is green with or without yellow stripes is the equipment-grounding conductor. If repair or replacement of the cord or plug is necessary, do not connect the equipment-grounding conductor to a live terminal. Check with a qualified electrician or serviceman if the grounding instructions are not completely understood, or if in doubt as to whether the appliance is properly grounded. Do not modify the plug provided with the appliance – if it will not fit the outlet, have a proper outlet installed by a qualified electrician.

This appliance is for use on a nominal 120 V circuit, and has a grounding plug that looks like the plug illustrated in sketch A in the following figure. A temporary adaptor, which looks like the adaptor illustrated in sketches B and C, may be used to connect this plug to a 2-pole receptacle as shown in sketch B if a properly grounded outlet is not available. The temporary adaptor should be used only until a properly grounded outlet can be installed by a qualified electrician. The green colored rigid ear, lug, and the like, extending from the adaptor must be connected to a permanent ground such as a properly grounded outlet box cover. Whenever the adaptor is used, it must be held in place by the metal screw.

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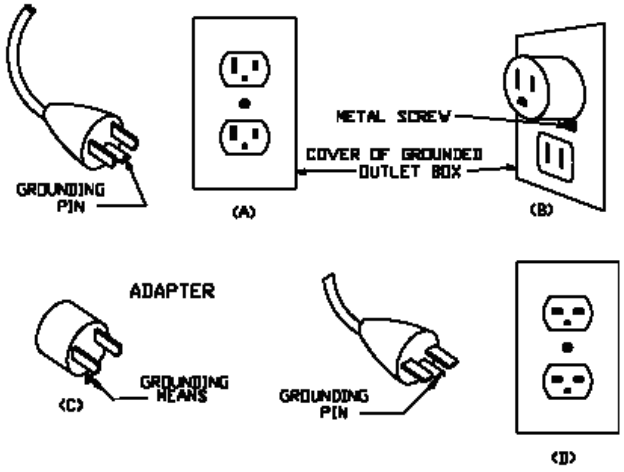
Grounding Methods



To Reduce the Risk of Electric Shock, this appliance has a polarized plug (one blade is wider than the other). This plug will fit in a polarized outlet only one way. If the plug does not fit fully in the outlet, reverse the plug. If it still does not fit, contact a qualified electrician to install the proper outlet. Do not change the plug in any way.

GROUNDING INSTRUCTIONS (Systems rated more than 120V and/or more than 15 A; cord connected)

This appliance must be grounded. In the event of malfunction or breakdown, grounding provides a path of least resistance for electric current to reduce the risk of electric shock. This appliance is equipped with a cord having an equipment-grounding conductor and a grounding plug. The plug must be plugged into an appropriate outlet that is properly installed and grounded in accordance with all local codes and ordinances.

DANGER - Improper connection of the equipment-grounding conductor can result in a risk of electric shock. The conductor with insulation having an outer surface that is green with or without yellow stripes is the equipment-grounding conductor. If repair or replacement of the cord or plug is necessary, do not connect the equipment-grounding conductor to a live terminal. Check with a qualified electrician or serviceman if the grounding instructions are not completely understood, or if in doubt as to whether the appliance is properly grounded. Do not modify the plug provided with the appliance – if it will not fit the outlet, have a proper outlet installed by a qualified electrician.

This appliance is for use on a circuit having a nominal rating more than 120 V (or This appliance is rated more than 15 A and is for use on a circuit having a nominal rating of 120 V), and is factory equipped with a specific electric cord and plug. No adapter should be used with this appliance. If the appliance must be reconnected for use on a different type of electric circuit, the reconnection should be made by qualified service personnel; and after the reconnection, the appliance should comply with all local codes and ordinances.

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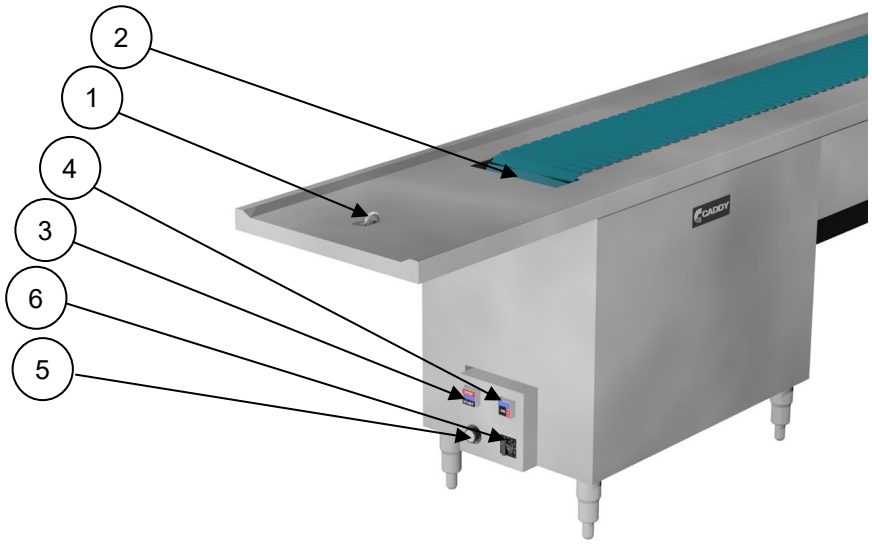
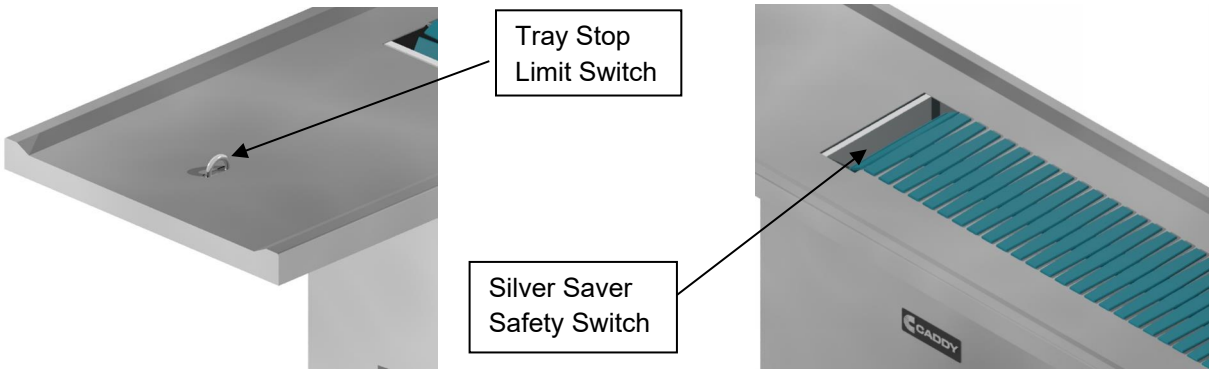
Nomenclature

Your Caddy Conveyor may have various combinations of optional features such as limit switches, safety switches, automatic belt washer, detergent injectors, power tray stacker, and other optional features.



1: Limit Switches : Caddy Conveyors are equipped with one or more conveyor limit switches. These are used to control the movement of trays or to provide protection for operating personnel. There are several basic types of limit switches, as illustrated below:

2: Silver Saver Safety Switch ⑥ : The silver saver switch is designed to stop the conveyor belt when any object tries to enter the opening at the end of the conveyor belt, drive end. When this occurs, the object must be removed, allowing the switch to reset. The conveyor is then restarted by pressing the start button.



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3: **On / Off Switches:** Switches are placed along the conveyor to provide easy and accessible On/Off control of conveyor

4: Fresh Water Belt Washer: The fresh water belt washer produces fan shaped sprays of lukewarm water to thoroughly wash all belt surfaces, after which the belt is wiped continuously.

4: Recirculating Belt Washer: Reduces consumption of water. Includes a pump which recirculates water from reservoir through spray nozzles. The operation of the belt washer is controlled by a solenoid valve which is integrally wired to an-On/Off switch of the conveyor, for automatic operation of the belt washer.

5: Variable Speed Controller: Your electronic motor controller is designed to control the speed of the conveyor belt at the turn of a dial.

6: Detergent Injector: This will inject a pre-determined amount of detergent into the belt washer. The injector is controlled either by manual or by automatic timer. Any Caddy approved conveyor cleaning and lubrication solution may be used with the detergent injector.

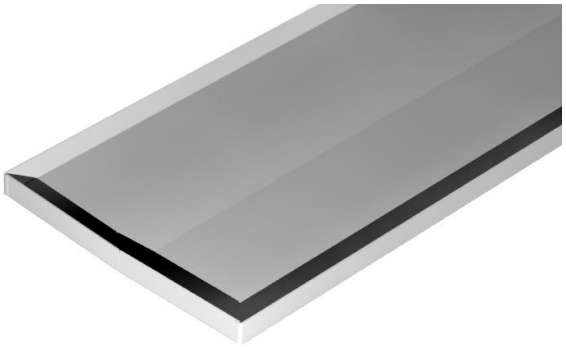
Automatic Water Saver Control: Operation of belt washer may be controlled by a solenoid valve integrally wired to On/Off switch of conveyor to provide automatic operation of belt washer.

Electrical: Electrical specifications vary according to conditions and requirements for each installation. For your specific electrical specifications, consult your customized electrical drawing enclosed.- **(All electrical components are housed in UL listed water-tight boxes and conduit.)**

Belt Slats: Caddy uses non-breakable Xenoy belt slats which easily snap on to a stainless steel chain, without the use of tools.

Drain Pan: Most Caddy Conveyors are equipped with a full length drip pan to catch any run-off from the conveyor, belt or bed area.

Drain Pan



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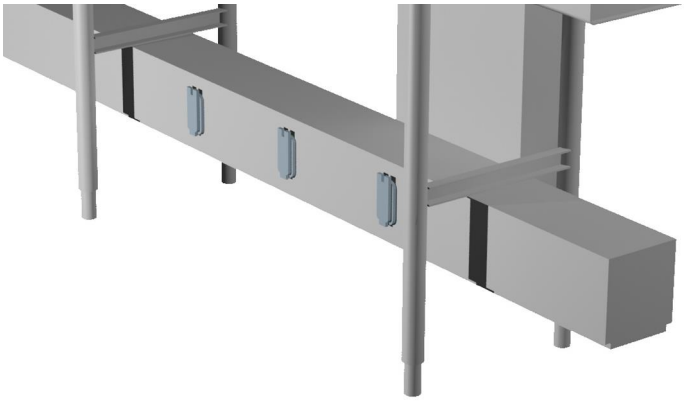
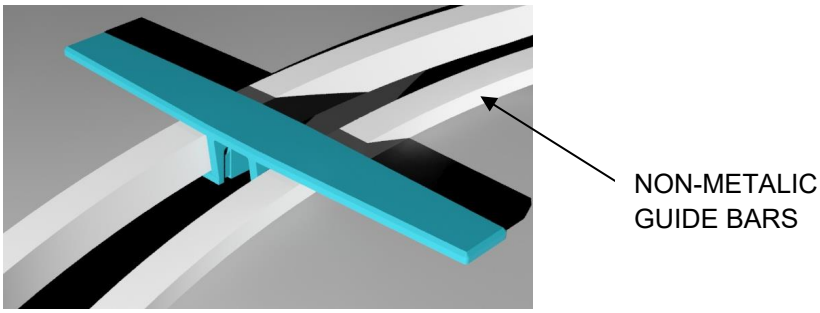
Wireway: A stainless steel enclosure, running the full length of most tray make-up conveyors, (models TM-10, TR-10) and containing all electrical receptacles for peripheral equipment.

Wireway



Turn Guides: Caddytron non-metallic bars with a "built-in" permanent lubricant positively iock both sides of the belt, providing smooth negotiation of all turns.

Turn Guide



Torque: Torque is the (adjustable) power developed by the motor, not the speed of the belt. To illustrate: if you have an extra heavy weight on the belt, the belt will stop. The torque, in this instance, would have been set too low to maintain movement of the belt. Weight, however, is normally never a problem; jams may be! When a fork or other utensil is jammed in the belt, the belt will stop rather than continue movement with possible damage to the belt slats. In our system, such stoppage will not harm the motor, belt or superstructure of the conveyor. See Page 11 for torque adjustment settings.

Skirting: Skirting is used to prevent clothing, hands or other items from getting caught in the returning belt.

Chain Guard: The chain guard prevents fingers, clothing or other objects from entering the chain drive area. **The conveyor should not be operated with the chain guard off.** If the chain guard is off, **STOP** the conveyor immediately, shut off main power to conveyor and then replace chain guard! **Any exposed drive sprocket is very dangerous.**

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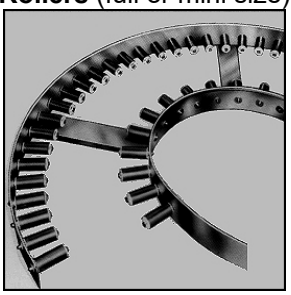
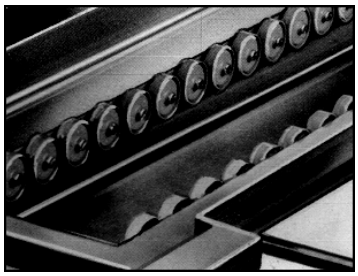
Types Of Conveyors

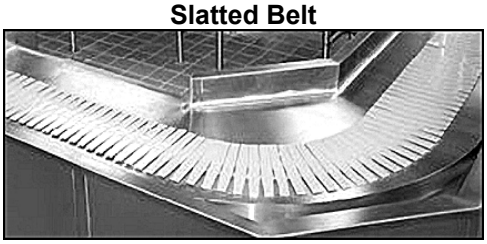
Rollers (full or mini size)



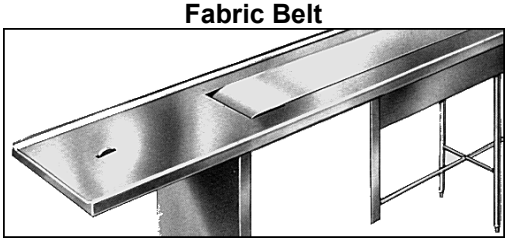
Skatewheel



Slatted Belt



Fabric Belt



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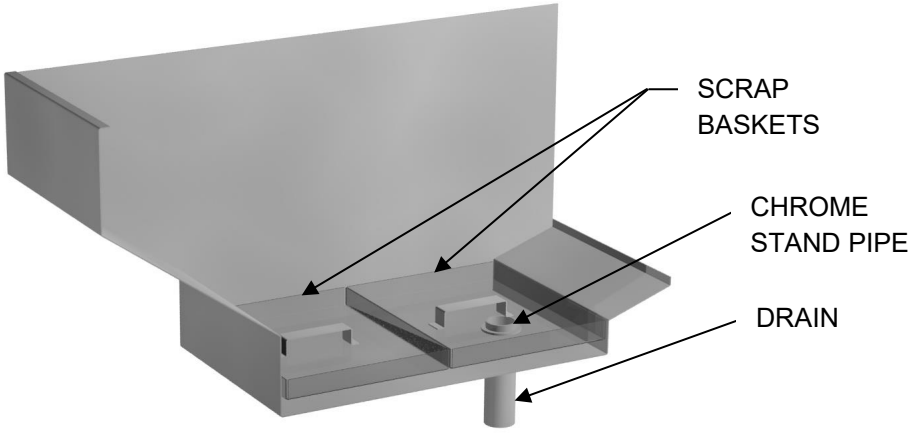
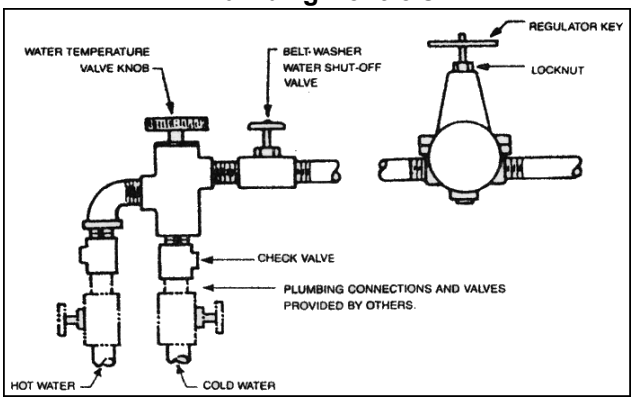
Start Up Instructions and Adjustments

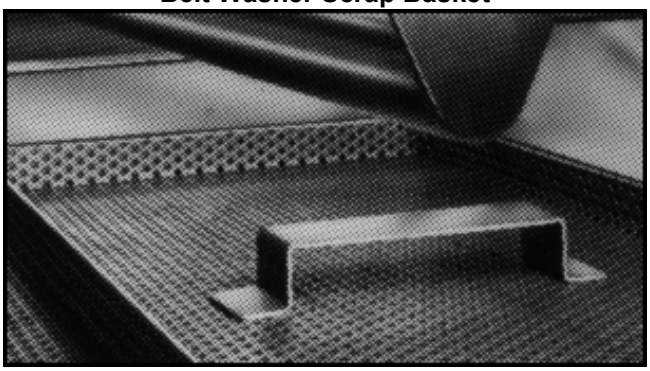
Belt Washer



Plumbing Controls



Belt Washer Scrap Basket



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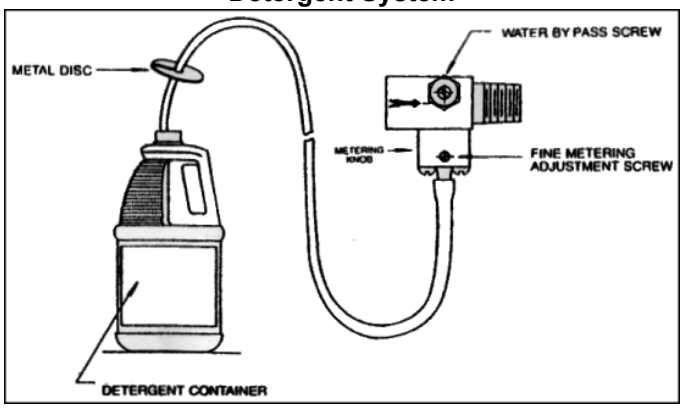
Detergent System



Before starting the conveyor for the first time, the following should be checked:

1. Conveyor and belt must be clear of all debris.
2. Wash grit off of belt and superstructure.
3. Check the belt washer. The only articles that should be in the belt washer are scrap baskets, furnished by Caddy Corp.
4. Make sure there are no objects on the belt.
5. Make sure that the speed control is set at zero.

Proceed by pushing the ON button (if provided) or the START button (if provided). The conveyor will not move until the speed is increased. To do this turn the speed dial until the belt begins to move.

CAUTION:
If any loud sounds are heard, shut the conveyor off immediately and look to see if an object is jamming the belt. If the belt moves smoothly, the speed may be increased by turning the speed dial to desired speed.

Note: The belt may "squeal" until it has been lubricated, Refer to the lubrication section (Page 14).

Torque: Torque control has been pre-set at the factory. Should additional adjustment be required, observe .. ie following: Push the off button. Locate the solid state controller in the main electrical box.
Proceed by turning the torque knob (marked CL on the motor controller) fully counter-clockwise. Now turn the ON/Off switch to the On position and turn the speed control knob up to 9. Slowly begin to turn the torque knob clockwise until the belt begins to move. Continue to turn the knob clockwise until the belt reaches maximum speed. CAUTION: Do not turn the torque knob further after the belt has reached its maximum speed. Under no circumstances should the torque knob be set to the maximum position (fully clockwise). Now the torque adjustment is complete and you may adjust the conveyor speed control to obtain desired speed.

CAUTION:
- Never place hands into the belt washer while the conveyor is in motion.
- Never place hands under the skirting of the conveyor while the conveyor is in motion.

Belt Washer: (see Page 10) Turn the conveyor to an OFF position. Open the housing access door to locate the belt

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washer door. Open and remove two scrap baskets. Also remove any installation debris that may be there. Make sure that drain screen is clear. Return scrap baskets and close belt washer door. NOW, open the hot and cold water valve and the chrome plated shut-off valve. (Belt washer temperature should not exceed 100°).

The belt washer is now ready for adjustment,

1. Turn the conveyor On/Off switch to an ON position.
2. Turn belt washer On/Off switch to an ON position; take note that Power On indicator light is on.

The belt washer should now be operating. Adjustment can be made to the water spray by loosening pressure regulator locknut and by turning regulator key (see Page 10) until the pressure reaches 25-30 PSI (pounds per square inch). This is standard for all conveyors with belt washer systems. Check the drain to see if it is properly draining. Your water temperature should be lukewarm: To adjust, turn water temperature valve knob (see Page 10). The direction is shown on the knob itself.
Before opening doors to belt washer, conveyor MUST be in the OFF position.

Belt Washer Cleaning: Scrap baskets should be removed and cleaned after every meal. Always check the drain screen to see be sure it is not clogged. (see Page 10)

Recirculating Belt Washer: To clean recirculating belt washer**,** turn OFF conveyor AND belt washer. Remove scrap baskets and chrome standpipe from belt washer. Clean away all food scraps from belt washer area. Re-install standpipe and scrap baskets. Remove filter and clean screen. This cleaning procedure should be followed daily.

CAUTION:
Never place a hand into the belt washer while the conveyor is in motion, or in the under-skirting of the conveyor. Never place a hand anywhere you can lose sight of it!

Detergent Injectors: Drop end of plastic tubing with strainer into Caddy Conveyor Detergent container. Cut tubing to convenient length and slip cut end over injector fitting. Container may be any reasonable distance below injector, but tube may not be more than 2 feet long. **Cover container by slipping metal disc over tubing.** (see Page 11)

Operation of Injector: Locate water bypass screw and fine metering adjusting screw (see Page11). Turn on conveyor, beltwasher and detergent timer. Be sure bettwasher shut-off valve is in the open position. The injector may draw momentarily as the system starts; however, normally it will stop as the system reaches full pressure. To adjust the injector, turn the bypass screw clockwise until detergent begins to be drawn from the container. After the liquid reaches the injector, the feed rate may be adjusted by turning the bypass screw. If the injection rate is too excessive, turn the fine metering screw counter clockwise to reduce the injection rate. (see Page 11)

Servicing Injector:
CAUTION: Turn off water supply before servicing.
The check valve parts (which are in the metering knob) can be cleaned by removing the four screws. If the belt washer spray jets become clogged or if downstream restriction increases, the detergent injector will stop drawing fluid. In this case, if it is inconvenient to remove the restriction immediately, the injector may be put back into operation by turning the water bypass screw **clockwise.** This will adjust the injector to the lower water flow rate. The bypass screw should be re-set once the restriction has been removed. (see Page 11)

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Belt Slack Adjustment

CF-10 Belt
Conveyor chain is of stainless steel with snap-on Xenoy slats. Proper belt length has been determined at the factory. Should length adjustment prove necessary, remove one link and slat to shorten. This can usually be done with a screwdriver by gently easing off the side plate of any chain link.
CAUTION: Use only factory furnished chain links.

Note: The conveyor chain should maintain proper tension without adjustment.

Fabric Belt
Note: On Fabric Belt Conveyors all adjustments are made from the tail (non-drive) end of the conveyor.

To adjust, follow these procedures:

1. Shut off conveyor, remove take-up cover plates as shown below.
2. Conveyor bed should be level and plumb. For stationary units adjust feet to level for floor slope. For mobile units adjust leg tube at gussets using set screw.
3. If belt slack is too great take up evenly on both threaded adjustments using a 15/16" socket. Belt should be snug, but should cause no strain on bearings and shaft.
4. If belt is tracking to the right, take up on right adjustment or loosen on left adjustment. This adjustment is made with conveyor running. After the adjustment has been made, conveyor should be allowed to run for two minutes, so that belt can seek new tracking position. If further adjustment is needed, repeat above procedure.
   CAUTION: Do not over tighten belt.
5. If belt is tracking to the left, take up on left adjustment or loosen up on right adjustment. This adjustment is made with conveyor running. After adjustment has been made, conveyor should be allowed to run for two minutes, so that belt can seek new tracking position. If futher adjustment is needed, duplicate above procedure.
   CAUTION: Do not over tighten belt.

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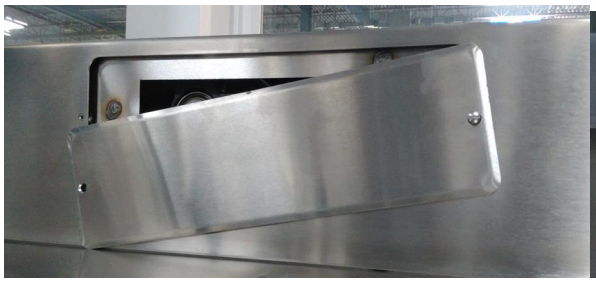

Adjustments and Lubrication

1. **Slats And Stainless Steel Chain:** Caddy recommends lubrication of the conveyor belt once a month, or as needed, with Lubriplate (Caddy Part # 3278-01, Lubriplate Cartridge) or any marine type "A" lubricant. Care must be taken to insure that lubricant is applied to both sides of the feet, on the slat itself. Lubricant is best applied at a point where the belt moves away from the nearest sprocket.
2. **Bearings:** The bearings at both the drive and tail end of the conveyor should be lubricated monthly, with general purpose grease.

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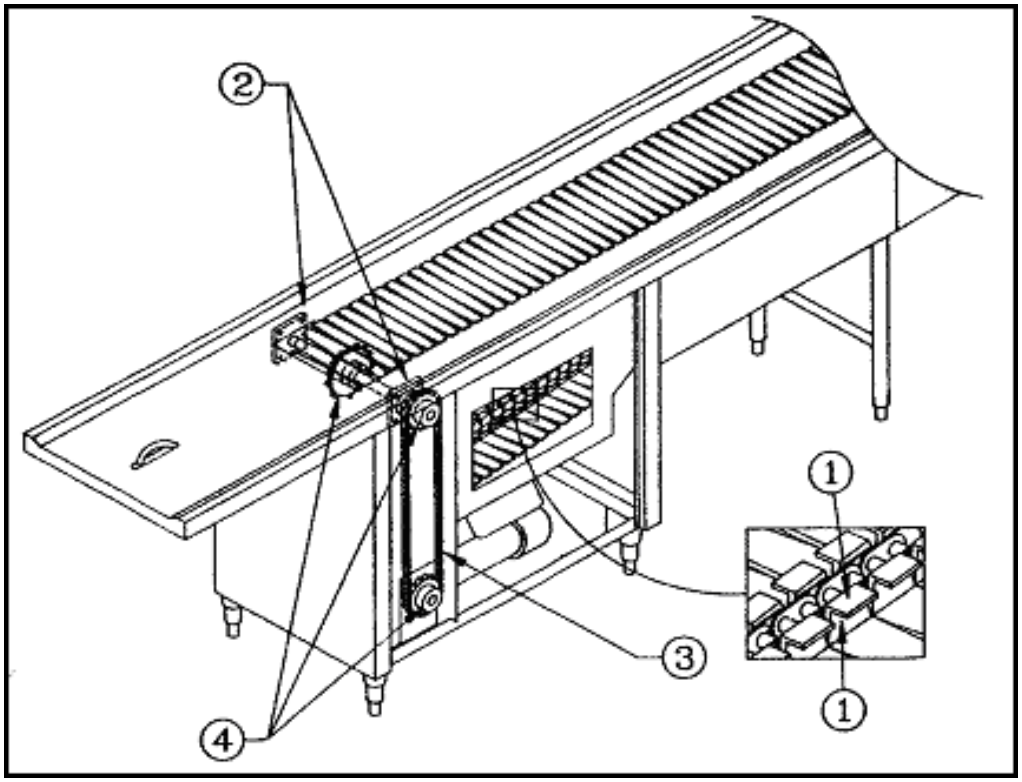
3. **Drive Chain:** The drive chain must be lubricated with light oil at least once every three months. Be sure belt is stopped when lubricating and the chain guard is reinstalled properly.
4. **Sprockets:** Check sprockets for tightness after one week of operation, tighten if necessary. Check and tighten each month after initial start-up.

CAUTION: Failure to maintain proper lubrication will cause excessive noise and premature failure of moving parts.



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Preventive Maintenance

Must Be Done Immediately Upon Installation Of Conveyor

CAUTION: Conveyor must be off for any inspection!

1. **Slats:** Missing or damaged slats should be replaced **IMMEDIATELY** since failure to do so may result in extreme damage to your conveyor.
2. **Main Drive Chain**: The main drive should be checked after the first week of operation, and excessive slack removed. The drive chain is generally kept with ¾" of slack (minimum), since a tight chain may cause bearings on the gear box to fail.

Notes:

- The drive chain is a standard roller chain. Links can be removed in the coventional manner.
- Half-links may be installed where required to insure the best adjustment.
- Final adjustment is achieved by moving the motor and gear reducer in its slotted mounting holes on the base plate.

Important: Improper slack left in the drive chain will give the chain a chance to "climb" the drive sprocket of the gear reducer and thus create a jam which may damage the gear reducer, the motor and the base.

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Preventive Maintenance

To Be Done Monthly

CAUTION: Conveyor must be off for any inspection!

1. **Belts:** Alignment or tracking of the belt should be checked on a regular basis, at least every month. At these intervals, the conveyor belt chain should be lubricated (see Page 14). Visual inspection at more frequent intervals is recommended to detect any sign of wear.
2. **Sprockets:** Sprocket should be checked, aligned, and their set screws tightened after the first week of operation and at least once a month thereafter.
3. **Return Track:** The track should be checked regularly for wear, sediment build-up and alignment.
4. **Bearings:** Bearings are located on each shaft of the conveyor. These bearings must be lubricated every three months with a general purpose bearing grease. The set screw on the bearings should be checked after the first week of operation and at three month intervals thereafter.

To Be Done Every Three Months

CAUTION: Conveyor must be off for any inspection!

Gear Reducer: Oil should be changed after the first month of operation and yearly thereafter. Oil level should be checked every three months and additional oil added as required (Mobile 600 W cylinder oil or equivalent is acceptable).

To Be Done Every Six Months

CAUTION: Conveyor must be off for any inspection!

Motors: A DC motor has been provided on all conveyors for the purpose of speed control and safety. DC motors are equipped with carbon brushes. These brushes should be checked semi-annually and replaced as necessary. **Replace carbon brushes with original factory brushes only. Any other type may result in rapid brush wear and/or motor failure.**

509 Sharptown Road P.O. Box 345 Bridgeport, NJ 08014
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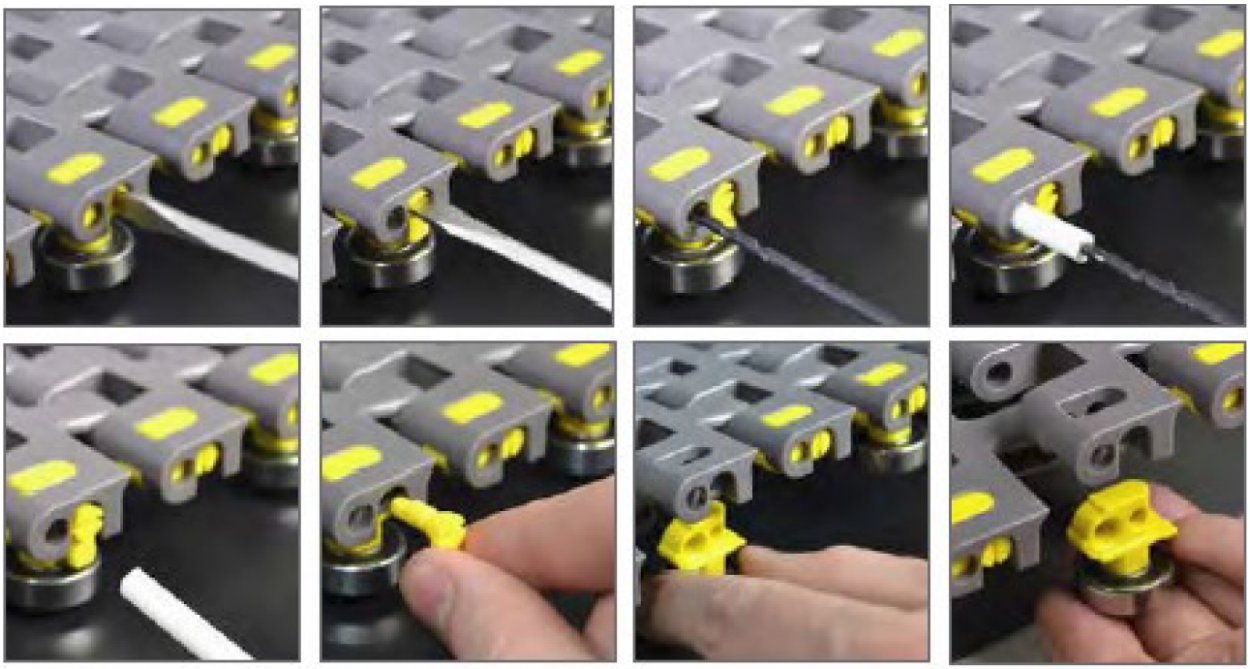
Internet: http://caddycorp.com Phone: 856-467-4222

Mat Top (MT) Belt Disassembly Instructions

Disassembly:

- **Rotate TwistLock™ counterclockwise**
- **Insert thread-puller into pin**
- **Remove pin**
- **Remove TwistLock plug**
- **Separate attachment from chain link by hand or with flat-blade screwdriver**



Assembly:

- **Reverse order**

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Trouble Shooting Guide for

Chain and Fabric Belt Conveyors

Condition	Probable Cause	Correction
Motor won't run	1. Object activating silver saver switch 2. Power off 3. Limit switch activated 4. Brushes worn 5. Water damaged component 6. Object jammed in belt 7. Frozen bearings 8. Drive chain jam 9. Controller defective 10. Torque too low	1. Remove object, restart conveyor 2. Restore power 3. Remove blockage 4. Replace brushes 5. Replace component 6. Remove object 7. Replace bearings 8. Remove jam and excessive slack 9. Replace controller 10. Increase torque setting (see Page 11)
Motor runs; belt does not	1. Belt sprocket mis-aligned 2. Defective gear box 3. Torque too low 4. Key out of drive shaft	1. Re-align sprocket and tighten set screws 2. Replace gear box 3. Increase torque setting (see Page 11) 4. Replace key and tighten set screw
Motor runs intermittently	1. Control erratic 2. Loose wire connection	1. Replace controls 2. Tighten connection
Feet break off belt slats	1. Sprockets are too high or too low .	1. Adjust height
Belt does not run smoothly	1. Belt needs lubrication 2. Belt slack excessive 3. Drive chain has excessive slack 4. Object in belt track 5. Turn material worn	1. Lubricate belt. 2. Remove slack 3. Remove slack 4. Remove object. Clean belt track. 5. Replace material
Belt jams on return	1. Worn return guides 2. Return guides out of alignment	1. Replace guides 2. Realign track
Belt falls out of return track	1. Worn return track 2. Misaligned return track 3. Slats missing from belt chain	1. Replace track 2. Realign return track 3. Replace slats
Noisy belt travel	1. Lack of lubrication on belt chain	1. Lubricate (see Page 14).

If further information is required, please contact the Caddy Corporation Service Department at (856)467-4222.

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Care and Cleaning of Stainless Steel Equipment

Contrary to popular belief, stainless steels ARE susceptible to rusting and pitting.

Corrosion on metals is everywhere. It is recognized quickly on iron and steel as unsightly yellow/orange rust. Such metals are called “active” because they actively corrode when their atoms combine with oxygen to form rust.

Stainless steels are passive metals because they contain other metals, like chromium, nickel and manganese that stabilize the atoms.

Chromium provides an invisible passive film that covers the steel’s surface acting as a shield against corrosion. As long as the film is intact and not broken or contaminated, the metal is passive and stainless. If the passive film of stainless steel has been broken, equipment starts to corrode. At its end, it rusts.

The Enemies of Stainless Steel

There are three basic things which can break down stainless steel’s passivity layer and allow corrosion to occur.

1. **Mechanical Abrasion** - Steel pads, wire brushes and scrapers are prime examples of things that will scratch a steel surface.
2. **Water and Deposits** - Water has varying degrees of hardness. Depending on the area you live in, you may have hard or soft water. Hard water may leave spots, and when heated, leave deposits that will break down the passive layer and rust stainless steel. Other deposits from food preparation and service must be properly removed.
3. **Chlorides** - Chlorides are found nearly everywhere. They are in water, food and table salt. Some of the worst chloride perpetrators come from household and industrial cleaners.

Here are a few steps that can help prevent stainless steel rust and pitting.

1. **Use the proper tools.**

   When cleaning stainless steel products, use non-abrasive tools. Soft cloths and plastic scouring pads will not harm steel’s passive layer. Stainless steel pads also can be used but the scrubbing motion *must* be in the direction of the manufacturers’ polishing marks.

2. **Clean with the polish lines**

   Some stainless steel comes with visible polishing lines or “grain”. When visible lines are present, always scrub in a motion parallel to the lines. When the grain cannot be seen, play it safe and use a soft cloth or plastic scouring pad.

3. **Use alkaline, alkaline chlorinated or non-chloride containing cleaners.**

   While many traditional cleaners are loaded with chlorides, the industry is providing an ever-increasing choice of non-chloride cleaners. If you are not sure of chloride content in the cleaner used, contact your cleaner supplier. If your present cleaner contains chlorides, ask your supplier if they have an alternative. Avoid cleaners containing quaternary salts; they can attack stainless steel and cause pitting and rusting.

4. **Treat your water.**

   Though this is not always practical, softening hard water can do much to reduce deposits. There are certain filters that can be installed to remove distasteful and corrosive elements. To insure proper water treatment, call a treatment specialist.

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5. **Keep your food equipment clean.**

   Use alkaline, alkaline chlorinated or non-chloride cleaners at recommended strength. Clean frequently to avoid build-up of hard, stubborn stains. If you boil water in stainless steel equipment, remember the single most likely cause of damage is chlorides in the water. Heating cleaners that contain chlorides have a similar effect.

6. **Rinse, rinse, rinse.**

   If chlorinated cleaners are used, rinse and wipe equipment and supplies dry immediately. The sooner you wipe off standing water, especially when it contains cleaning agents, the better. After wiping equipment down, allow it to air dry; oxygen helps maintain the stainless steel's passivity film.

7. **Never use hydrochloric acid (muriatic acid) on stainless steel.**

Review

- Stainless steels rust when passivity (film-shield) breaks down as a result of scrapes, scratches, deposits and chlorides.
- Stainless steel rust starts with pits and cracks.
- Use the proper tools. Do not use steel pads, wire brushes or scrapers to clean stainless steel.
- Use non-chlorinated cleaners at recommended concentrations. Use only chloride-free cleaners.
- Soften your water. Use filters and softeners whenever possible.
- Wipe off cleaning agents and standing water as soon as possible. Prolonged contact eventually causes problems.

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Product Warranty

Products manufactured by Caddy Corporation are warranted to the original purchaser as follows:

Mechanical components are warranted to be free from defects in material and workmanship under normal use, storage and service for a period of one year from the date of installation or eighteen months from factory shipment, whichever occurs first.

Electrical components are warranted to the original purchaser to be free from defects in material and workmanship under normal use, storage and service for a period of ninety days from the date of shipment.

Caddy Corporation shall repair or replace, at our discretion, any part or product which we determine to be defective during the warranty period.

Under no circumstances will Caddy Corporation honor any repair or back charges by any party regardless of whether such equipment is within the warranty period, unless the Service Department of Caddy Corporation has authorized such work in writing.

If the equipment is repaired or altered in any way whatsoever by any person without prior written consent by Caddy Corporation, this warranty shall not apply.

The following are ***NOT*** covered under this warranty:
- Normal wear on parts, such as bulbs, gaskets, etc.
- Defects or damages resulting from accidents, alterations, abuse or misuse of equipment and/or any of its components.
- Damage of electrical components resulting from connecting the equipment to any power supply other than specified on the nameplate, or resulting from unauthorized altering of the equipment.
- Damage from water conditions causing malfunction of electric components and/or control equipment.

There is no other express warranty.
Any and all implied warranties are excluded to the extent permitted by law. Implied warranties, when included by law, including those merchantability and fitness for a particular purpose, are limited to one year from the date of shipment.

Liability for consequential damages under any and all warranties is excluded. This warranty is the buyer's exclusive remedy.

It is Caddy's policy to constantly improve the design and manufacture of our products. Accordingly, all equipment is subject to change consistent with such policy without prior notice and some items may be discontinued without obligation.

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CADDY CORPORATION
Food Service Equipment Air Systems

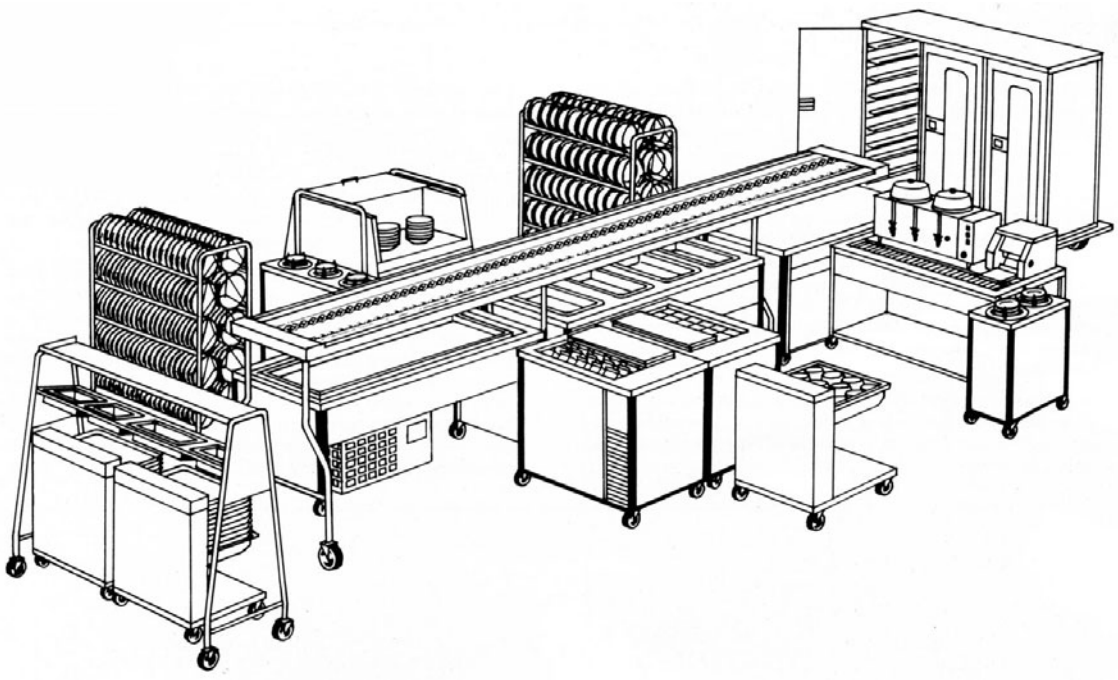
Tray Makeup Conveyors - Skatewheel Models

SWF - SkateWheelVeyor
SWC - SkateWheelVeyor: Cantilever Supported, Mobile
SKW - SkateWheelVeyor: Mounted on Hot Food Table or Counter

Part Description	Part Number
1.90" Dia. Plastic Skatewheel	4226-01
5" Dia. Stem Caster	66-05
5" Dia. Stem Caster With Brake	70-65
Bushing Caster, Press in	6473-05
Bullet Foot With Thread	1326-01
Flanged Foot, Press in	1780-01

Electrical Information and Parts

See electrical drawing or contact Caddy.
Please have conveyor Model, Serial Number and facility location prior to contact.

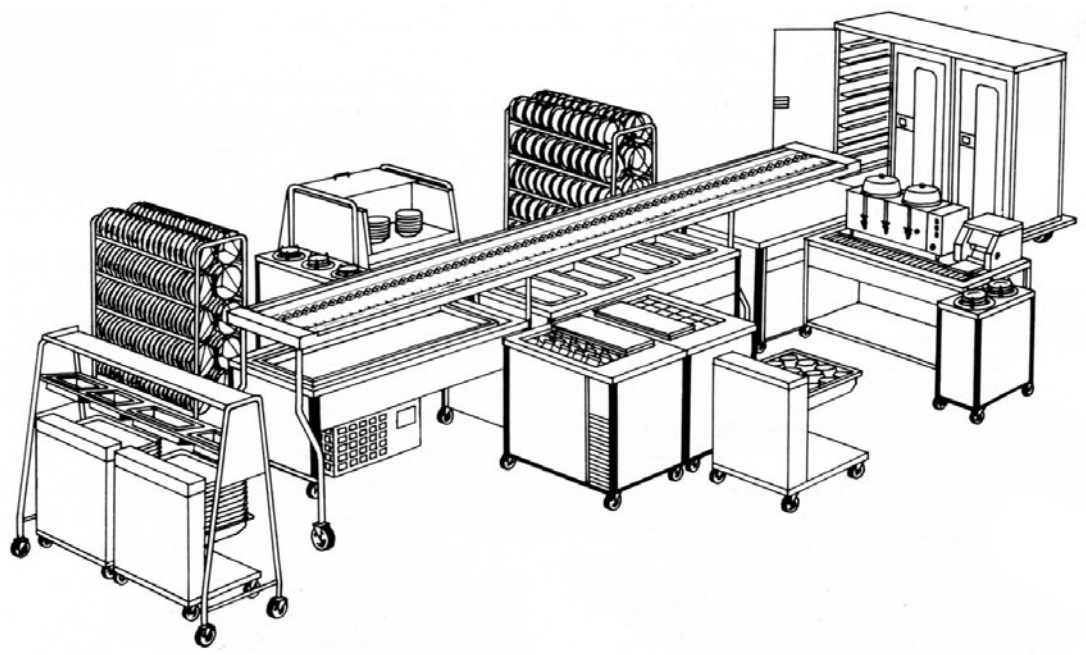


CADDY CORPORATION
Food Service Equipment
Air Systems

Tray Makeup Conveyors - Roller Models

RCF - RollerVeyor RCC - RollerVeyor: Cantilever Supported, Mobile	
Part Description	**Part Number**
Roller Conveyor w/hardware	6947-01
5" Dia. Stem Caster	66-05
5" Dia. Stem Caster With Brake	70-65
Bushing Caster, Press in	6473-05
Bullet Foot With Thread	1326-01
Flanged Foot, Press in	1780-01

Electrical Information and Parts
See electrical drawing or contact Caddy. Please have conveyor Model, Serial Number and facility location prior to contact.



CADDY CORPORATION
Food Service Equipment Air Systems

Tray Makeup Conveyors - Fabric Belt Models

SM-10 Servmaster: PVC Belt	
Part Description	**Part Number**
Belt Polytex, 10 Inch, White	3352-01
Pulley, Drive, 6" Dia.	3042-01
Pulley, Tail, 5" Dia.	3043-01
Lacing, Alligator	3293-01
5" Dia. Stem Caster	66-05
5" Dia. Stem Caster With Brake	70-05
5" Dia. Platform Swivel Caster	74-05
5" Dia. Platform Swivel Caster W/Brake	75-05
Bushing Caster, Press in	6473-01
Bullet Foot With Thread	1326-01
Flanged Foot, Press in	1780-01
Drive Shaft	4123-01
Bearing Flanged, (4 hole) Drive	1364-01
Tail Shaft	4122-01
Bearing Take-Up, 1" Bore	1366-01
Sprocket, #60, 21 Tooth (Trantorque)	6807-01
Trantorque Collet Hub	6810-01
Sprocket, #60, 21 Tooth (Keyway)	1319-01

Electrical Information and Parts
See electrical drawing or contact Caddy.
Please have conveyor Model, Serial Number and facility location prior to contact.

CADDY CORPORATION
Food Service Equipment Air Systems

Tray Makeup Conveyors - Slatted Belt Models

TR-10 Traymaster: Caddyflex Belt TM-10 Tray Makeup: Caddyflex Belt with Belt Washer	
Part Description	**Part Number**
10 Inch Wide Blue Belt (Assembled)	3117-01
Slat 10 Inch Blue Caddy	3118-03
5" Dia. Stem Caster	66-05
5" Dia. Stem Caster With Brake	70-65
Bushing Caster, Press in	6473-05
Bullet Foot With Thread	1326-01
Flanged Foot, Press in	1780-01
Drive Shaft	6813-01
Bearing Flanged, (4 hole) Drive	1364-01
Tail Shaft	6819-01
Bearing Flanged, (2 hole) Tail	1365-01
Sprocket, #60, 21 Tooth (Trantorque) 1 3/4" Bore	6807-01
Trantorque Collet Hub	6810-01
Sprocket, #60, 21 Tooth (Keyway) 1" Bore	1319-01

Belt Washer and Electrical Information and Parts
See electrical drawing or contact Caddy. Please have conveyor Model, Serial Number and facility location prior to contact.

CADDY CORPORATION
Food Service Equipment Air Systems

Soiled Tray Conveyors - Slatted Belt Models

CF-10 Soiled Tray: Caddyflex Belt with Belt Washer	
Part Description	**Part Number**
10 Inch Wide Blue Belt (Assembled)	3117-01
Slat 10 Inch Blue Caddy	3118-03
Bullet Foot With Thread	1326-01
Flanged Foot, Press in	1780-01
Drive Shaft (Trantorque)	6813-01
Bearing Flanged, (4 hole) Drive	1364-01
Tail Shaft (Trantorque)	6814-01
Bearing Flanged, (2 hole) Tail	1365-01
Sprocket, #60, 21 Tooth (Trantorque) 1 3/4" Bore	6807-01
Trantorque Collet Hub	6810-01
Drive Shaft (Keyway)	3987-01
Tail Shaft (Keyway)	4015-01
Sprocket, #60, 21 Tooth (Keyway) 1" Bore	1319-01

BU-10-10 Busmaster: Caddyflex Belt BV-10-10 Busing-Veyor: Caddyflex Belt with Belt Washer SV-10-10 Sorting-Veyor: Caddyflex Belt with Belt Washer	
Part Description	**Part Number**
10 Inch Wide Blue Belt (Assembled)	3117-01
Slat 10 Inch Blue Caddy	3118-03
Bullet Foot With Thread	1326-01
Flanged Foot, Press in	1780-01
5" Dia. Stem Caster	66-05
5" Dia. Stem Caster With Brake	70-65
Bushing Caster, Press in	6473-05
5" Dia. Platform Caster	74-05
5" Dia. Platform Caster With Brake	75-65
Drive Shaft	6815-01
Bearing Flanged, (4 hole) Drive	1364-01
Tail Shaft (BV-10-10, SV-10-10)	6816-01
Tail Shaft (BU-10-10)	6828-01
Bearing Flanged, (2 hole) Tail	1365-01
Sprocket, #60, 21 Tooth (Trantorque) 1 3/4" Bore	6807-01
Trantorque Collet Hub	6810-01
Sprocket, #60, 21 Tooth (Keyway) 1" Bore	1319-01

Belt Washer and Electrical Information and Parts
See electrical drawing or contact Caddy. Please have conveyor Model, Serial Number and facility location prior to contact.

Soiled Tray Conveyor - Belt Washers

Single Belt Conveyor 12" Beltwasher	
Part Description	**Part Number**
Nozzle, Vee Jet, 1/4" IPS	1374-01
Top Spray Pipe Assembly	6957-01
Bottom Spray Pipe Assembly	6957-02
Top Wiper Deflector	3183-16
Bottom Wiper Deflector	3183-13
Scrap Basket	6295-01
Roller Assembly, 12"	6952-01
1/2" IPS, Check Valve	6115-01
Tempering Valve	1569-01
3/8" IPS, Stop Valve	1351-01
3/8" IPS, Solenoid Valve (120V)	6618-03
3/8" IPS, Solenoid Valve (240V)	6618-04
Pressure Regulator	1568-02
3/8" IPS, Pressure Gauge	5405-01
1/2" IPS, Vacuum Breaker	1972-01
Vacuum Breaker Bracket	5271-01

Double Belt Conveyor 22" Beltwasher	
Part Description	**Part Number**
Nozzle, Vee Jet, 1/4" IPS	1374-01
Top Spray Pipe Assembly	6959-01
Bottom Spray Pipe Assembly	6959-02
Top Wiper Deflector	3183-16
Bottom Wiper Deflector	3183-13
Scrap Basket	6295-02
Roller Assembly, 22"	6952-02
1/2" IPS, Check Valve	6115-01
Tempering Valve	1569-01
3/8" IPS, Stop Valve	1351-01
3/8" IPS, Solenoid Valve (120V)	6618-03
3/8" IPS, Solenoid Valve (240V)	6618-04
Pressure Regulator	1568-02
3/8" IPS, Pressure Gauge	5405-01
1/2" IPS, Vacuum Breaker	1972-01
Vacuum Breaker Bracket	5271-01

Intermediate Swill Sink	
Part Description	**Part Number**
Scrap Basket	6295-03

BeltWasher Electrical Information and Parts
See electrical drawing or contact Caddy.