




**SC118 - Stowaway Slush/Cocktail  
OWNER'S MANUAL**


Manual No. 513556 Jan., 2001 Rev. 0




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**OWNER'S MANUAL  
FOR MODEL SC118  
STOELTING COUNTER MODEL FREEZER**

This manual provides basic information about the freezer. Instructions and suggestions are given covering its operation and care.

The illustrations and specifications are not binding in detail. We reserve the right to make changes to the freezer without notice, and without incurring any obligation to modify or provide new parts for freezers built prior to date of change.

**DO NOT ATTEMPT** to operate the freezer until instructions and safety precautions in this manual are read completely and are thoroughly understood. If problems develop or questions arise in connection with installation, operation or servicing of the freezer, contact the company at the following location:

STOELTING, LLC  
502 Hwy 67  
Kiel, WI 53042-1600

Tele: 920-894-2293

Fax: 920-894-7029



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## SECTION 1 INTRODUCTION

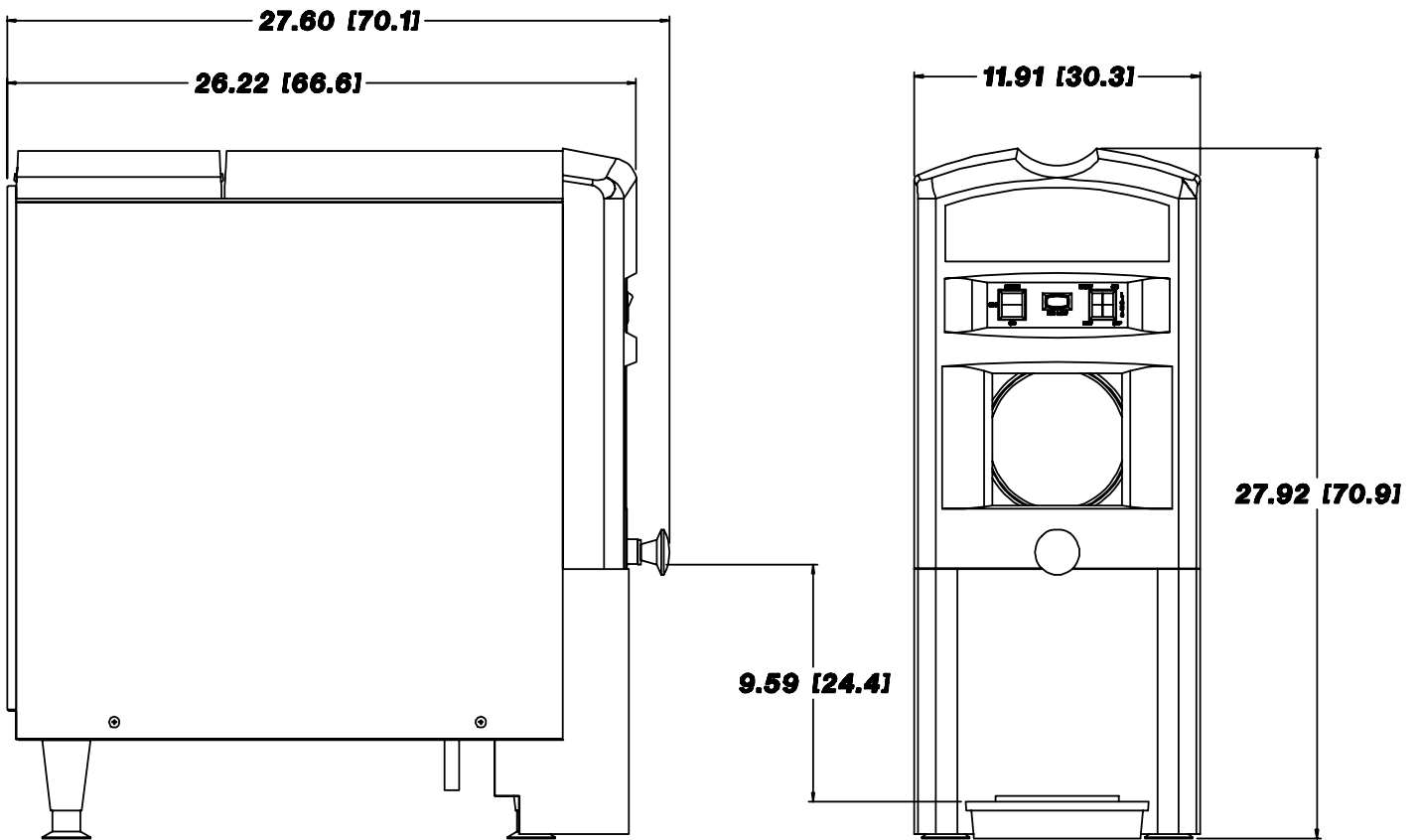
The Stowaway is a countertop profit machine. This compact unit fits onto any crowded bar, yet its high capacity means it will turn out more than seven gallons every hour. And the Stowaway is as versatile as it is fast, dispensing frozen, pre-mixed or ready-to-serve blends all with the same smooth consistency.



**Figure 1. Model SC118**

### **Stowaway Features**

- ☞ Easy plug-in installation.
- ☞ Lighted, moving product and front-mounted flavor label attract attention and merchandise product.
- ☞ Large 5.5 quart freezing cylinder serves cups, glasses or pitchers.
- ☞ Mix-low warning light notifies when to refill.
- ☞ Night-mode thermostat allows you to schedule cleaning frequency.
- ☞ Front air intake requires less counter space.
- ☞ Belt-drive system means quiet, dependable operation.
- ☞ Torque control ensures consistent quality product.



**Figure 2. Specifications**

**Specifications**

12 running amps 115/60/1

15-amp fuse

2.5 gallon (9.5 liter) hopper capacity

5.5 quart (5.2 liter) barrel capacity

1/3 horsepower drive motor

UL & C-UL approved, and NSF approved

## SECTION 2 INSTALLATION INSTRUCTIONS

### 2.1 SAFETY PRECAUTIONS

Do not attempt to operate the freezer until the safety precautions and operating instructions in this manual are read completely and are thoroughly understood.

Take notice of all warning labels on the freezer. The labels have been put there to help maintain a safe working environment. The labels have been designed to withstand washing and cleaning. All labels must remain legible for the life of the freezer. Labels should be checked periodically to be sure they can be recognized as warning labels.

If danger, warning or caution labels are needed, indicate the part number, type of label, location of label, and quantity required along with your address and mail to:

**STOELTING, INC.**  
**ATTENTION: Customer Service**  
**502 Hwy. 67**  
**Kiel, Wisconsin 53042**



Figure 3. Leveling Unit

### 2.2 SHIPMENT AND TRANSIT

The freezer has been assembled, operated and inspected at the factory. Upon arrival at the final destination, the complete freezer must be checked for any damage which may have occurred during transit.

With the method of packaging used, the freezer should arrive in excellent condition. THE CARRIER IS RESPONSIBLE FOR ALL DAMAGE IN TRANSIT, WHETHER VISIBLE OR CONCEALED. **Do not** pay the freight bill until the freezer has been checked for damage. Have the carrier note any visible damage on the freight bill. If concealed damage and/or shortage is found later, advise the carrier within 10 days and request inspection. The customer must place claim for damages and/or shortages in shipment with the carrier. **Stoelting, Inc. cannot make any claims against the carrier.**

### 2.3 FREEZER INSTALLATION

Installation of the freezer involves moving the freezer close to its permanent location, removing all crating, setting in place, assembling parts, and cleaning.

#### WARNING

**DO NOT USE SPIGOT SPOUT AS A HANDLE TO LIFT OR MOVE THE FREEZER.**

- A. Uncrate the freezer.
- B. The freezer must be placed in a solid level position. To level adjust bottom portion of leg.
- C. Place all switches in the OFF position.



**Figure 4. Power Cord**

- D. Connect the power cord. The plug is designed for 115 volt/15 amp duty. The unit must be connected to a properly grounded receptacle. The electrical cord furnished as part of the freezer has a three prong grounding type plug. The use of an extension cord is not recommended. If one must be used, use one with a size 12 gauge or heavier with a ground wire. Do not use an adaptor to get around grounding requirements.

**CAUTION**

**DO NOT ALTER OR DEFORM PLUG IN ANY WAY!**

- E. Install the drip tray, cover and other miscellaneous parts on the freezer.

**2.4 INSTALLING PERMANENT WIRING**

If permanent wiring is required by local codes, the following procedure must be performed.

**WARNING**

**DISCONNECT FREEZER FROM THE SOURCE OF ELECTRICAL SUPPLY BEFORE SERVICING.**

- A. Remove the necessary panels to gain access to the power cord connection.
- B. Disconnect the black and white wires from the terminal block (L1 and common). Disconnect the green ground wire from the grounding screw.
- C. Remove the strain relief connector from the bottom of the freezer base. Remove the power cord.
- D. Install permanent wiring according to local code.
- E. Connect black wire to L1 on the terminal block. Connect the white wire to the common on the terminal block. Connect the green or yellow and green striped ground wire to the grounding screw.
- F. Replace all panels.

## SECTION 3 INITIAL SETUP AND OPERATION

### 3.1 OPERATOR'S SAFETY PRECAUTIONS

SAFE OPERATION IS NO ACCIDENT; Observe these rules:

- A. **Know the freezer.** Read and understand the Operating Instructions.
- B. **Notice all warning labels on the freezer.**
- C. **Wear proper clothing.** Avoid loose fitting garments, and remove watches, rings or jewelry which could cause a serious accident.
- D. **Maintain a clean work area.** Avoid accidents by cleaning up the area and keeping it clean.
- E. **Stay alert at all times.** Know which switch, push button or control you are about to use and what effect it is going to have.
- F. **Disconnect electrical cord for maintenance.** Never attempt to repair or perform maintenance on the freezer until the main electrical power has been disconnected.
- G. **Do not operate under unsafe operating conditions.** Never operate the freezer if unusual or excessive noise or vibration occurs.

### 3.2 OPERATING CONTROLS AND INDICATORS

Before operating the freezer, it is required that the operator know the function of each operating control. Refer to Figure 8 for the location of the operating controls on the freezer.

#### A. Clean OFF ON Switch

The clean off on switch is a three position switch. In the clean position only the drive and condenser fan will run. In the ON position the drive and condenser fan and compressor will run until the proper consistency is reached, then the compressor will stop and the drive and condenser fan will continue to run.

#### B. Mix Low Light

The mix low light will illuminate when the liquid level in the hopper is less than 2".

#### C. Standby Serve Switch

The standby switch is a two position switch. In the standby position mix temperature will be maintained between 32° and 40°F. In the serve position the product temperature in the barrel will be determined by product consistency.

#### D. Lights Off On Switch

The lights Off On Switch is a two position switch. When the switch is in the ON position the lights will illuminate, when the switch is in the off position the lights will be OFF.



Figure 5. Controls

#### E. High Pressure Cut Out Switch

The high pressure cut out switch is located under the right side frame about halfway back. Push up to reset.



Figure 6. Disassembling Freezer

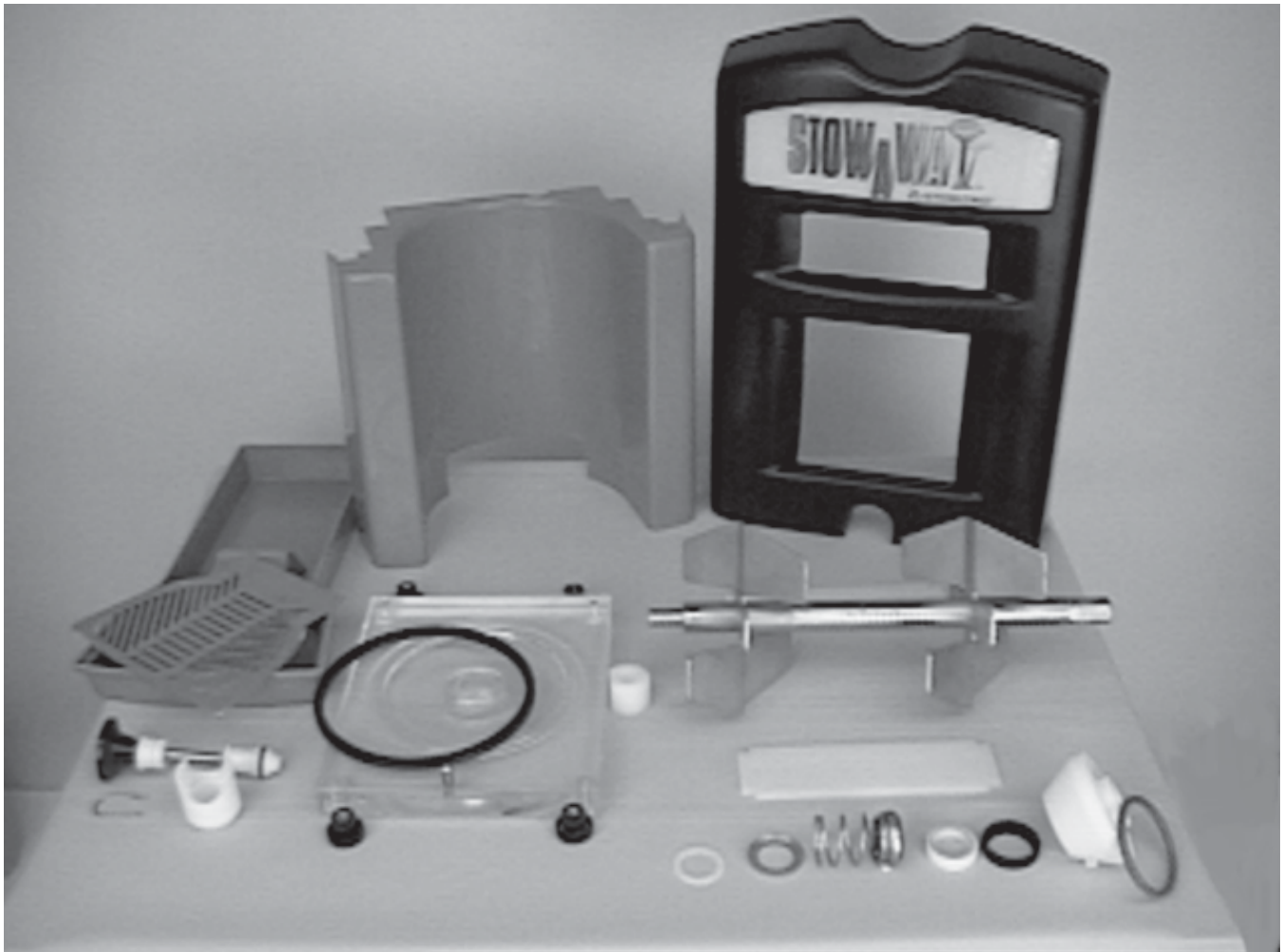
### 3.3. DISASSEMBLY OF FREEZER PARTS

#### CAUTION

**PLACE THE CLEAN OFF ON SWITCH IN THE OFF POSITION BEFORE DISASSEMBLING FOR CLEANING OR SERVICING.**

Inspection for worn or broken parts should be made at every disassembly of the freezer for cleaning or other purposes. All worn or broken parts should be replaced to ensure safety to both the operator and the customer and to maintain good freezer performance and a quality product. Frequency of cleaning must comply with the local health regulations.





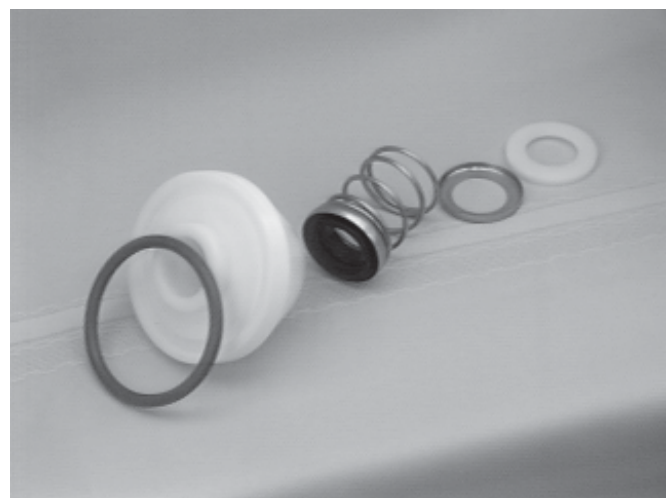
**Figure 7. Front Door and Auger Assembly**

To disassemble the freezer, refer to the following steps:

- A. Remove the front door by removing the upper and lower plastic shrouds then turn off the knobs, and pull the front door off the studs.
- B. Remove the spigot body from the spout by pulling the horse shoe clip up and out. Then pull the spigot body out of the spout. Disassemble by turning off the black plastic knob and removing all loose pieces.
- C. Pull the agitator assembly out of the freezer barrel.
- D. Keep the rear of the agitator assembly tipped up once it is clear of the freezer barrel to avoid dropping rear seal.
- E. Remove the front agitator support bearing and the two agitator blades.
- F. Remove the rear seal assembly and disassemble.
- G. Wipe socket lubricant from the drive end (rear) of the agitator with a cloth or paper towel.

H. Remove all "O" Rings.

**WARNING**  
**DO NOT USE ANY TYPE OF SHARP OBJECT TO REMOVE THE "O" RINGS.**



**Figure 8. Rear Seal Assembly**

### 3.4 CLEANING THE FREEZER PARTS

Place all loose parts in a pan or container and take to the wash sink for cleaning. To clean freezer parts refer to the following steps:

- A. Place all parts in warm mild detergent water and clean with brushes provided. Rinse all parts with clean hot water.

#### CAUTION

**DO NOT DAMAGE PARTS BY DROPPING OR ROUGH HANDLING.**

- B. Wash the freezer barrel and spout with warm detergent water and brushes provided.
- C. The exterior should be kept clean at all times to preserve the lustre of the stainless steel. A mild alkaline cleaner is recommended. Use a soft cloth or sponge to apply the cleaner.
- D. Remove the drip tray and insert. Clean with a soap solution. Rinse with clean hot water.

### 3.5 SANITIZE FREEZER AND FREEZER PARTS

- A. Use a sanitizer mixed according to manufacturer's instructions to provide a 100 parts per million strength solution. Mix sanitizer in quantities of no less than 2 gallons (7.5 liters) of 120°F water. Allow the sanitizer to contact the surfaces to be sanitized for 5 minutes. Any sanitizer must be used only in accordance with the manufacturer's instructions.
- B. Place all parts in the sanitizing solution, then remove and let air dry.

### 3.6 ASSEMBLY OF FREEZER

To assemble the freezer parts, refer to the following steps:

#### NOTE

Petro-Gel sanitary lubricant or equivalent must be used when lubrication of parts is specified.

#### NOTE

The United States Department of Agriculture and the Food and Drug Administration require that lubricants used on food processing equipment be certified for this use. Use lubricants only in accordance with the manufacturer's instructions.

- A. Assemble all "O" Rings onto parts dry, **without lubrication**. Then apply a thin film of sanitary lubrication to exposed surfaces of the "O" Rings. Apply a thin film of sanitary lubricant on the front of the agitator shaft.
- B. Assemble the rear seal assembly onto the agitator. Be sure the "O" Rings and gaskets are in place before installing the rear seal.

- C. Lubricate the drive end of the agitator (rear) shaft with a small amount of white socket lubricant. A small container of socket lubrication is shipped with the freezer.

- D. Install the two plastic agitator blades onto the agitator. Install front agitator bearing.
- E. Push the auger into the freezer barrel and rotate slowly until the agitator engages the drive.
- F. Assemble and install the spigot body with "O" Rings into the spout. Push straight in until the spigot is in place. Then install the horse shoe clip.
- G. Install door "O" Ring.
- H. Install the front door on the freezer.
- I. Install the knobs on the freezer studs and tighten.

#### CAUTION

**FINGER TIGHTEN THE KNOBS EVENLY. DO NOT OVER-TIGHTEN KNOBS.**

Look for the paper seal between the freezer barrel door, "O" Ring, and front door.

### 3.7 SANITIZING

Sanitizing must be done after the freezer is clean and just before filling with mix. **Sanitizing the night before is not effective.** However, you should always clean the freezer and parts after using it.

#### WARNING

**THE UNITED STATES DEPARTMENT OF AGRICULTURE AND FOOD AND DRUG ADMINISTRATION REQUIRE THAT ALL CLEANING AND SANITIZING SOLUTIONS USED WITH FOOD PROCESSING EQUIPMENT BE CERTIFIED FOR THIS USE. USE "STERA-SHEEN" OR EQUIVALENT.**

When sanitizing the freezer, refer to local sanitary regulations for applicable codes and recommended sanitizing products and procedures. The frequency of sanitizing must comply with local health regulations. Mix sanitizer according to manufacturer's instructions to provide a 100 parts per million strength solution. Mix sanitizer in quantities of no less than 2 gallons (7.5 liters) of 120°F water. Allow sanitizer to contact the surfaces to be sanitized for 5 minutes. Any sanitizer must be used only in accordance with the manufacturer's instructions.

#### NOTE

Stoelting, Inc. has found that STERA-SHEEN GREEN LABEL SANITIZER AND CLEANER does an effective job of properly sanitizing and cleaning a soft serve freezer. We therefore include a sample with each new freezer. For further information read the directions on the packet. Other products may be as effective.

**CAUTION**  
**PROLONGED CONTACT OF SANITIZER WITH FREEZER MAY CAUSE CORROSION OF STAINLESS STEEL PARTS.**

In general, sanitizing may be conducted as follows:

- A. Prepare 2 gallons (7.5 liters) of sanitizing solution following manufacturer's instructions.
- B. Pour sanitizer into hopper.
- C. Place the CLEAN OFF ON switch in the CLEAN position. Check for leaks around the front door seal.
- D. After five minutes, open spigot to drain sanitizing solution. When solution has drained, place the CLEAN OFF ON switch in the OFF position. Allow the freezer barrel to drain completely.

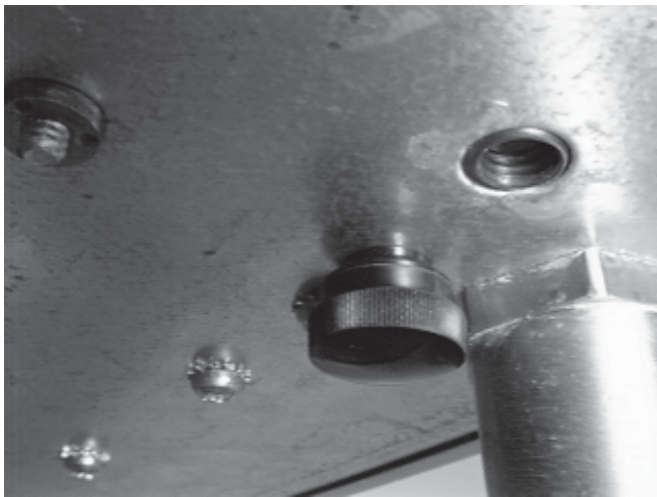
**3.8 INITIAL FREEZE DOWN AND OPERATION**

This section covers the recommended operating procedures to be followed for the safe operation of the freezer.

- A. Sanitize just prior to use.
- B. Place the CLEAN OFF ON switch in the OFF position.
- C. Fill the hopper with mix.
- D. Place the CLEAN OFF ON switch in the ON position. The product will be ready to serve in about 20-30 minutes.

**3.9 CONSISTENCY ADJUSTMENT**

The consistency adjustment knob is located next to the right front leg. Turn clockwise for a thicker product and counterclockwise for a thinner product. Allow 15-30 minutes for the product to change consistency.



**Figure 9. Consistency Control Knob**



## SECTION 4 BULB REPLACEMENT

### 4.1 LIGHT BULB REPLACEMENT

1. Remove the upper plastic shroud.
2. Remove the four retaining screws from the electrical panel and tip forward.
3. Grasp faulty bulb and pull out.
4. Push in replacement bulb until it snaps into place.
5. Replace the electrical panel and secure with the four retaining screws.
6. Replace the plastic shroud.

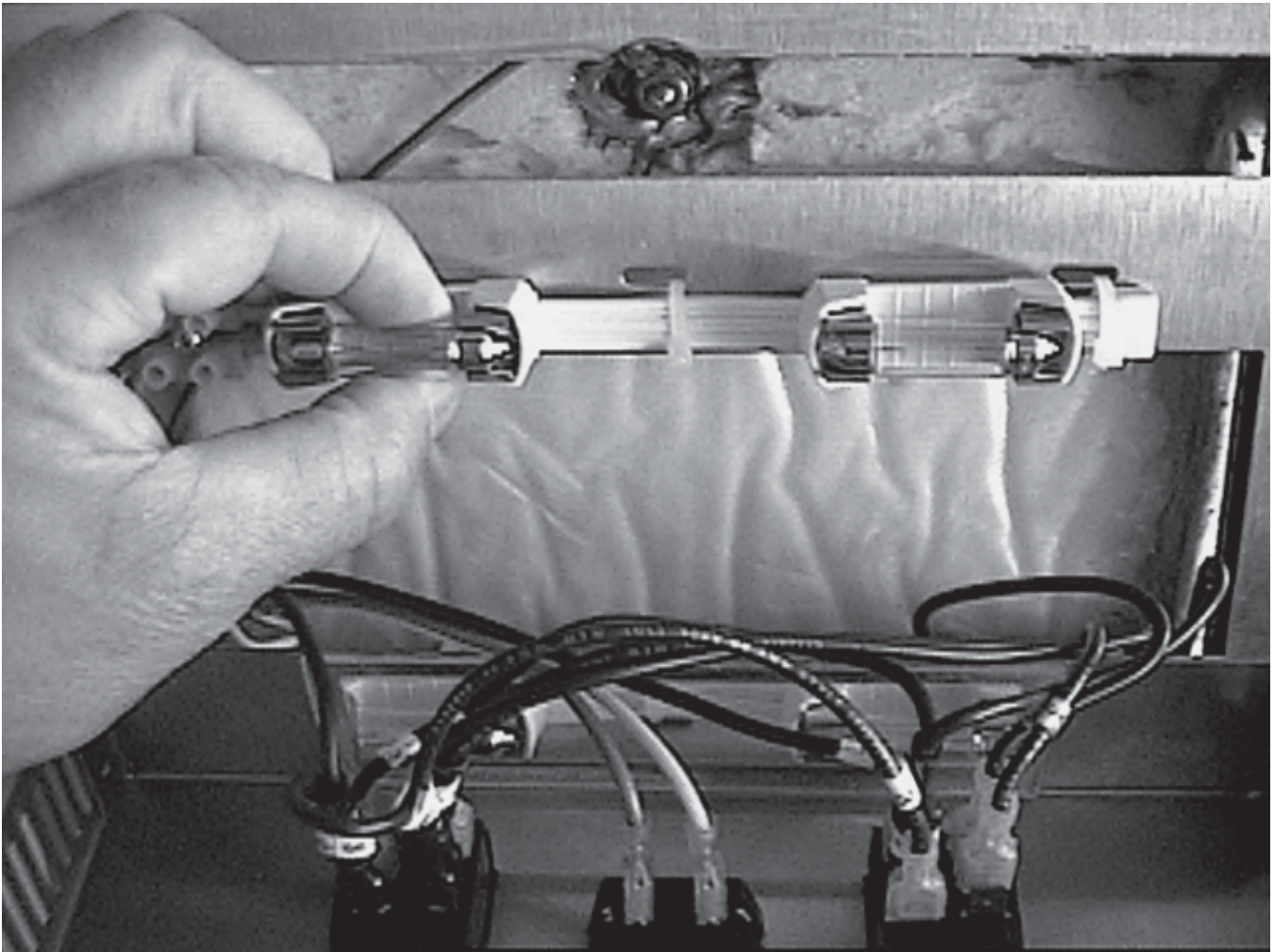


Figure 10. Light Bulb



## SECTION 5 SEQUENCE OF OPERATIONS

### 5.1 LIGHTS

On/Off light switch is independent of all other switches. When on, the light transformer is operational and the lights illuminate.

### 5.2 SWITCHES

<u>On/Off/Clean Switch Position</u>	<u>Mode Switch Position</u>	<u>Sequence of Operations</u>
Clean	Serve or Standby	-Drive Motor and Condenser Fan Motor start and run together, No time limit exists. -Power Transformer, torque switch, compressor, liquid level control, and mix low light are non-operational.
On	Serve	-Drive Motor and Condenser Fan start and run together continuously. -Power Transformer is on. -Liquid level control and mix low light are operational. -With liquid mix or loose slush in the freezing cylinder, the torque switch is closed. The delay-on-make timer starts the compressor after a 10-30 second delay. -When the slush reaches consistency, the torque switch opens and the compressor immediately shuts off. The drive motor and condenser fan motor continue to run.
On	Standby	-Power transformer, liquid level control and mix low light are operational only when the temperature control is closed. -Drive motor, condenser fan motor, and compressor cycle on and off with the temperature control (compressor start delays 10-30 seconds).

#### NOTE

If the temperature control is set too cold, control will default to the torque switch to prevent freeze-up.

### 5.3 SAFETY SWITCH

**Door Switch** - If the front door is removed, the freezer will not function.

**Motor Internal Thermostat** - If the motor overheats, the freezer will not function.

**Warning** - The motor internal thermostat automatically resets as the motor cools. The freezer will automatically restart. Disconnect freezer from power source for servicing.

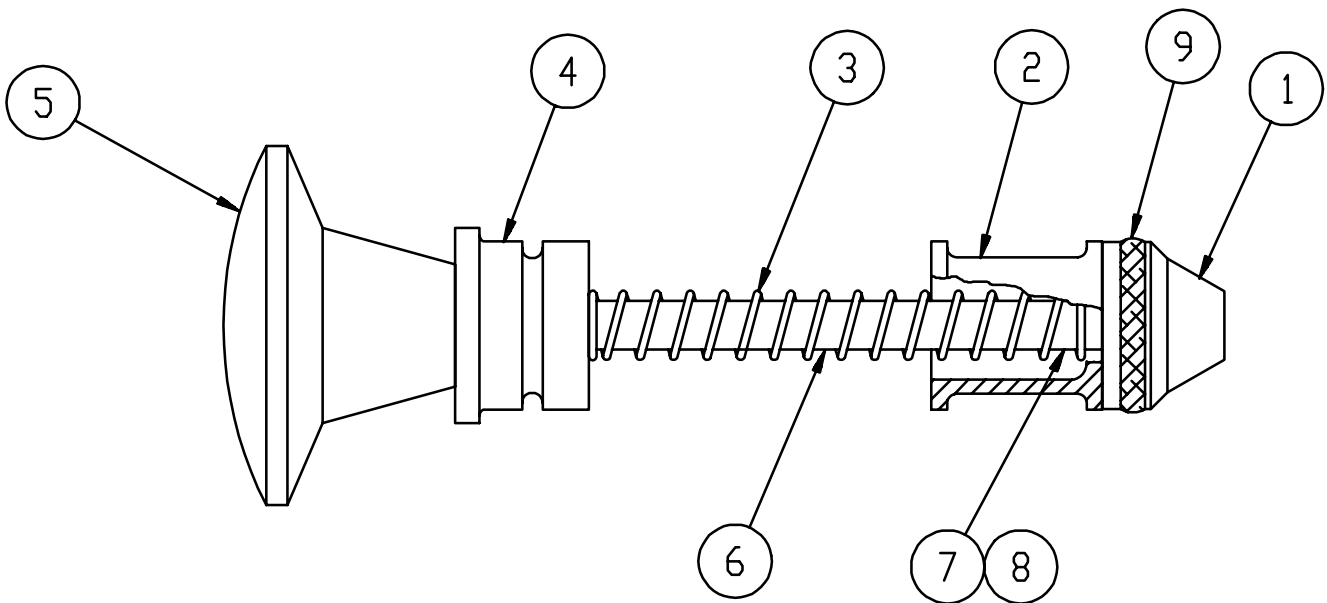
**High Pressure Cutout Switch** - If the compressor discharge pressure exceeds 470 PSIG, the freezer will not function.



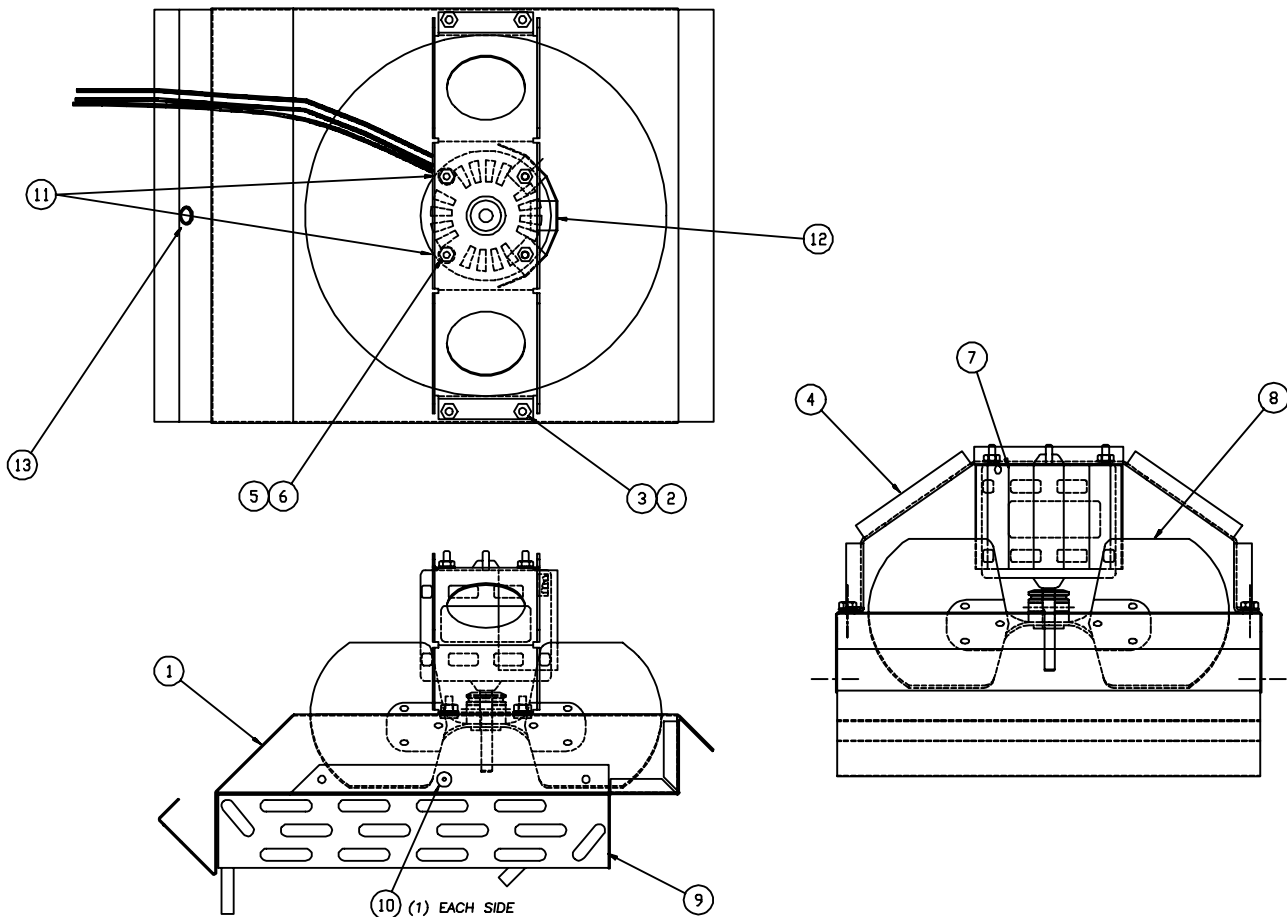
## SECTION 6 TROUBLESHOOTING

PROBLEM:	CAUSE	CORRECTION
High Pressure Cutout Switch Tripped.	Dirty condenser.	Clean condenser
Drive motor overload trips. (Freezer shuts down when running)	Improper Brix reading.	Refill with product that has Brix reading between 11 and 13.
Product dispenses incorrectly.	No mix in product cylinder or low mix in hopper.	Keep product cylinder and hopper full.
	Scraper blade missing from agitator.	Replace scraper blade.
	Freezer is being overdrawn.	Slow down rate of draw.
Product is too thin.	Ambient temperature is about 100°F (37.7°C).	Move or direct hot air away from freezer.
	Freezer is being overdrawn.	Slow down the rate of draw.
	Condenser is dirty.	Clean condenser.
Agitator Does Not Rotate	Drive motor overload tripped off.	Turn freezer off for 5 minutes, allow automatic reset.
	Agitator stuck or frozen.	Check for locked or bent fingers. Thaw product in freezer if frozen.
	No power to drive motor.	Check wire harness and switches in drive circuit and repair or replace.
	Drive motor is defective.	Check and replace if necessary.
Toggle Switch in Standby	Toggle switch in OFF or CLEAN position.	Place toggle switch in ON position.
No Ice Crystals on Initial Freeze Down	Blown fuse in building or no input power to freezer.	Check for blown fuse or input power to freezer.
	Mix too rich.	Take "Brix" reading. Fill with properly mixed product.
	Restricted air flow to freezer.	Air enters lower front and discharges out the top back, make certain both areas are clear.
	Consistency set for too thin a product.	Set consistency to a thicker product.
Spigot Leaking or Stuck.	Spigot "O" rings defective or missing.	Drain mix to below spigot level. Remove spigot, clean, replace "O" rings as needed, lubricate and install.
	Dried mix in spigot assembly.	Drain mix to below spigot level. Remove spigot retainer and spigot. Disassemble and clean with hot water and brush. Lubricate, re-assemble and install. Fill with liquid mix.

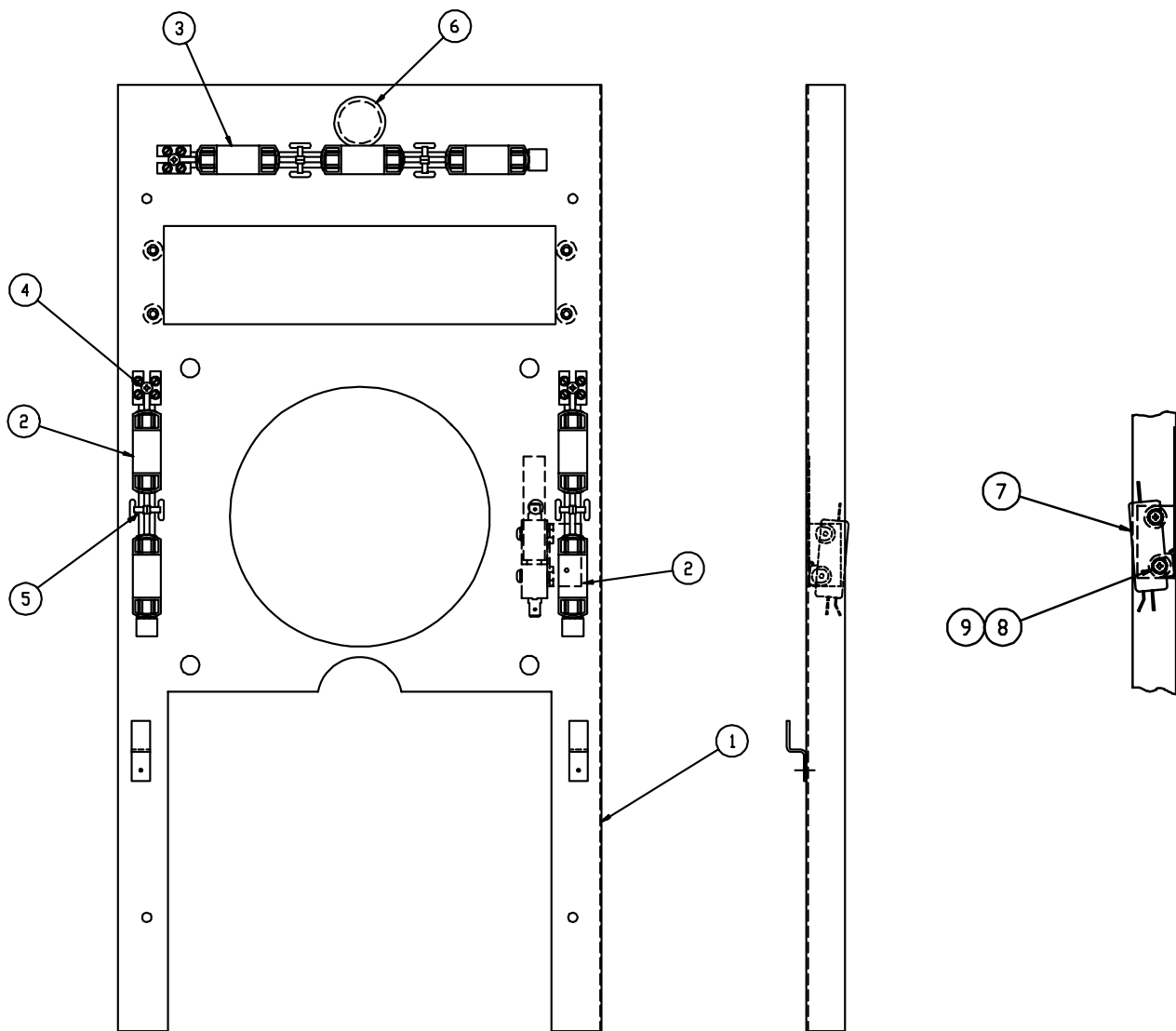
ITEM	STOELTING PN	QTY	DESCRIPTION
1	5114-101	1	PLUG & O-RING RETAINER
2	1120918	1	SPLASH DEFLECTOR
3	694400	1	SPRING COMP 3X.281X13/32
4	232002	1	RETAINER CAP
5	482024	1	KNOB 1-27/32 PLASTIC BLACK
6	2171830	1	SPIGOT SHAFT
7	M820302	.001	ADHESIVE, RESIWELD A
8	M820303	.001	ADHESIVE, RESIWELD B
9	624607	1	RING O 11/16X7/8X3/32 SPECIAL



ITEM	STOELTING PN	QTY	DESCRIPTION
1	4171833	1	FAN SHROUD
2	766948	4	WASHER SHAKEPROOF 10 ZINC
3	538297	4	NUT HEX FULL 10-24 ZP
4	3171831	1	BRACKET, CONDENSER FAN
5	766940	4	WASHER SHAKEPROOF 8 ZINC PLATE
6	538280	4	NUT HEX 8-32X11/32X1/8 STL
7	522833	1	MOTOR, FAN
8	162067	1	BLADE FAN 9IN DIA 4-BLADES
9	284081	1	CONDENSER
10	628032	2	RIVET C'SUNK 3/16'DIA.ALUMINUM
11	766430	2	WASHER #8
12	2177026	1	FAN GUARD
13	222997	1	BUSHING SNAP 9/32 ID, 3/8 HOLE
14	M820172	00	LOCTITE (BLUE)

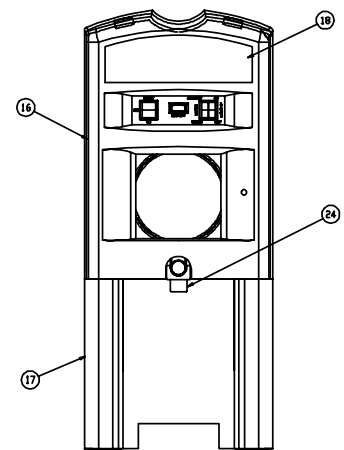
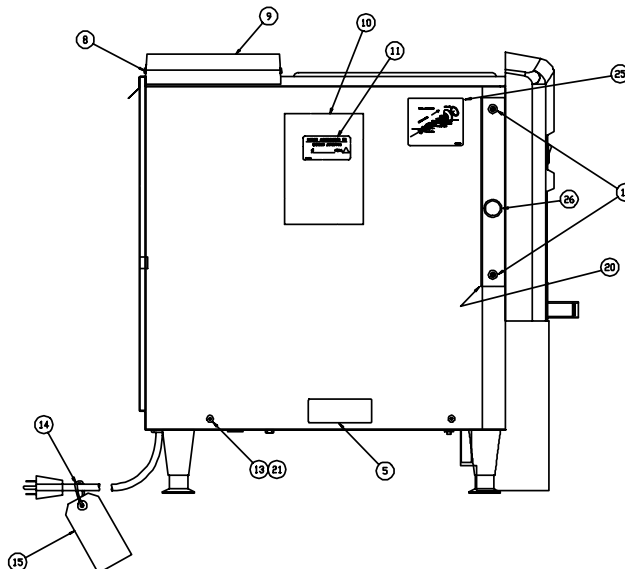
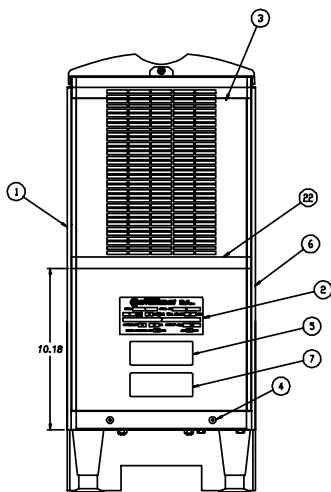
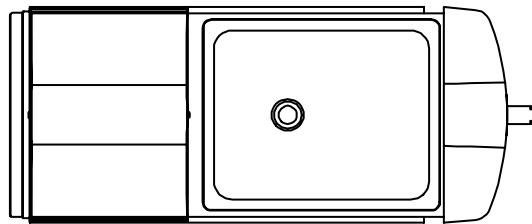


ITEM	STOELTING PN	QTY	DESCRIPTION
1	3172952	1	FRONT PANEL
2	2172966-02	2	2 LIGHT STRIP W/ CAP & TERMINAL
3	2172966-03	1	3 LIGHT STRIP W/ CAP & TERMINAL
4	647416	3	SCREW MACH 6-32 X 5/8 RD HD PH
5	739040	4	TIE 8.0 LG X 1/8 WIDE NEUTRAL
6	584200-13	1	PLUG HOLE 1.00 DIA MTG HOLE
7	1170836	1	LIMIT SWITCH ASSEMBLY
8	766933	2	WASHER SHAKEPROOF 6X5/16
9	647432	2	SCREW MACH 6-32 X 7/8 PAN HD PH



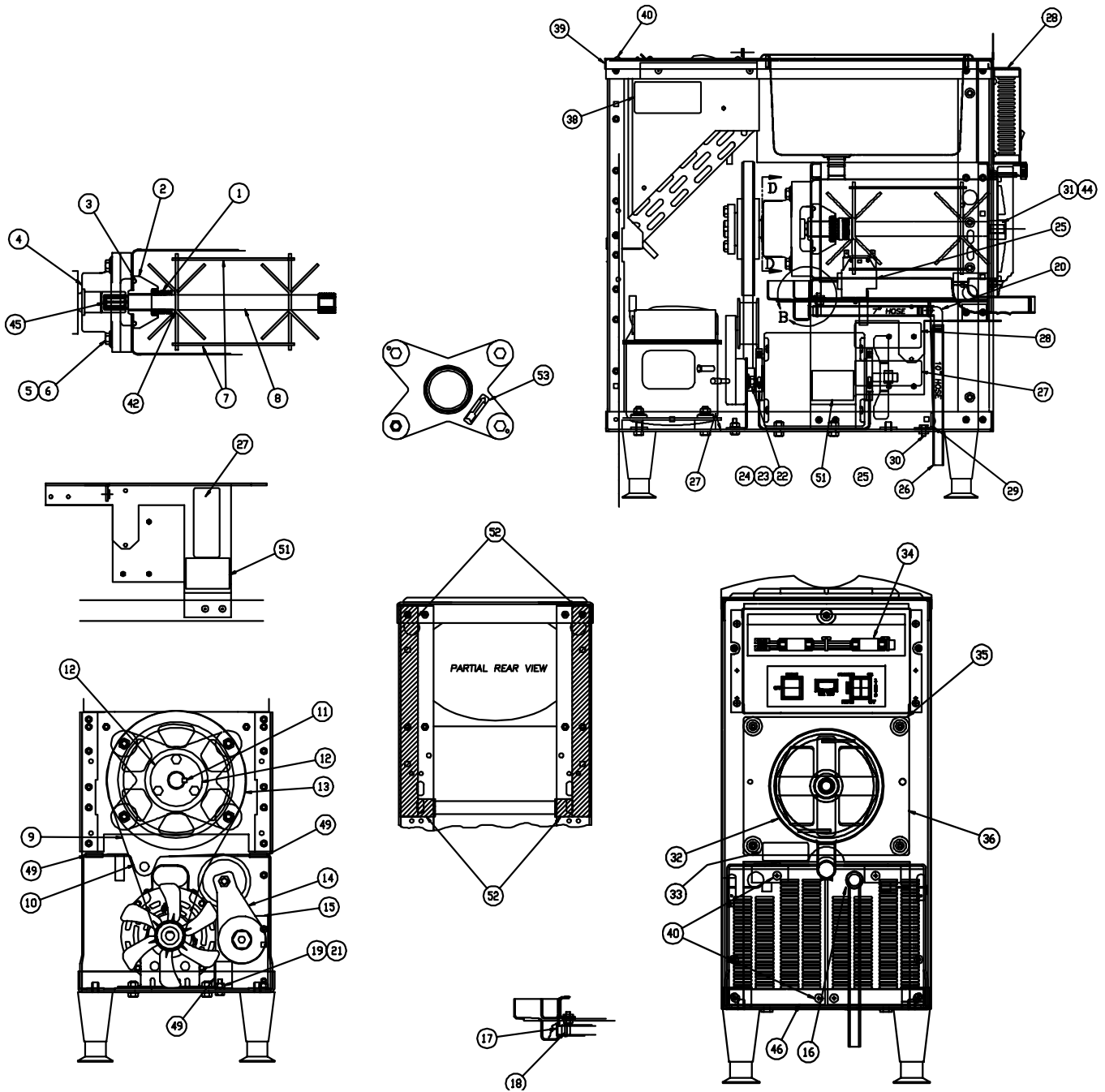


ITEM	STOELTING PN	QTY	DESCRIPTION
1	3177173	1	PANEL, RIGHT SIDE
2	.	1	MODEL ID PLATE
3	4177157	1	PANEL, BACK
4	647653	2	SCREW MACH 10-24 X 3/8 TRS HD
5	324107	3	DECAL, CAUTION MOVING PARTS
6	3177174	1	PANEL, LEFT SIDE
7	324113	1	DECAL CAUTION GROUNDED PLUG
8	647512	2	SCREW MACH 8-32 X 3/8 PAN HD
9	521232	1	COVER, VENT SC118-37
10	130000	1	BAG, ENVELOPE FRONT LOADING
11	324566	1	DECAL - WIRED ACCORDING TO
12	.	1	WIRING DIAGRAM
13	701007	4	STANDOFF, SCREW GROMMET #10
14	739040	1	TIE 8.0 LG X 1/8 WIDE NEUTRAL
15	723529	1	TAG CAUTION
16	521231	1	PANEL, HEADER C118-37H
17	521230	1	PANEL, SPLASH C118-37H
18	324677	1	DECAL, HEADER C118-37H
19	647886	4	SCREW MACH 1/4-20 X 1/2 TRS HD
20	2177179	2	SPACER, DRINK MIX ASSY.
21	649000-39	4	SCREW MACH 10-24 X 3/4 TRS HD ST
22	728088	.95 FT	TAPE INSULATION 1/2X1X33FT
23	368140	1	CONDENSER FILTER
24	2177040	1	SPIGOT EXTENSION
25	324689	1	DECAL-REAR SEAL ASSEMBLY
26	422074	2	GROMMET RUBBER BLACK

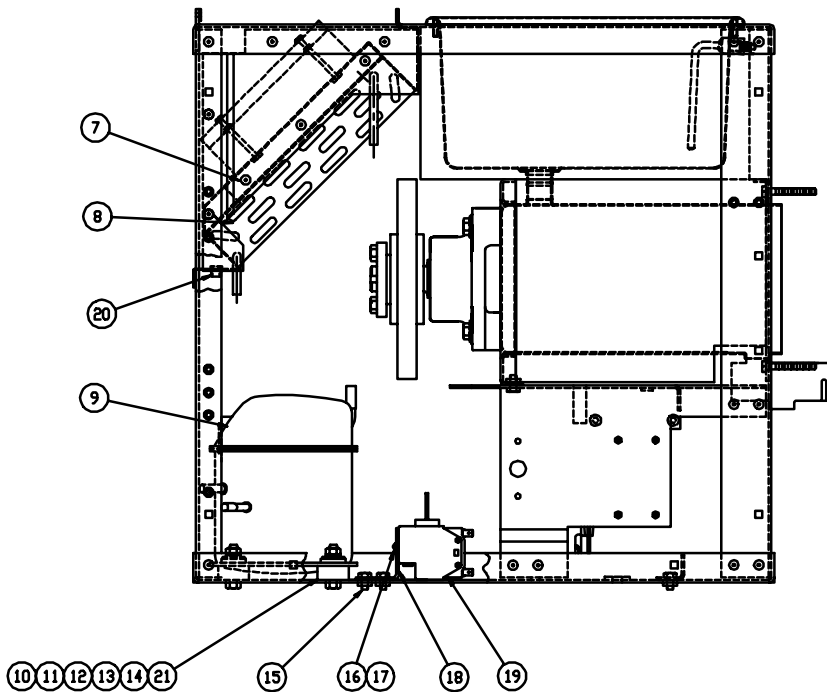
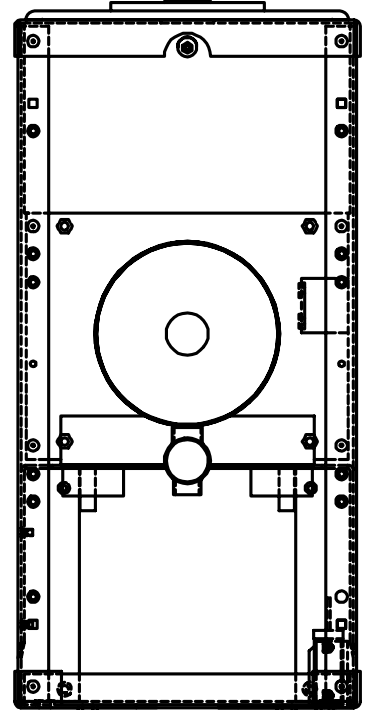
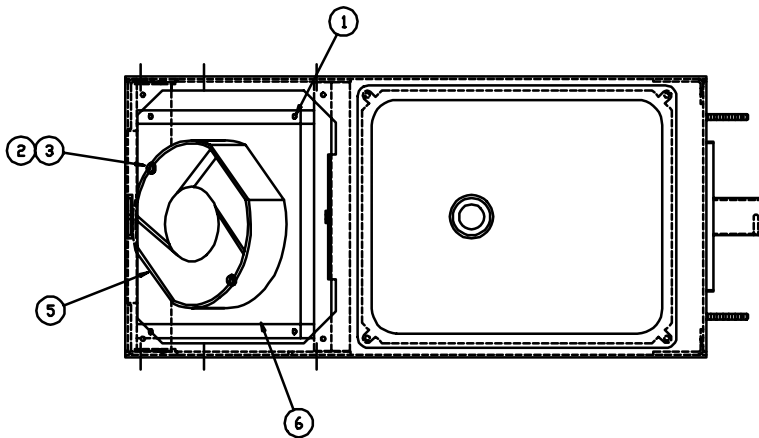


27	324107	3	DECAL CAUTION MOVING PARTS
28	324105	2	DECAL CAUTION-ELECT SHOCK
29	2172928	1	STIFFENER BRACKET
30	644093	3	SCREW CAP 1/4-20 X 1/2 HX HD
31	1170892	1	AUGER BUSHING
32	625311	1	RING QUAD 5.75 ID, 50 DURD
33	324141	1	DECAL CAUTION-ROTATING BLADES
34	493064	4	LIGHT INCANDESCENT, 24V, 10 WATT
35	482043	4	KNOB, 1/4-20 FEMALE W/ THRU HOLE
36	3177121	1	FRONT DOOR ASSY
37			
38	324208	2	DECAL REFRIG LEAK CHECK
39	3172887	1	PANEL, TOP
40	647653	10	SCREW MACH 10-24 X 3/8 TRS HD
41	M820309	.001	SEALANT, DOW CORNING
42	2177118	1	WASHER FLAT, ACETRON 1.25OD X .94ID
43			
44	508135	.001	LUBE GREASE PETROL GEL 4 OZ
45	508033	.001	LUBRICANT FEL-PRO #51171
46	2172898	2	PANEL, SLOTTED
47			
48			
49	714039-03	3.5"	STRIP PROTECTIVE LINER
50			
51	324686	2	DECAL, DANGER STARTS AUTOMATIC
52	M820323	2.18'	TAPE INSUL 1 X 1/4 IN THICK
53	324014	1	DECAL BLK ARROW ON WHITE BACK

ITEM	STDELTING PN	QTY	DESCRIPTION
1	667892	1	SEAL, SHAFT, C118
2	3172965	1	ADAPTER, REAR SEAL
3	624857	1	RING O 21/4IDX25/BDDX3/16CS
4	3170878	1	BEARING HOUSING ASSY
5	766982	4	WASHER SHAKEPROOF 3/8 ZINC
6	644605	4	SCREW CAP 3/8-16 X 2 HX HD ZP
7	162156	2	BLADE SCRAPER HDPE
8	4172948	1	VELDMENT, AUGER
9	152227	1	BELT, POLY-V 34' LONG 6 GROOVE
10	744269	1	DRIP TRAY PER DVG 744269 C
11	1981462-0200	1	KEYSTOCK SQ CR 1/4 C 1/4 X 2.00
12	599170	1	BUSHING, PULLEY
13	598331	1	PULLEY, POLY-V 8.0" O.D. 6 GROOVE
14	454016	1	IDLER PER DVG 454016A
15	2171878	1	BRACKET, IDLER
16	223058	1	BUSHING SNAP 11/16ID 7/8 MTG
17	1172693	1	DRAIN TUBE
18	264061	1	CLAMP, LOOP TYPE JAW 5/8
19	644091	2	SCREW CAP 1/4-20 X 1/2 HX HD
20	375892	1	90 DEGREE ELBOW 1/2 X 1/2
21	538335	2	NUT HEX 1/4-20 X 7/16 STL ZP
22	644541	1	SCREW CAP 3/8-16 X 1 HX HD ZP
23	767216	1	WASHER FLAT 3/8X17/16 14GA ZP
24	766081	1	WASHER LOCK 3/8IN MED
25	324723	1	DECAL, TEMP ADJUSTMENT
26	756085	17.0'	TUBING, 1/2 ID X 5/8 OD CLEAR PVC



ITEM	STOELTING PN	QTY	DESCRIPTION
1	628007	4	RIVET 1/8DIA X .232LG STEEL
2	647483	2	SCREW, MACH 8-32 X 2 PAN HD
3	766941	2	WASHER SHAKEPROOF #8
4	538280	2	NUT HEX 8-32X11/32X1/8 STL
5	357036	1	FAN 6IN DIA
6	3172936	1	SHROUD, FAN
7	628032	6	RIVET, C'SUNK 3/16' DIA ALUM
8	284081	1	CONDENSER
9	282022	1	COMPRESSOR, 115V, 60Hz, 1PH
10	422065	4	GROMMET 7/16 HOLE DIA X .92 H
11	644355	4	SCREW CAP 5/16-18 X 1-1/2 HX
12	767211	4	WASHER FLAT 5/16,7/8X3/8X14GA
13	766073	4	WASHER LOCK 5/16 .125X.078 MED
14	684015	4	SLEEVE 5/16 ID X 29/32 LONG
15	644073	2	SCREW CAP 1/4-20 X 3/8 HX HD
16	647393	2	SCREW MACH 6-32 X 3/8 RD HD PH
17	766933	2	WASHER SHAKEPROOF 6X5/16
18	1172932	1	HI-PRESSURE CUT OUT BRACKET
19	718768	1	SWITCH HI-PRESS.LIMIT CONTROL
20	222997	1	BUSHING SNAP 9/32 ID, 3/8 HOLE
21	538344	4	NUT HEX 5/16-18 X 1/2 STL ZP



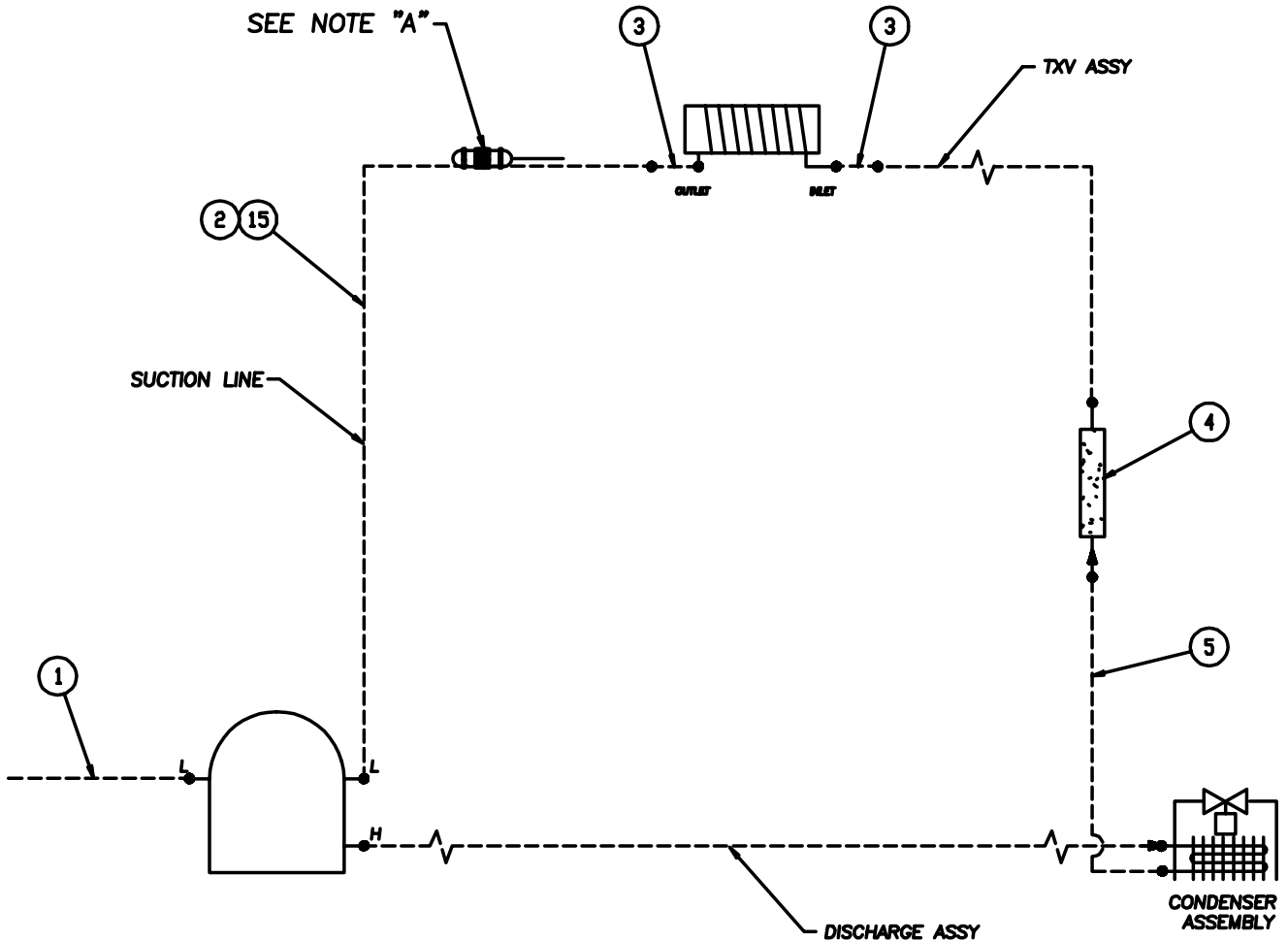
ITEM	STDELTING PN	QTY	DESCRIPTION
1	4172960-06	1	REFRIGERATION TUBING - SEE SHEET 3
2	4172960-01	1	REFRIGERATION TUBING - SEE SHEET 3
3	375127	2	FTG SOLDER RED EL 1/2X3/8 OD
4	342004	1	DRIER, FILTER
5	4172960-03	1	REFRIGERATION TUBING - SEE SHEET 3
6	519502	1	MASTIC THERMAL ND 440.22
7	739114	4	TIE 15IN LONG X 3/16WIDE WHITE
8	728091	1	TAPE INSULATING 1/8 X 2 X 30'
9	M820322	AS REQ	ADHESIVE ARMSTRONG R520
10	M860162	AS REQ	RUST INHIBITOR SPRAY 710
11	M000392	AS REQ	ALCOHOL, RUBBING
12	728220	4.6 FT	TAPE, ALUMINUM FOIL 2" WIDE
13	M002468	AS REQ	SILICONE
14	728221	5.0 FT	TAPE, VINYL FOAM
15	464262	23.0'	INSUL FOAM TUBING 3/8X1/4
16	756164	3.02'	TUBING REFRIG 1/4OD COPPER
17	756168	2.17'	TUBING REFRIG 3/8OD COPPER
18	615205	14 OZ	REFRIGERANT, R404A - DUPONT

**NOTES**

- 1: BRAZE AND APPLY RUST INHIBITOR (ITEM 10) PER SES 50-50-04.
- 2: WHEN BRAZING CONNECTIONS TO EXPANSION VALVE USE HEAT SINK TO PROTECT FROM OVER HEATING.
- 3: INSTALL DRIER LAST TO PREVENT CONTAMINATION OF DESSICANT.
- 4: INSULATE SUCTION LINES ONLY.
- 5: LEAK CHECK AND EVACUATE PER SES 50-54-17. CHARGE WITH 14OZ OF ITEM(18).

**NOTE A: EXPANSION VALVE BULB MOUNTING.**

- NOTE: INSURE HANDS ARE CLEAN PRIOR TO STARTING STEP 1.
- STEP 1 CLEAN BULB AND SUCTION LINE WITH ITEM (11) ALCOHOL. LOCATE TXV BULB ON SUCTION LINE. ORIENT BULB ON TOP OF SUCTION LINE.
  - STEP 2 CUT A 4" LONG PIECE OF ALUMINUM TAPE ITEM (12) CUT THIS PIECE IN HALF, RESULTING IN (2) 1" X 4" PIECES. SECURE BULB TO SUCTION LINE WITH FOIL TAPE.
  - STEP 3 APPLY A SMALL AMOUNT OF SILICONE ITEM (13) OVER TXV CAPILLARY TUBE TO FORM A COMPLETE SEAL WHEN ALUMINUM TAPE IS APPLIED IN STEP 4.
  - STEP 4 CUT (6) 4" LONG STRIPS OF ALUMINUM TAPE ITEM (12). WRAP FIRST 4" LONG PC. ONE TAPE WIDTH FROM END OF BULB (OPPOSITE CAPILLARY SIDE).  
NOTE: ALL WRAPS ARE STRAIGHT NON-SPIRALLING. APPLY SECOND PC. WITH 1/2 OVERLAP. FORM OPEN END CLOSED. APPLY THIRD & FOURTH WRAPS WITH 1/2 OVERLAP. APPLY FIFTH WRAP WITH 1/2 OVERLAP PARTIALLY COVERING SILICONE. FORM OPEN END CLOSED. APPLY SIXTH WRAP OVER CAPILLARY TUBE. SEAL OVER SILICONE. SILICONE SHOULD OOOZE DUE TO SEALING. PRESS AND FORM ALUMINUM TAPE IN PLACE TO INSURE A GOOD SEAL.
  - STEP 5 CLEAN ALUMINUM WRAP WITH ITEM (6) ALCOHOL.  
NOTE: DO NOT CUT ITEM (14).  
STARTING AT CAPILLARY END OF BULB, STRAIGHT WRAP (2) FULL TURNS OF ITEM (14) FOAM TAPE. SPIRAL WRAP WITH 1/2 OVERLAPS UNTIL FLUSH WITH END OF ALUMINUM TAPE. FINISH WITH (2) FULL STRAIGHT WRAPS.
  - STEP 6 INSULATE SUCTION LINE FROM EVAPORATOR TO BULB AND FROM BULB TO NEXT COMPONENT.  
FULL TAPES & PRESS SEAM TOGETHER FIRMLY. ADHERE INSULATION TO EVAPORATOR WITH ITEM (9) ADHESIVE.
  - STEP 7 CUT INSULATION APPROX 1/2" LONGER THAN THE AREA TO BE COVERED OVER BULB. APPLY ADHESIVE ITEM (9) TO ALL ENDS TO BE CONTACTED. FIRMLY PRESS ALL SURFACES TO BE SEALED, CREATING AN AIR TIGHT SEAL. APPLY TIES ITEM (7) AFTER ADHESIVE HAS CURED.

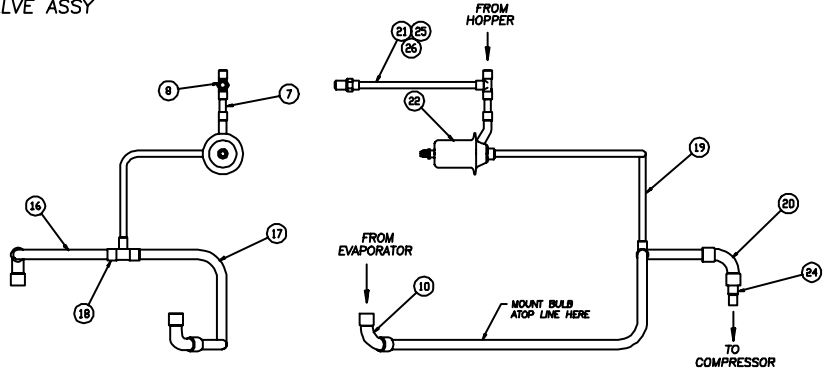


ITEM	STEELTING PN	QTY	DESCRIPTION
1	4171837-12	1	REFRIGERATION TUBING, SEE SHEET 4
2	4171837-01	1	REFRIGERATION TUBING, SEE SHEET 4
3	342006	1	DRIER, FILTER
4	4171837-03	1	REFRIGERATION TUBING, SEE SHEET 4
5	762410	1	VALVE EXPANSION ADJUSTABLE
6	4171837-08	2	REFRIGERATION TUBING, SEE SHEET 4
7	4171837-09	2	REFRIGERATION TUBING, SEE SHEET 4
8	375242	4	FTG SOLDER TEE 1/4 OD
9	375003	1	FITTING, SHORT RAD.90 STR.ELBOW
10	375127	2	FTG SOLDER RED EL 1/2X3/8 OD
11	342020	1	DRIER
12	4171837-10	1	REFRIGERATION TUBING, SEE SHEET 4
13	4171837-11	2	REFRIGERATION TUBING, SEE SHEET 4
14	4171837-05	1	REFRIGERATION TUBING, SEE SHEET 4
15	4171837-02	1	REFRIGERATION TUBING, SEE SHEET 4
16	4171837-07	1	REFRIGERATION TUBING, SEE SHEET 4
17	4171837-06	1	REFRIGERATION TUBING, SEE SHEET 4
18	375253	1	FTG SOLDER TEE 3/8 X3/8 X1/4OD
19	4171837-04	1	REFRIGERATION TUBING, SEE SHEET 4
20	375011	1	FTG SOLDER ELBOW 90DEG 3/8 OD
21	375813	2	ACCESS FITTING ASSEMBLY
22	762978	1	VALVE EPR R22
23	231105	1	CAPILLARY TUBE .072 X .026
24	374845	1	FITTING, REDUCER
25	762359	2	VALVE CORE
26	232065	1	CAP, QUICK SEAL, 1/4" SAE

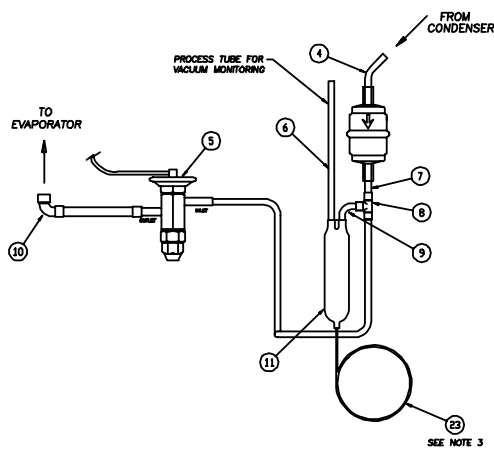
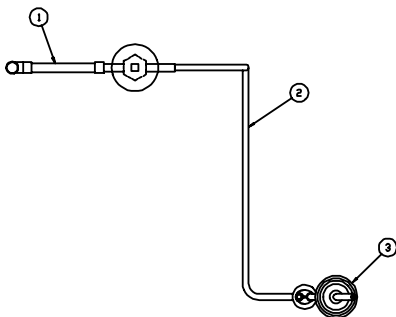
NOTES:

1. FOR BRAZING, SEE SES-50-50-4
2. PROTECT SUB-ASSEMBLIES IF PUT INTO STOCK.
3. CAP TUBE TO FEED FRONT HOPPER TUBE. LOCATE CAP TUBE TO SIDE OF EVAPORATOR & MOUNT TO TOP OF EVAPORATOR SUPPORT

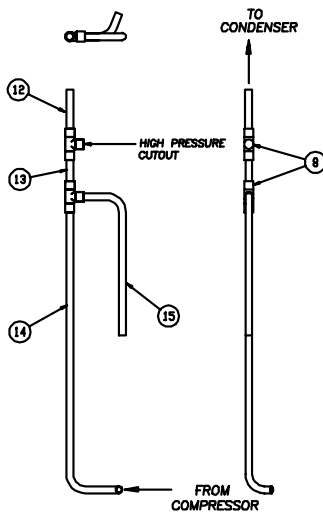
EPR VALVE ASSY



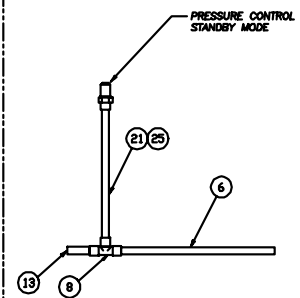
TXV ASSY



DISCHARGE ASSY



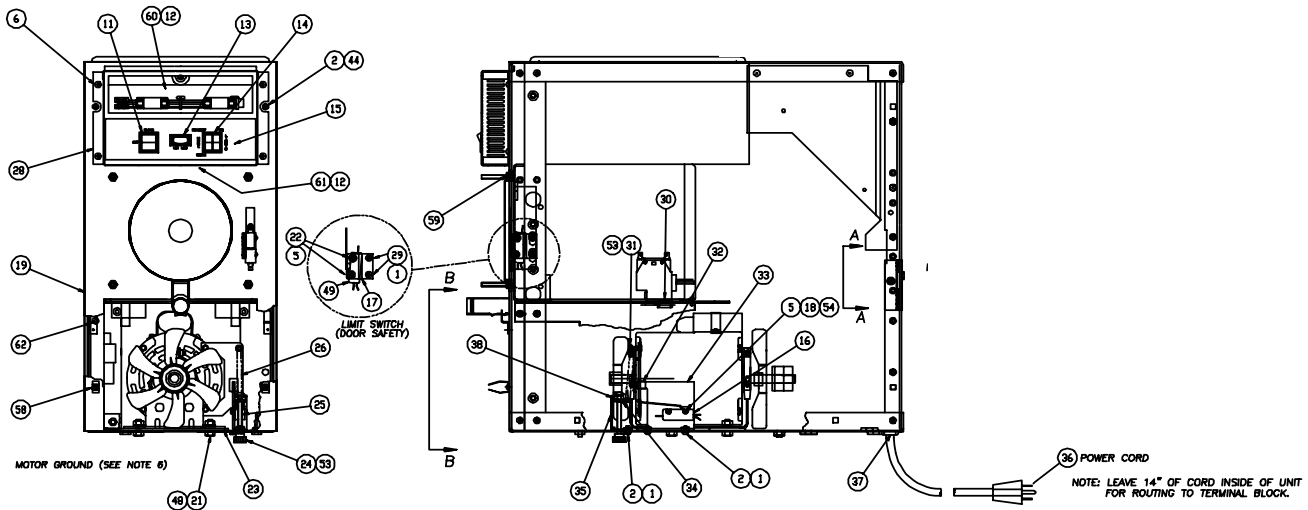
PROCESS LINE ASSY



ITEM	STOELTING PN	QTY	DESCRIPTION
1	766948	6	WASHER SHAKEPROOF 10 ZINC
2	647658	9	SCREW MACH 10-24 X 3/8 RD HD
3	744142	2	TRANSFORMER
4	647393	4	SCREW MACH 6-32 X 3/8 RD HD PH
5	766933	8	WASHER SHAKEPROOF 6X5/16
6	647645	4	SCREW MACH 10-24 X 1/4 TRS HD
7	732010	1	TERMINAL BLOCK
8	.	.	.
9	296179	1	CONTROL LIQUID LEVEL 24V
10	739543	1	TIMER, DELAY-ON-MAKE
11	718886	1	SWITCH, ROCKER 15 AMP 125 VAC
12	M970188	.001	LOCTITE 454
13	458104	1	INDICATOR, LIGHT 28V RED LENS
14	718887	1	SWITCH, ROCKER 15 AMP 125 VAC
15	324676	1	DECAL, SWITCH BOX
16	1170896-01	1	LIMIT SWITCH ASSEMBLY
17	2177151	1	DOOR SWITCH BRACKET
18	647441	2	SCREW MACH 6-32 X 1 RD HD PH
19	3177185	1	FRONT PANEL & LIGHT ASSY
20	522418	1	MOTOR, 1/3HP 115V 60HZ 1 PHASE
21	644307	4	SCREW CAP 5/16-18 X 3/4 HX HD
22	647432	2	SCREW MACH 6-32 X 7/8 PAN HD
23	766568	4	WASHER, FLAT RUBBER 2-1/4 OD X 3/8
24	482004	1	KNOB PLASTIC BLACK 3/4" DIA
25	647979	1	SCREW, 1/4-20 X 2-1/2 SS SLOTTED
26	695763	1	SPRING, EXT .240 OD X 3 FREE LENGTH
27	2172951	1	BRACKET, MOTOR
28	3177113	1	BOX, SWITCHES & LIGHTS
29	647653	2	SCREW MACH 10-24 X 3/8 TRS HD

30	223058	2	BUSHING SNAP 11/16ID 7/8 MTG
31	538280	4	NUT HEX 8-32X11/32X1/8 STL
32	796209	.50"	TUBING VACUUM 7/32ID X 13/32OD
33	1171921	1	BRACKET, TORQUE SWITCH
34	1171924	1	BRACKET, ADJUSTING
35	1171923	1	BRACKET, ADJUSTING SCREW
36	430168	1	HARNESS POWER CORD 15 AMP 125V
37	223162	1	BUSHING STRAIN RELIEF 7/8 HOLE
38	714035	.62"	STRIP, EDGE LINER PROTECTOR
39	3177154	1	BRACKET, ELECTRICAL
40	524091	5	MOUNT ADHESIVE BACK 1X1 PLASTC
41	739040	5	TIE 8.0 LG X 1/8 WIDE NEUTRAL
42	647665	1	SCREW MACH 10-32 X 3/8 HX HD
43	146449	2	BEARING, BALL 1.5748 ID
44	701005	4	STANDOFF, SCREW GRDMET #10
45	1172969	2	BUSHING, MOTOR
46	766940	8	WASHER SHAKEPROOF 8 ZINC PLATE
47	647513	5	SCREW MACH 8-32 X 3/8 RD HD PH
48	538351	4	NUT HEX 5/16-18 X 1/2 STL ZP LF
49	1170836	1	LIMIT SWITCH (DOOR SAFETY)
50	162051	1	BLADE, FAN 6" CV
51	162052	1	BLADE, FAN 6" CCW
52	598012	1	PULLEY, POLY-V 1.50" O.D. 6 GROOVE
53	M820172	.001	ADHESIVE LOCTITE 242-31
54	538265	2	NUT HEX #6-32 X 5/16 STL ZP
55	647650	1	SCREW MACH 10-24 X 1/2 FL HD
56	647499	2	SCREW MACHINE 8-32 X 1/4
57	295011	1	CONTACTOR MAGNETIC 2 POLE
58	2177028	2	CLIP, SPRING
59	538327	4	NUT, HEX JAM 1/4-20 S'STL
60	771004	1	WINDOW, FRONT
61	771005	1	WINDOW, LOWER
62	M820309	.001	SEALANT DOW CORNING ALUMINUM

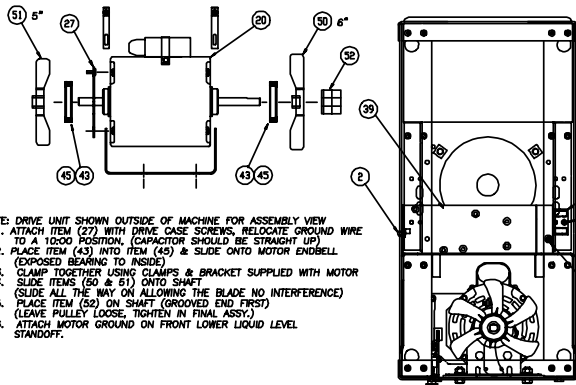
SECTION D-D



MOTOR GROUND (SEE NOTE 6)

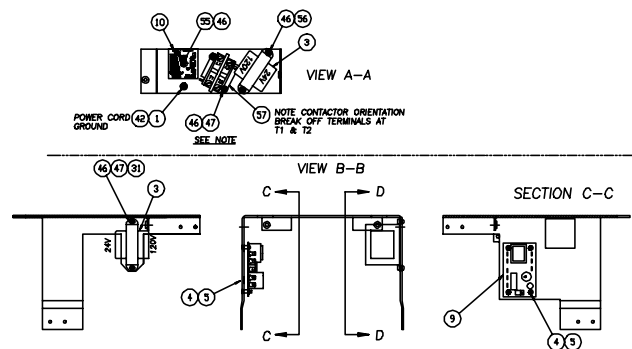
POWER CORD

NOTE: LEAVE 14" OF CORD INSIDE OF UNIT FOR ROUTING TO TERMINAL BLOCK.



REAR

- NOTE: DRIVE UNIT SHOWN OUTSIDE OF MACHINE FOR ASSEMBLY VIEW
1. ATTACH ITEM (27) WITH DRIVE CASE SCREWS, RELOCATE GROUND WIRE TO A 120° POSITION. (CONTACTOR SHOULD BE STRAIGHT UP)
  2. PLACE ITEM (43) INTO ITEM (45) & SLIDE ONTO MOTOR ENDBELL (EXPOSED BEARING TO INSIDE)
  3. CLAMP TOGETHER USING CLAMPS & BRACKET SUPPLIED WITH MOTOR
  4. SLIDE ITEMS (50 & 51) ONTO SHAFT (SLIDE ALL THE WAY ON ALLOWING THE BLADE NO INTERFERENCE)
  5. PLACE ITEM (52) ON SHAFT (GROOVED END FIRST) (LEAVE PULLEY LOOSE, TIGHTEN IN FINAL ASSY.)
  6. ATTACH MOTOR GROUND ON FRONT LOWER LIQUID LEVEL STANDOFF.



VIEW A-A

POWER CORD GROUND

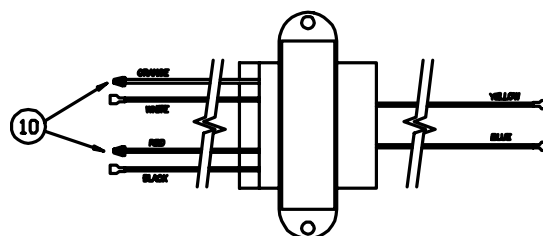
SEE NOTE

NOTE CONTACTOR ORIENTATION BREAK OFF TERMINALS AT T1 & T2

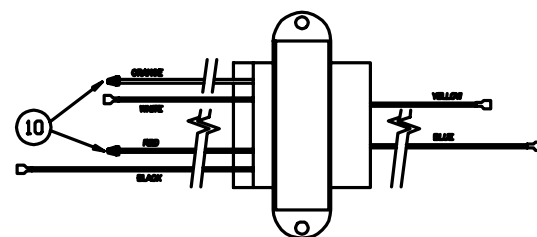
VIEW B-B

SECTION C-C

ITEM	STOELTING PN	QTY	DESCRIPTION
1	430776	1	HARNESS, 4 WIRE
2	430777	1	HARNESS, 7 WIRE
3	430778	1	HARNESS, 6 WIRE
4	430779	1	HARNESS, 3 WIRE
5	430780	1	HARNESS, 4 WIRE
6			
7	430782	1	HARNESS, 5 WIRE
8	430783	1	HARNESS, 2 WIRE
9	732096	2	TERMINAL FEMALE 14-16 GA
10	732133	4	TERMINAL
11	732116	13	TERMINAL FEMALE 18-20 GA
12	739040	2	TIE 8.0 ' LG X 1/8 WD
13	732202	1	1/4' TERMINAL FULLY INSULATED QC
14	538296	1	NUT HEX #10 X 3/8 SS
15	766950	1	SHAKEPROOF WASHER #10
16	430784	1	HARNESS, WIRE WKK02E2B
17	430631	1	WAA05E2B HARNESS



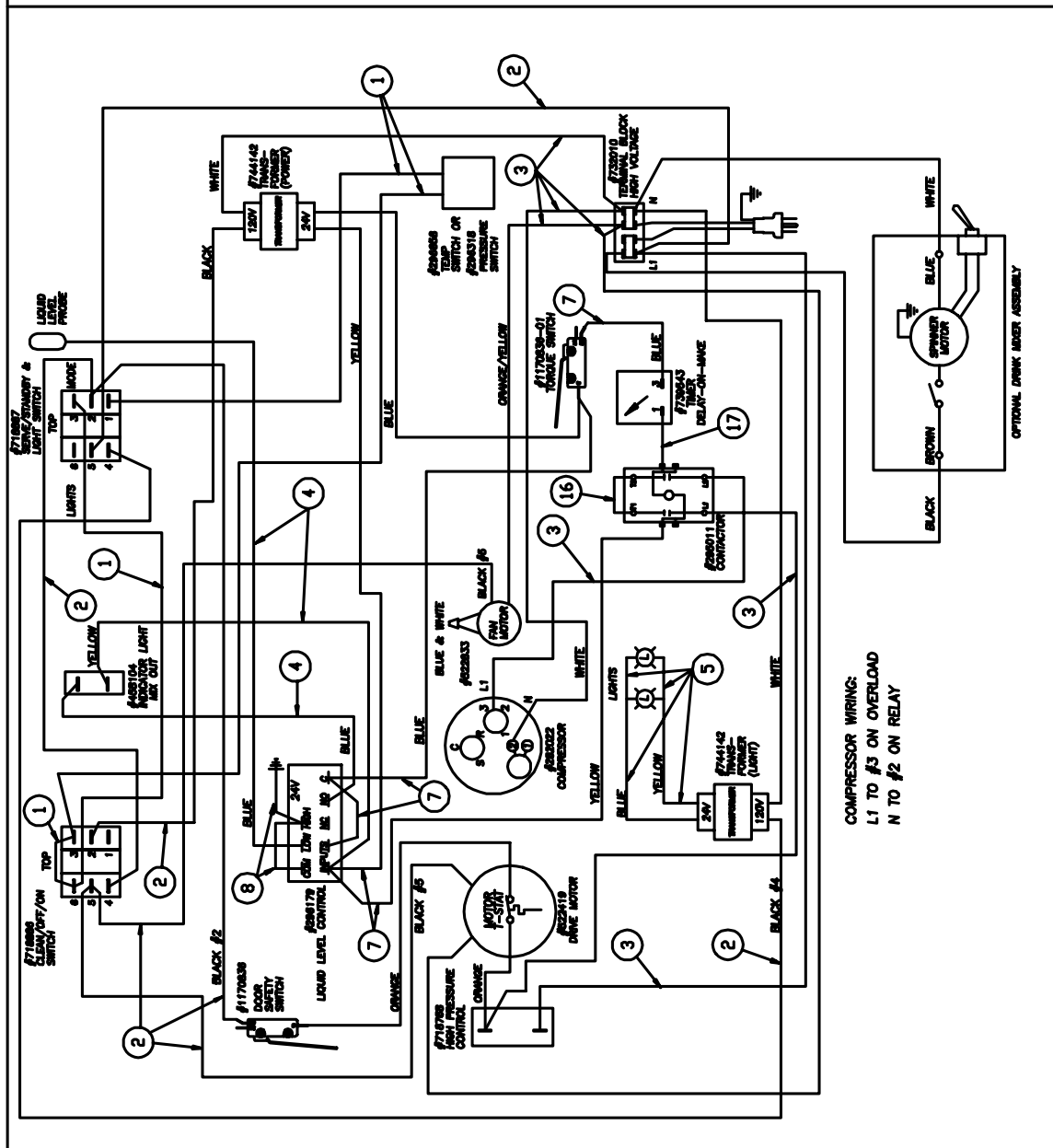
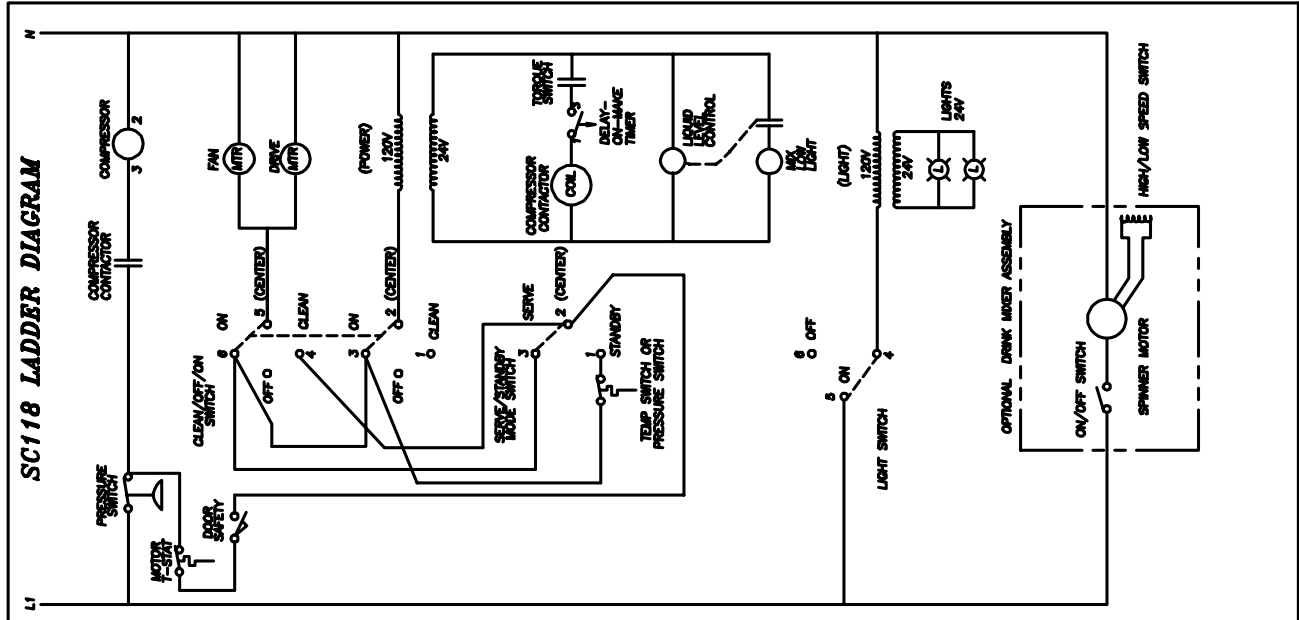
LIGHT TRANSFORMER



POWER TRANSFORMER

**NOTES:**

1. LIGHT TRANSFORMER DO NOT TRIM LEADS, TERMINATE BLACK, WHITE, BLUE & YELLOW WIRES WITH ITEM(11) FEMALE TERMINALS.
2. POWER TRANSFORMER: TRIM WHITE & YELLOW LEADS TO 4" LONG; BLACK & BLUE LEADS SHOULD BE FULL LENGTH. TERMINATE BLACK, WHITE, YELLOW & BLUE LEADS WITH ITEM(11) FEMALE TERMINALS.
3. CAP OFF RED & ORANGE WIRES ON EACH TRANSFORMER WITH ITEM(10) TERMINALS. COIL CRIMPED WIRES & SECURE WITH ITEM(12).
4. TRIM WHITE LEAD OF DRIVE MOTOR TO 4" AND TERMINATE WITH ITEM(11) FEMALE TERMINAL. TERMINATE BLACK MOTOR LEAD WITH ITEM(11) FEMALE TERMINAL ALONG WITH BOTH MOTOR THERMOSTAT LEADS (ORANGE).  
MOTOR TO BE WIRED FOR CLOCKWISE ROTATION FACING LEAD END. (PURPLE TO YELLOW) (PURPLE TO YELLOW)
5. TERMINATE POWER CORD LEADS WITH ITEM(9) FEMALE TERMINALS.
6. MOUNT LIGHT TRANSFORMER W/LOW VOLTAGE TO TOP. MOUNT POWER TRANSFORMER W/LOW VOLTAGE TO REAR OF FREEZER.
7. TRIM FAN MOTOR WIRES TO 23" LONG,(ORANGE, YELLOW & BLACK). TRIM BLUE & WHITE WIRES TO 6", TERMINATE THESE WIRES WITH ITEM (10), COIL THEM & TIE TO CONDENSER BRACKET. ROUTE THE ORANGE, YELLOW & BLACK WIRES THROUGH HOLE IN SHROUD. TERMINATE THE BLACK WIRE WITH ITEM (11), THE YELLOW & ORANGE GET TERMINATED TOGETHER WITH ITEM (13).  
ROUTE FAN WIRES AWAY FROM BLADE & SECURE WITH ITEM (12).
8. ATTACH ITEM (15), THEN RING TERMINAL FOR LIQUID LEVEL PROBE, TIGHTEN DOWN WITH ITEM (14) & RTV TO COMPLETE LIQUID LEVEL PROBE



COMPRESSOR WIRING:  
L1 TO #3 ON OVERLOAD  
N TO #2 ON RELAY

**CAUTION**  
DISCONNECT POWER  
SUPPLY BEFORE  
SERVICING

**STOELTING**  
KIEL, WISCONSIN U.S.A. 53042  
ELECTRICAL WIRING DIAGRAM  
MODEL NO. : SC118-37  
DIAGRAM NO. : 4171838-WD





## WARRANTY MIX TRANSFER PUMPS / COCKTAIL / SLUSH

**1. Scope:**

Stoelting LLC warrants to the first user (the “Buyer”) that the evaporator assembly and compressor (if applicable) of Stoelting mix transfer pump, cocktail and slush equipment will be free from defects in materials and workmanship under normal use and proper maintenance appearing within five (5) years (two (2) years for “Mirage” equipment), and that all other components of such equipment manufactured by Stoelting will be free from defects in material and workmanship under normal use and proper maintenance appearing within twelve (12) months after the date that such equipment is originally installed.

**2. Disclaimer of Other Warranties:**

**THIS WARRANTY IS EXCLUSIVE; AND STOELTING HEREBY DISCLAIMS ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR PARTICULAR PURPOSE.**

**3. Remedies:**

Stoelting’s sole obligations, and Buyer’s sole remedies, for any breach of this warranty shall be the repair or (at Stoelting’s option) replacement of the affected component at Stoelting’s plant in Kiel, Wisconsin, or (again, at Stoelting’s option) refund of the purchase price of the affected equipment, and, during the first ninety (90) days of the warranty period, deinstallation/reinstallation of the affected component from/into the equipment. Those obligations/remedies are subject to the conditions that Buyer (a) signs and returns to Stoelting, upon installation, the Warranty Registration Card for the affected equipment, (b) gives Stoelting prompt written notice of any claimed breach of warranty within the applicable warranty period, and (c) delivers the affected equipment to Stoelting or its designated service location, in its original packaging/crating, also within that period. Buyer shall bear the cost and risk of shipping to and from Stoelting’s plant or designated service location.

**4. Extensions:**

The warranty period for deinstallation/reinstallation of the affected component from/into the equipment is extended to twelve (12) months on the following models: SO218, SO318, SO328. The warranty period for the drive motor to be free of defects in materials and workmanship extended to five (5) years on the following models: SO218, SO318, SO328.

**5. Exclusions and Limitations:**

This warranty does not extend to parts, sometimes called “wear parts”, which are generally expected to deteriorate and to require replacement as equipment is used, including as examples but not intended to be limited to o-rings, hoses, seals and drive belts. All such parts are sold

**AS IS.**

Further, Stoelting shall not be responsible to provide any remedy under this warranty with respect to any component that fails by reason of negligence, abnormal use, misuse or abuse, use with parts or equipment not manufactured or supplied by Stoelting, or damage in transit.

**THE REMEDIES SET FORTH IN THIS WARRANTY SHALL BE THE SOLE LIABILITY STOELTING AND THE EXCLUSIVE REMEDY OF BUYER WITH RESPECT TO EQUIPMENT SUPPLIED BY STOELTING; AND IN NO EVENT SHALL STOELTING BE LIABLE FOR ANY INCIDENTAL OR CONSEQUENTIAL DAMAGES, WHETHER FOR BREACH OF WARRANTY OR OTHER CONTRACT BREACH, NEGLIGENCE OR OTHER TORT, OR ON ANY STRICT LIABILITY THEORY.**

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