



OPERATOR MANUAL

IMPORTANT INFORMATION, KEEP FOR OPERATOR

888-994-7636, fax 888-864-7636
groen.com

THIS MANUAL MUST BE RETAINED FOR FUTURE REFERENCE. READ, UNDERSTAND AND FOLLOW THE INSTRUCTIONS AND WARNINGS CONTAINED IN THIS MANUAL.

WARNING Improper installation, adjustment, alteration, service or maintenance can cause property damage, injury or death. Read the installation, operating and maintenance instructions thoroughly before installing or servicing this equipment.

NOTIFY CARRIER OF DAMAGE AT ONCE It is the responsibility of the consignee to inspect the container upon receipt of same and to determine the possibility of any damage, including concealed damage. Groen suggests that if you are suspicious of damage to make a notation on the delivery receipt. It will be the responsibility of the consignee to file a claim with the carrier. We recommend that you do so at once.

Manufacture Service/Questions 888-994-7636.

This manual provides information for:

LOW HEIGHT STEAM JACKETED KETTLE MODEL AHS [WITH STANDARD ELECTRONIC IGNITION]



- Self-contained
- Stainless Steel
- Gas Heated
- Floor Mounted
- Stationary

ZEP MANUFACTURING CO.
1310-T Seaboard Industrial Blvd.
Atlanta, Georgia 30318

REFERENCES

CSA International
8501 East Pleasant Valley Road
Cleveland, Ohio 44131

NSF INTERNATIONAL
789 N. Dixboro Rd.
P.O. Box 130140
Ann Arbor, Michigan 48113-0140

KLENZADE SALES CENTER ECOLAB. Inc.
370 Wabasha
St. Paul, Minnesota 55102

AMERICAN NAT'L STANDARDS INST., INC.
1430 Broadway
New York, New York 10018

Z223.1-1984 - National Fuel Gas Code
Z21.30 - Installation of Gas Appliances & Piping

NATIONAL FIRE PROTECTION ASSOCIATION
60 Battery March Park
Quincy, Massachusetts 02269

NFPA/54 - Installation Gas Appliances & Piping
NFPA/70 - The National Electrical Code

- e. Low-water cutoff: Turns off the burner if the water level in the jacket gets too low for safe operation

Instruments also are provided to show what is happening inside the unit. These are:

- Water level sight glass: Indicates whether there is enough water in the steam jacket.
- Pressure/vacuum gauge: Shows steam pressure, and whether too much air has entered the jacket.
- Heating indicator light: Indicates that the kettle is being heated.
- Power on indicator light: Glows when the unit is turned on.
- Low water indicator light: Lights to show that jacket water needs to be replenished.

The kettle body is welded into one piece and has a rim reinforced by a rectangular bar. The interior and exterior of the kettle is polished to a 180 emery grit finish. The unit is ASME shop inspected and registered with the National Board for working pressures up to 30 PSI.

The standard 2 inch tangent draw-off is a 316 stainless steel, compression disc valve. A removable strainer with ¼ inch holes keeps pieces of product from entering the draw-off during cooking.

The jacket is filled at the factory with water containing rust inhibitors. The kettle can operate at steam pressures up to 30 PSI, which provide temperatures of 150°F (65°C) to approximately 250°F (121°C). This range allows warming, simmering, boiling, or braising.

EQUIPMENT DESCRIPTION

Groen AHS steam kettles are stainless steel, floor mounted kettles with a self-contained steam source heated by gas. A closed steam jacket covers the lower 2/3 of the kettle. Heat from the gas burner boils water in the jacket to produce steam under pressure. To ignite the burners, Model AHS uses electronic spark ignition.

The kettles are stationary (non-tilting). Liquids can be removed through the tangent draw-off valve.

Exposed surfaces are stainless steel. Insulated sheathing protects the kettle body, and a housing encloses the controls. Three tubular legs support the unit. Bullet feet adjust to level the kettle.

A one piece dome cover is hinged to the kettle on the AHS. Covers for 40 gallon kettles are supplied with counterbalancing spring actuators to hold the covers in the fully open or closed position.

Controls provided include the ON/OFF switch, to control electric power for the unit, and the thermostat, to set the cooking temperature. The automatic controls and a brief description of each are as follows.

- Gas pressure regulator: Protects the unit from high pressure in the gas supply line
- Automatic gas valves: Allow gas into the burners as needed
- Pressure limit switch: Turns off the burner when jacket pressure reaches 27 PSI. Lights the burner when pressure drops to 22 PSI.
- Safety valve: Lets steam out of the jacket if the steam pressure exceeds 30 PSI.



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IMPORTANT - READ FIRST - IMPORTANT

IMPORTANT: THIS APPLIANCE IS MARKED “CE” ON THE BASIS OF COMPLIANCE WITH EMC AND LOW VOLTAGE DIRECTIVE.

WARNING: BEFORE REPLACING ANY PARTS, DISCONNECT THE UNIT FROM THE ELECTRIC POWER SUPPLY.

CAUTION: BE SURE ALL OPERATORS READ, UNDERSTAND AND FOLLOW THE OPERATING INSTRUCTIONS, CAUTIONS, AND SAFETY INSTRUCTIONS CONTAINED IN THIS MANUAL.

WARNING: THIS UNIT IS INTENDED FOR USE IN THE COMMERCIAL HEATING, COOKING AND HOLDING OF WATER AND FOOD PRODUCTS, PER THE INSTRUCTIONS CONTAINED IN THIS MANUAL. THIS EQUIPMENT IS NOT FOR CONTINUOUS MASS PRODUCTION OF FOOD PRODUCTS OR ANY OTHER USE COULD RESULT IN SERIOUS PERSONAL INJURY OR DAMAGE TO THE EQUIPMENT AND WILL VOID WARRANTY.

WARNING: KETTLE MUST BE INSTALLED BY PERSONNEL QUALIFIED TO WORK WITH ELECTRICITY AND PLUMBING. IMPROPER INSTALLATION CAN RESULT IN INJURY TO PERSONNEL AND/OR DAMAGE TO EQUIPMENT.

DANGER: ELECTRICALLY GROUND THE UNIT AT THE TERMINAL PROVIDED. FAILURE TO GROUND UNIT COULD RESULT IN ELECTROCUTION AND DEATH.

WARNING: AVOID ALL DIRECT CONTACT WITH HOT EQUIPMENT SURFACES. DIRECT SKIN CONTACT COULD RESULT IN SEVERE BURNS.

WARNING: AVOID ALL DIRECT CONTACT WITH HOT FOOD OR WATER IN THE KETTLE. DIRECT CONTACT COULD RESULT IN SEVERE BURNS.

CAUTION: DO NOT OVER FILL THE KETTLE WHEN COOKING, HOLDING OR CLEANING. KEEP LIQUIDS A MINIMUM OF 2-3” (5-8 cm) BELOW THE KETTLE BODY RIM TO ALLOW CLEARANCE FOR STIRRING, BOILING AND SAFE PRODUCT TRANSFER.

WARNING: TAKE SPECIAL CARE TO AVOID CONTACT WITH HOT KETTLE BODY OR HOT PRODUCT WHEN ADDING INGREDIENTS, STIRRING OR TRANSFERRING PRODUCT TO ANOTHER CONTAINER.

WARNING: WHEN TILTING KETTLE FOR PRODUCT TRANSFER:

1) USE CONTAINER DEEP ENOUGH TO CONTAIN AND MINIMIZE PRODUCT SPLASHING.

2) PLACE CONTAINER ON STABLE, FLAT SURFACE, AS CLOSE TO KETTLE AS POSSIBLE.

3) DO NOT OVER FILL CONTAINER. AVOID DIRECT SKIN CONTACT WITH HOT CONTAINER AND ITS CONTENTS.

CAUTION: KEEP FLOORS IN FRONT OF KETTLE WORK AREA CLEAN AND DRY. IF SPILLS OCCUR, CLEAN IMMEDIATELY, TO AVOID SLIPS OR FALLS.

WARNING: FAILURE TO CHECK PRESSURE RELIEF VALVE OPERATION PERIODICALLY COULD RESULT IN PERSONAL INJURY AND/OR DAMAGE TO EQUIPMENT.

WARNING: DO NOT CONNECT ANY PIPING TO THE PRESSURE RELIEF VALVE. IT MUST BE FREE TO VENT STEAM AS NEEDED. TO AVOID BURNS FROM THE VENTED STEAM THE VALVE DISCHARGE SHOULD POINT DOWNWARD. IMPROPER INSTALLATION WILL VOID WARRANTY.

WARNING: DO NOT STAND OR APPLY UNNECESSARY WEIGHT OR PRESSURE ON THE KETTLE FRONT OR POURING LIP. THIS COULD RESULT IN THE OVERLOAD AND FAILURE OF THE TILT MECHANISM, AND POSSIBLE SERIOUS INJURY AND BURNS TO THE OPERATOR AND OTHERS.

NOTICE: DO NOT USE A CLEANING, DE-LIMING, OR DEGREASER AGENT THAT CONTAINS ANY SULFAMIC ACID, CHLORIDE, HYDROCHLORIC ACID, POTASSIUM AND SODIUM HYDROXIDE OR THAT IS ALKALINE. IF CONTENTS OF ANY PRODUCT IS UNCLEAR, CONSULT THE MANUFACTURER.

NOTICE: NEVER LEAVE SANITIZER IN CONTACT WITH STAINLESS STEEL SURFACES LONGER THAN 10 MINUTES. LONGER CONTACT CAN CAUSE CORROSION.

WARNING: WHEN TESTING, AVOID ANY EXPOSURE TO THE STEAM BLOWING OUT OF THE PRESSURE RELIEF VALVE. DIRECT CONTACT COULD RESULT IN SEVERE BURNS.

WARNING: TO AVOID INJURY, READ AND FOLLOW ALL PRECAUTIONS STATED ON THE LABEL OF THE WATER TREATMENT COMPOUND.

WARNING: KEEP WATER AND SOLUTIONS OUT OF CONTROLS AND ELECTRICAL EQUIPMENT. NEVER USE A WATER JET SPRAY, HIGH PRESSURE HOSE OR STEAM TO CLEAN KETTLE SURFACES.

CAUTION: MOST CLEANERS ARE HARMFUL TO THE SKIN, EYES, MUCOUS MEMBRANES AND CLOTHING. PRECAUTIONS SHOULD BE TAKEN. WEAR RUBBER GLOVES, GOGGLES OR FACE SHIELD AND PROTECTIVE CLOTHING. CAREFULLY READ THE WARNINGS AND FOLLOW THE DIRECTIONS ON THE LABEL OF THE CLEANER TO BE USED.

CAUTION: USE OF ANY REPLACEMENT PARTS OTHER THAN THOSE SUPPLIED BY THE MANUFACTURER OR AN AUTHORIZED DISTRIBUTOR CAN CAUSE OPERATOR INJURY AND DAMAGE TO THE EQUIPMENT, AND WILL VOID ALL WARRANTIES.

IMPORTANT: SERVICE PERFORMED BY OTHER THAN FACTORY AUTHORIZED PERSONNEL WILL VOID WARRANTIES.

WARNING: DO NOT HEAT AN EMPTY KETTLE. EXCESSIVE STEAM PRESSURE COULD DEVELOP.

NOTICE: IT IS RECOMMENDED THAT AN INSTANT-READ THERMOMETER BE USED TO CHECK THE INTERNAL TEMPERATURE THROUGHOUT THE COOKING PROCESS AND AFTER THE COOKING PROCESS HAS BEEN COMPLETED TO ENSURE THE FOOD HAS BEEN COOKED SUFFICIENTLY.

CAUTION: THIS APPLIANCE CAN BE USED BY CHILDREN AGED FROM 8 YEARS AND ABOVE AND PERSONS WITH REDUCED PHYSICAL, SENSORY OR MENTAL CAPABILITIES OR LACK OF EXPERIENCE AND KNOWLEDGE IF THEY HAVE BEEN GIVEN SUPERVISION OR INSTRUCTION CONCERNING USE OF THE APPLIANCE IN A SAFE WAY AND UNDERSTAND THE HAZARDS INVOLVED.

CAUTION: CHILDREN SUPERVISED ARE NOT TO PLAY WITH THIS APPLIANCE.

CAUTION: CLEANING AND USER MAINTENANCE SHALL NOT BE MADE BY CHILDREN WITHOUT SUPERVISION

For AHS kettles, options include:

- a. Larger (3 inch) draw-off *
- b. Solid disc strainer or strainer with 1/8 inch perforations
- c. Water Fill faucet
- d. Automatic, metered water filler (Gallon Master)
- e. TRI-BC basket
- f. Kettle brush kit
- g. Gallon etch marks*
- h. Flanged feet
- i. 316 stainless steel liner (for high acid products)*
- j. Powered agitators (TA/3 or INA/2)*

* Factory installed options

KETTLE CHARACTERISTICS			
		Firing Rate, BTU/hour	
Kettle	Ignition	Natural Gas	Propane Gas
AHS-40	Spark	115,000	115,000

KETTLE CHARACTERISTICS							
Model	Kettle Capacity Gallons (Liters)	Jacket Capacity Gallons (Liters)	Kettle Diameter Inches (mm)	Kettle Depth Inches (mm)	Overall Width Inches (mm)	Front to Back, Inches (mm)	Rim Height Inches (mm)
AHS-40	40 (150)	7 (26.5)	26 (660)	22 (559)	38.25 (971.55)	45 (1143)	38.6 (981)

INSPECTION & UNPACKING

WARNING: THIS UNIT MUST BE INSTALLED BY PERSONNEL WHO ARE QUALIFIED TO WORK WITH ELECTRICITY AND PLUMBING. IMPROPER INSTALLATION CAN CAUSE INJURY TO PERSONNEL AND/OR DAMAGE TO THE EQUIPMENT. THE UNIT MUST BE INSTALLED IN ACCORDANCE WITH APPLICABLE CODES.

CAUTION: SHIPPING STRAPS ARE UNDER TENSION AND CAN SNAP BACK WHEN CUT. TAKE CARE TO AVOID PERSONAL INJURY OR DAMAGE TO THE UNIT BY STAPLES LEFT IN THE WALLS OF THE CARTON.

UNIT WEIGHS FROM 468 LBS. (212 KG) TO 1120 LBS. (508 KG). FOR SAFE HANDLING, INSTALLER SHOULD OBTAIN HELP AS NEEDED AND USE MATERIAL HANDLING EQUIPMENT TO REMOVE THE UNIT FROM THE SKID AND MOVE IT TO ITS PLACE OF INSTALLATION.

The unit arrives completely assembled, except for the TDO valve, flue stack and flue elbow which are usually packed separately and shipped inside the kettle. The unit is strapped on a skid in a heavy box. Inspect the box carefully for damage. Open the container and check the unit for hidden damage. Report shipping damage or shipment errors to the delivery agent.

Write down the model number, serial number, and installation date for your unit at the top of the Maintenance and Service Log at the back of this manual. Keep the manual on file and available for operators to use.

To remove the kettle from the box, cut any straps from around the box. Detach the box sides from the skid. Pull the box up off the unit, taking care to avoid damage or injury from any staples left in the box walls. When installation is to begin, cut the straps holding the kettle to the skid, and lift the kettle straight up off the skid. Examine the packing materials to make sure no loose parts are discarded with the materials.

Once the kettle is unpacked, the tangent draw-off valve is easily attached, as shown below. The large nut which attaches the valve to the kettle should be **hand tightened** only.



Assemble and attach the tangent draw-off valve after the kettle is unpacked.

INSTALLATION AND INITIAL START-UP

WARNING: THE KETTLE MUST BE INSTALLED BY PERSONNEL QUALIFIED TO WORK WITH ELECTRICITY AND PLUMBING. IMPROPER INSTALLATION CAN CAUSE INJURY TO PERSONNEL AND/OR DAMAGE TO THE EQUIPMENT.

THIS UNIT IS FOR COMMERCIAL USE. NEVER USE HOME OR RESIDENTIAL GRADE GAS CONNECTIONS. THEY DO NOT MEET GAS CODES AND COULD BE HAZARDOUS.

NOTICE: TO AVOID DAMAGING PARTS OF THE BURNER SYSTEM UNDERNEATH THE KETTLE, LIFT THE UNIT ONLY BY THE RING BENEATH THE OUTER PORTION OF THE BODY.

WARNING: DO NOT ATTACH THE UNIT TO A TYPE "B" VENT. FAILURE COULD RESULT IN FIRE OR PROPERTY DAMAGE.

CAUTION: DO NOT USE KETTLE WITHOUT GROEN SUPPLIED FLUESTACK & ELBOW INSTALLED. FLUE RISER, 17 INCHES HIGH MUST BE ATTACHED HERE. NOT SUITABLE FOR CONNECTION TO TYPE B GAS VENT.

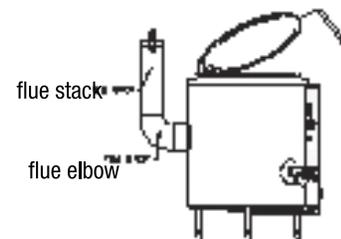
CAUTION: DO NOT CONNECT ANY PIPING TO THIS PRESSURE RELIEF VALVE. IT MUST BE FREE TO VENT STEAM AS NEEDED. ELBOW SHOULD POINT DOWN TOWARD FLOOR. IMPROPER INSTALLATION WILL VOID WARRANTY!

DANGER: DANGER ELECTRICALLY GROUND THE UNIT AT THE TERMINAL PROVIDED. FAILURE TO GROUND UNIT COULD RESULT IN ELECTROCUTION AND DEATH.

A. Installation

The unit should be installed in a ventilated room for efficient performance. Items which may obstruct or restrict the flow of air for combustion and ventilation must be removed. The area directly around the appliance must be cleared of all combustible materials.

1. Installation requires connection with gas and electrical services. See items 8 to 14 for details.
2. To protect the unit from damage, leave it on the shipping pallet until the time of installation. When installation is to begin, cut the straps holding the kettle, and hoist the kettle straight up off the skid.
3. Unit is for use only on non-combustible floors.
4. Install the unit with a minimum clearance to combustible and non-combustible construction of two inches at the sides and four inches at rear. Also leave enough room for cleaning, maintenance, and service.
5. The flue stack and flue elbow shipped with the kettle is the correct height and shape to give maximum performance. Install the flue stack and flue elbow as shown on the sketch below.



Unit must be installed under a ventilation hood only. Installation of a ventilation hood should comply with local codes and/or ANSI/NFOA-96 Latest Edition. Also, local codes may require that the kettle be electrically interlocked to shut off the gas supply and prevent the operation of the unit if the exhaust fan is not operating or if the fire suppression system is activated. Failure to follow these instructions can cause bodily injury and/or property damage.

6. To level the unit, adjust leg length by turning the bullet feet
7. Make sure the water level is correct in the jacket, by confirming that the level is between the marks on the gauge glass. If the water level is low, follow the instructions under "Jacket Filling" in the "Maintenance" Section of this manual.
8. To protect personnel from steam coming out of the pressure relief valve, the open end of the elbow at the outlet must be directed down. If it is not, turn the elbow to the correct position.
9. Provide 115 VAC, 60 HZ, 1 PH, 15 AMP electrical service for standard unit. Unit may be equipped for alternate electrical service of 208 VAC or 240 VAC, as ordered. Use 1/2 inch waterproof conduit and waterproof connections. Observe local codes and/or The National Electrical Code in accordance with ANSI/NFPA 70 - latest edition. **AN ELECTRICAL GROUND IS REQUIRED.** The electrical schematic is located on the inside of the service panel.
In Canada, provide electrical service in accordance with the Canadian Electrical Code, CSA C22.2 Part 1 and/or local codes.
10. The internal gas lines of the unit were cleaned and closed off with a gas cock before the unit was shipped from the factory. Free all external gas lines of lint, dirt, metal chips, sealant, grease, oil, and other contaminants, before you connect the lines to the kettle.
11. Connect the gas cock of the kettle to the gas service main with 3/4 inch IPS line or approved equivalent
12. Installation must conform with local codes, or in the absence of local codes, with the National Fuel Gas Code, ANSI Z 223.1-1988 (or latest edition). The unit should be installed in an adequately ventilated room with a provision for adequate air supply. The best ventilation will utilize a vent hood and exhaust fan with no direct connection between the vent duct and the flue. Do **NOT** obstruct the flue or vent duct after installation.

In Canada, the installation must conform to the CAN/CGA B149 Installation Codes for Gas Burning Appliances and Equipment and/or local codes.

13. Adequate space for proper service and operation is required. Do **NOT** block any air intake spacings to the combustion chamber or obstruct the air flow by piling or stacking anything near the kettle.
14. After the kettle has been connected to the gas supply, all gas line joints must be checked for leaks. **DO NOT USE A FLAME TO CHECK FOR LEAKS.** A thick soap solution or other suitable leak detector should be employed.
15. **PRESSURE TEST WARNING**
 - a) Test pressure exceeding 1/2 PSIG (3.45 kPa). During pressure testing of the gas supply piping system at pressures exceeding 1/2 PSIG, the appliance and its individual shutoff valve must be disconnected from the gas supply piping system.
 - b) Test pressure equal to or less than 1/2 PSIG (3.45kPa.) During pressure testing of the gas, gas supply piping system at pressures equal to or less than 1/2 PSIG, the kettle must be isolated from the gas supply piping system closing its individual manual shutoff valve.
16. Check the following points to confirm that your AHS kettle has been installed properly.
 - a. Unit installed on non combustible floor.
 - b. Enough room between the kettle and nearby objects for cleaning and service.
 - c. Minimum clearance of 2 inches from sides and 4" rear clearance.
 - d. Unit installed under a ventilation hood.
 - e. Kettle Level
 - f. Correct amount of water in the jacket.
 - g. Safety valve outlet pointed down.
 - h. Connected with a waterproof, 115 volt, 15 amp supply of electric power in accordance with electrical codes.
 - i. Gas lines cleaned before connection.
 - j. Gas connected with 3/4 inch pipe or equivalent.
 - k. Gas lin joints checked for leaks.
 - l. No obstruction to air supply or venting.

B. Initial Start-Up

After the kettle has been installed, the installer should test to ensure that it is operating correctly.

1. Remove literature and packing materials from inside and outside of the unit.
2. Install the TDO valve handle.
3. Put a small amount of water into the kettle.
4. Verify that kettle water level is normal and that kettle is holding vacuum in jacket. Correct if not. (See operating instructions to correct)
5. Make sure the supplies of gas and electric power are on.
6. Follow the Start Kettle Heating instructions in the Operation section of this manual. Begin heating the water at the highest thermostat setting. The indicator light should come on and heating should continue until the water boils.
7. To turn off the unit, follow "To Stop Kettle Heating" in "Operating Instructions," below.

If the kettle functions as described, it is ready for use. If the unit does not operate as designed, contact authorized Groen Service Agent.

OPERATION

WARNING: ANY POTENTIAL USER OF THE EQUIPMENT MUST BE TRAINED IN SAFE AND CORRECT OPERATING PROCEDURES.

WARNING: KEEP AREA AROUND KETTLE FREE AND CLEAR OF ALL COMBUSTIBLE MATERIALS.

DO NOT ATTEMPT TO LIGHT ANY BURNER WITH A FLAME.

CAUTION: HEATING AN EMPTY KETTLE MAY CAUSE THE RELEASE OF STEAM FROM THE SAFETY VALVE.

WARNING: AVOID ALL DIRECT CONTACT WITH HOT FOOD OR WATER IN THE KETTLE. DIRECT CONTACT COULD RESULT IN SEVERE BURNS.

TAKE CARE TO AVOID CONTACT WITH HOT KETTLE BODY OR HOT PRODUCT, WHEN ADDING INGREDIENTS, STIRRING OR TRANSFERRING PRODUCT TO ANOTHER CONTAINER.

CAUTION: DO NOT OVERFILL THE KETTLE WHEN COOKING, HOLDING OR CLEANING. KEEP LIQUIDS 2-3" (5-8 CM) BELOW THE KETTLE RIM TO ALLOW CLEARANCE FOR STIRRING, BOILING PRODUCT AND SAFE TRANSFER.



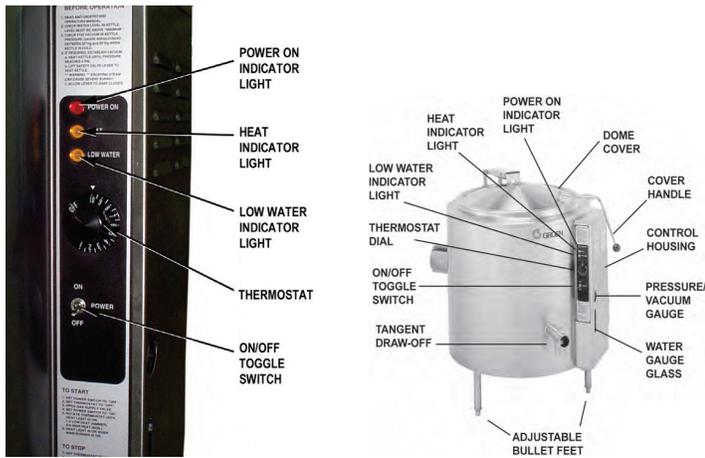
A. Controls

Operator controls for the AHS kettle are:

1. Manual gas valve which controls the supply of gas from the main line to the unit.
2. On-Off (toggle) switch. This switch turns the control circuit power supply on or off.
3. Thermostat dial, which turns the thermostat on or off, and sets the kettle operating temperature.
4. Indicator Lights to alert operator of unit conditions:
 - a. Power On Indicator - shows that the unit is turned on
 - b. Heat Indicator - indicates that main gas is on to produce steam in the kettle jacket.
 - c. Low Water indicator - shows that jacket water is low
 - d. Unit gas pressure regulator adjustment - located behind the access door in the kettle skirt.

B. Operating Instructions

1. To Start Kettle
 - a. CHECK THE WATER LEVEL IN THE JACKET EVERY DAY. The level should be at the middle of the sight glass. If the level is low, see Jacket Filling in the Maintenance section of this manual
 - b. Check the pressure/vacuum gauge. If the gauge does not show 20 to 30 inches of vacuum (i.e. a reading of 20 to 30 below zero), see Jacket Vacuum in the Maintenance section of this manual.
 - c. DO NOT attempt to light any burner with a flame.
 - d. Open main supply gas valve (handle in line with the pipe).
 - e. Turn the toggle switch to ON. For 90 seconds, or until it succeeds, the electronic ignition control will attempt to light the pilot.
 - f. Once the pilot is lit, turn the thermostat to the desired setting.
 - g. If the pilot does not light, turn it off and wait five minutes. At that time follow the instructions for starting once again.
 - h. If the unit repeatedly fails to light, contact an authorized Groen Service Agency.



2. To Stop Kettle Heating

- a. Turn the thermostat dial to OFF.
- b. Turn the toggle switch OFF.
- c. or a prolonged shut-down:
 - 1) Follow the procedure above.
 - 2) Turn the manual gas valve OFF (handle at right angle to gas line).
 - 3) Disconnect the unit's electrical power.

3. To Relight Kettle

- a. Close main gas supply valve.
- b. Set on-off switch to OFF.
- c. Set thermostat to OFF.
- d. Wait five minutes, then proceed as directed under To Start Kettle.

4. If Electric Power Fails do not attempt to operate the unit. When power is restored, proceed as directed in To Start Kettle.

C. Use of Common Accessories

1. Basket Insert

An optional kettle basket insert set (Tri-BC) will assist in cooking water-boiled products including eggs, potatoes, vegetables, shell fish, pasta and rice. The nylon mesh liners must be used when cooking product smaller than the mesh size of the basket, which is approximately 1/4" (6 mm). This includes rice and small pasta shapes.

Tips for Use

- 1) Allow for water displacement by the baskets and product to be cooked. This may mean only filling the kettle half full of water. Test the basket and product displacement with the kettle OFF, and with cold water in the kettle.
- 2) Load baskets on a level, stable work surface.
- 3) Lift the loaded baskets with both hands. Get help from another person, if the basket is too heavy for safe handling.
- 4) Slowly lower product into the kettle.
- 5) When removing baskets with cooked product, lift basket straight up, ensuring bottom of basket clears the rim and pouring lip of the kettle. Wear protective oven mitts and protective apron.
- 6) Allow hot water to fully drain from product, before moving basket away from the kettle.
- 7) If basket is too heavy for individual to lift and safely move, get help from another person. Remove product immediately from basket into another container, being sure to avoid contact with hot product and hot basket or.

8) Place basket with food on stable, flat surface, setting it inside a solid steamer or bake pan, to catch any remaining hot water draining from product.

SEQUENCE OF OPERATION

The following "action-reaction" outline is provided to help understand how the AHS kettle works.

1. When the power switch is turned on, it starts the spark igniter and opens the automatic valve for the pilot burner. The spark ignites a pilot flame, which heats the sensor. The sensor then sends a signal to turn off the spark. The flame thereafter acts as a standing pilot until the power is turned off.
2. If the pilot flame is not sensed within 90 seconds after spark begins, a timer shuts down the entire operation. To attempt a second trial for ignition, turn off the power switch. Check the gas supply valves and wait five minutes before trying again by switching power on. If you cannot establish a pilot flame in four tries, close all valves, turn off the power, and contact an authorized Groen Service Agency.
3. When the operator sets a temperature on the thermostat, it causes the automatic valve to admit gas to the main burner, where it is ignited by the pilot flame. When the kettle reaches the set temperature, the thermostat switch opens. This stops the signal to the gas control valve and shuts off gas to the main burner. The pilot flame stays lit.
4. When the kettle cools below the set temperature, the thermostat switch closes and starts another cycle. On and off cycling continues and maintains the kettle at the desired temperature. This action is indicated by the Heat indicator light.

The kettle has the following safety features in addition to the 90-second ignition timer:

1. Low water cutoff relay that will shut off gas supplies to all burners until the jacket water level is corrected.
2. High limit pressure switch, set to open at about 26 PSI and to shut down the burners until jacket pressure is decreased.
3. Pop safety valve, which will release steam if jacket pressure exceeds 30 PSI.
4. Gas pressure regulator built into the gas control valve.

CLEANING

WARNING: KEEP WATER AND SOLUTIONS OUT OF CONTROLS AND BURNERS. NEVER SPRAY OR HOSE THE CONTROL CONSOLE, ELECTRICAL CONNECTIONS, ETC.

CAUTION: NEVER LEAVE A SANITIZER IN CONTACT WITH STAINLESS STEEL SURFACES LONGER THAN 30 MINUTES. LONGER CONTACT CAN CAUSE CORROSION.

CAUTION: DO NOT MIX PARTS OF DIFFERENT DRAW-OFF VALVE ASSEMBLIES. THE PARTS ARE NOT INTERCHANGEABLE.

CAUTION: MOST CLEANERS ARE HARMFUL TO THE SKIN, EYES, MUCOUS MEMBRANES AND CLOTHING. PRECAUTIONS SHOULD BE TAKEN TO WEAR RUBBER GLOVES, GOGGLES OR FACE SHIELD AND PROTECTIVE CLOTHING. CAREFULLY READ THE WARNINGS AND FOLLOW LABEL DIRECTIONS.

NOTICE: NEVER LEAVE A CHLORINE SANITIZER IN CONTACT WITH STAINLESS STEEL SURFACES LONGER THAN 30 MINUTES. LONGER CONTACT CAN CAUSE STAINING AND CORROSION.



1. Suggested Cleaning Supplies

- a. Cleaner, such as Klenzade HC-10 or HC-32 from ECOLAB.
- b. Kettle brushes in good condition.
- c. Sanitizer such as Klenzade XY-12.
- d. Film remover such as Klenzade LC-30.

- e. Groen Spray Degreaser (P/N 114801)
- f. Groen delimer/descaler (P/N 114800)

2. Precautions

Before any cleaning, shut off the kettle by turning the thermostat dial to "OFF" and the On/Off switch to Off .

3. Procedure

- a. Clean food contact surfaces as soon as possible after use, preferably while the kettle is still warm. If the unit is in continuous use, clean and sanitize inside and outside at least once every 24 hours.
- b. Scrape and flush out large amounts of food residues. Be careful not to scratch the kettle with metal implements.
- c. Prepare a solution of the detergent/cleaning compound as instructed by the supplier. Clean the unit thoroughly. A cloth moistened with cleaning solution can be used to clean controls, housing, electrical conduit, etc.
- d. Rinse the kettle thoroughly with hot water. Then drain completely.
- e. Disassemble the tangent draw-off valve. Clean the draw-off port and each valve part with a brush.
- f. Rinse the kettle and draw-off valve parts thoroughly with hot water, then drain completely.



When attaching the draw-off valve, just hand-tighten the nut.

- g. When you reassemble the draw-off valve, **hand-tighten** the nut which holds it in place.
- h. As part of the daily cleaning program, clean all inside and outside surfaces that may have been soiled. Remember to check such parts as the underside of the cover, control housing, etc.
- i. To remove materials stuck to the equipment, use a brush, sponge, cloth, plastic or rubber scraper, or plastic wool along with the detergent solution. To make washing easier, let the detergent solution sit in the kettle and soak into the residue, or warm the detergent solution briefly. Do not use any metal material (like metal sponges) or metal (like a spoon, scraper, or wire brush) that might scratch the surface. Scratches make the surface hard to clean and provide places for bacteria to grow. Do not use steel wool, which may leave particles imbedded in the surface and cause eventual corrosion and pitting.



Use sponge, cloth or plastic brush to clean the kettle.

- j. The outside of the unit may be polished with a recognized stainless steel cleaner like "Zepper" from Zep Manufacturing Company.
- k. When the equipment needs to be sanitized, use a sanitizing solution equivalent to one that supplies 200 parts per million chlorine. Obtain advice on the best sanitizing agent from your supplier of sanitizing products.
- l. Following the supplier's instructions, apply the sanitizing agent, after the unit has been cleaned and drained. Rinse off the sanitizer thoroughly.
- m. It is recommended that the unit be sanitized just before use.
- n. If there is difficulty removing mineral deposits or a film left by hard water or food residues, clean the kettle thoroughly. Then use a de-liming agent, such as Groen De-limer De-Scaler (Part Number 114800), Lime- Away from ECOLAB or an equivalent, following manufacturer directions. Rinse and drain the unit thoroughly before further use.
- o. If especially difficult cleaning problems persist, contact your cleaning product supplier for assistance. The supplier has a trained technical staff with laboratory facilities to serve you.



Scrapers or steel wool can harm the kettle surface.

MAINTENANCE

NOTICE: CONTACT GROEN OR AN AUTHORIZED GROEN SERVICE REPRESENTATIVE WHEN REPAIRS ARE REQUIRED.

WARNING: AVOID ANY EXPOSURE TO THE STEAM BLOWING OUT OF THE SAFETY VALVE. SEVERE BURNS CAN RESULT ON EXPOSED SKIN.

FAILURE TO CHECK PRESSURE RELIEF VALVE OPERATION PERIODICALLY COULD RESULT IN PERSONAL INJURY AND/OR DAMAGE TO EQUIPMENT.

WHEN TESTING, AVOID ANY EXPOSURE TO THE STEAM BLOWING OUT OF THE SAFETY VALVE. DIRECT CONTACT COULD RESULT IN SEVERE BURNS.

WARNING: TO AVOID INJURY, READ AND FOLLOW ALL PRECAUTIONS STATED ON THE LABEL OF THE WATER TREATMENT COMPOUND.

WARNING: BEFORE REPLACING ANY PARTS, DISCONNECT THE UNIT FROM THE ELECTRIC POWER SUPPLY AND CLOSE THE MAIN GAS VALVE. ALLOW FIVE MINUTES FOR UNBURNED GAS TO VENT.



PERIODIC MAINTENANCE

NOTICE: Contact Groen or an authorized Groen Service Representative when repairs are required.

A Service Log is provided at the rear of this manual. Each time service is performed on this Groen equipment, enter the date on which the work was done, and who did it. Keep this manual with the equipment.

Periodic inspection will minimize equipment down time and increase the efficiency of operation. The following points should be checked:

1. Jacket Vacuum/Removing Air from Jacket

When the kettle is cold, a positive pressure/ vacuum gauge reading or a reading near zero indicates that there is air in the jacket. Air in the jacket acts as an insulator, and slows kettle heating.

To remove air:

- Start the unit. (Be sure there is water or product in the kettle when heating).
- When the pressure/vacuum gauge reaches a positive pressure reading of five PSI, release the trapped air and steam by pulling up the safety valve ring for about five seconds. Repeat this step three or four times. Then let the pull ring snap back into the closed position.
- If there is little discharge (mostly air), and the pressure gauge drops back to zero PSI, allow the pressure to build back to five PSI and repeat the procedure.
- Once steam has been vented from the jacket as described in b, remove the hot water from the kettle and replace it with cold. This will condense steam in the kettle jacket, and the pressure gauge should show a reading of 20 to 30 inches mercury (Hg) below zero. If it does not, or if the vacuum is leaking down, contact a Groen authorized service agency.

2. Test Pressure Relief Valve

Carefully test the pressure relief valve at least twice each month. With the kettle operating at five psi (105 kPa), pull the test lever and let it snap back to its closed position. If there is little discharge (mostly air), and the pressure gauge drops back to zero PSI, allow the pressure to build back to five PSI and repeat the procedure. (Tip: Using a screwdriver or other implement to pull the ring will help you avoid contact with the steam.)

If the valve does not activate, or there is no evidence of discharge, or the valve leaks, stop using the kettle and contact a qualified Groen service representative.

3. Jacket Filling

Every day, **before you turn on the unit**, make sure the water level is approximately in the center of the water gauge glass. The jacket was filled at the factory with the proper amount of treated water, and is air-tight, but over time steam may be vented and water lost.



From time to time, you may need to restore the water to its proper level. To restore this water, either because it was lost as venting steam or by draining. If you are replacing water lost as steam, use distilled water. If you are replacing treated water that ran out of the jacket, prepare more treated water as directed in "Water Treatment Procedure," below.



Allow the kettle to cool completely. The procedure will be easier with the kettle under vacuum (pressure gauge reading below zero).

- Remove pressure gauge with open-ended wrench or crescent wrench.
- Position a funnel in the opening and fill it with properly treated water.
- Pull the pressure relief while filling to allow water to be sucked into the jacket and air to vent.
- Check water level in the jacket to ensure that it is between minimum and maximum marks on glass.
- Apply Teflon tape to pressure gauge threads in a clockwise pattern, then reinstall.
- Reestablish the jacket vacuum as described in Paragraph 2, above, if the pressure gauge does not show a negative reading of 20 to 30 inches mercury (Hg).

4. Water Treatment Procedure

- Obtain water treatment compound and a pH test kit from your Groen Service Agent.
- Fill a mixing container with the measured amount of water required. (See table) Distilled water is recommended.
- Hang a strip of pH test paper on the rim of the container, with about 1 inch of the strip below the surface of the water.
- Measure the water treatment compound. One way to do this is to add the compound from a measuring cup.
- Stir the water continuously, while you slowly add treatment compound, until the water has a pH between 10.5 and 11.5. Judge the pH by frequently comparing the test strip color with the color chart provided in the test kit. **Caution:** Do not add excess amount of treatment compound. Excess amount could cause extensive corrosion.

Model	Kettle Capacity	Jacket Capacity
AHS-40	40 Gallons	7 Gallons

- As you add water to the jacket, check water level to ensure that it is in the middle of the sight glass.
- Record the exact amounts of water and treatment compound needed. These amounts may be used again, if the same water sources and compound are used. However, it is best to check the pH each time treated water is prepared.

5. Component Replacement

When component replacement involves breaking a gas pipe connection, check the new connection with soap solution or an appropriate leak detector. **DO NOT USE A FLAME TO TEST FOR LEAKS.**

Internal wiring is marked as shown on the circuit schematic drawings (inside control housing and in this manual). Be sure that new components are wired in the same manner as old components. An examination of the circuit schematic shows that the safety components are wired in series. In most cases, a faulty component may be isolated with a jumper wire to verify that the component is faulty. If this determination is made, contact a certified Groen Service Agency for assistance.

TROUBLESHOOTING

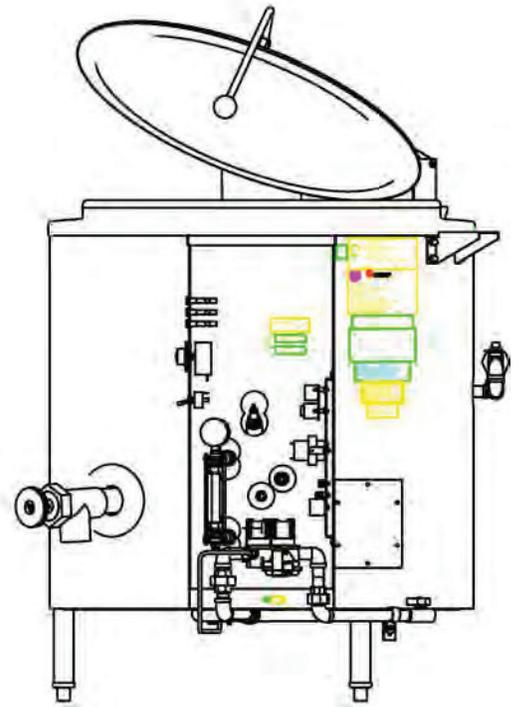
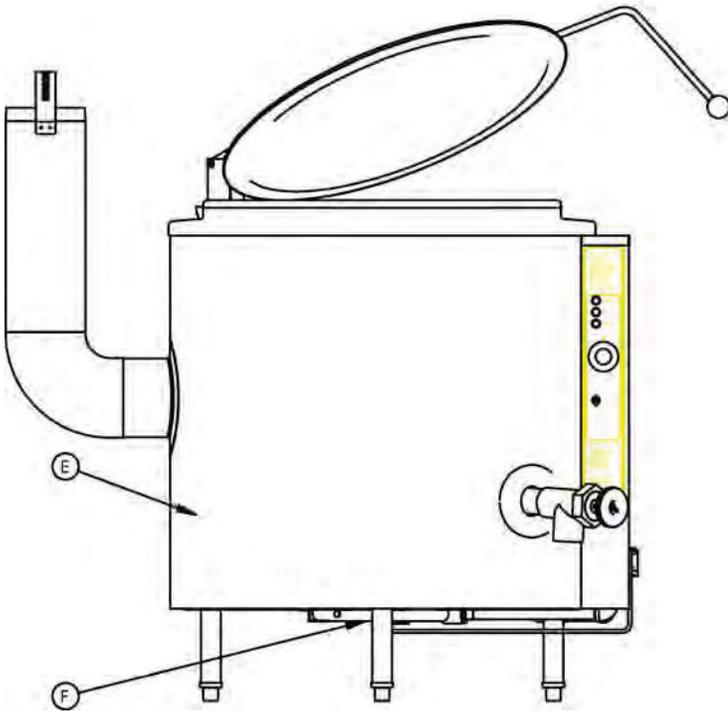
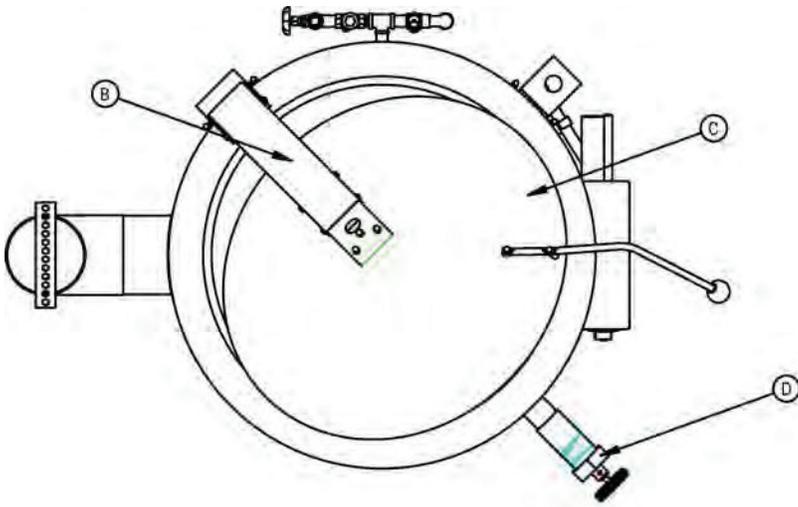
WARNING: BEFORE REPLACING ANY PARTS, DISCONNECT THE UNIT FROM THE ELECTRIC POWER SUPPLY AND CLOSE THE MAIN GAS VALVE. ALLOW FIVE MINUTES FOR UNBURNED GAS TO VENT.

CAUTION: USING REPLACEMENT PARTS OTHER THAN THOSE SUPPLIED BY GROEN OR THEIR AUTHORIZED DISTRIBUTOR CAN CAUSE OPERATOR INJURY AND EQUIPMENT DAMAGE AND WILL VOID ALL WARRANTIES.

Your Groen kettle is designed to operate smoothly and efficiently if properly maintained. However, the following is a list of checks to make in the event of a problem. Wiring diagrams are furnished inside the service panel and in this manual. **If an item on the list is followed by, the work should be done by a qualified service representative.**

SYMPTOM	WHO	WHAT TO CHECK
Kettle continues heating after it reaches desired temperature.	User	a. Thermostat dial setting.
	Authorized Service Rep Only	b. Thermostat calibration. c. Thermostat operation. The thermostat should click when the dial is rotated to settings above and below the temperature of the kettle.
Kettle stops heating before it reaches the desired temperature.	User	a. Thermostat dial setting.
	Authorized Service Rep Only	b. Thermostat calibration. c. Thermostat operation. The thermostat should click when the dial is rotated to settings above and below the temperature of the kettle.
Pressure relief valve pops open	User	a. For air in the jacket. See "Jacket Vacuum" in the Maintenance section. b. Thermostat dial setting.
	Authorized Service Rep Only	c. For defective thermostat. The thermostat should click when the dial is rotated to settings above and below the temperature of the kettle. If defective, replace. d. For defective pressure relief valve. If the valve pops at pressures below 29 PSI, replace.
Burners will not light.	User	a. That the main gas supply valve is open. (handle is in line with the gas pipe). b. Gas supply to the building.
	Authorized Service Rep Only	d. Thermostat operation. The thermostat should click when the dial is rotated to settings above and below the temperature of the kettle.
System does not produce a spark	Authorized Service Rep Only	a. AC voltage between terminals on secondary side of transformer with unit power turned on. If it is not 24 Volt, replace the transformer. b. That the high tension cable is firmly attached and in good condition. If cracked or brittle, replace. c. Pilot burner ceramic insulator for crack or break. d. Pilot spark gap. Regap.

SYMPTOM	WHO	WHAT TO CHECK
Spark is present but the pilot will not light.	Authorized Service Rep Only	a. That the pilot valve is securely connected to terminals. b. For 24 VAC at terminals PV and PV/MV. If 24V is not present, replace the ignition control module. b. That gas pressure is at least 3.5" W.C.(8.7818 b). c. For gas at the pilot. If it is not flowing: (1) Check the pilot gas line for kinks and obstructions. (2) Clean orifice, if necessary. (3) Check magnetic operator for pilot valve on gas valve. Repair or replace as necessary. d. That the pilot spark gap is located in the pilot gas stream. If not, adjust or replace the pilot burner. e. For drafts. Shield the pilot burner, if necessary.
Pilot lights, but main burner will not come on and spark does not stay on.	Authorized Service Rep Only	a. For 24 V between terminals MV and PV/MV while pilot is burning. If 24V is not present, replace the ignition control module. b. That gas pressure is at least 3.5" W.C.(8.7818 b). c. Electrical connections of the main valve to terminals, to assure that they are securely attached. Check magnetic operator for main valve on gas valve. Repair or replace as necessary.
Pilot lights, but main burner will not come on, the spark stays on.	Authorized Service Rep Only	a. Check for bad burner ground. If necessary, repair with high temperature wire. b. Pilot burner ceramic insulator for cracks. c. That cable is not grounded out. If it is, correct the ground-out condition or replace cable. d. For proper gas pressure. e. Clean pilot assembly, or replace if necessary. f. Tighten all mechanical and electrical connections. g. If the pilot flame is weak, increase pilot orifice size. h. Replace ignition control module.
Main burner comes on but will not stay on.	Authorized Service Rep Only	a. Check burner ground for bad wire or connection. Replace if necessary with high temperature wire. b. Check for low gas supply pressure. If necessary, replace ignition control module.
Pressure relief valve leaks a small amount of steam when the kettle is operating.	User	a. For contamination that prevents seating of valve. With full pressure in the jacket, pull the lever all the way briefly to blow the valve clean, then let the lever snap back to seat the valve.
	Authorized Service Rep Only	b. Pressure relief valve for defects. Replace any defective valve with an identical valve.



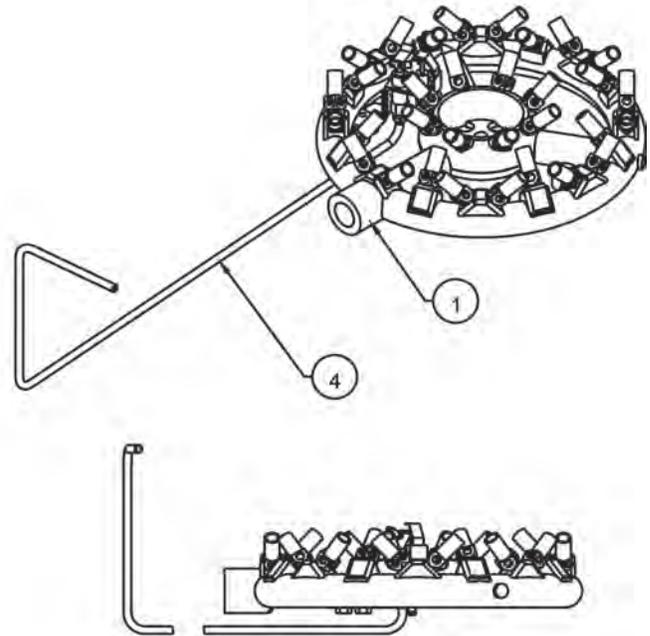
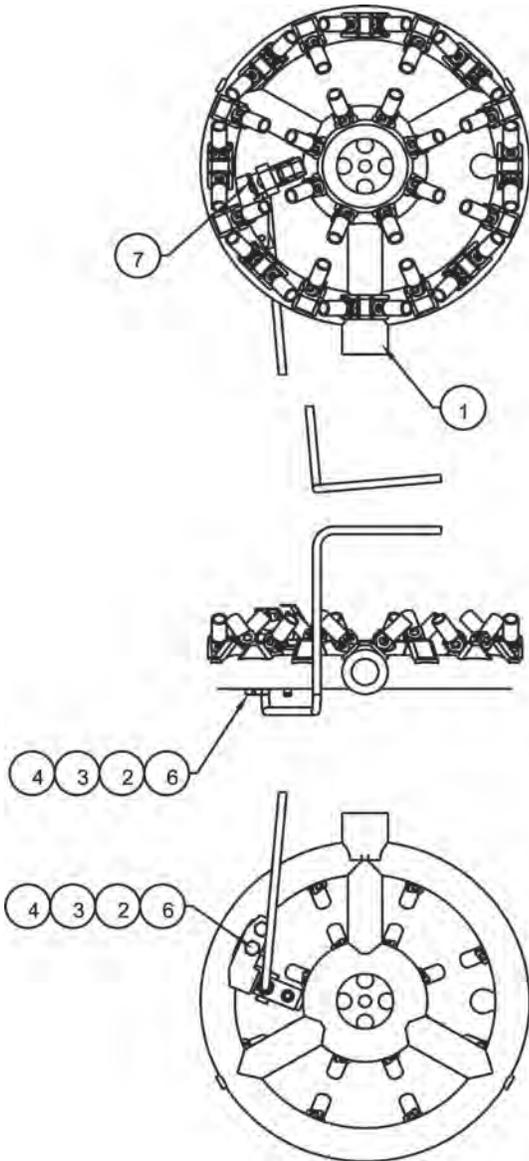
To order parts, contact your Groen Certified Service Agency. Supply the model designation, part description, and number, quantity, and where applicable, voltage and phase.

KEY	DESCRIPTION	PART NO.
A	HARDWARE ASM AH/1E-40 SPARK IGNITION	139192
	NAMEPLATE CLASS II 1" X 4-1/2" LONG	003479
	PLATE, CAUTION 1-3/8 X 2-1/4"	008350
	CHAIN SINGLE, JACK LINK #16 600" LONG	009009
	SCREW, SHEET METAL PAN HD #12 X 1/2" LG	008769
	BRACKET, FAUCET MOUNTING 16 GA X 4-3/4"	009054
	NUT HEX KEPS 1/4"-20 W/SHAKEPROOF WASHER	NT1101
	NAMEPLATE, GROEN - LARGE	055450
	LABEL, WARRANTIES VOID...	059201
	LABEL WARNING	093614
	SAFETY VALVE AND WATER FILL ASSY	097010
	SAFETY VALVE 30 PSI 1/2" NPT	097009
	NIPPLE BLK 1/2" NPT X 4 LONG	Z005554
	LABEL, WARNING	098171
	WIRING DIAGRAM LABEL	123863

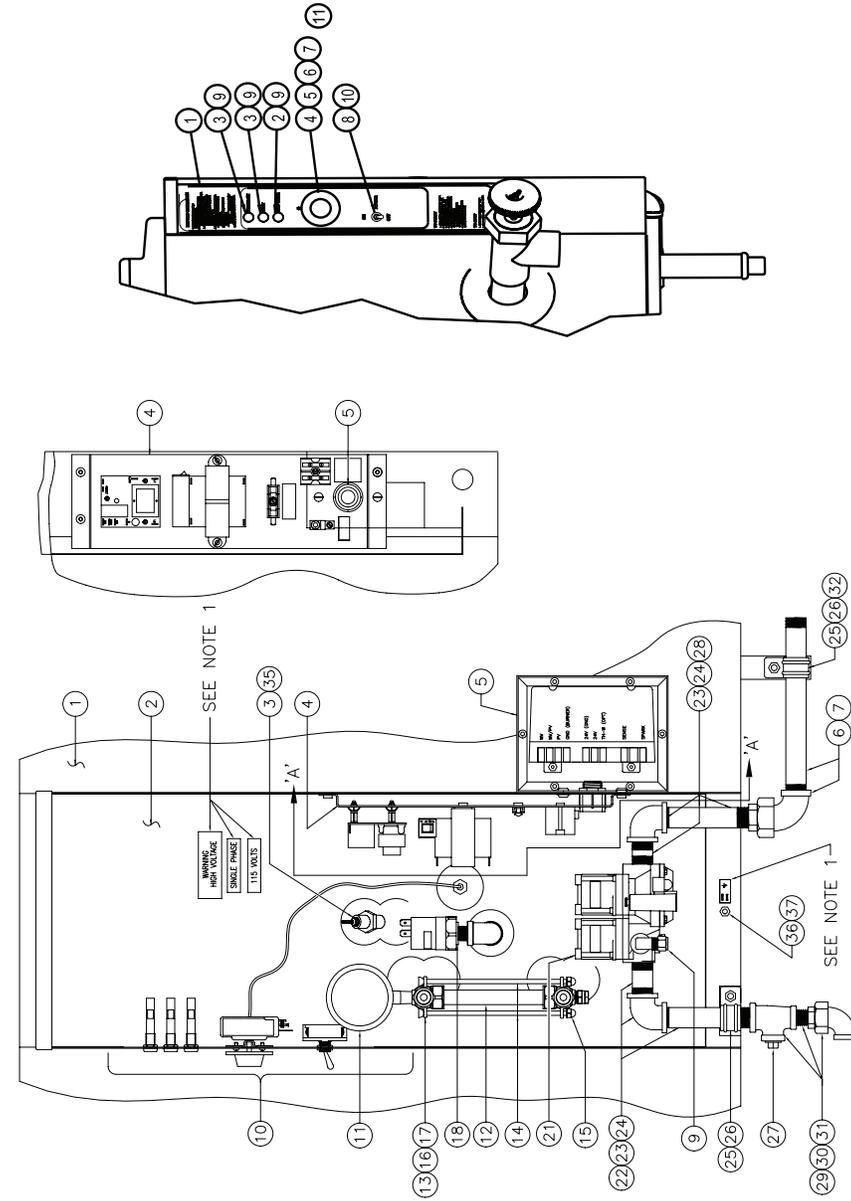
KEY	DESCRIPTION	PART NO.
B	COVER POWER AID ASSEMBLY	047693
C	POT INNER ASSEMBLY	
D	TDO KIT	100573
	NUT, WING #10-24 FOR 1-1/2" & 2"	009028
	HANDLE, 3" DIA SANITARY & TDO VALVE	009029
	STRAINER ASSEMBLY 9" DIA, 1/4" HOLES FOR 2"	009044
	VALVE, DRAW OFF 2"	009046
E	SHELL OUTER/INNER ASSEMBLY	
F	BURNER AND SENSOR ASSEMBLY	139195
G	GAS VALVE, & PIPING ASSEMBLY	139197
	IGNITION MODULE BOX ASSEMBLY	127334
	ELECTRICAL PANEL ASSEMBLY	139060

See Following Pages for Assembly Parts.

To order parts, contact your Groen Certified Service Agency. Supply the model designation, part description, and number, quantity, and where applicable, voltage and phase.

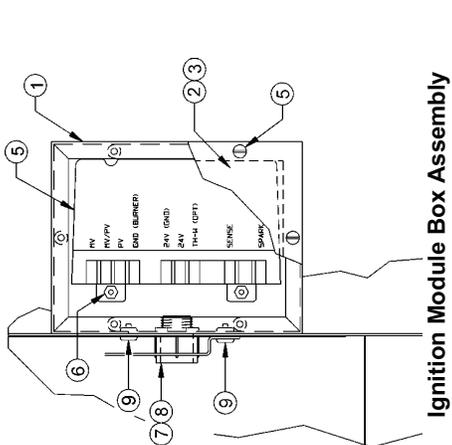


KEY	DESCRIPTION	PART NO.
F	BURNER ASSEMBLY, AHS-40 (NATURAL GAS)	139195
	BURNER ASSEMBLY, AHS-40 (PROPANE)	140062
1	ASM. BURNER MANIFOLD (NATURAL GAS)	139831
	ASM. BURNER MANIFOLD (PROPANE)	140061
2	PILOT BRACKET, AHS-40	139181
3	ASM. PILOT BURNER (NATURAL GAS)	102258
	ASM. PILOT BURNER (PROPANE)	104392
4	TUBE PILOT	139833
5	CABLE HI VOLT SPARK IGNITION	096728
6	SCREW/HEX HD 1/4-20 X 3/8	085199
7	SCREW PAN HD #10-32 X 1/4	003254

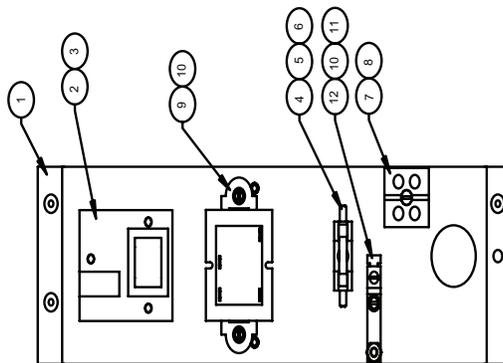


Front Panel Components Assembly

Gas Valve, Piping & Electrical Control Panel Assembly



Ignition Module Box Assembly



Electrical

To order parts, contact your Groen Certified Service Agency. Supply the model designation, part description, and number, quantity, and where applicable, voltage and phase.

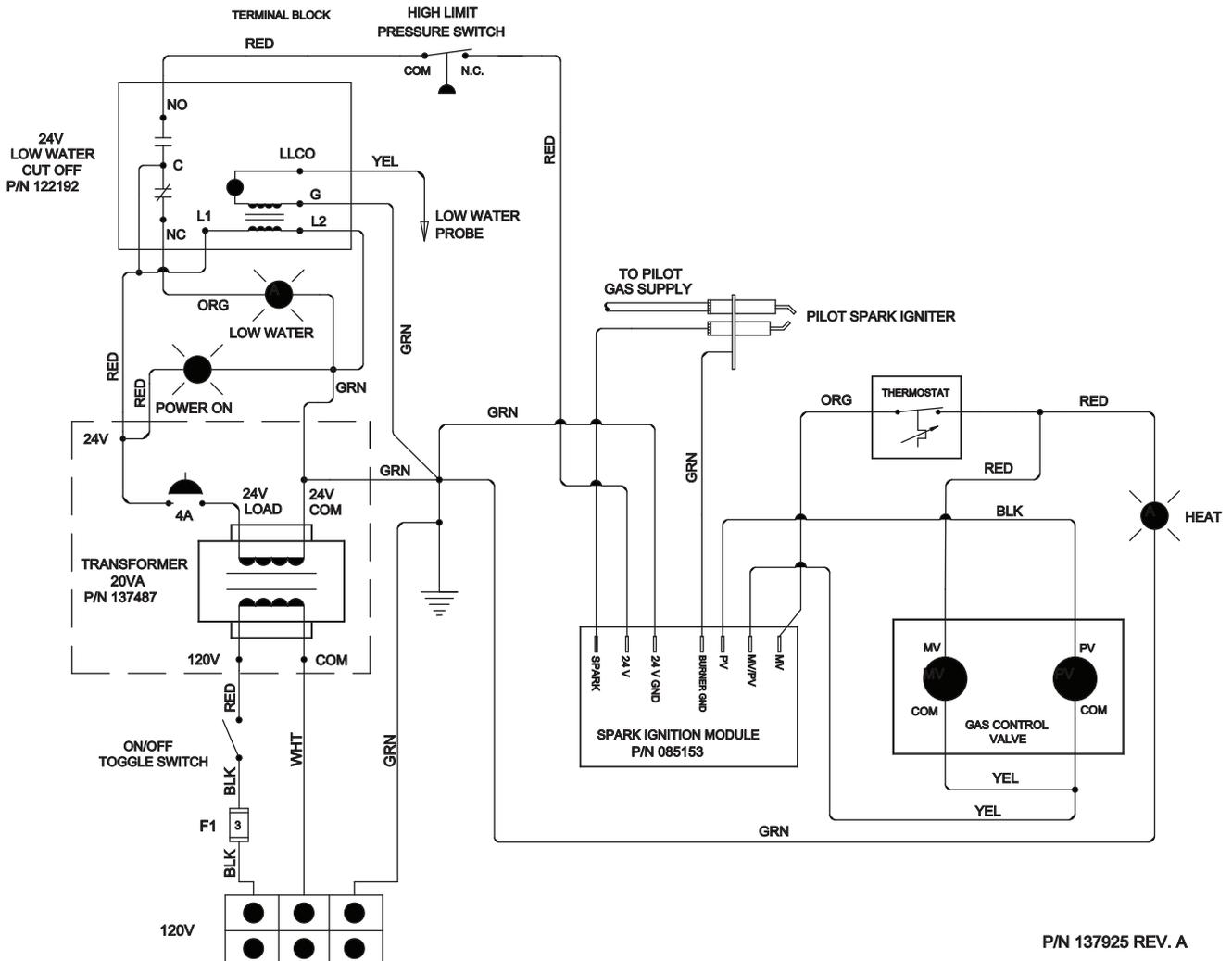
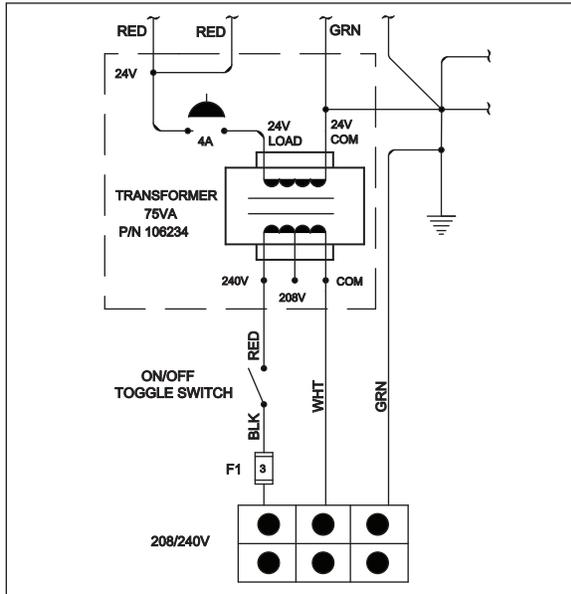
KEY	DESCRIPTION	PART NO.
G	GAS VALVE & PIPING ASSY	139197
3	WATER LEVEL ELECTRODE	074665
4	ELECTRICAL COMPONENTS ASSEMBLY	139060
5	IGNITION MODULE BOX ASSEMBLY	127334
6	ELBOW, 90° UNION, 1/2" NPT	005495
7	NIPPLE, 1/2" NPT X 8" LONG	005557
8	VALVE, GAS, MANUAL SHUT-OFF 1/2" NPT	098458
9	FITTING 90° 1/8" NPT MALE X 1/4" TUBE	097195
10	FRONT PANEL COMPONENTS ASSY	123805
11	PRESSURE GAUGE 2" DIAMETER	084208
12	SIGHT TUBE, 5/8" DIA X 4-3/4" LONG	008742
13	FITTINGS, SIGHT GLASS ASSEMBLY	002845
14	GUARD ROD FOR GAUGE GLASS	002981
15	NUT, HEX #10-24	005470
16	COUPLING, FULL 1/2" NPT	005722
17	NIPPLE, 1/2" NPT X 2-1/2" LG.	005552
18	PRESSURE SWITCH ASSEMBLY, 27 PSI	182595
21	VALVE, GAS	123815
22	NIPPLE, 1/2" NPT	008877
23	ELBOW 1/2" NPT STREET	004185
24	NIPPLE, 1/2" NPT X 2-1/2" LONG	005552
25	CLAMP, RIGID CONDUIT 3/4" NFPC	127345
26	NUT, HES KEPS 1/4-20	NT1101
27	UNION, 1/2 NPT - 004186	008504
28	NIPPLE, 1/2" NPT X 1-1/2" LONG	004184
29	ELBOW	008747
32	BOLT, HH, 1/4-20 X 3/4" LONG	005698
33	BRACKET, GAS MANIFOLD	139861
35	BOOT, LOW WATER PROBE	101143
36	STUDWELD, #10-32 X 3/8"	002928
37	NUT, KEPS 10-32 W/SHAKEPROOF WASHER	071256

KEY	DESCRIPTION	PART NO.
ELECTRICAL MOUNTING ASSEMBLY		139060
1	ASM., ELECTRICAL PANEL AHS-40	139187
2	WATER LEVEL CONTROL BOARD	122192
3	PC BOARD MOUNTING POST	099901
4	FUSE BLOCK	077854
5	FUSE 3.0 AMP	077853
6	SCREW #6-32 X 3/8" ROUND HD MACHINE	009697
7	TERMINAL BLOCK	003887
8	SCREW #8-32 X 1-1/4" ROUND HD MACHINE	005056
9	TRANSFORMER	137487
10	SCREW #8-32 X 3/8" HEX HD CAP	069789
11	NUT HEX #10-32 W/SHAKEPROOF WASHER	071256
12	LUG GROUND #14-#16 AWG	129714
13	HARNESS, WIRING (NOT SHOWN)	123864

KEY	DESCRIPTION	PART NO.
IGNITION MODULE BOX		127334
1	SPARK IGNITION MODULE ENCLOSURE	123775
2	COVER IGNITION MODULE ENCLOSURE	104948
3	GASKET, COVER	104941
4	SCREW 8-32 X 3/8" LONG	005764
5	IGNITION MODULE	085153
6	NUT, KEPS 6-32	071289
7	CONDUIT, PLASTIC MALE ADAPTER 1/2" NPT	123733
8	CONDUIT NUT, 1/2"	005487
9	SCREW 10-32 X 3/8" LONG	069773

KEY	DESCRIPTION	PART NO.
FRONT PANEL COMPONENTS		
1	LABEL INDICATOR LIGHTS & INSTRUCTIONS	123803
2	INDICATOR LIGHT AMBER W/BEZEL	116384
3	INDICATOR LIGHT RED W/BEZEL	116383
4	THERMOSTAT	012313
5	THERMOSTAT ADAPTER (SHAFT BUSHING)	107172
6	SCREW ROUND HEAD 6-32 X 3/8" LONG	009697
7	KNOB, THERMOSTAT	012314
8	TOGGLE SWITCH, SPST, ON-OFF	006904
9	GASKET, LAMP	137434
10	GASKET, SWITCH	137435
11	GASKET, THERMOSTAT	123585

Electrical Schematic



P/N 137925 REV. A

