

RC14-3500

Conveyor Dryer

24" wide by 5' long conveyor dryer
Document # 16-405

Assembly and Operating Instructions

Please review all these instructions prior to assembly.

The RyoCure Jr is packaged in two cartons for shipment. Please make sure that all pieces have been received before attempting assembly.

Tools Required: Two ½" wrenches & needle nose pliers

Label on Box	Qty	Contents
RC08-C	1	Conveyor Take-Up Assembly
	1	Conveyor Drive Assembly
	1	Conveyor Belt
	4	Legs
	2	Cross member
RC14-3500C	1	Heating Chamber
	1	4" Duct Start Collar
	1	Assembly Instructions

Note: Portions of the assembly procedure require two people.

Unpack, identify, and inspect all parts. Report any missing or damaged items.

Cover a 4' X 9' area on the floor with towels, cardboard, carpet, etc. to protect the painted parts from being scratched during assembly.

Conveyor Bed Assembly:

1. Place the Conveyor Take-Up Assembly on the covered floor upside-down.
2. Attach (2) Legs and Cross Member w/Bolts & Nuts. (Note roller groove location) (See Fig. 1)
3. Butt the Conveyor Take-Up Assembly to the Drive Assembly. Be sure that the groove on each roller drum is on the same side of the bed.
4. Bolt the bed assembly together using four 5/16-18 Bolts & Nuts.
5. Bolt Cross Member & Legs to Drive Assembly. (See Fig. 1).
6. Route cord thru conveyor holes and plug to motor leads. (inside conveyor)

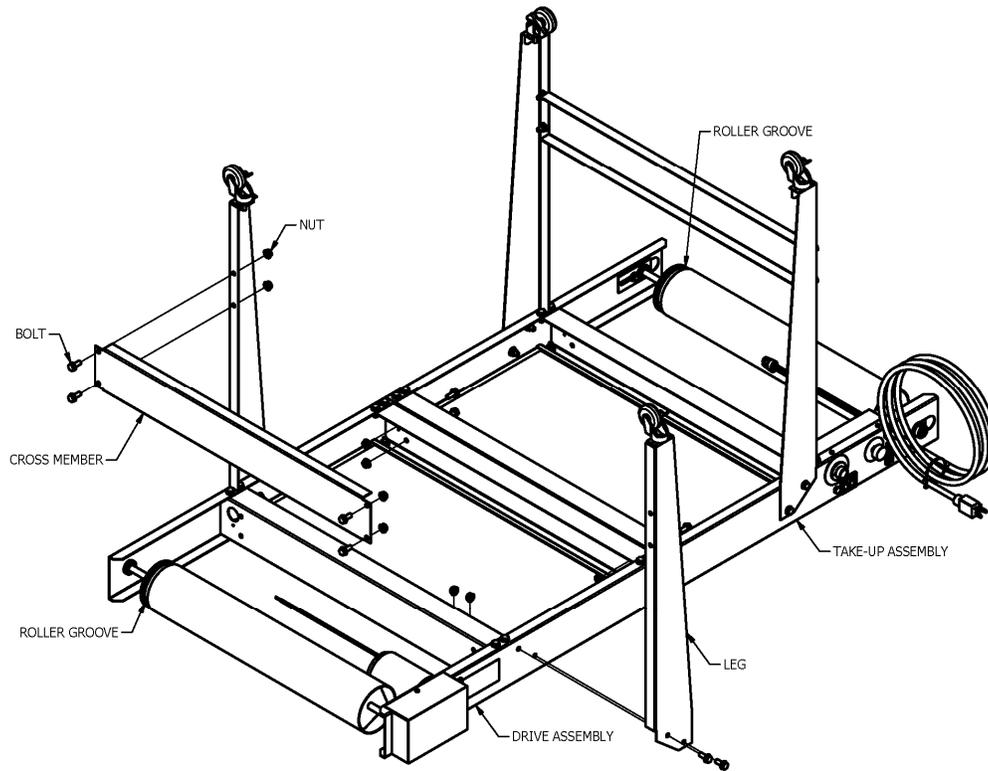


Figure 1 - Conveyor Bed Assembly

7. **Using two people** turn conveyor bed over onto its legs.

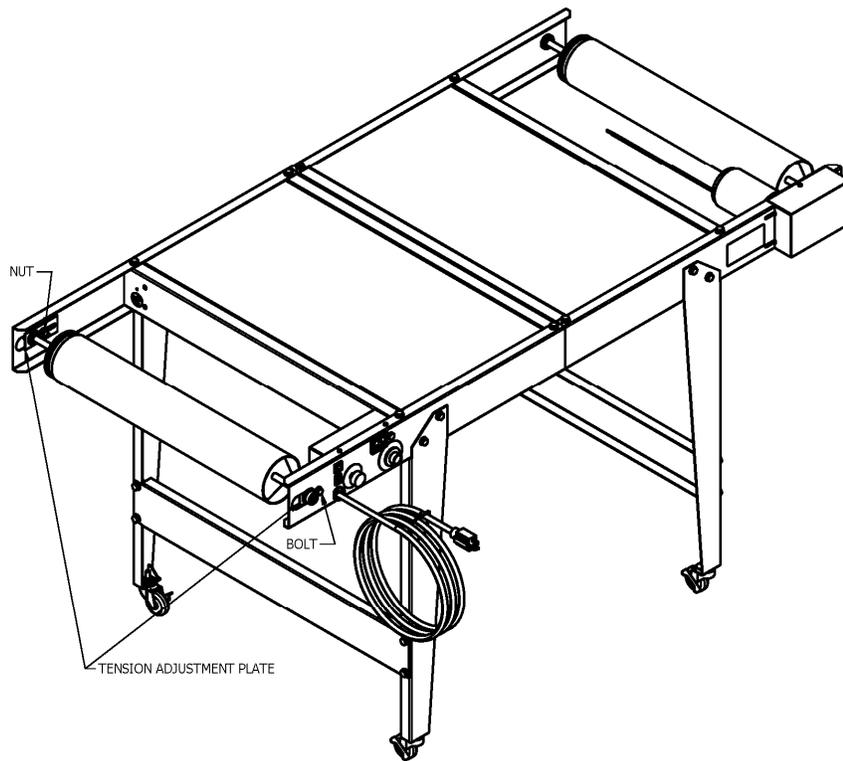


Figure 2 - Chamber Floor Assembly

Conveyor Belt Installation:

1. Loosen (but do not remove) the two bolts securing the Tension Adjustment Plates (see Fig. 2) to allow the Take-Up roller drum to slide in the bearing slot.
2. Locate the rubber guide that is stitched onto one edge of the belt. This guide is designed to ride in the roller drum grooves to provide Hassle-Free-Tracking.
3. Carefully remove the splice pin from the inside teeth of the splice connector by pulling gently with needle nose pliers. **DO NOT BEND**; this pin will be reinserted later.
4. Lay the belt on the conveyor bed aligning the edge guide with the roller drum grooves.
5. Pull the ends of the belt together meshing the teeth of the splice paying close attention to ensure edges of belt are aligned. Have a **second person** reinsert the splice pin (removed earlier) into the channel formed by the interlocked metal teeth. It may be easier to rotate the belt so that the splice is on top of the conveyor bed before inserting pin. Using needle nose pliers, fully insert the pin until it is centered.
6. **Tighten belt tension** by pulling each side of the drum roller back by hand and tightening the Belt Tensioning Bolts. The tension needs only to be great enough to prevent the belt from slipping during operation. Over-tightening will cause damage to the belt over time.

Proper tension = belt should sag 1 – 1.5 inches below the cross-members as the belt travels under the conveyor bed.

Attaching Heating Chamber:

1. **Using two people** set the chamber onto the conveyor bed (see Fig. 3). The Heating Chamber cord must be on the same side of the Conveyor Bed as the Heater Controls
2. The Heating Chamber has openings on the underside rails that fit over the hex-head bolts. The chamber should rest flatly on the conveyor bed.
3. Insert the Duct Start Collar into the hole in the top of the Heating Chamber. Once in position, bend the tabs at the base of the collar outward to secure it in place.

Note: The chamber will function properly with only the duct start collar installed. Installing a two to three foot section of 6" diameter ductwork on the start collar will improve the capture of heat and vapors created during the curing process.

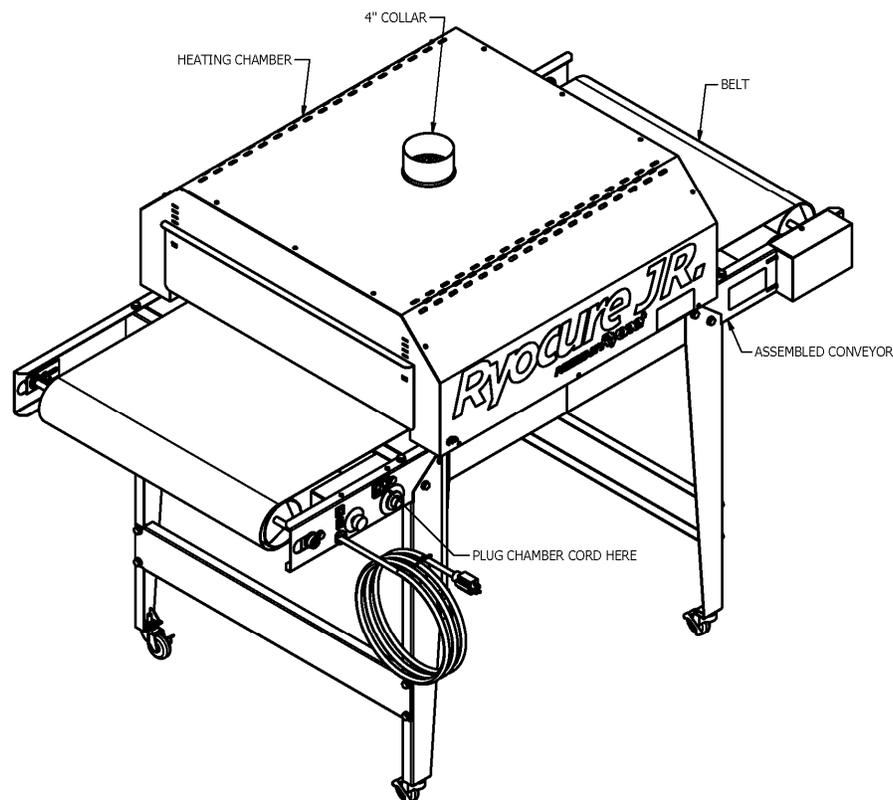


Figure 3 - Heating Chamber Assembly

4. Plug the Heating Chamber cord into the receptacle on the side of conveyor.

Recommended Initial Start-Up Procedure:

1. **DO NOT** plug the equipment in (or apply power) until instructed to do so.

Note: The RyoCure Jr Heating Chamber requires a dedicated 240 Volt, 20 Amp circuit. Any attempt to operate the RyoCure Jr without the cord/plug provided by the manufacturer will void the warranty.

2. Plug Power Cord into a dedicated 240 Volt, 20 Amp circuit.
3. Turn the Belt Speed switch to the ON position to start belt. Set speed to "5" the halfway point and listen for any unusual noises. Check to see if the rubber edge guide is riding in the roller drum grooves. Belt speed is adjusted by rotating knob on the control. (The higher the number the faster the belt will move)
4. Turn the Heat Control Switch to the on position. (Green Pilot On)

Caution: DO NOT operate Heating Chamber unless belt is moving. Heat will damage an idle belt.

5. Turn Heat Control Knob to 50%. Verify that the heating elements are functioning: after about a minute of operation, briefly feel just inside both the entrance and exit ends of the chamber. The area should be warm.

Caution: Heating elements are exposed inside the chamber and are operation at very high temperatures. Keep your hand close to the moving belt (without touching it).

Note: Some smoke/vapor and odor may be noticed during initial start-up due to residual material from the manufacturing process burning off the elements.

6. Working temperature will be reached after a ten-minute warm-up.

Test articles may be run to determine the optimal speed & temperature for your environment and products.

Note: The speed and temperature of the unit may vary slightly with fluctuations in power/voltage servicing the equipment.

Verify belt speeds by placing a small item that will not melt, like a coin, on the conveyor belt and recording the time it takes to travel through the chamber. **Warning:** The item will be HOT after it passes through the oven.

Process an item through the dryer. Evaluate the completed article according to your quality standards. If the equipment is being used for curing of ink on garments, we recommend washing the processed garment as the definitive test.

The conveyor dryer is now ready for normal **Use and Operation**.

At the end of this manual we have added a Cure Success Sheet. Copy as needed to record important information.

Routine Maintenance: Performed after first week and every 100 hours of operation.

1. The belt should be replaced if it has any tears, voids, separations, fraying, or no longer rides in the roller-drum groove due to excessive wear.
2. Belt tension: the belt will relax over time and tension may have to be adjusted by the instructions above.

MANUFACTURES WARRANTY

All products are warranted against defects in workmanship at the time of shipment.

The obligation under the above warranty shall be limited to the repair or replacement of any part or parts manufactured by the dryer manufacturer without charge F.O.B. factory that may prove defective within 12 months from the date of shipment, which are returned to dryer manufacturer.

The above warranties are the only warranties made with respect to the equipment. There is no implied warranty of merchantability or of fitness.

EXCLUSIONS:

There is no warranty on parts not manufactured by the dryer manufacturer, other than the respective manufacturer's warranty, if any.

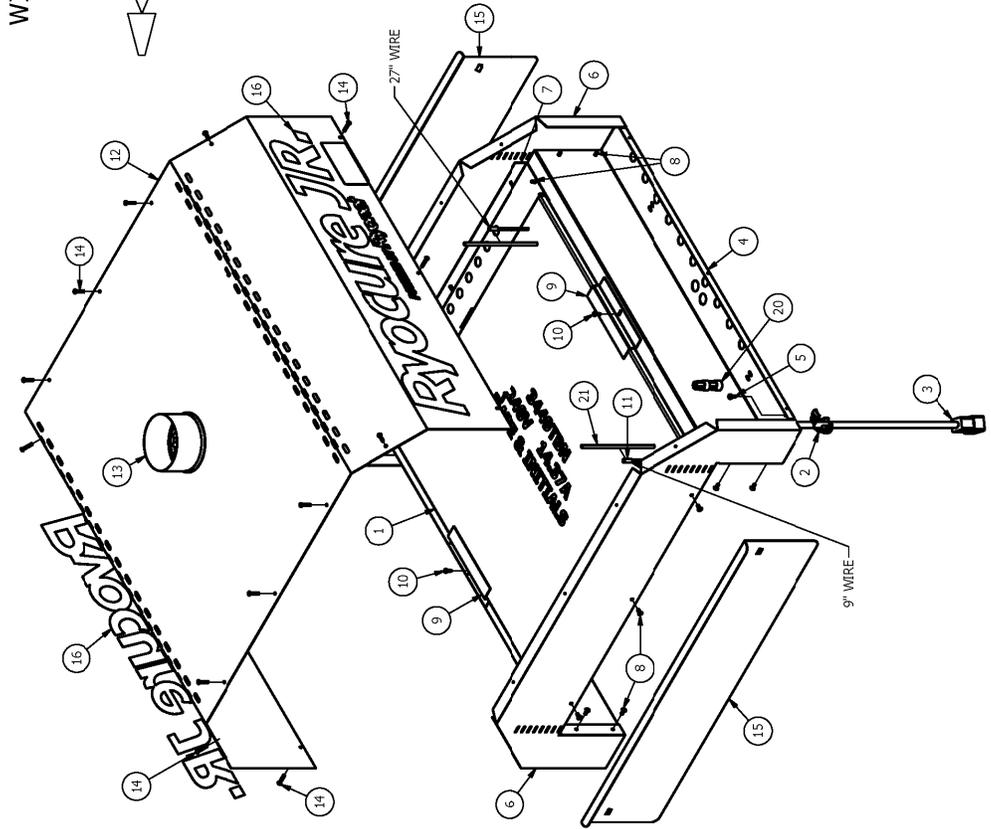
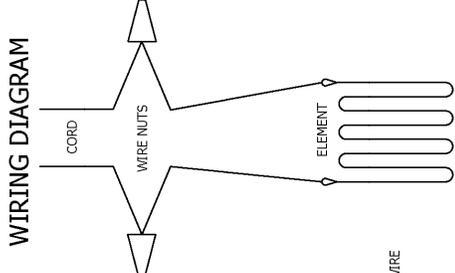
The warranty against defects shall not extend to damage caused from any of the following:

- Transport by carrier
- Corrosion
- Operation or use in a manner inconsistent with specifications and/or operating instructions
- Ordinary wear, accident, improper installation, or maintenance
- Alterations made to equipment in any way

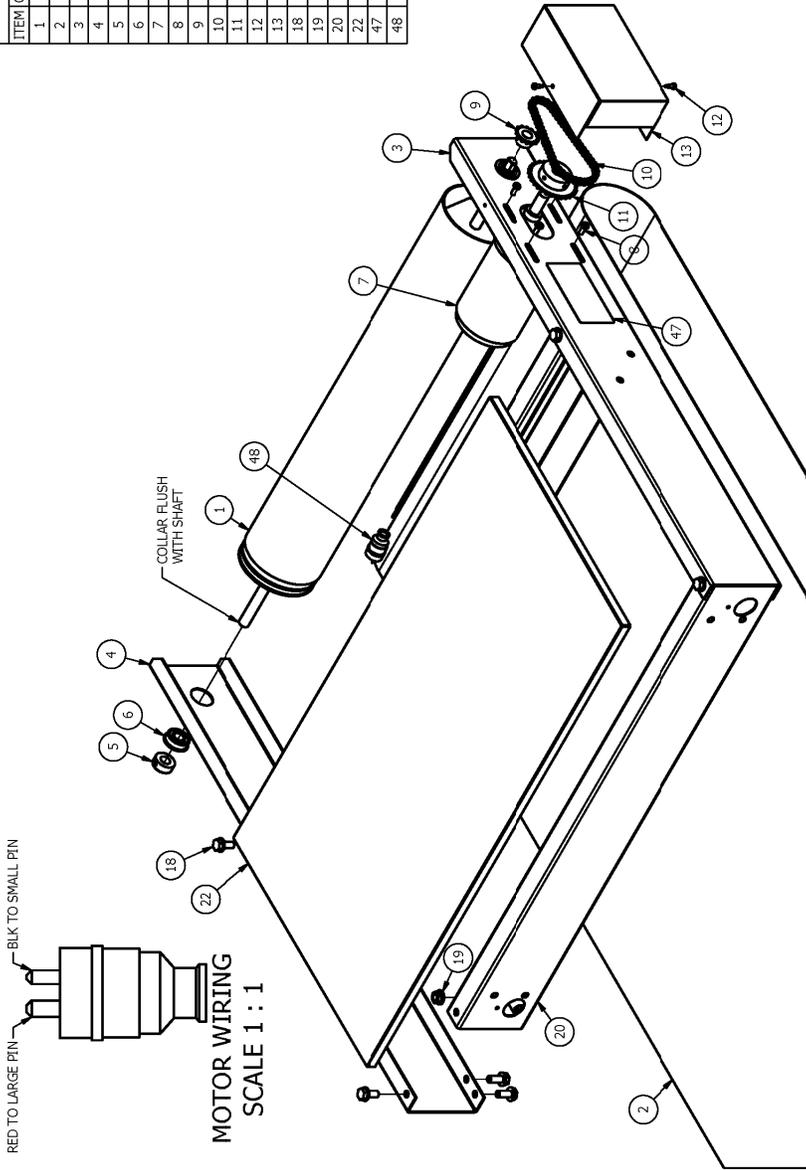
Dryer manufacturer shall not be liable for losses or damages, including but not limited to incidental or consequential damages, suffered or incurred because the equipment proves to be defective either upon installation or during its operation or use.

Shipment of defective parts to the dryer manufacturer and the return shipment of any repaired or replacement parts from the dryer manufacturer shall be the purchaser's/user's expense.

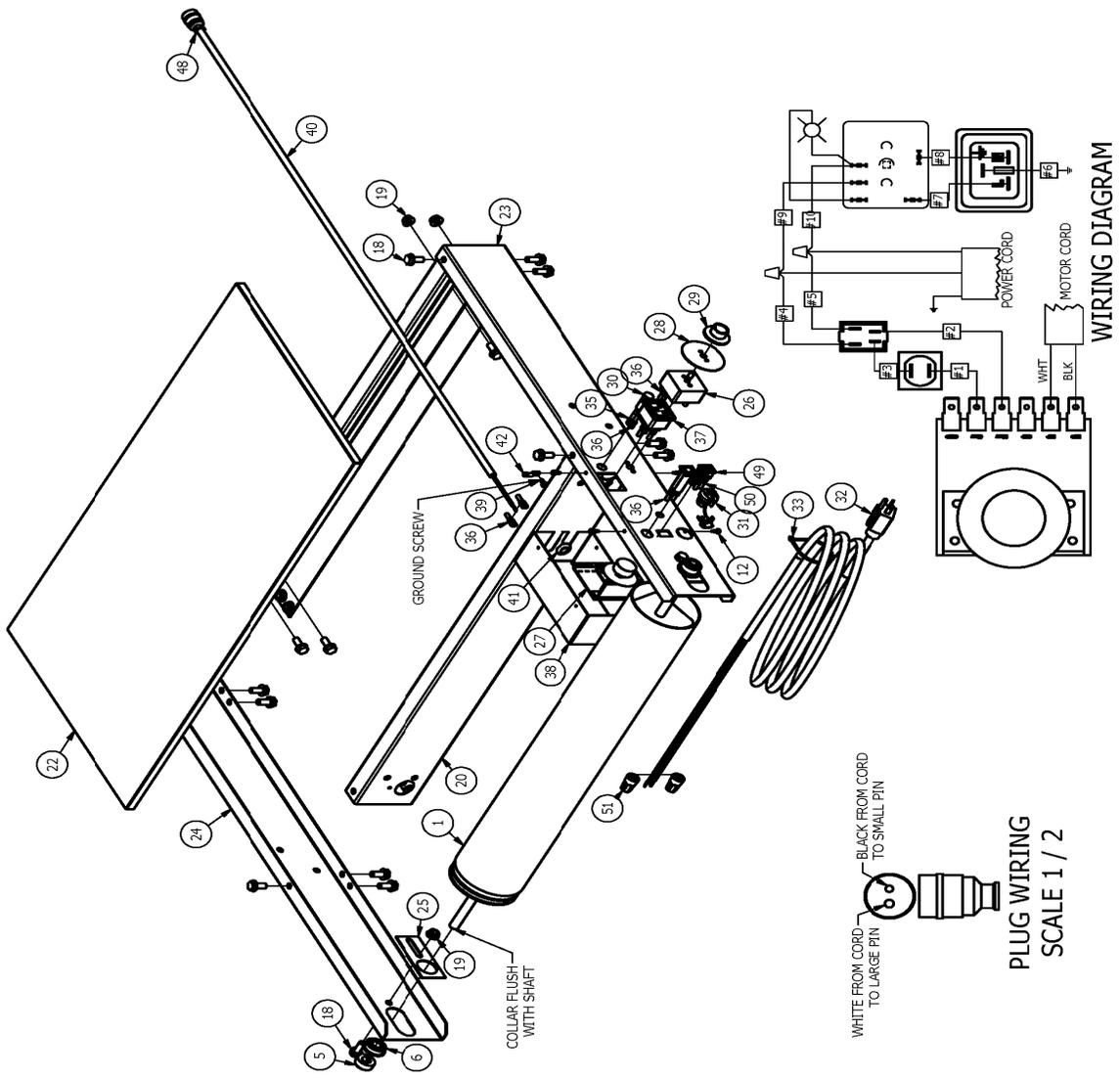
PARTS LIST			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	3449TBN	ELEMENT
2	1	22-074	STRAIN RELIEF 12/3 CORD
3	1	80-478	CORSET 20" C-20
4	2	RC14-011	INNER PANEL
5	1	25-018	SCREW #8-32 X 3/8 TYPE F
6	2	RC14-012	END CAP
7	2	RC14-013	BAFFLE
8	22	25-206	RIVET 5/32 52D
9	2	LB09-003	ELEMENT BRACKET
10	2	25-001	SCREW #6 X 3/8 PHSMS BO
11	2	87-010	CRIMP X- LARGE
12	1	RC14-014	TOP
13	1	22-093	4" START COLLAR
14	16	25-266	SCREW 6-20X.75L PHSMS ZINC TYPE B
15	2	RC14-015	END SHIELD
16	2	15-015	Label-Ryocure Jr
17	17.92	33-007	INSULATION DURABACK
18	3	90-312	12 GA MGI000
19	.09#	43-008	3/8 BANDING
20	2	87-005	WIRE NUT (2PC) MODEL 22
21	2	22-020(6L)	3/16 SLEEVING (6'L)
22	1	BOX-LB02C	BOX 34x32x15
23	1	15-204	Label-Power Generic
24	1	16-405	MANUAL
25	8	FM-12	FOAM BAG 12"

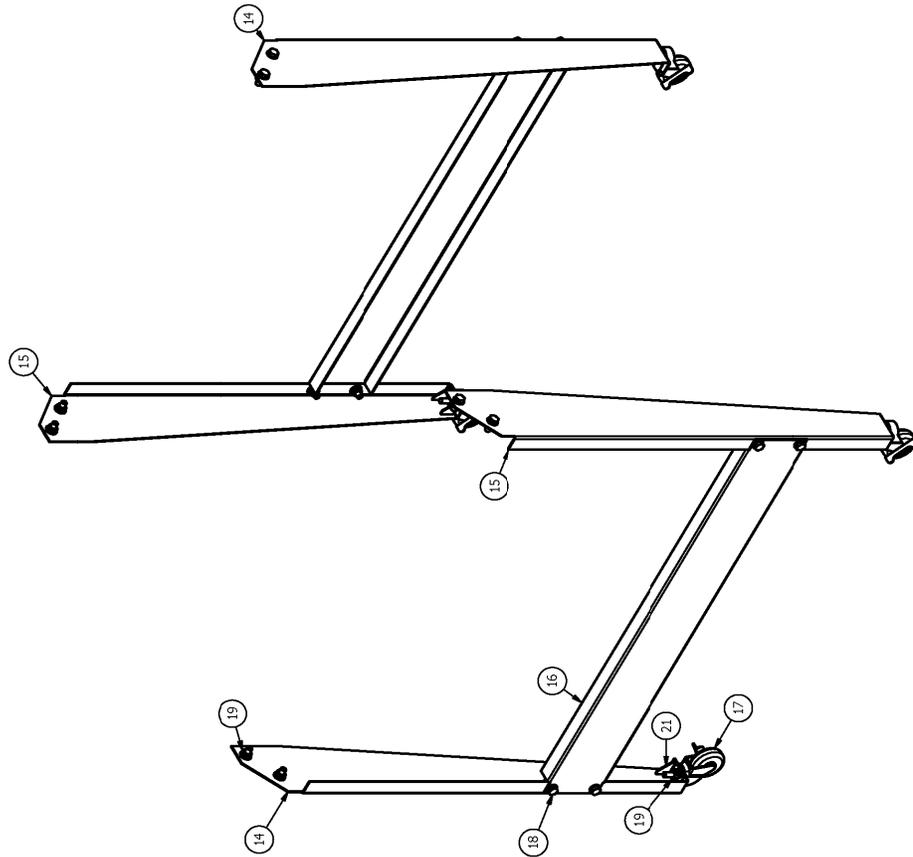


PARTS LIST			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	2	BB08-006	CONVEYOR ROLLER
2	1	RC14-300	BELT 24" W x 124.9" L w/ guide
3	1	RC14-001	SIDE RAIL
4	1	RC14-002	SIDE RAIL
5	3	97-100	COLLAR 1/2 SC50Z
6	4	11-108	BEARING 6384K361
7	1	08-252-2	GEARMOTOR
8	4	25-176	SCREW #10-32 x 1/2
9	1	08-213	SPROCKET 25B14 .5 BORE KEY SETSCREW
10	1	18-268	Chain - 51 Links - 12.75 L W/MASTER
11	1	08-012	SPROCKET 25B30 W/2 SET
12	6	25-001	SCREW #6 x 3/8 PHSMS 60
13	1	A1R-229	CHAIN COVER
18	46	25-025	BOLT 5/16-18 X3/4 SERRATED
19	50	24-012	NUT 5/16-18 SERRATED
20	4	RC14-010	Crossmember
22	2	RC14-006	Chamber Floor
47	1	15-204	Label-Power Generic
48	1	90-400	PLUG SET 2 POLE



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ITEM	QTY	PART NUMBER DESCRIPTION
1	2	BB08-006 CONVEYOR ROLLER
2	3	97-100 COLLAR 1/2 SC50Z
3	4	11-108 BEARING 6384K361
4	6	25-001 SCREW #6 x 3/8 PHISMIS BO
5	12	46 25-025 BOLT 5/16-18 X 3/4 SERRATED
6	18	50 24-012 NUT 5/16-18 SERRATED
7	20	4 RC14-010 Crossmember
8	22	2 RC14-006 Chamber Floor
9	23	1 RC14-003 SIDE RAIL
10	24	1 RC14-005 SIDE RAIL
11	25	2 AIR-200 ADJUSTMENT PLATE
12	26	1 82-313 INFINITE SWITCH 240V
13	27	1 09-006-1 Speed Control-120-240VAC 1, 90-180VDC
14	28	1 98-051 LEGEND PLATE
15	29	1 98-100 KNOB
16	30	1 91-011 GREEN LIGHT 230V
17	31	1 22-074 STRAIN RELIEF 12/3 CORD
18	32	1 90-472 CORIBSET 12-3 230V
19	33	1 16-300 CABLE TIE 8" L. PLT2M
20	34	1 73-280 BREAKER 1/2 A
21	35	1 87-192 1/4 Female QC Piggyback
22	36	14 87-203 TERMINAL RED 1/4 FEMALE QC
23	37	1 60-031 POWER OUTLET 5/703
24	38	1 RC14-009 CONTROL COVER
25	39	1 25-018 SCREW 8-32 x 3/8 TYPE F
26	40	1 90-502(3.5) CORD 18/2 SO 3.5'
27	41	1 22-078 GROMMET
28	42	1 87-191 TERMINAL RED RING #8 STUD
29	43	2 90-318 WIRE 18 AWG MGT1000
30	44	2 75 90-160 WIRE BLK 18 AWG MTW
31	45	1 90-162 WIRE GRN 18 AWG MTW
32	46	1 90-400 PLUG SET 2 POLE
33	49	1 98-083 Switch - DPST, 10A/125VAC, 8A/250VAC
34	50	4 87-193 TERMINAL 3/16 QC .032 TAB
35	51	2 87-005 WIRE NUT (2PC) MODEL 22





PARTS LIST		
ITEM	QTY	PART NUMBER DESCRIPTION
14	2	RC14-004-L LEG
15	2	RC14-004-R LEG
16	2	RC14-007 CROSS BRACE
17	4	28-012 CASTER 2" W/BRAKE
18	46	25-025 BOLT 5/16-18 X 3/4 SERRATED
19	50	24-012 NUT 5/16-18 SERRATED
21	4	RC14-008 GUSSET
46	1	BOX-LB02C BOX 34x32x15

Cure Success Sheet

page ___ of ___

Job #	Customer	Heat Setting	Belt Speed
Shirt Color		Ink Color	
Shirt Type		Ink Type	
Shirt Weight		Date/Temp/Humidity	
Notes			

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Shirt Color		Ink Color	
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Shirt Weight		Date/Temp/Humidity	
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