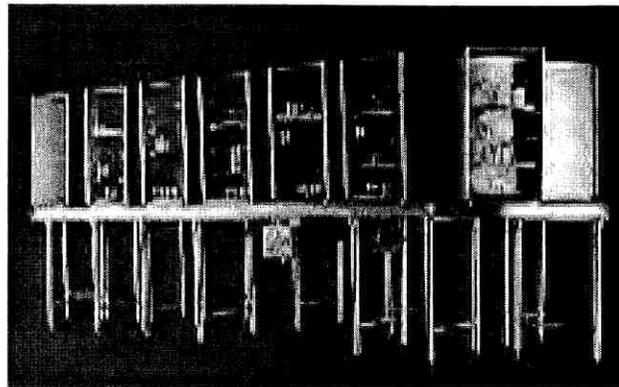




# INSTRUCTION & PARTS MANUAL

---

## TRAY ACCUMULATOR



**STERO**  
Dishwashing Machines

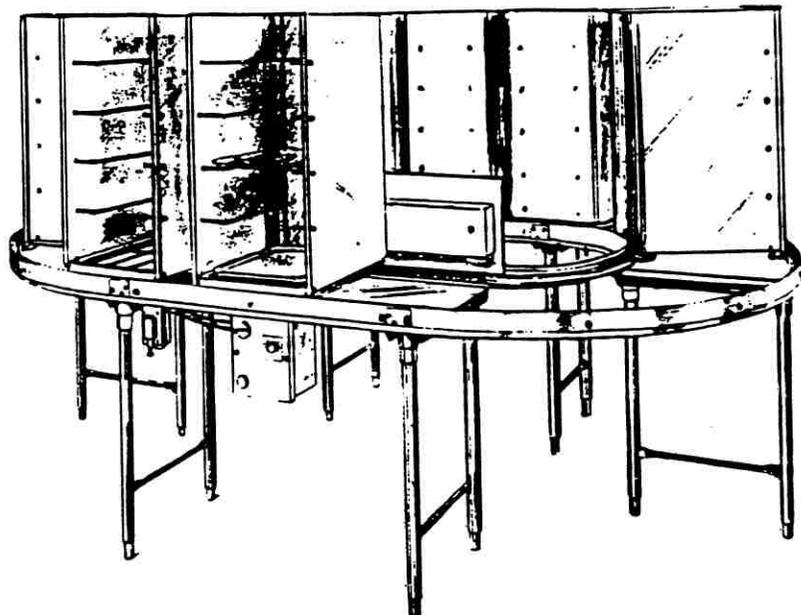




# STAC STERO TRAY ACCUMULATOR CONVEYOR

*This instruction manual covers:*

- *Installation*
- *Operation*
- *Trouble-shooting Guide*
- *Maintenance*
- *Parts*



# **The Stero Company**

## **WARRANTY POLICY**

*This warranty is in lieu of all other warranties, expressed or implied, including without limitation any implied warranty of merchantability, fitness for a particular purpose or non-infringement, and of any other obligation or liability on the part of Stero, whether in contract, strict liability, tort or otherwise.*

*The Stero Company warrants this equipment to be free from defects in material and workmanship, under normal use and operation, for a period of one (1) year from the date of initial start up or eighteen (18) months from the date of shipment from the factory, whichever comes first. This warranty is conditioned upon the customer's maintenance and care as outlined in the service manual and upon return of the warranty registration card. Repairs will be performed during Stero's authorized service agencies' normal business hours. If the customer requires after hours service the customer will be responsible for the overtime premium.*

*Machine is warranted only for the initial place of installation. Removal of machine automatically terminates the warranty.*

*Stero shall have no liability under this warranty unless the customer promptly notifies Stero or its factory authorized service agent of any alleged defects. All defective parts become the property of Stero and must be returned to Stero, or its agent, at Stero's expense, within thirty (30) days from the date of the part's replacement. Parts replaced within the warranty carry only the unexpired portion of the machine's warranty. Not covered by this warranty are changes (parts and/or labor) necessitated by or damage resulting from: water conditions, accident, alteration, improper use, abuse, tampering, improper installation or failure to follow operating and maintenance procedures. Examples of the foregoing, but without limitations are: (1) Damage to the machine resulting from excessive concentrations of chlorine or delimiting acid solutions; (2) Use with utility service other than designated on the rating plates; (3) Improper connection to utility service; (4) Inadequate or excessive water and/or steam pressure; (5) Leaks caused by faulty installation; (6) Component failures caused by water leaks due to faulty installation; (7) Failure to comply to local building codes; (8) Failures due to deposits resulting from water or steam conditions, detergents, chemicals, or improper cleaning; (9) Resetting breakers, overloads, or safety thermostats; (10) Adjustments of thermostats after 90 days of operation; (11) Improper opening of utility supply valves; (12) Cleaning drain valves, line strainers, rinse nozzles, etc.; (13) Improper installation or malfunction of chemical dispensing equipment supplied by others; and (14) Failure to provide regular maintenance and daily cleaning as outlined in the service manual. In no event will Stero be liable for loss or damage to or loss of use of facilities or other property, additional labor costs, loss of revenue, loss of anticipated profits, or other damages of any kind what so ever, whether direct, indirect, incidental or consequential.*

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# **INSTRUCTION & PARTS MANUAL**

## **INTRODUCTION**

The information present in this manual is set forth as clearly as possible so that the operator may be able to follow without any difficulty the necessary instruction.  
No special training is required.

Careful attention to the instructions outlined herein as to installing, starting, operating, and maintaining the equipment will insure long and satisfactory service from the Stero Tray Accumulator Conveyor.

### **NOTE**

When ordering parts for a specific machine always include the model number and serial number of the machine.

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<b>Section I</b>	<b>Page</b>
Specification & fact sheet .....	3 - 4
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Start-up .....	7
Maintenance .....	7
Trouble Shooting Guide .....	8

### **Section II**

Parts Drawings, Parts Numbers & Description, Wiring Diagrams.

# STAC

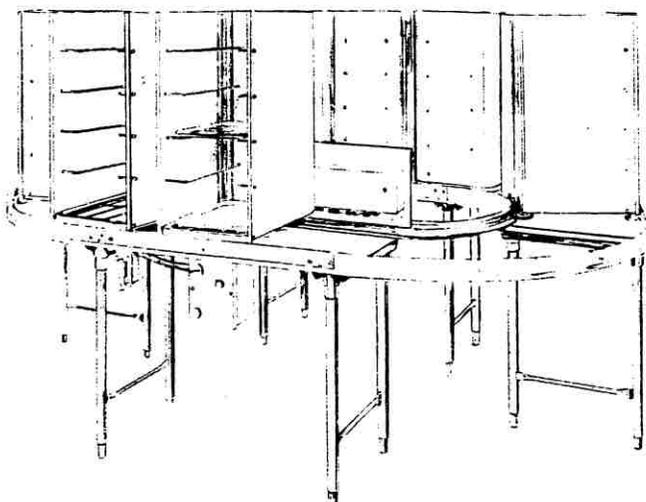


## STERO TRAY

## ACCUMULATOR CONVEYOR

This trouble-free conveyor system offers **true** accumulation. Trays are loaded by the patron and transported to the dishroom, where they are unloaded by the dishmachine operator. If all trays are not unloaded at that time, they continue around the system until they return to the operator. No worry about trays backing up during peak hours. No having to shut down the conveyor during peak periods when the load is greatest.

This system utilizes the "tried and true" components of the Stero Systematic which have proven their reliability for many years.



**CONSTRUCTION:** Heavy duty #12 gauge stainless steel formed frame. Bolt together construction for ease of assembly. The frame is supported by stainless steel leg sets with adjustable stainless steel bullet feet.

**DESIGN:** Can be constructed in oval, triangle or "L" shape. Any length from a minimum oval of 9'-8" long to as long as your application requires, or your imagination desires.

**TRAY CARRIERS:** Unit consists of individual carriers which have a five tray capacity. Carriers are interconnected to complete a continuous circle of transportation. Carriers are each supported on four stainless steel ball-bearing wheels which roll in a formed stainless steel track. Carriers are on approximately 20" centers and are interconnected.

**DRIVE:** A single 1/2 h.p. 115 volt., variable speed (adjustable) drive unit drives a stainless steel chain which contacts drive pins on each carrier. This propels the entire circle of carriers.

**CAPACITY:** Tray capacities vary with the size and shape of the system. The following are typical examples:

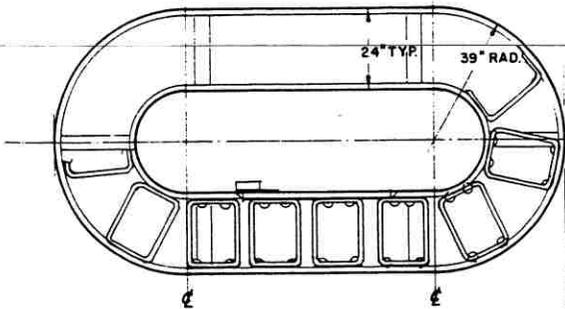
- 9'-8" oval unit: 55 tray capacity
- 15'-8" oval unit: 85 tray capacity
- 20'-8" oval unit: 115 tray capacity
- 25'-8" oval unit: 145 tray capacity

The above lengths are for reference. Conveyors can be built to any length ending with 8 inches.

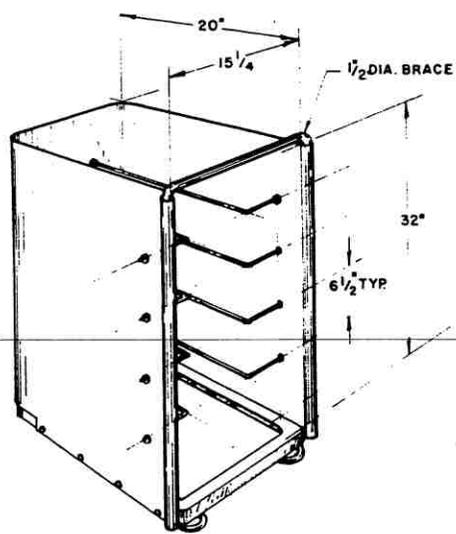
See reverse side for layout examples.

MACHINE SIZED BY OVER-ALL LENGTH  
 MINIMUM LENGTH = 9'-8", INCREASED IN 12" INCREMENTS

O.A. LENGTH - 78" -  $\phi$  -  $\phi$



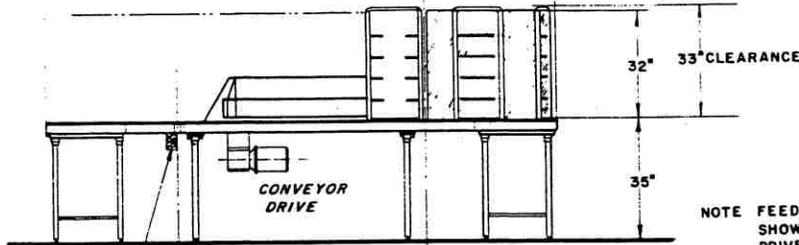
NOTE: NUMBER OF TRAY CARRIERS\*  
 IS A FUNCTION OF O.A. LENGTH



**STERO'S TRAY CARRIER**

CAPACITY: 5 TRAYS

NOTE, WHEN ORDERING PLEASE  
 SPECIFY TRAY SIZE

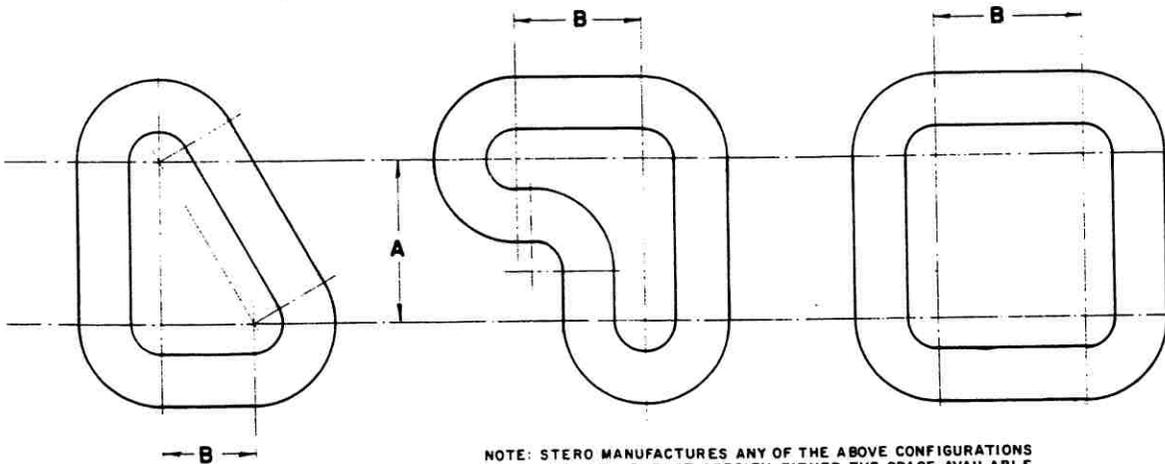


ELECTRICAL BOX / SWITCH APPROXIMATELY  
 AS SHOWN, K.O. IN BACK: MOTOR - 1/2 HP.  
 115V - 1PH - 60CYC.

NOTE FEED DIRECTION OPTIONAL, CLOCKWISE  
 SHOWN, COUNTER-CLOCK HAS CONVEYOR  
 DRIVE ON OPPOSITE END, PLEASE SPECIFY  
 ROTATION

**STAC- OUTLINE DIMENSIONS**

**STAC- OPTIONAL MACHINE CONFIGURATIONS**



NOTE: STERO MANUFACTURES ANY OF THE ABOVE CONFIGURATIONS  
 TO ORDER, PLEASE SPECIFY EITHER THE SPACE AVAILABLE  
 OR DIMENSIONS "A" & "B" HOWEVER ONE LEG ( $\phi$  TO  $\phi$ ) SHOULD  
 BE AT LEAST 50" FOR THE DRIVE SECTION, THE PREFERRED  
 LOCATION OF WHICH, IS A FUNCTION OF LOADING, UNLOADING  
 AND FEED DIRECTION

## INSTALLATION INSTRUCTIONS

1. Start by setting the straight section with mounted conveyor drive and control ox in place. Working from either end of the straight side and in one direction, fasten each section together as marked by the factory.

**NOTE:** The longer the conveyor, the more straight sections are used. Be sure the last section connected is a radius.

Level the conveyor all the way around. Place your level across the tracks and level front to back.

Place your level along the track and level lengthwise around the machine. Each leg has an adjustable stainless steel foot, screw the feet in or out as necessary.

Each stainless steel foot has a maximum 2F" adjustment.

2. Now that the machine is set in place and leveled you can place the doly cabinet or tray carrier, into the tracks,

Two notches are provided in the inner track and labeled "INSTALL OR REMOVE DOLLIES HERE". Place the two outer wheels into the outside track and lower the two inner wheels through the notches and into the inner track. The cabinet opening faces out.

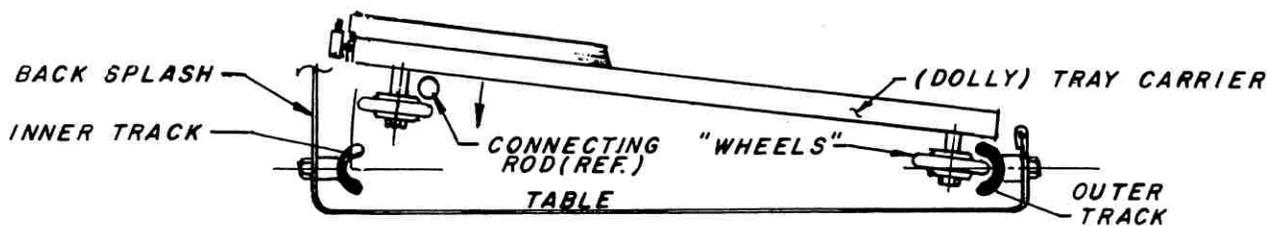


Figure 1

Connect the dollies together as you proceed by placing the connecting links, pin down, into the stationary bar welded to the rear side of the dolly.

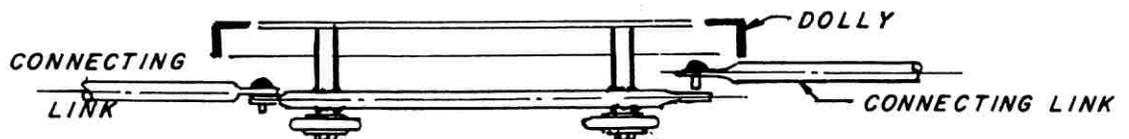


Figure 2

An adjustable flexing connecting link is provided and should be the last link connected. This link is adjusted at the factory and should not be changed.

The adjustable link must be installed so that it flexes toward the center of the table.

**NOTE:** If adjustment of the flexible link is required, push the two disconnected dollies away from each other taking all the slack out of the conveyor. Measure the distance between the pin holes in the stationary links of the two separated dollies then pull the two dollies together as close as possible, re-measure between the two pin holes, divide the difference in half and lock the adjustable link by tightening the lock nut.

Example: Dollies spread apart = 12" pin hole to pin hole.  
Dollies drawn together = 8" pin hole to pin hole.  
Adjust link to 10"

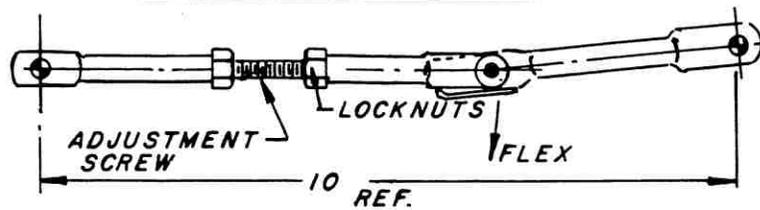
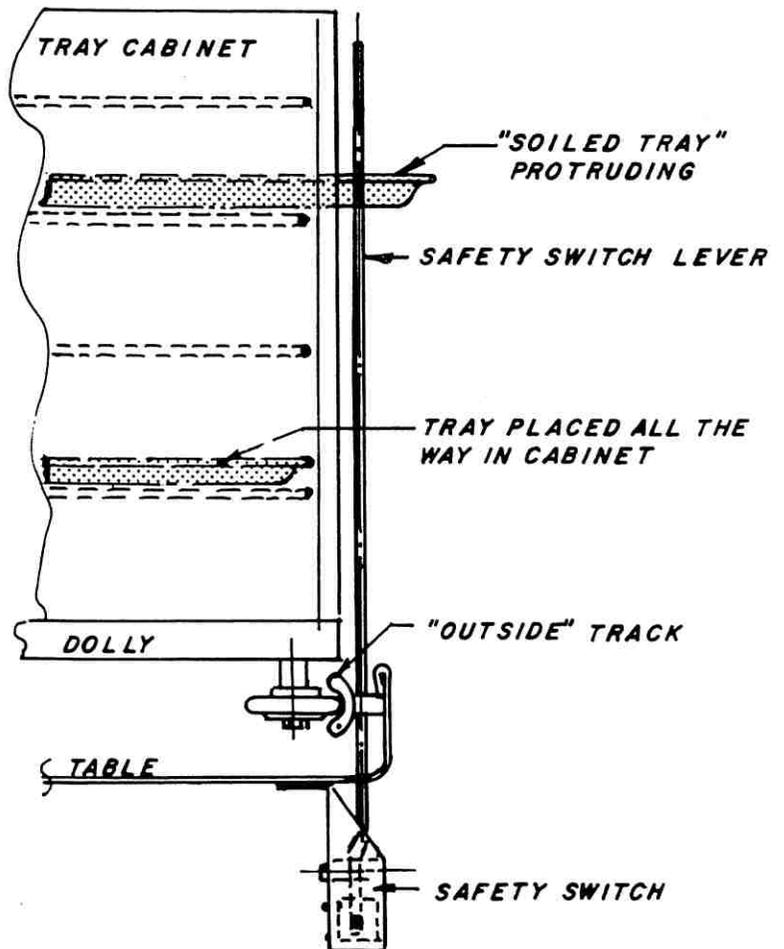


Figure 3

**IMPORTANT NOTICE**

A safety switch is mounted to the outside track of the conveyor as a safety feature. If the soiled tray is not placed all the way into the tray cabinet, the tray will come up against the safety switch activating the lever, which stops the conveyor. When the tray is pushed into the cabinet, the activating lever will return to the run position and the conveyor will restart. See Figure 4.



**3. Plumbing Connections**

**COMPLY WITH LOCAL PLUMBING CODES**

A drain may be placed in the table and must be connected to drain off any liquids spilled during placement of the trays into the tray cabinet. This drain is an option and your accumulator may not have this feature.

When a drain is supplied the pipe size will be on 2" I.P.S. connection.

## **UL 73 Grounding Instructions:**

**This Appliance must be connected to a grounded, metal, permanent wiring system; or an equipment-grounding conductor must be run with the circuit conductors and connected to the equipment-grounding terminal or lead on the appliance.**

4. **Electrical connections.**

**COMPLY WITH LOCAL ELECTRICAL CODES.**

All Stero tray accumulators are 115 volts, and a terminal strip marked L1 and N is provided in the control box for your service connection. A knock-out is provided in the control box for your electrical conduit.

**NOTE:** See the name plate on the control box and size the circuit breaker and wire accordingly.

**OPERATION: START-UP**

Before starting the conveyor, check the following:

- 1 - The machine is properly set in place with all sections firmly fastened together and the entire conveyor leveled.
- 2 - The plumbing and electrical connections are properly made.
- 3 - **The safety switch is in place.**
- 4 - The dollies with cabinets are properly set in tracks and linked together.
- 5 - The circuit breaker is on.
- 6 - The toggle switch on control box is in forward position.

When all of the above are correct, push the start switch to "start" and the conveyor will run.

**MAINTENANCE:**

Daily Maintenance:

- 1 - Using a good all purpose cleaning detergent, wash away all spills and wipe down the interior of the tray cabinets. Clean up any unsightly spills that occur so that the conveyor cabinets will not appear offensive to your customers.

Weekly Maintenance:

- 1 - Wash all cabinets, interior and exterior and apply a good stainless steel polish and wipe off. This will keep your conveyor looking good.
- 2 - Check and clean thoroughly the conveyor tracks. Coffee, milk, soft drinks, etc., spilled and allowed to get on the tracks will cause a sticky layer of soil to build up on the tracks and cause overloading and drag on the conveyor drive motor and gear box.
- 3 - Using WD-40 or a similar spray lubricant, spray the dolly wheels, directing the lubricant into the ball bearings.

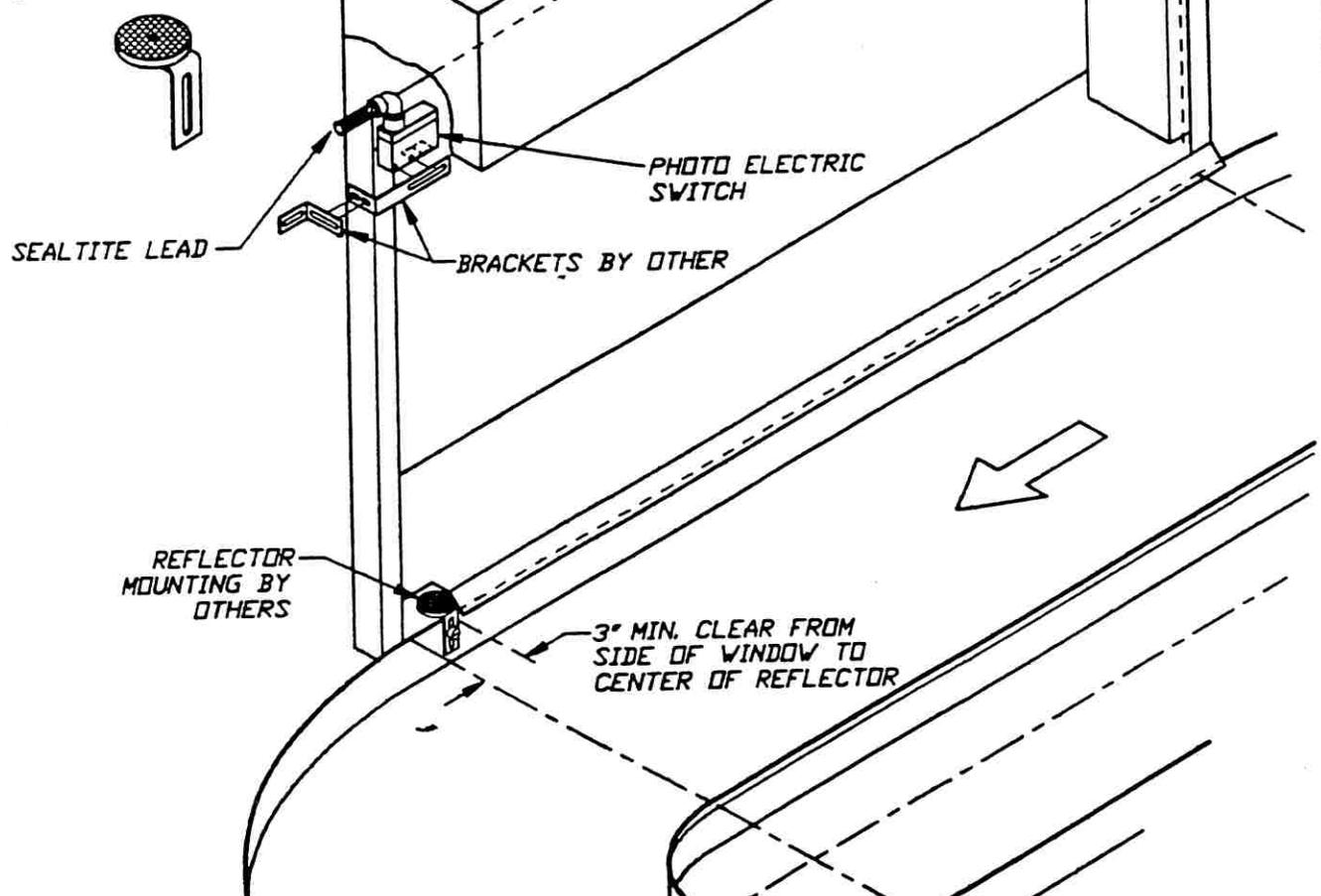
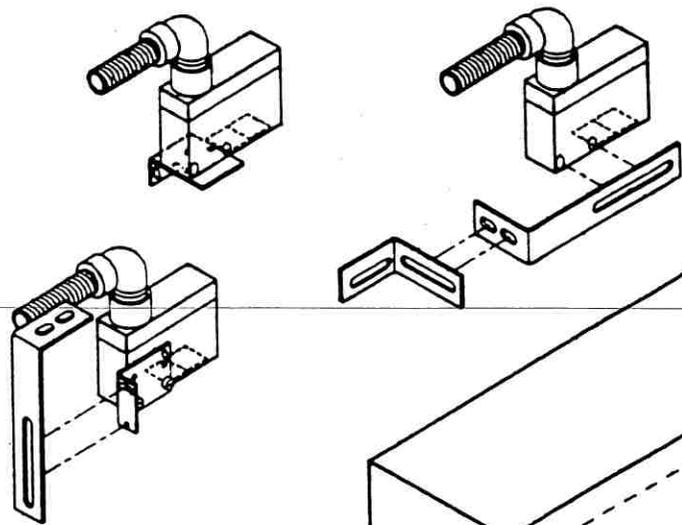
Monthly Maintenance:

- 1 - Check gear box oil level. If gear lubricant level is low add all purpose gear lube SAE 90.
- 2 - Locate the hole punched in the stainless steel conveyor drive chain cover and using a hand operated grease gun, shoot a small amount of #2 all purpose grease into the grease fitting (see #24 page 15). This lubricates the needle bearings that ride on the shaft.

NOTE: THIS APPLIANCE MUST BE CONNECTED TO A GROUNDED, METAL, PERMANENT WIRING SYSTEM; OR /

## STAC TROUBLE SHOOTING GUIDE

PROBLEM	LOOK FOR	CORRECTION
<p style="text-align: center;"><b>CONVEYOR MOTOR WILL NOT START</b></p>	<p>1) Circuit breaker not on.            2) Fuse blown.            3) Check circuit board.            4) Forward - Off - Reverse            5) Safety switch tripped to open position or faulty.            6) Tray against safety stop switch.               Check Start-Stop switch.</p>	<p>1) Find circuit breaker panel &amp; turn on circuit breaker.            2) Check reset fuse &amp; reset. Replace if necessary.            3) Replace if faulty.            4) Place switch in Forward position.            5) Check Safety switch - activating lever should be free.               Check switch - replace if necessary (see #5 page 28).            6) Check switch, replace if necessary (see #5 page 28).</p>
<p style="text-align: center;"><b>CONVEYOR JAMMED</b></p>	<p>1) Dolly wheel forced out of track.</p> <p><b>NOTE:</b> When placing the Forward-Off-Reverse switch in the reverse position you will have to physically reverse the conveyor. The reverse position will run the motor and chain drive only in reverse. The pawls will not lock into the chain.            This is a safety feature built-in to prevent damage to the dolly, wheel, or track when the track is obstructed.</p>	<p>1) Return dolly to installation point - labeled "INSTALL. OR REMOVE DOLLIES HERE". You may have to disconnect the dolly by removing the two connecting links in order to free up the dolly and physically move the dolly to the installation point on the conveyor.  <b>NOTE: "DO NOT FORCE THE DOLLY WHEEL(S) INTO THE TRACK WITH A CROW BAR OR ANY OTHER FORCING BAR"</b> The use of a forcing bar will bend the track dolly frame, or wheels and compound the track jumping problem.            Be sure to look for &amp; remove any obstruction that caused the dolly to jump the track.</p>
<p style="text-align: center;"><b>CONVEYOR DRIVE MOTOR TRIPPING OUT ON OVERLOAD</b></p>	<p>1) Dolly wheels dragging.            2) Dolly wheels not lubricated.            3) Conveyor running at maximum speed.            4) Check wiring.</p>	<p>1) Clean track of any tacky substance that may have been spilled, causing a drag on the dolly wheels.            2) Lube dolly wheels - use WD-40 or equal.            3) Reduce speed so dollies will travel 5 to 10 feet per minute.            4) Re-check wiring for shorts and shorts to ground.</p>



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**THE STERO COMPANY**



3200 LAKEVILLE HWY.  
 PETALUMA, CA. 94954

PHONE: 707 762-0071  
 FAX: 707 762-5036

TITLE: PHOTO ELECTRIC EYE RECOMMENDED INSTALLATION STAC-ACCUMULATOR	MATERIAL:	REVISION:
	DIM. TOL.	SHEET: OF:
DRAWN BY: J.M. DATE: 8/7/92	SCALE: NONE	PRT. NO.
		DWG. NO. A20-1249

1/4-20x1/2"  
FLATHEAD SCREW  
NYLOCK NUT

NOTE: SEAL TABLE JOINT  
AND ALL SCREW HOLES  
W/PERMAGUM STRIP SUPPLIED  
TO ENSURE A TIGHT SEAL

1/4-20x1/2"  
ROUND HEAD SCREW  
NYLOCK NUT

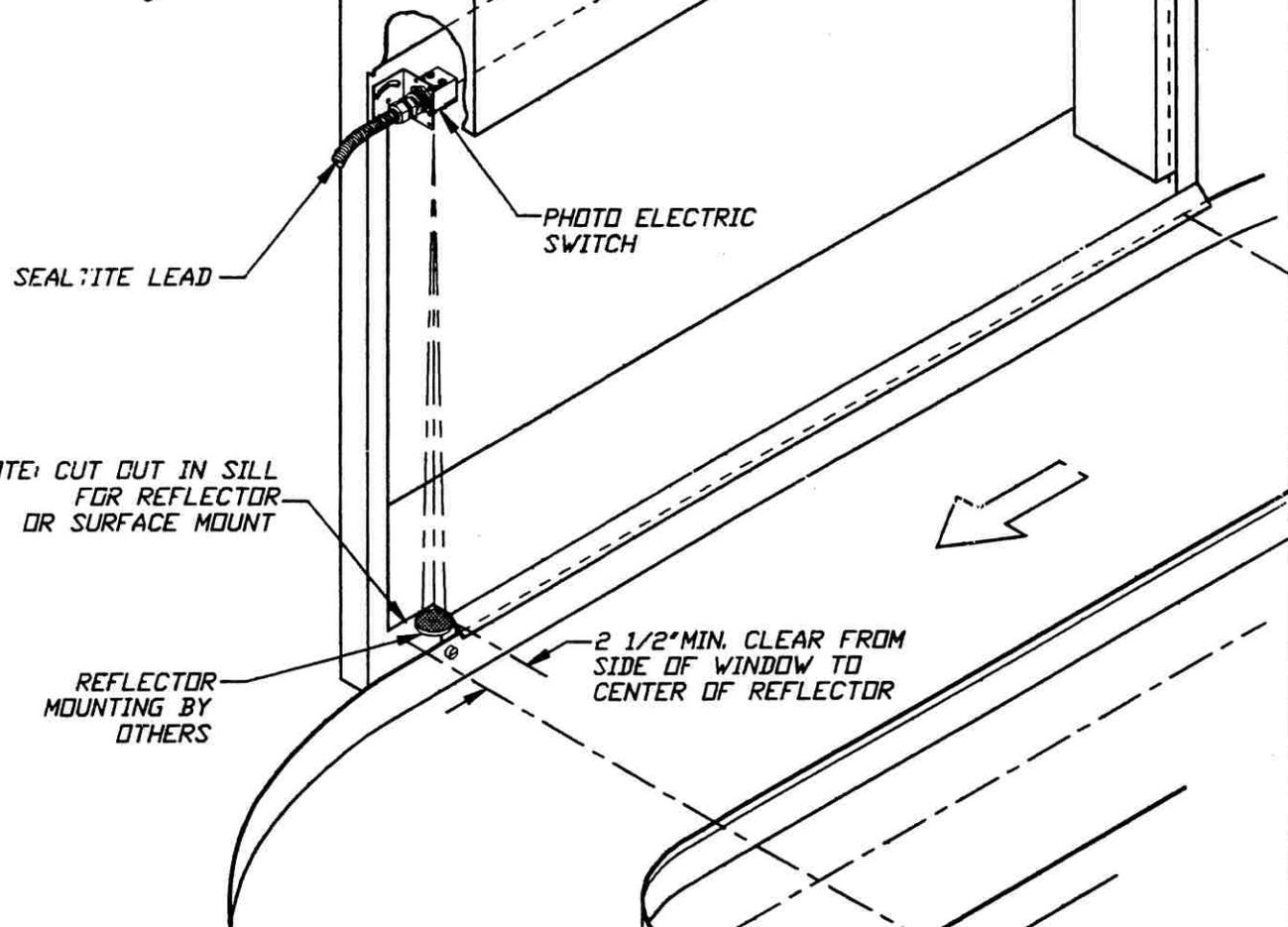
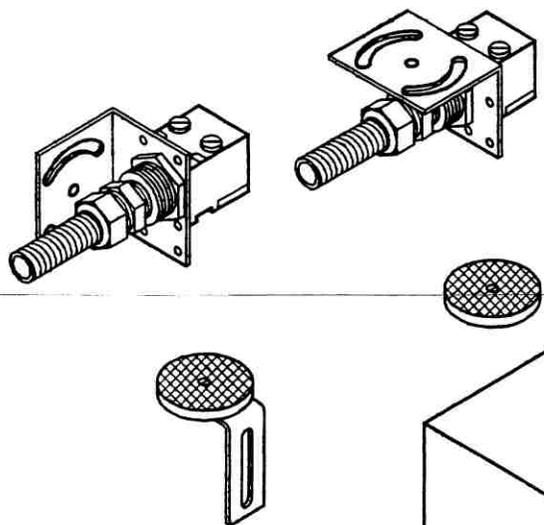
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3200 LAKEVILLE HWY. PHONE: 707 782-0071  
PETALUMA, CA. 94954 FAX: 707 782-5036

**THE STERO COMPANY**

TITLE: COMMON TABLE SEALED JOINT SOLID TABLE STAC LEG ASSY.	MATERIAL: STAIN. STEEL	REVISION:
	DIM. TOL.	SHEET: OF:
DRAWN BY: J.M. DATE: 8/4/92	SCALE: NONE	PRT. NO.
		DWG. NO. A20-1248



SEAL-ITE LEAD

PHOTO ELECTRIC SWITCH

NOTE: CUT OUT IN SILL FOR REFLECTOR OR SURFACE MOUNT

REFLECTOR MOUNTING BY OTHERS

2 1/2" MIN. CLEAR FROM SIDE OF WINDOW TO CENTER OF REFLECTOR

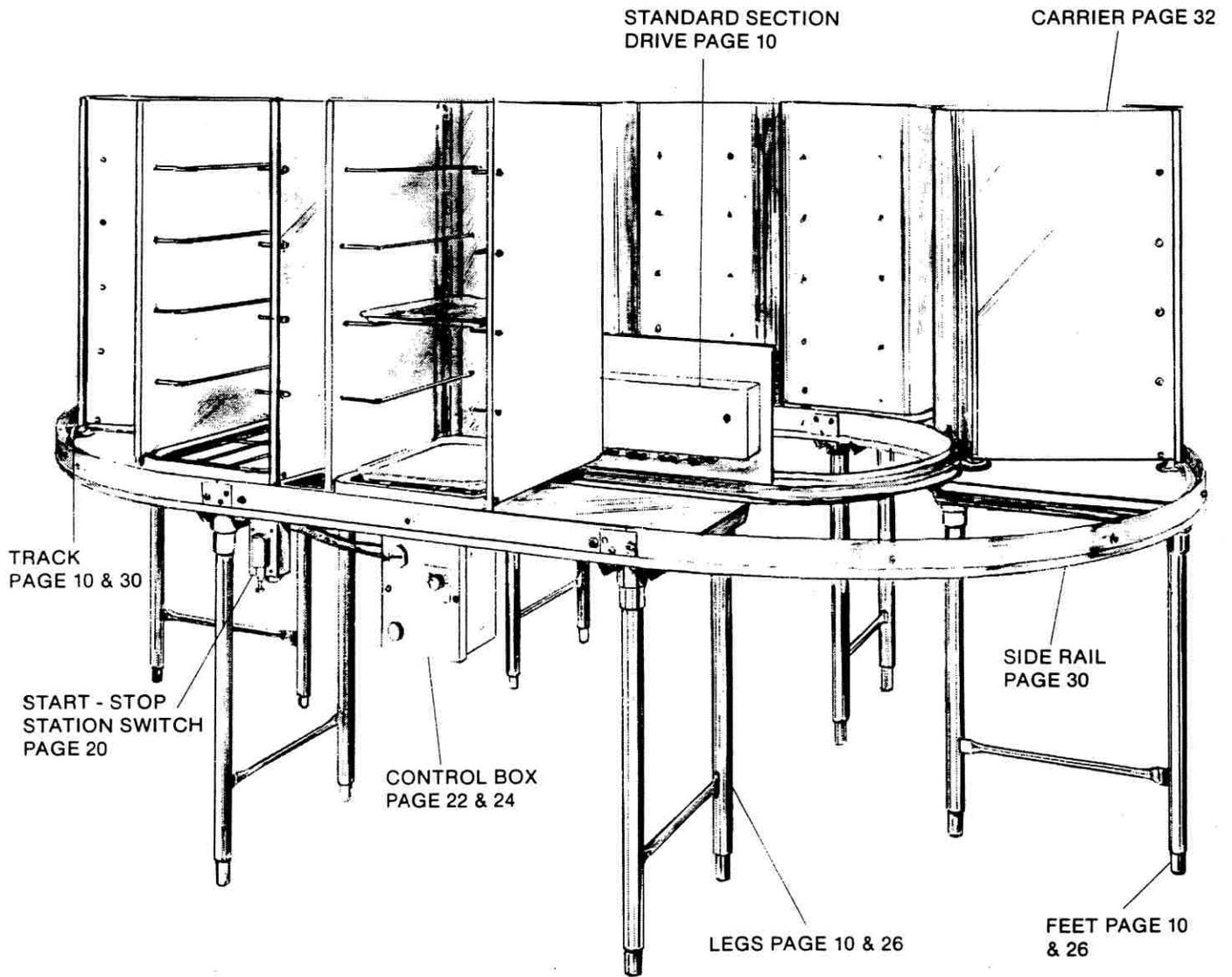
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**THE STERO COMPANY**



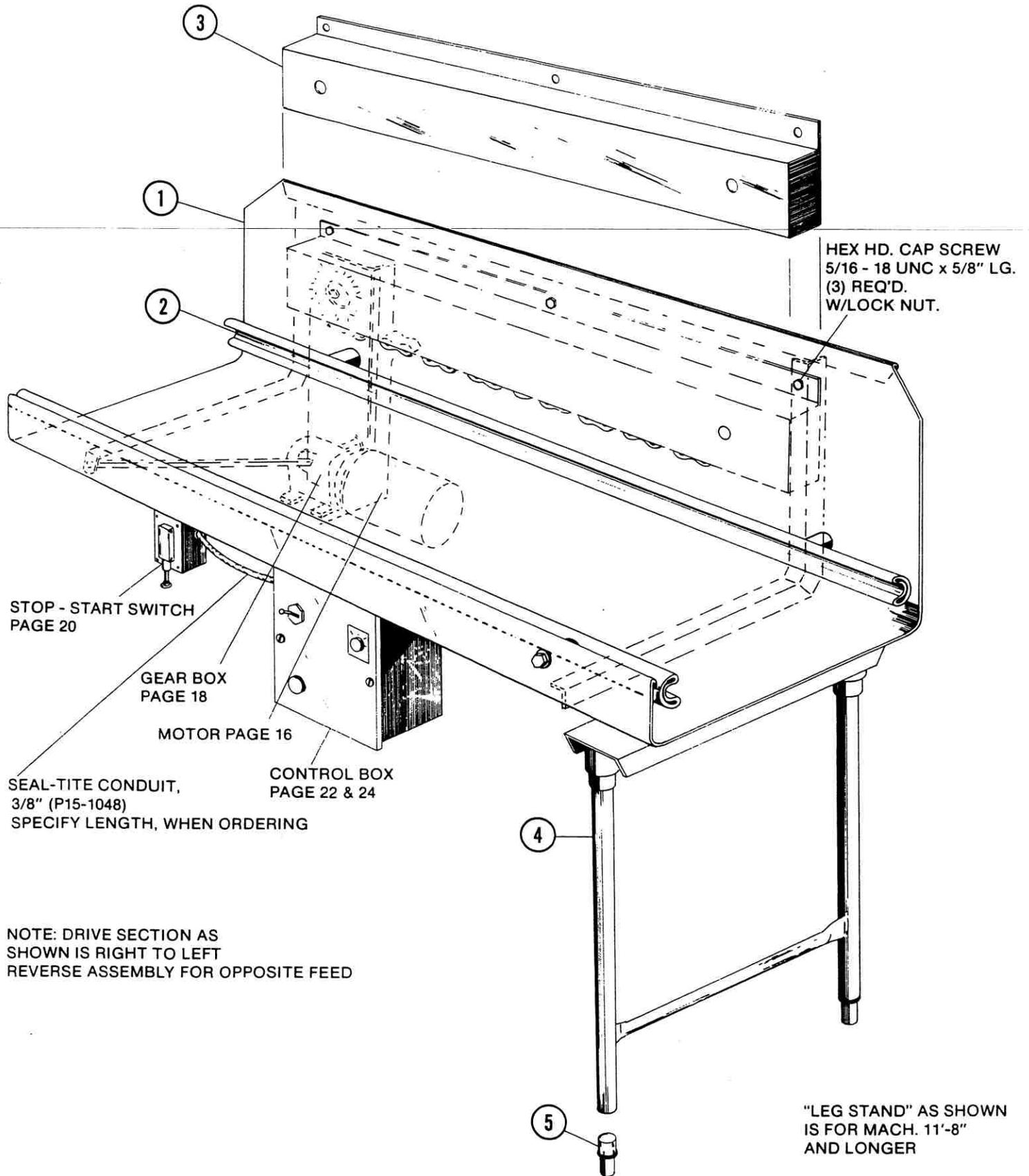
3200 LAKEVILLE HWY. PHONE: 707 762-0071  
 PETALUMA, CA. 94954 FAX: 707 762-5036

TITLE: PHOTO ELECTRIC EYE RECOMMENDED INSTALLATION STAC-ACCUMULATOR	MATERIAL:	REVISION: A 12/31/92 CHANGED PHOTO-EYE
	DIM. TOL.	SHEET: OF:
DRAWN BY: J.M. DATE: 8/7/92	SCALE: NONE	PRT. NO. DWG. NO. A20-1249A



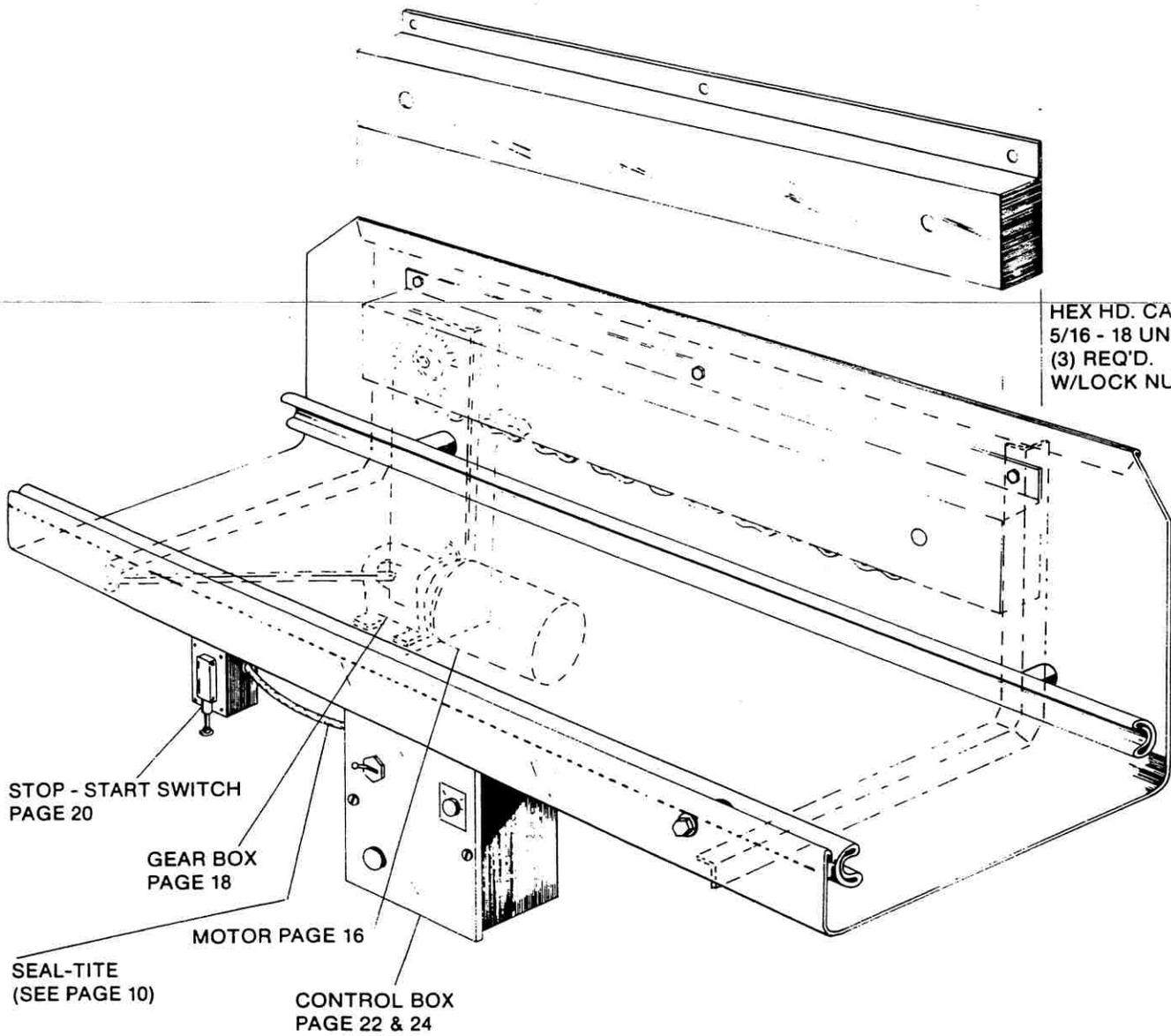
NOTE: INTER-WIRING I.E. BOX TO MOTOR, TO SWITCHES USE  
3/8" SEAL-TITE: STERO N° P15-1048.  
SWITCHES ARE LOCATED TO CUSTOMERS REQUIRE-  
MENTS THEREFORE SPECIFY SEAL-TITE LENGTH  
IF REPLACEMENT IS ORDERED.

GENERAL ASSEMBLY  
(Clockwise Rotation Shown)



## STAC STANDARD DRIVE SECTION





NOTE: DRIVE SECTION, AS SHOWN, IS  
RIGHT TO LEFT, REVERSE ASSEMBLY  
FOR OPPOSITE FEED DIRECTION

**STAC SPECIAL DRIVE SECTION  
38" LONG FOR 9'-8" MACHINE**



CONVEYOR CHAIN ADJUST. SCREW  
HEX HD. CAP SCREW  
5/16-18 UNC x 2 1/4" LG.

FLAT HD. CAP SCREW  
5/16-18 UNC x 3/4" LONG  
(2) REQ'D.

SEE PAGE 10  
+ CHECK MACHINE FEED  
LENGTH FOR PART #

1/2 I.D. WASHER

1/2 I.D. FLAT STEEL  
WASHER

1/2 I.D.  
WASHER

1/4 - 20 NUT -  
LOCKWASHER

1/4 - 20 UNC  
7/8" LG.

5/16-18 UNC  
HEX HD. CAP SCREW  
W/LOCKWASH.

(4) PAN. HD. SCREW  
1/4-20 UNC x 1/2"

3/4" FLATWASHER

3/8" FLATWASHER

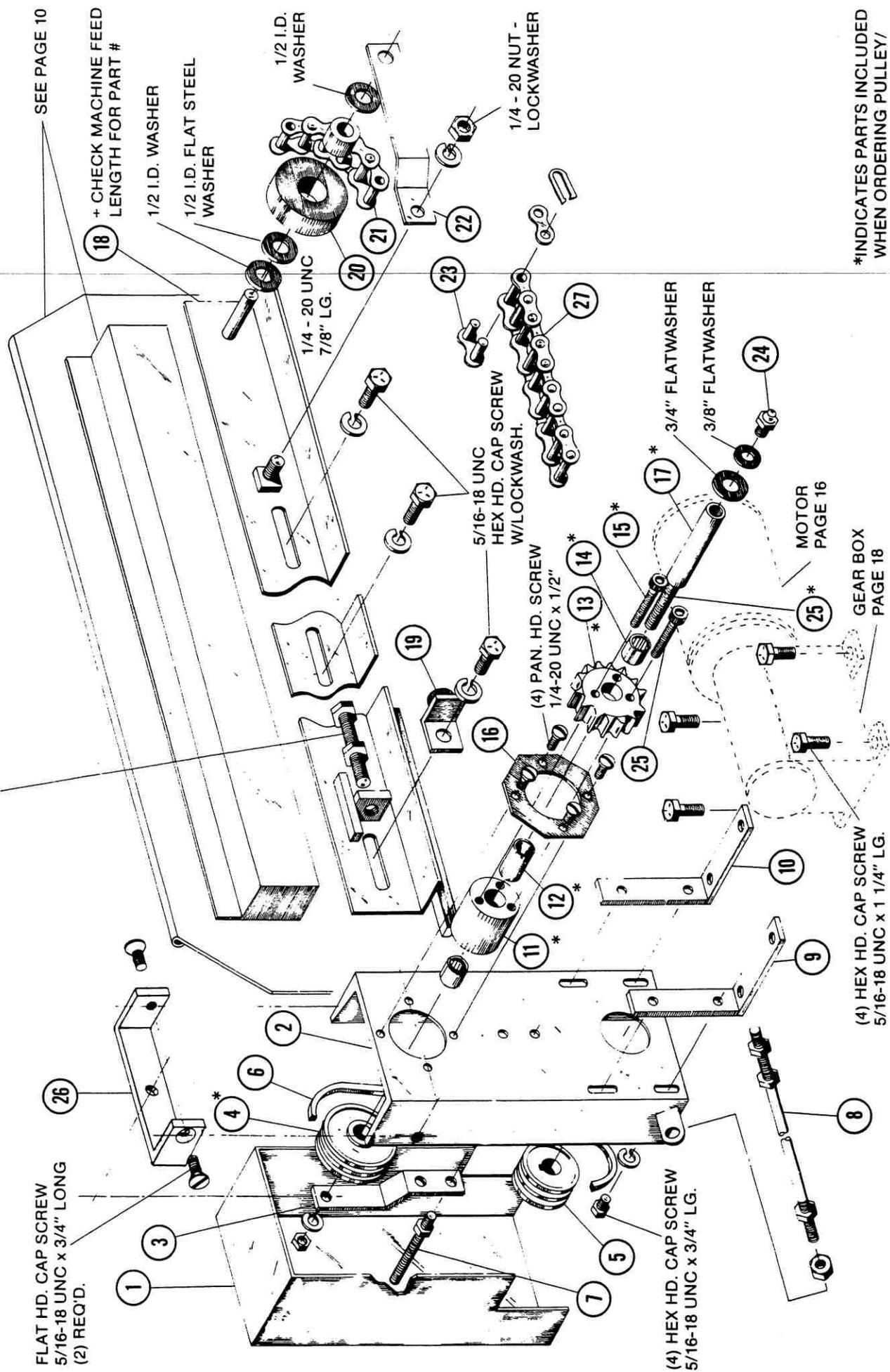
MOTOR  
PAGE 16

GEAR BOX  
PAGE 18

(4) HEX HD. CAP SCREW  
5/16-18 UNC x 1 1/4" LG.

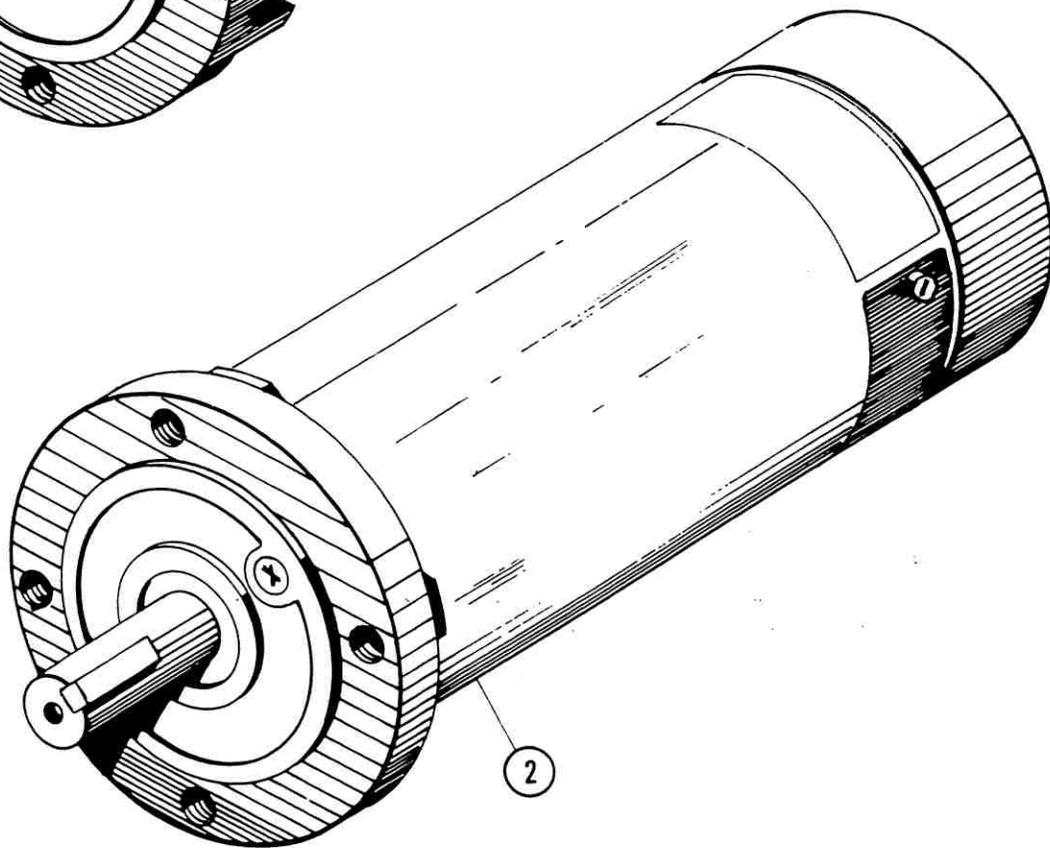
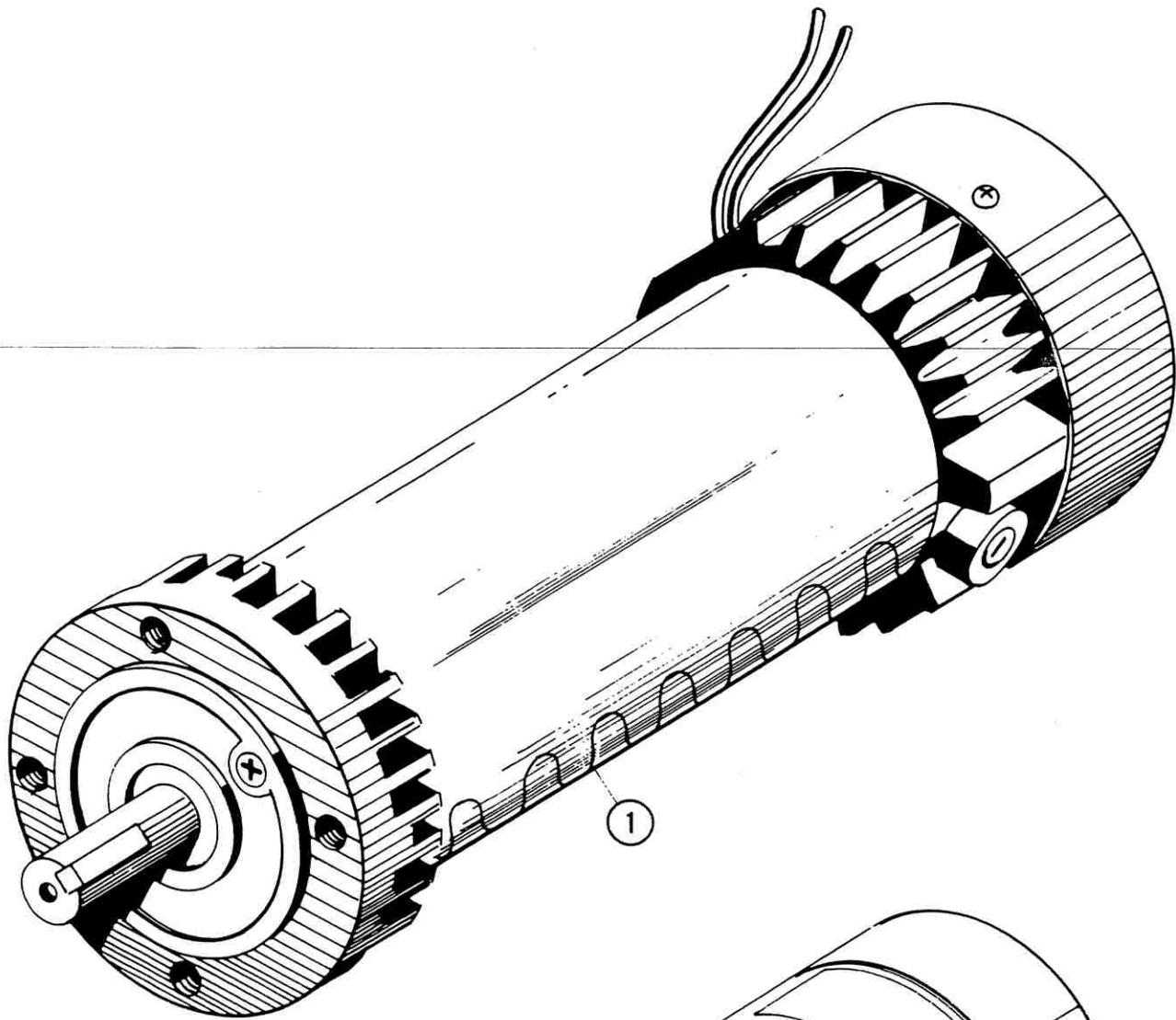
# CONVEYOR DRIVE ASSEMBLY

\*INDICATES PARTS INCLUDED  
WHEN ORDERING PULLEY/  
SPROCKET ASSEMBLY



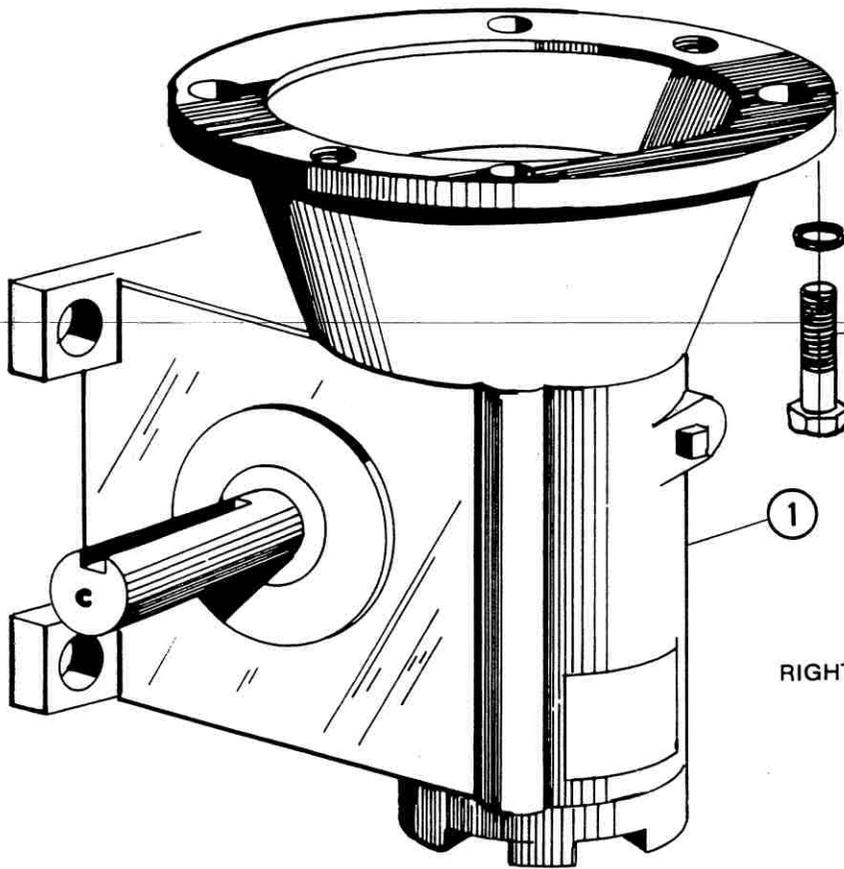
# CONVEYOR DRIVE ASSEMBLY

ITEM NO.	DESCRIPTION	REMARKS	PART NO.
1	"V" BELT COVER		B10-1653
2	MOUNTING FRAME		B10-1654
3	PULLEY BRACKET		A10-1655
4	DRIVEN PULLEY		A10-1848
5	DRIVE PULLEY		P15-1210
6	V BELT	2 REQ'D	P15-1287
7	COVER BOLT		A10-1656
8	BRACE W/LOCKWASHERS & NUTS		A10-1657
9	MOTOR MOUNT BRACKET	RIGHT HAND	A10-1658
10	MOTOR MOUNT BRACKET	LEFT HAND	A10-1779
11	SPROCKET ADAPTER		A10-1075
12	SPACER BUSHING		P15-1211
13	SPROCKET		B10-1327
14	NEEDLE BEARING	2 REQ'D	P15-1208
15	ALLEN HEAD CAPSCREW	3 REQ'D	P15-1212
16	PHENOLITE SHIELD		B10-1688
17	DRIVE SHAFT		A10-1766
18	CHAIN MOUNT. PLATE: 50" SECT.	CLOCK	B10-1791
18	CHAIN MOUNT. PLATE: 50" SECT.	COUNTERCLOCK	B10-1792
18	CHAIN MOUNT. PLATE: 38" SECT.	CLOCK	B10-1793
18	CHAIN MOUNT. PLATE: 38" SECT.	COUNTERCLOCK	B10-1794
19	ADJUSTING LUG		A10-1692
20	IDLER WHEEL		A10-1693
21	IDLER WHEEL BEARING		P15-1207
22	IDLER RETAINER		A10-1694
23	DRIVE CHAIN - MASTER LINK		P15-1220
24	GREASE FITTING		P15-1221
25	ALLEN HEAD SET SCREW		P15-1282
26	UPPER PULLEY BRACE		B10-1778
27	DRIVE CHAIN - 50" SECTION	84" LONG	A10-1851
27	DRIVE CHAIN - 38" SECTION	64" LONG	A10-1852
*	PULLEY/SPROCKET ASSEMBLY		B10-1846



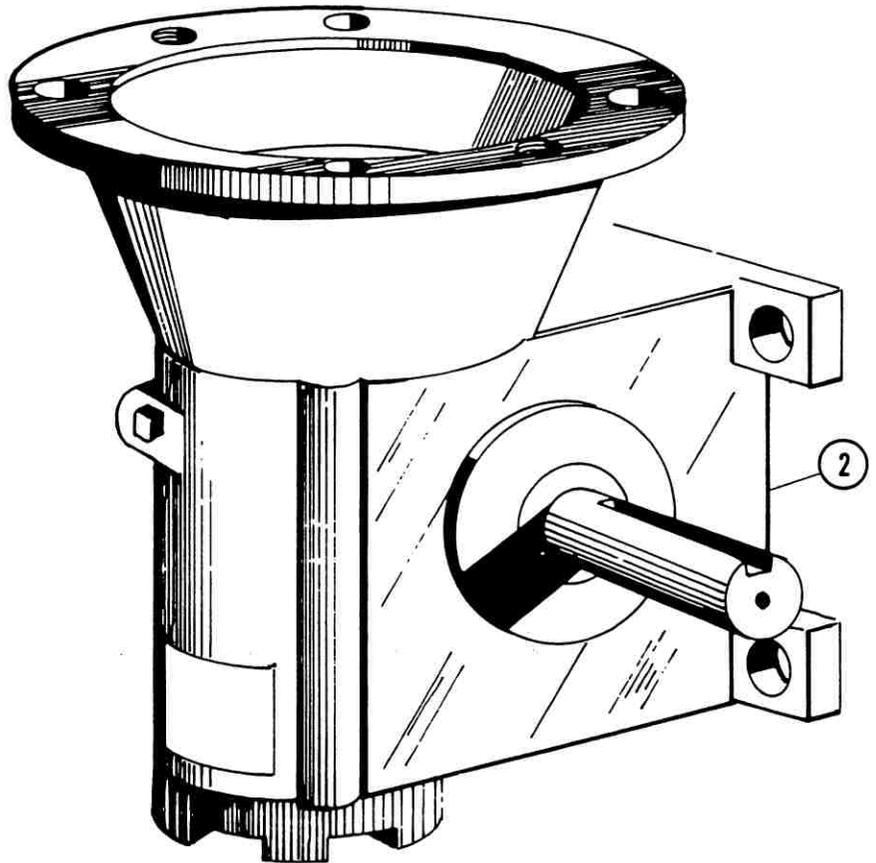
MOTOR IDENTIFICATION





HEX HD. CAP SCREW  
3/8" - 16 UNC x 1 3/4" LG.  
WITH LOCKWASHERS  
(4) REQ'D - TYP.

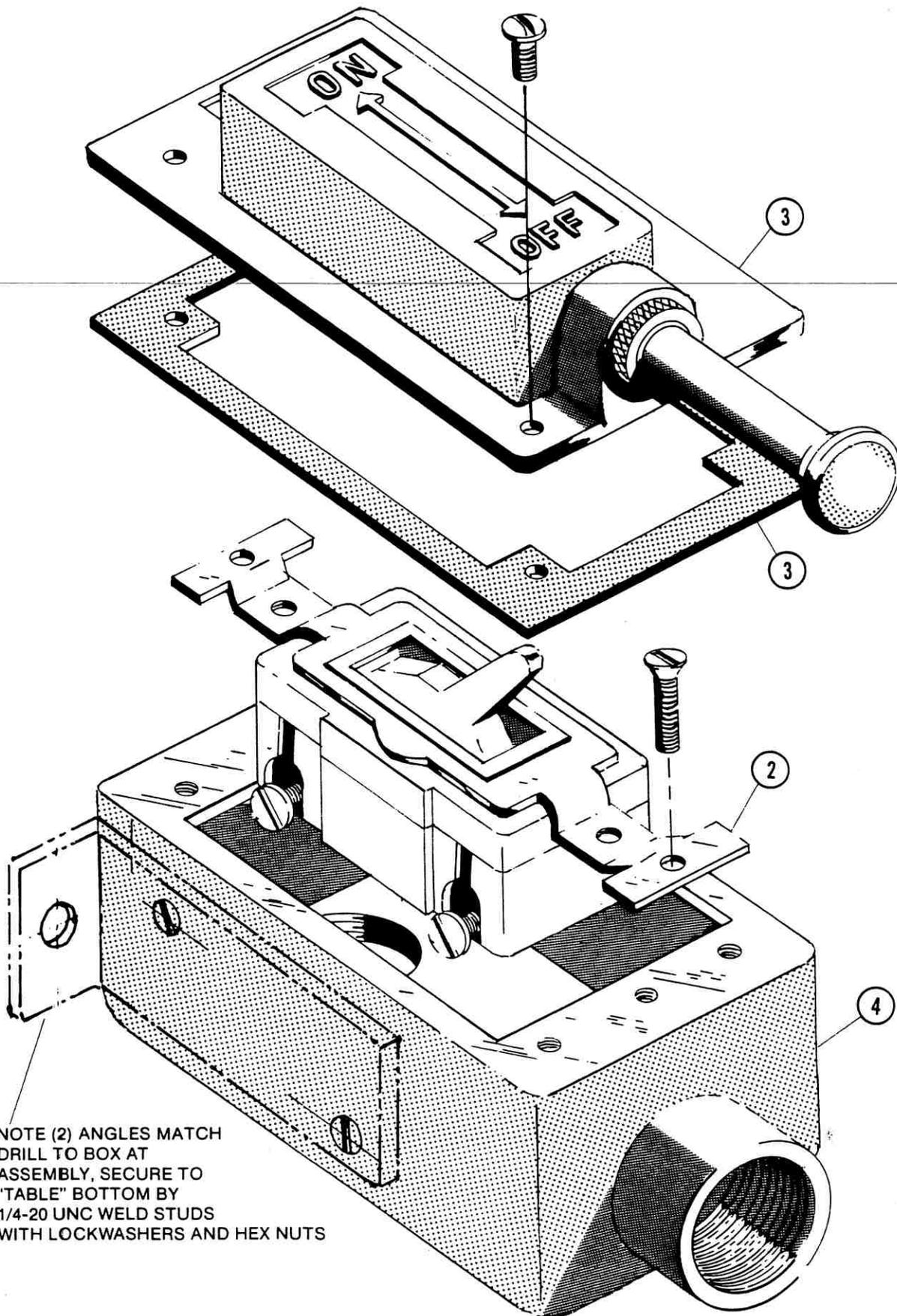
RIGHT HAND



LEFT HAND

### GEAR BOX ROTATION IDENTIFICATION





NOTE (2) ANGLES MATCH  
 DRILL TO BOX AT  
 ASSEMBLY, SECURE TO  
 "TABLE" BOTTOM BY  
 1/4-20 UNC WELD STUDS  
 WITH LOCKWASHERS AND HEX NUTS

STOP - START STATION SWITCH

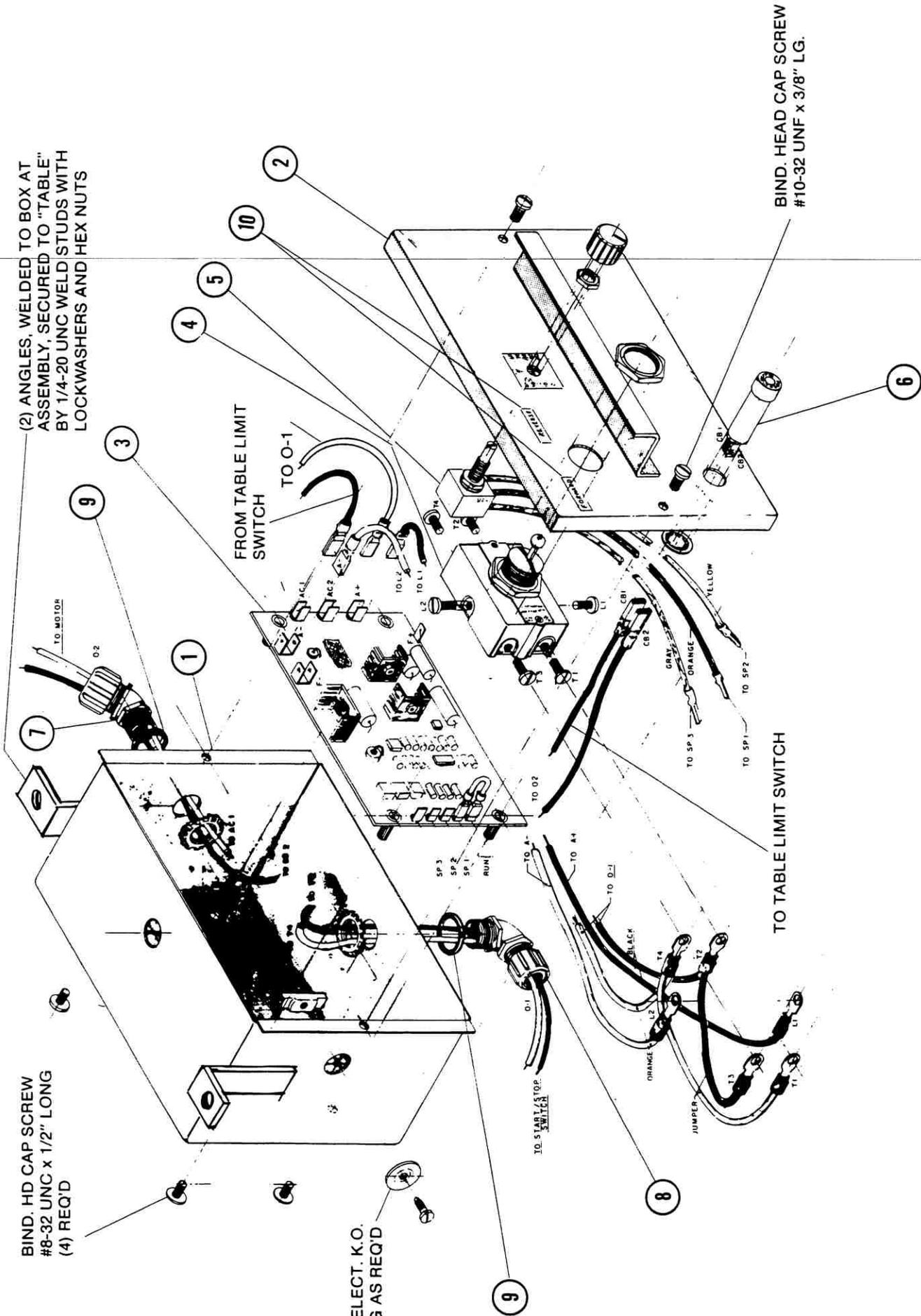


BIND. HD CAP SCREW  
#8-32 UNC x 1/2" LONG  
(4) REQ'D

(2) ANGLES, WELDED TO BOX AT  
ASSEMBLY, SECURED TO "TABLE"  
BY 1/4-20 UNC WELD STUDS WITH  
LOCKWASHERS AND HEX NUTS

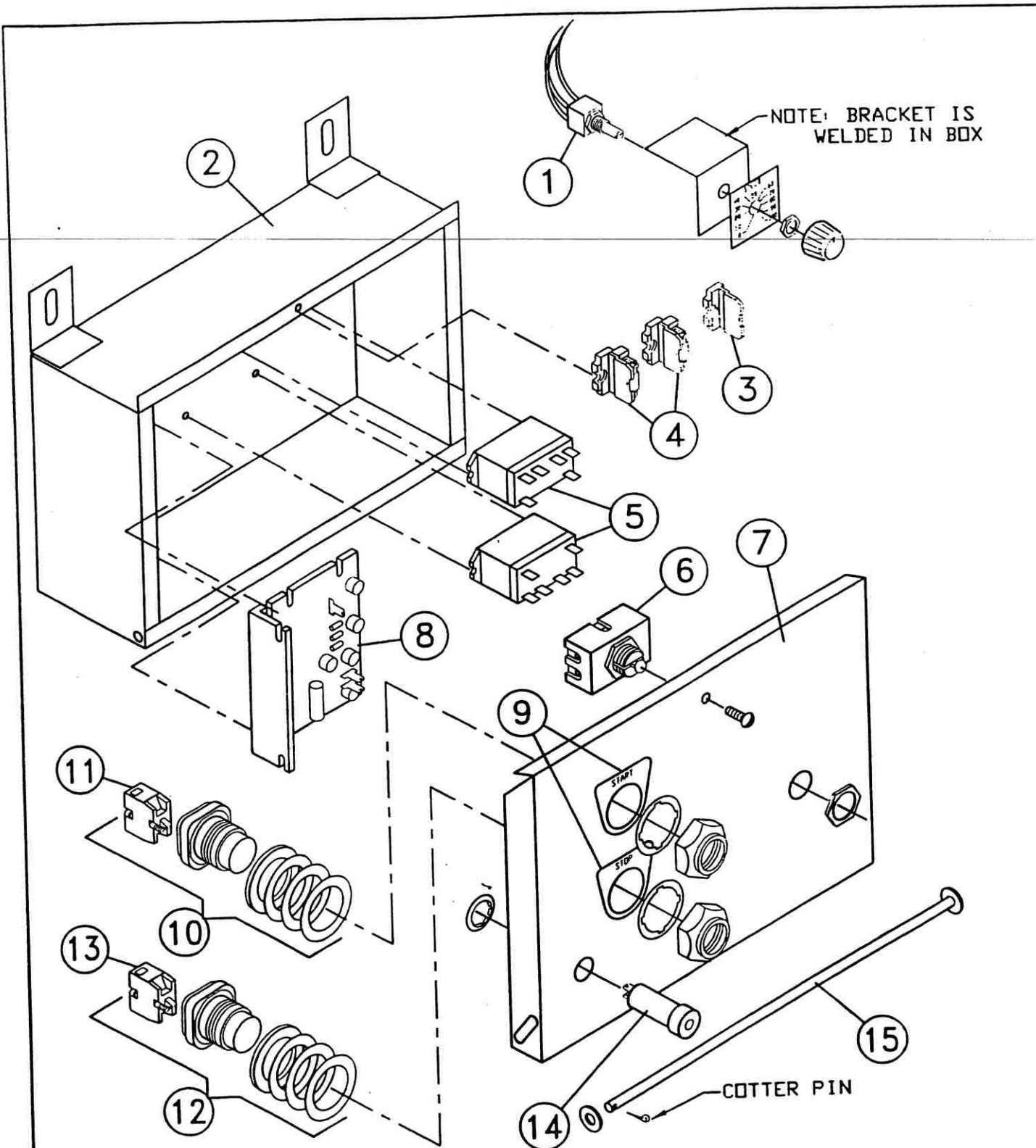
1/2" ELECT. K.O.  
PLUG AS REQ'D

BIND. HEAD CAP SCREW  
#10-32 UNF x 3/8" LG.



# CONVEYOR DRIVE - 1/2 HP CONTROL BOX ASSEMBLY





NOTE: BRACKET IS WELDED IN BOX

COTTER PIN

# THE STERO COMPANY

3200 LAKEVILLE HIGHWAY PHONE: (707)762-0071  
 PETALUMA, CALIFORNIA 94954 FAX: (707)762-5036

TITLE: VARIABLE SPEED CONTROL BOX ASSY., REF. STAC TRAY ACCUMULATOR		
MATERIAL:		DIMENSION TOLERANCE: FRAC. ± 1/64" , DEC. ± .005"
DATE: 2/1/95	<small>PROPRIETARY AND CONFIDENTIAL DATA          THIS DOCUMENT MAY CONTAIN PROPRIETARY OR CONFIDENTIAL          DATA OF THE STERO COMPANY. NO DISCLOSURE IN PRODUCT-          ION OR USE OF ANY PART THEREOF MAY BE MADE WITHOUT          WRITTEN PERMISSION OF THE STERO COMPANY.</small>	SCALE: NONE
DRAWN BY: J.M.		SHEET # 1 OF 2
		PART #
		DRAW. # A20-1340



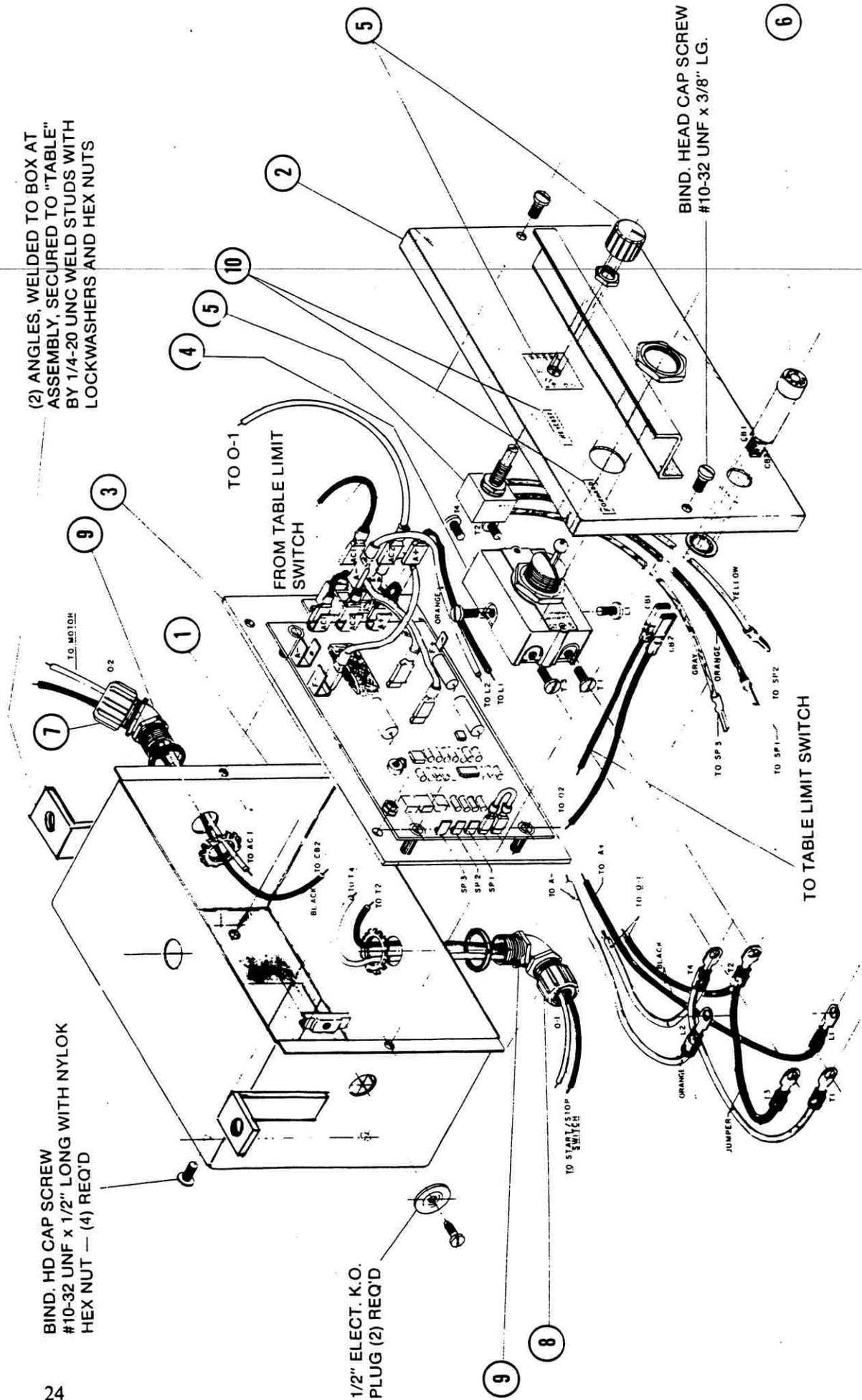
BIND. HD CAP SCREW  
#10-32 UNF x 1/2" LONG WITH NYLOK  
HEX NUT - (4) REQ'D

1/2" ELECT. K.O.  
PLUG (2) REQ'D

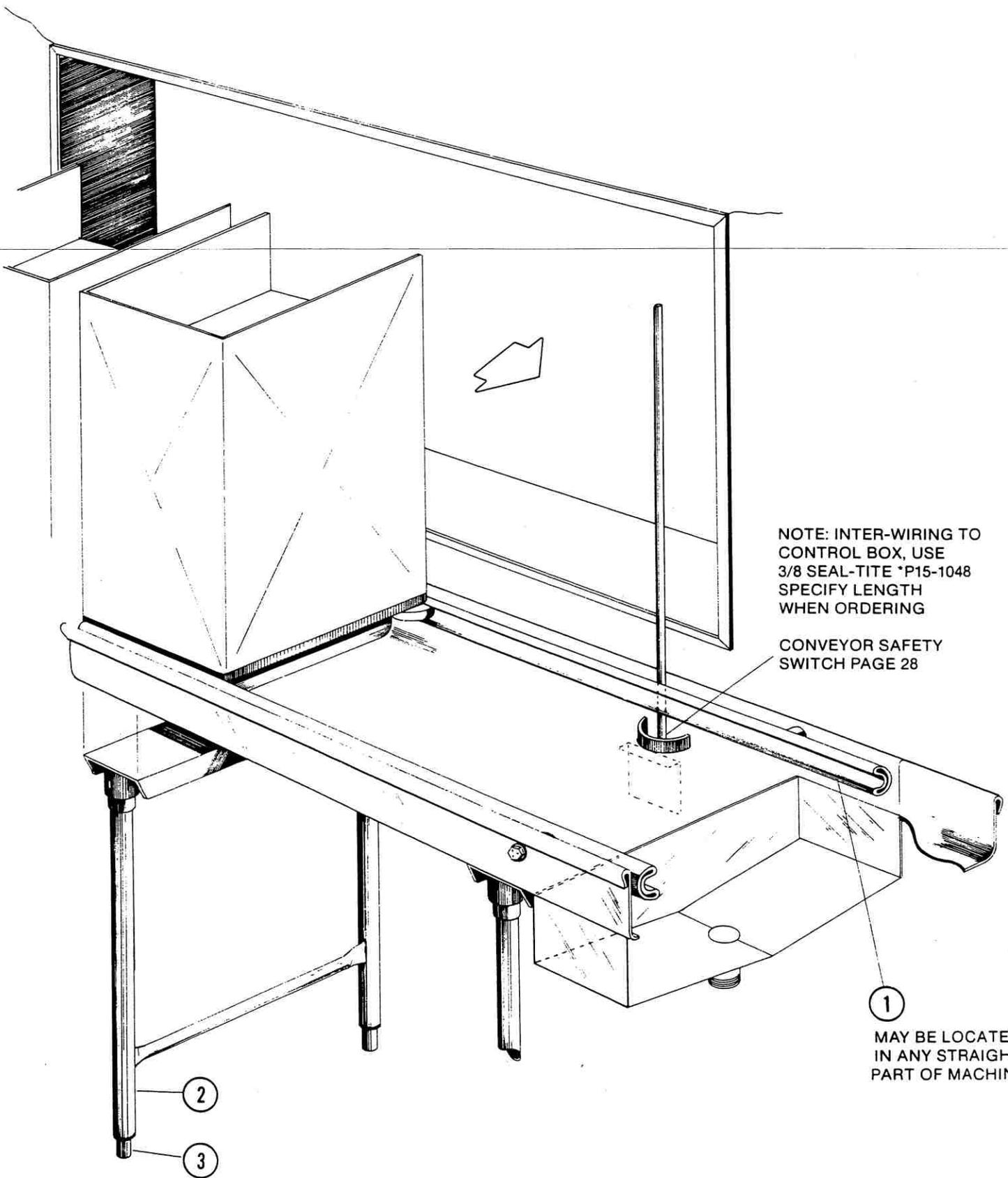
(2) ANGLES, WELDED TO BOX AT  
ASSEMBLY, SECURED TO "TABLE"  
BY 1/4"-20 UNC WELD STUDS WITH  
LOCKWASHERS AND HEX NUTS

BIND. HEAD CAP SCREW  
#10-32 UNF x 3/8" LG.

# CONVEYOR DRIVE - 1 HP CONTROL BOX ASSEMBLY

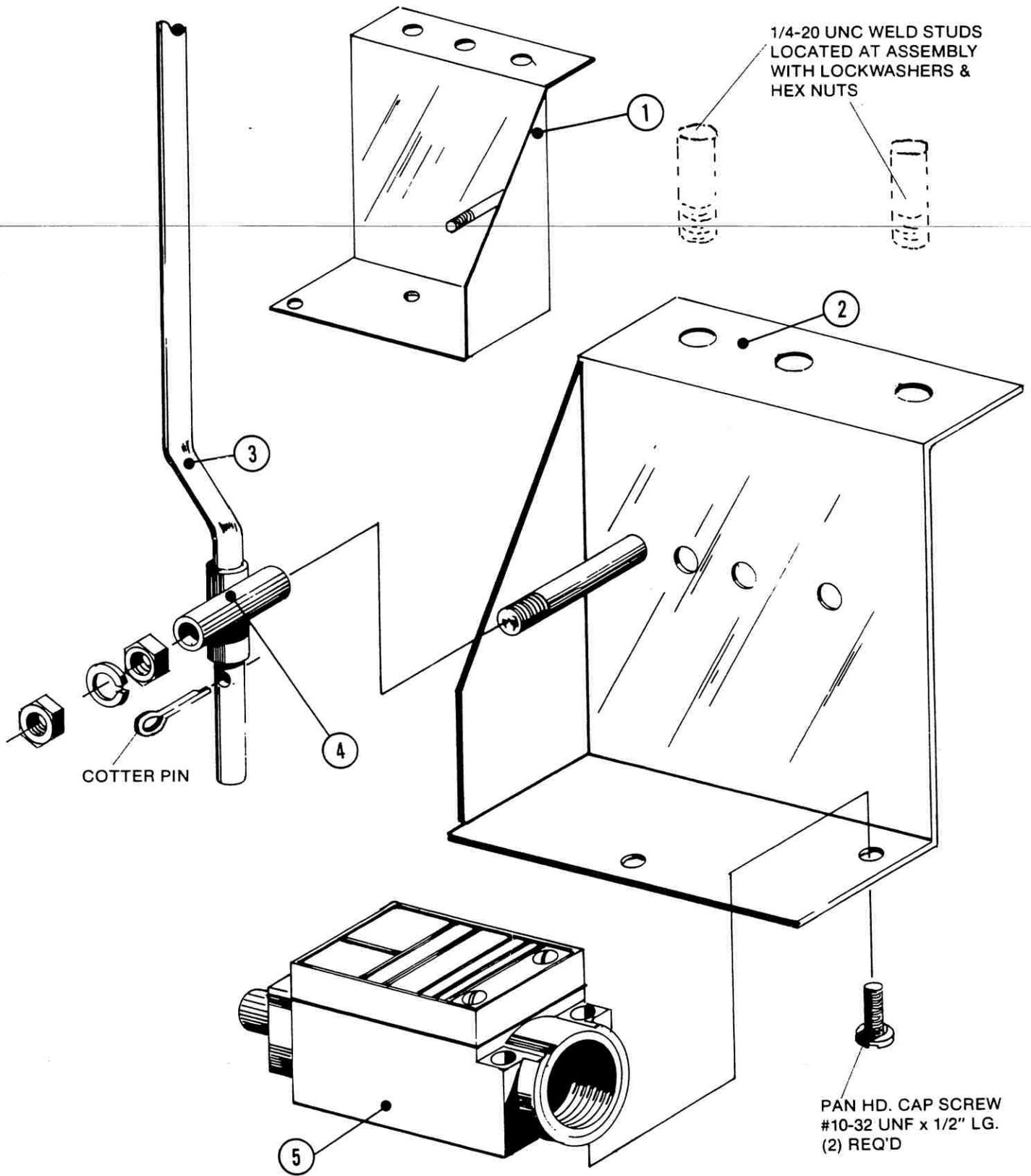






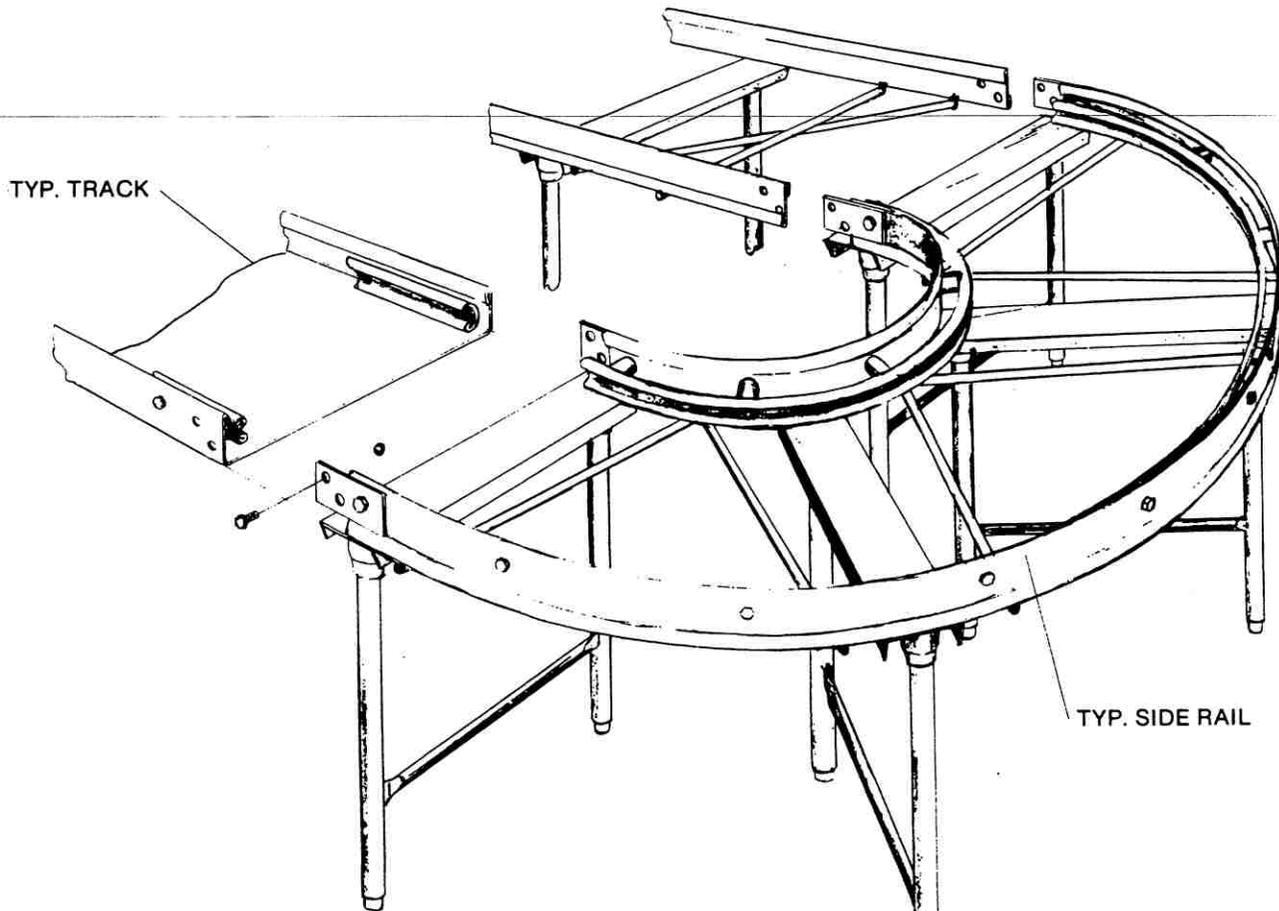
TYP. PASS THRU WINDOW WITH SAFETY SWITCH LOCATION



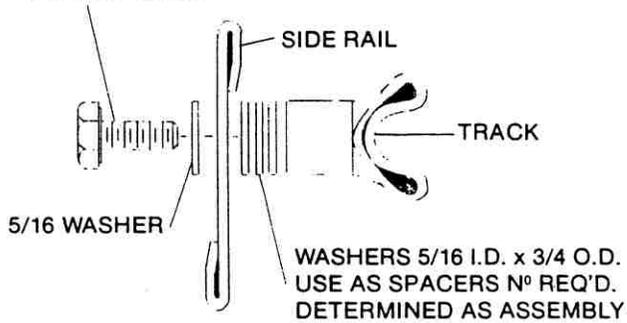


CONVEYOR SAFETY SWITCH





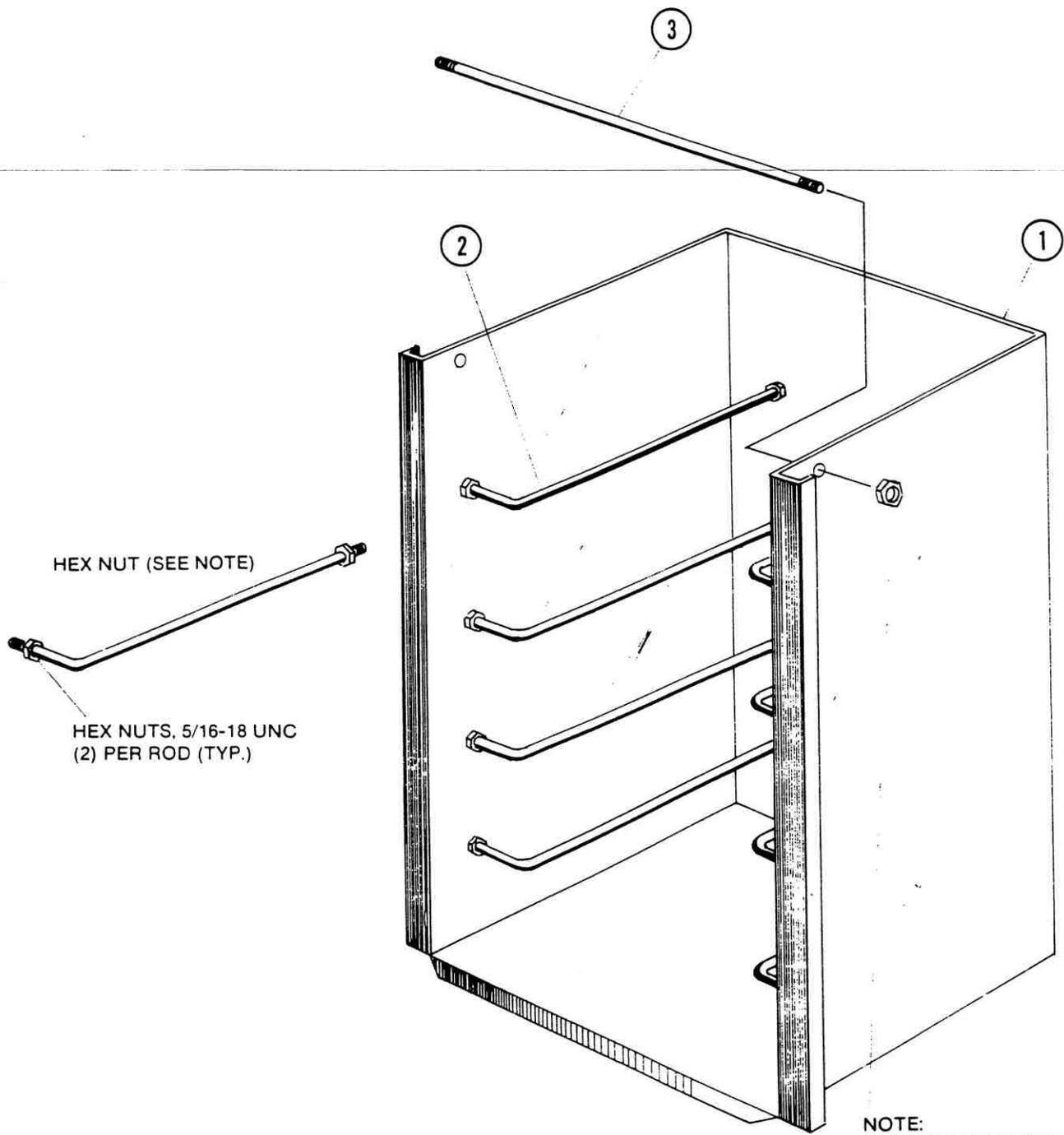
5/16-18 UNC HEX HD. CAP SCREW  
LTH AS REQ'D.



TYP. MOUNTING  
TRACK TO SIDE

## CURVED SECTION





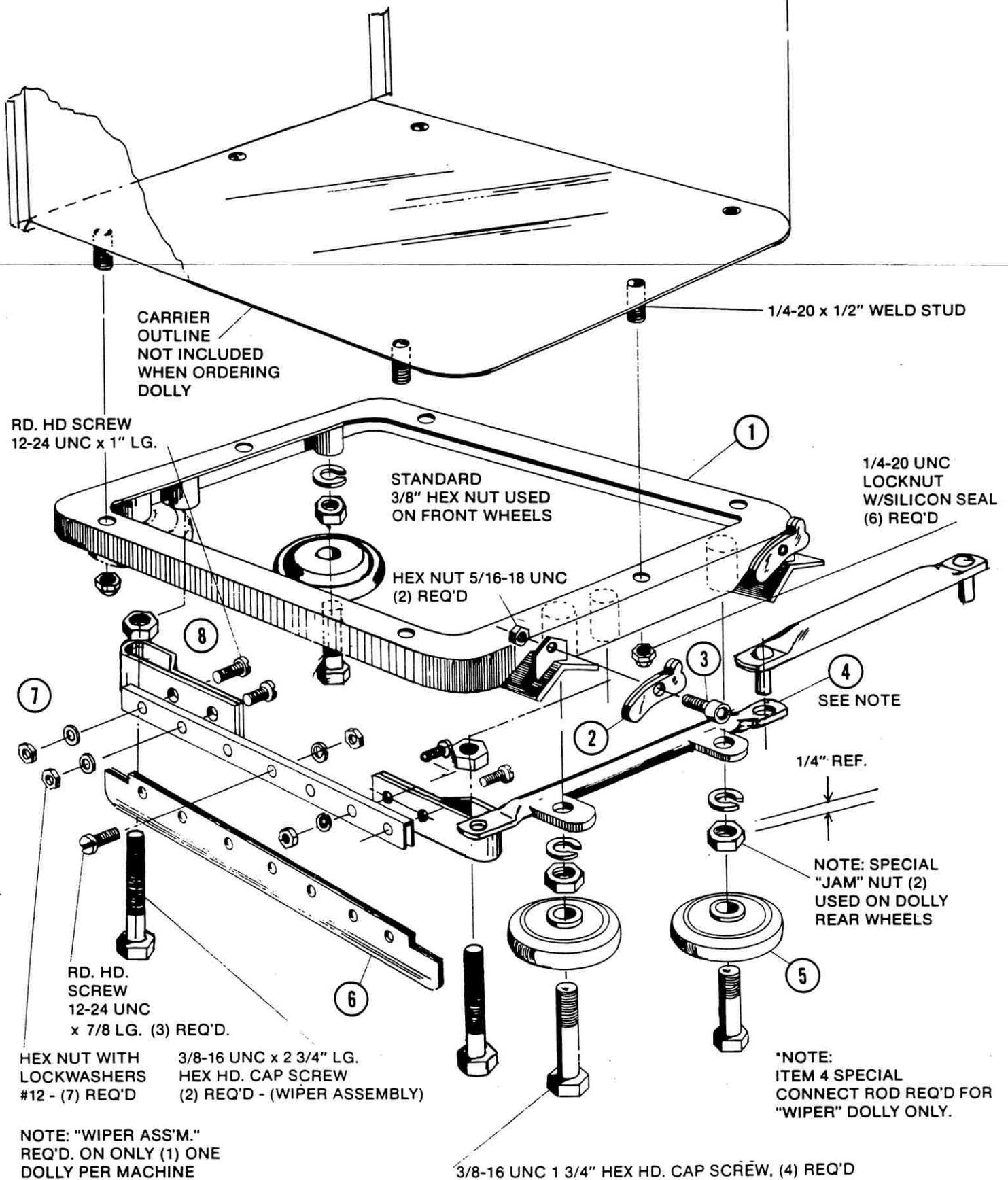
HEX NUT (SEE NOTE)

HEX NUTS, 5/16-18 UNC  
(2) PER ROD (TYP.)

NOTE:  
HEX "NYLOK" NUTS  
5/16-18 UNC ASSEMBLY  
WITH SILICON RUBBER  
AFTER INSTALLATION  
TYP. ALL "RODS"  
(18 REQ'D)

### DISH RACK CARRIER

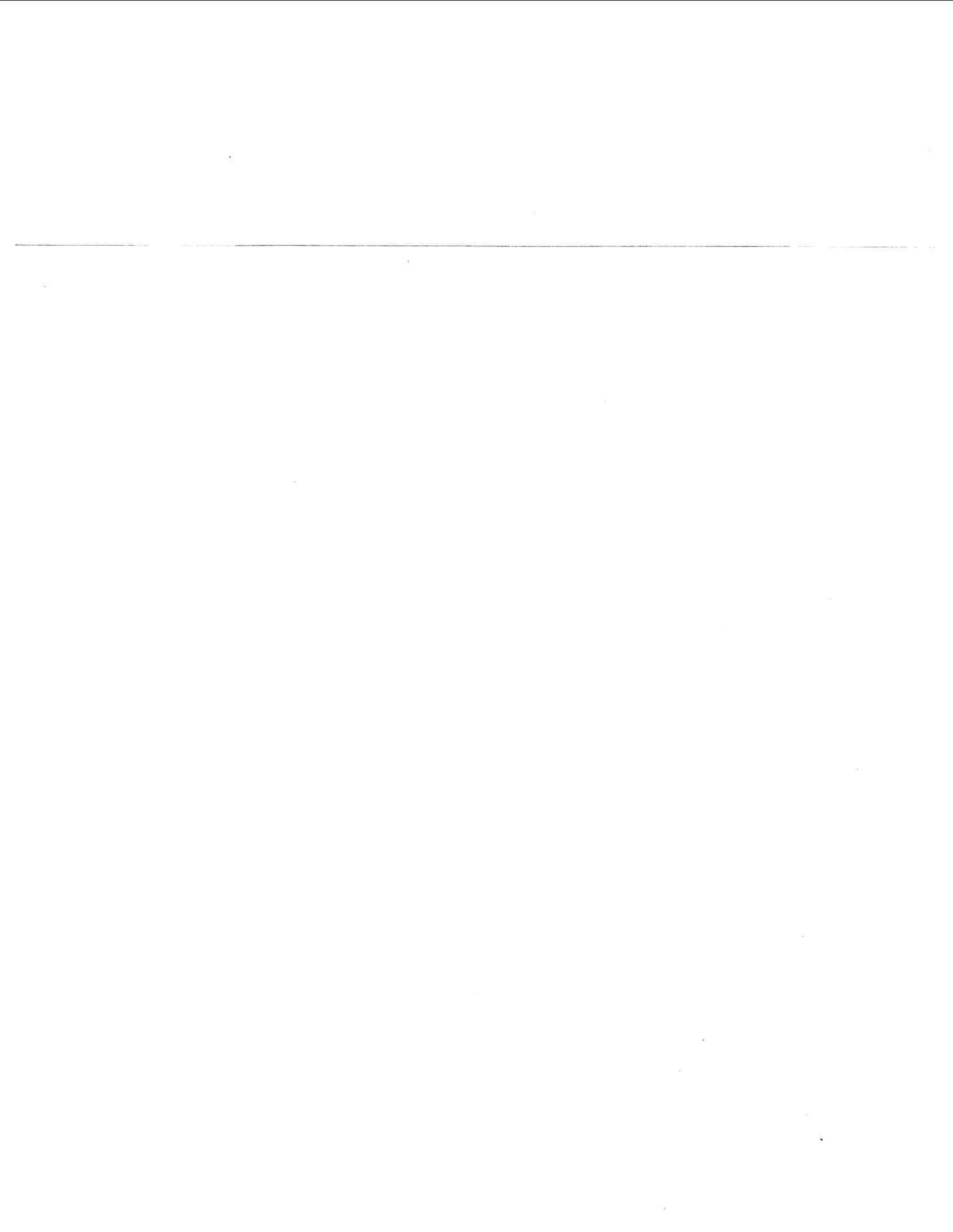




## TYPICAL DOLLY ASSEMBLY









The Stero Company  
3200 Lakeville Highway  
Petaluma, CA 94954

(800) 762-7600

Toll free to Parts & Service  
(877) 762-3200