



## K00019 STACKING KIT E-1100 & G-1700

### Installation Instructions

Parts List:

| <u>Item</u> | <u>Description</u>                                       | <u>Quantity</u> | <u>Part Number</u> |
|-------------|--|-----------------|--------------------|
| 1.          | Lower Ice Chute Weldment (one with insulation)           | 2               | 6605514            |
| 2.          | Upper Ice Chute Weldment                                 | 2               | 6605414            |
| 3.          | Front Chute Support                                      | 1               | 6608614            |
| 4.          | Top Front Mounting Bracket                               | 1               | 6605614            |
| 5.          | Bottom Front Mounting Bracket                            | 1               | 6605714            |
| 6.          | Bottom Rear Mounting Bracket (Angle <math>\angle</math>) | 2               | 6213314            |
| 7.          | Top Rear Mounting Bracket (90° <math>\perp</math>)       | 2               | 6213214            |
| 8.          | Water Shield Weldment                                    | 1               | 6653414            |
| 9.          | Stabilizer Bracket                                       | 1               | 6611814            |
| 10.         | #10-32 x 1/2 Machine Screw                               | 1               | 5027021            |
| 11.         | 1/4-20 x 5/8 Hex Brass Machine Screw                     | 2               | 5031841            |
| 12.         | #10-24 x 5/8 Self-tapping Screw                          | 14              | 5202053            |
| 13.         | #10-24 x 3/8 Self-tapping Screw                          | 6               | 5202103            |
| 14.         | #10-32 Hex Nut   | 1               | 5429431            |
| 15.         | 1/4-20 Hex Nut   | 2               | 5429531            |
| 16.         | #8-32 Wing Nut   | 12              | 5489021            |
| 17.         | 1/4 Split Ring Lock Washer                               | 2               | 5545111            |
| 18.         | #10 Split Ring Lock Washer                               | 1               | 5573163            |
| 19.         | Installation Instructions                                | 1               | 8001953            |
| 20.         | Locking Plate  | 1               | 6236814            |
| 21.         | Foam Tape  | 250''           | 9202393            |
| 22.         | Corner Brace   | 1               | 6604714            |

Installation Instructions:

1. The K019 stacking kit is used for stacking two E-1100 machines, two G-1700 machines, or one E-1100 and one G-1700 machine. The bin must be leveled before proceeding to step 2.
2. INSTALLATION OF CORNER BRACE:
  - A. Remove foam tape, as shown on Illustration 1.
  - B. Remove seven screws on the top of the bin and locate corner brace, as shown in Illustration 1. Secure with seven screws previously removed.
  - C. Use foam tape from kit around the perimeter of corner brace, as shown in Illustration 1.
3. INSTALLATION OF MACHINES:
  - A. See service manual for uncrating and inspection of both machines.
  - B. Remove top cover from lower machine.
  - C. Set machine carefully and squarely on bin.
  - D. Position water shield from kit, as shown in Illustration 2. Apply foam tape on the perimeter and across partition panel, as shown in Illustration 2.
  - E. Set top machine carefully and squarely on bottom machine.
  - F. Remove front, back, and side panel on the evaporator end of both machines.

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## Installation Instructions (continued):

- G. Lock the two machines together. The front of the machines should be locked by using the locking plate. The locking plate is supplied with the kit and is 2 3/8" x 3" in size with three holes 7/32" in diameter. Three existing screws to be removed from machine cornerpost and locking plate applied. The rear of the machines should be locked by using the two 1/4-20 x 5/8" long bolts, lock washers, and hex nuts (supplied with kit). The bolts should be mounted into the 5/16" diameter holes in the bottom channel of the top machine and the top rail of the bottom machine.
- H. Remove curtain limiter brackets and/or ice deflector racks from the top machine. Remove curtain limiter brackets from the bottom machine. If the bottom machine is equipped with ice deflector racks, remove only the rear deflector.
4. INSTALLATION OF ICE CHUTES (BACK):
- A. Install upper ice chute in back of machine (upper ice chutes are identical) with lip of ice chute over the edge of the sump trough of the top machine.  
NOTE: Check to make sure the sump trough is centered below the evaporators. If not, adjust by loosening the wing nuts, which hold the sump trough to the machine base. Retighten after adjusting.
- B. Install the lower back ice chute (back chute has insulation) to upper ice chute with studs on upper chute going through slotted holes of lower chute.
- C. Fasten two top rear-mounting brackets with #10-24 x 5/8 self-tapping screws. Do not tighten down at this point.  
NOTE: The upper chute must be flexed in order to position the flange of the top chute into the inside of the lower chute.
- D. Position stabilizer bracket from kit over weldstuds of upper ice chute, as shown in Illustration 3.
- E. Secure the bottom of chute with the bottom back mounting brackets to base channel of lower machine with screws provided in kit.  
NOTE: After chutes, bracket, and support angles are in place, make final tightening up on screws and wing nuts.
- F. Check for free movement of water curtain.
5. INSTALLATION OF ICE CHUTES (FRONT):
- A. Install upper ice chute with lip on ice chute over the edge of the sump trough of the top machine.
- B. Attach top front mounting bracket to base channel of top machine using screws provided in kit. Do not tighten down at this point.
- C. Bring lower front chute up through bin opening and attach to upper chute with studs on upper chute going through slots on lower. Do not tighten down at this point.  
NOTE: The upper chute must be flexed in order to position the flange of the top chute inside the lower chute.
- D. Secure the bottom of chute with the bottom front mounting bracket to base channel of lower machine with screws provided in kit.
- E. Locate the support angle, as shown in Illustration 3 and secure with the nut and bolt from kit.  
NOTE: After chutes, brackets, and support angles are in place, make final tightening up on screws and wing nuts.
- F. Check for free movement of water curtain, both front and rear.
- G. Proceed to service manual for electrical and water hook-up and start-up procedure.
- H. Reattach front, rear, and side panels on both upper and lower ice machines.