



MARKET FORGE

MT 25/40/60 GALLON SERIES MODULAR BASE DIRECT STEAM TILTING KETTLES PARTS AND SERVICE MANUAL

EFFECTIVE OCTOBER 11, 2016

Superseding All Previous Parts Lists.

The Company reserves the right to make substitution in the event that items specified are not available.

ERRORS: Descriptive and/or typographic errors are subject to correction.

MARKET FORGE

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P/N 14-0324 Rev B

TABLE OF CONTENTS

ADJUSTMENTS	3
ILLUSTRATED PARTS LIST	
TILTING MECHANISM.....	4
KETTLE CABINET BASE	5
DRAIN ASSEMBLY.....	8
PISTON ASSEMBLY	9
VALVE AND FAUCET.....	10
CRANK SHAFT	11
VALVE ASSEMBLY.....	12
KETTLE JACKET ASSEMBLY.....	13
STEAM SUPPLY VALVE	14
SWING DRAIN.....	14
DRAW OFF VALVE.....	15
STEAM TRAP	16

ADJUSTMENTS

GENERAL INSPECTION & CLEANING

The screw assembly should run smoothly throughout the entire stroke. If operation is not uniform, remove the screw assembly and proceed as follows:

1. Inspect screw shaft for accumulation of foreign matter in the ball grooves.
2. Using cleaning fluid or solvent, remove dirt from ball grooves. Be sure to flush the ball nut assembly thoroughly.
3. Cycle the ball nut along the screw shaft several times. Then, wipe with a dry, lint less cloth and lubricate immediately.

CABINET EXTERIOR REMOVAL

Side and rear panels of all cabinets in which kettles are mounted are easily removed without the use of tools. Each panel is grasped at the bottom edge and lift up and out towards you to release it from the panel mounting brackets

Replacement is completed by pushing panel up under cabinet top allow hook to fall in place at the bottom until panel mounting brackets are engaged. Door may be removed to improve access to cabinet interior for repairs.

The two flat head screws and nuts holding cabinet hinge are removed and the door lifted out. When doors are re-mounted the final tightened position of hinge determines the alignment of the door and must be set with care.

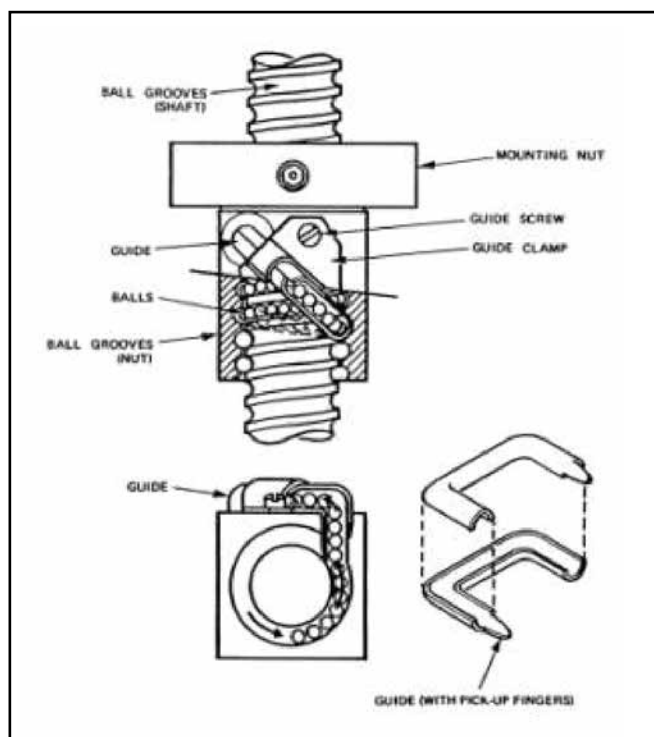
DRAW-OFF VALVE – COMMON LEAK REPAIRS

To repair a valve leak, the source must first be determined. Leaks from around the valve stem are corrected by replacing the rubber "O" ring. Dripping from the valve outlet which occurs with the valve tightly closed indicates faulty seating of the valve disc against the valve seat. Dripping is often corrected by cleaning residue from disc and seat using very fine emery.

DRAW-OFF VALVE – VALVE SEAT LAPPING

Should either the disc, or seat be found damaged it is necessary to either replace the entire valve or perform the lapping procedure as follows:

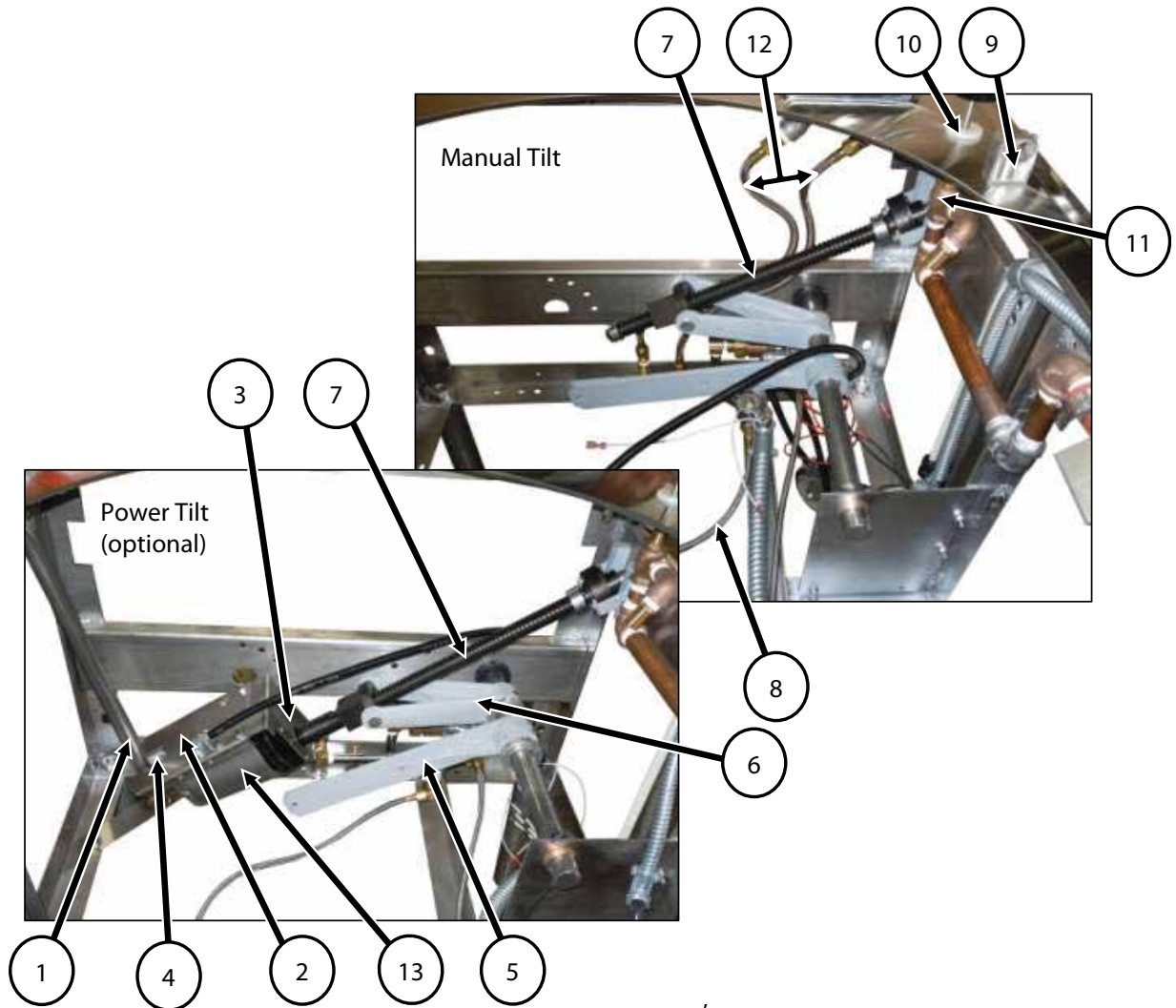
1. Disassemble the valve and clean both the disc and the valve seat.
2. Attach the handle to the stem with the valve bonnet removed.
3. Apply a good grade of fine lapping compound to the disc and insert it into the valve to make light contact against the seat.
4. Rotate the stem disc against the seat by turning the handle, allowing the stem to wobble in the space the bonnet would normally occupy. Continue with light pressure until compound dries.
5. Reassemble and test for leaks with valve closed. If dripping occurs repeat the lapping procedure as many times as required to obtain a watertight seal.



REPAIR & REPLACEMENT

In the event that the kettle fails to operate correctly, the difficulty should first be isolated to either the kettle itself or the steam supply which heats the kettle. While mechanical problems are obvious faults of the kettle, any deficiencies in volume and pressure of steam should be traced to the steam generator and the cause determined.

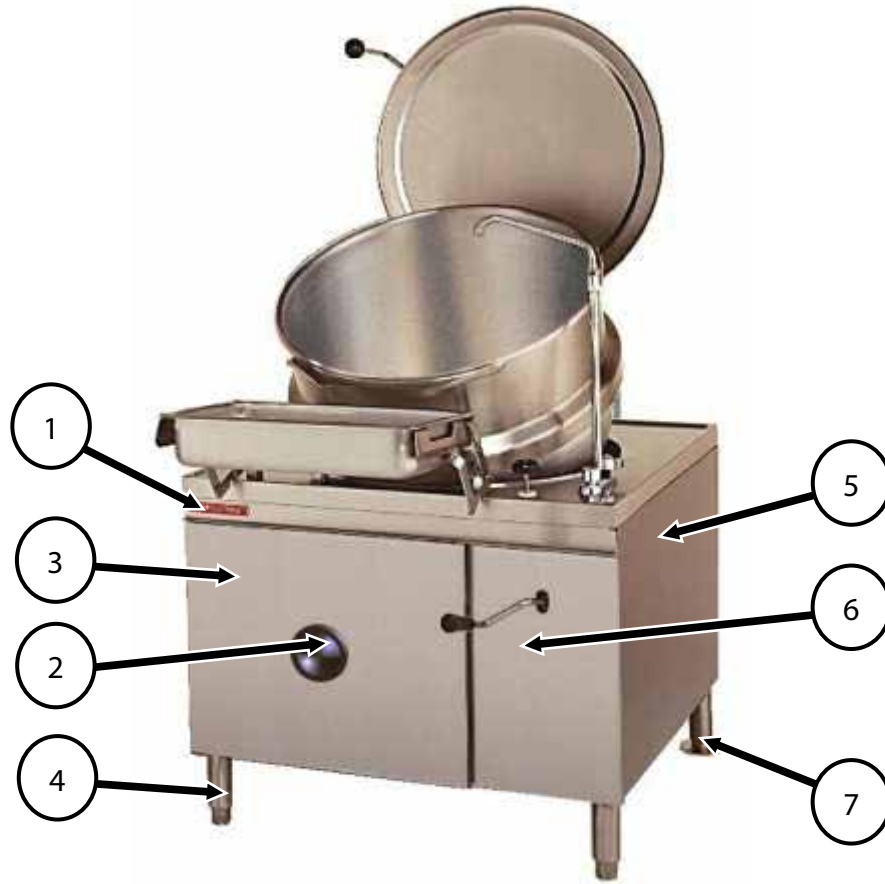
TILTING MECHANISM



ITEM	PART NO.	DESCRIPTION
1	91-9335	POWER TILT MOTOR WELD ASSEMBLY
2	91-9336	MOTOR MOUNTING PLATE
3	98-1726	POWER LIFT FOOT BRACKET
4	91-9353	POWER TILT NYLON STRIP
5	98-0555	LIFTING LEVER ARM
6	91-9387	LEVER ARM
7	91-9324	LIFT SCREW ASSEMBLY
8	98-4131	CONDENSER HOSE
9	90-3490	HINGE BLOCK
10	08-5217	VALVE RETAINER COLLAR
11	10-5242	VALVE
12	98-4128	FAUCET HOSE
13	98-3676	MOTOR

KETTLE CABINET BASE

ALL MODELS

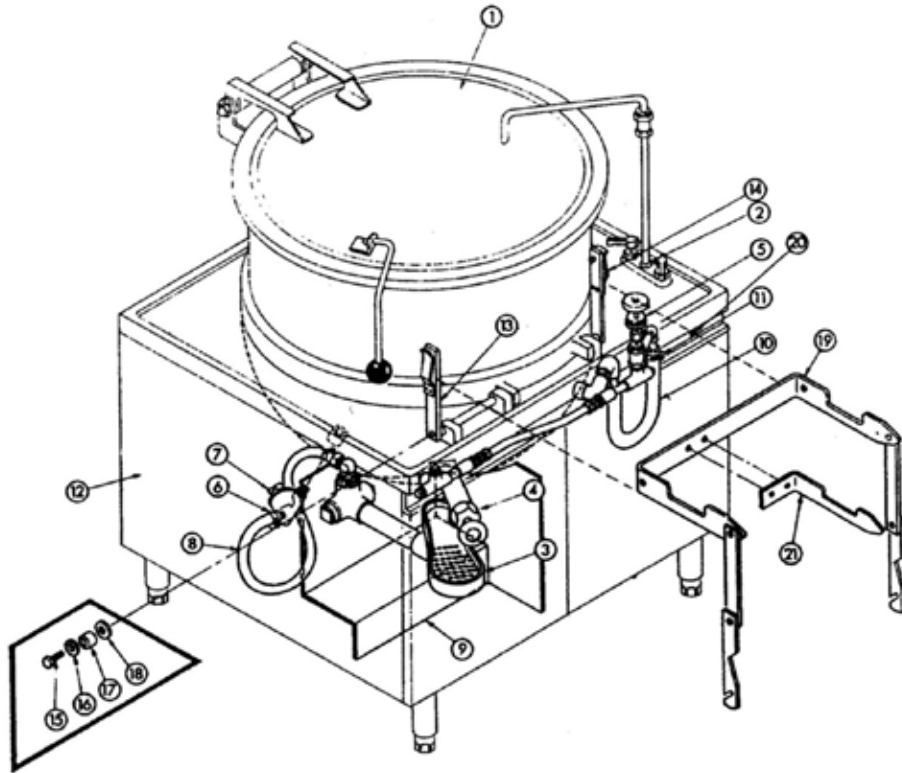


ITEM	PART NO.	DESCRIPTION
1	08-5894	MARKET FORGE NAMEPLATE LOGO
2	91-5795	HANDLE, FRONT
3	98-3992	PANEL, FRONT ASSEMBLY, 24"
3	98-3993	PANEL, FRONT ASSEMBLY, 36"
3	98-3986/98-1621	PANEL, FRONT ASSEMBLY, 48" (60-Gallon)
4	10-0631	LEG, 6"
*4	08-5211	LEG, 10"
*4	08-5206	LEG, 8"
5	98-3994	PANEL, SIDE ASSEMBLY
6	91-9103	HAND CRANK PANEL
7	08-5208	LEG, FLANGED 6"
*8	98-3996	PANEL, REAR ASSEMBLY, 36"
*8	98-3995	PANEL, REAR ASSEMBLY, 48" (MT-60) (NEED QTY. OF 2)
*9	10-0326	CASTER, 5" (OPTIONAL)

* NOT SHOWN.

KETTLE CABINET BASE

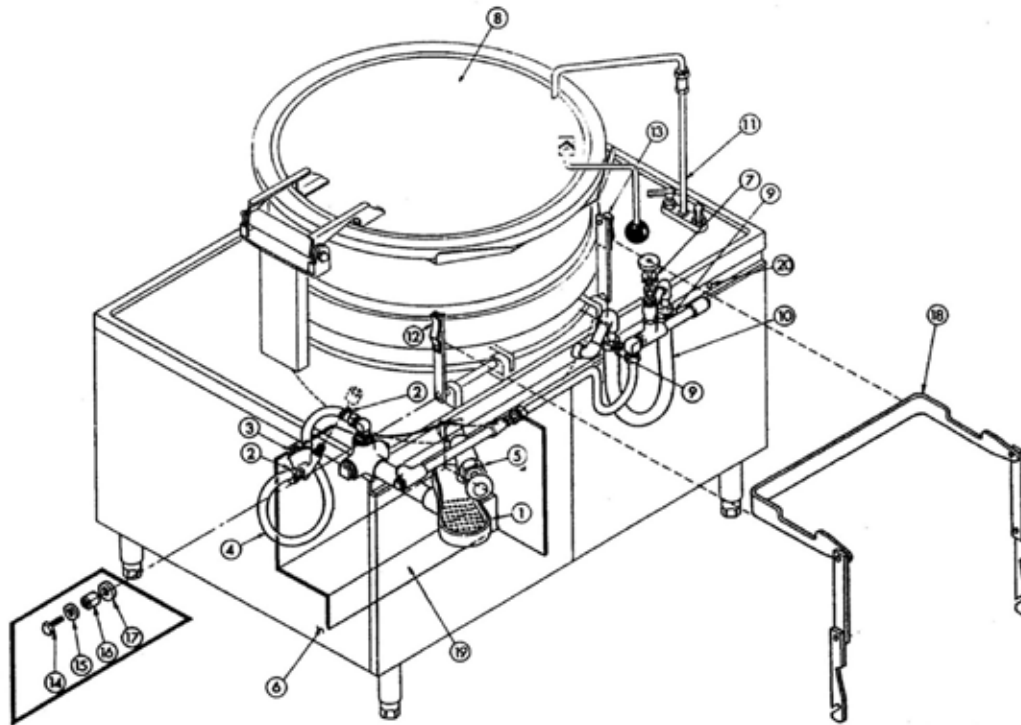
MT25 AND MT40



ITEM	PART NO.	DESCRIPTION
1	91-2717	HINGE AND LID ASSEMBLY
2	--	FAUCET AND SPOUT ASSEMBLY (see page 10)
3	10-0412	SWING DRAIN
4	97-5063	2" DRAW OFF VALVE
5	10-5242	1/2" ANGLE STEAM VALVE
6	10-3945	CLAMP, CONDENSATE HOSE
7	08-5469	STEAM TRAP WITH HOSE FITTING
8	90-7493	CONDENSATE HOSE, 3/8" ID 36" LG.
9	90-8725	SPLASH GUARD ASSEMBLY
10	90-7495	STEAM HOSE, 3/4" ID
11	10-3916	CLAMP, STEAM HOSE
12	REF	36" CABINET
13	90-3788	PAN SUPPORT UPRIGHT, LEFT
14	90-3783	PAN SUPPORT UPRIGHT, RIGHT
15	10-1791	MACHINE SCREW, 1/4" x 7/8" LG.
16	10-2403	WASHER, 1/4"
17	10-6784	SPACER, SMALL
18	90-3476	SPACER, LARGE
19	90-3389	PAN SUPPORT, REMOVABLE
20	--	TILT MECHANISM (see page 4)

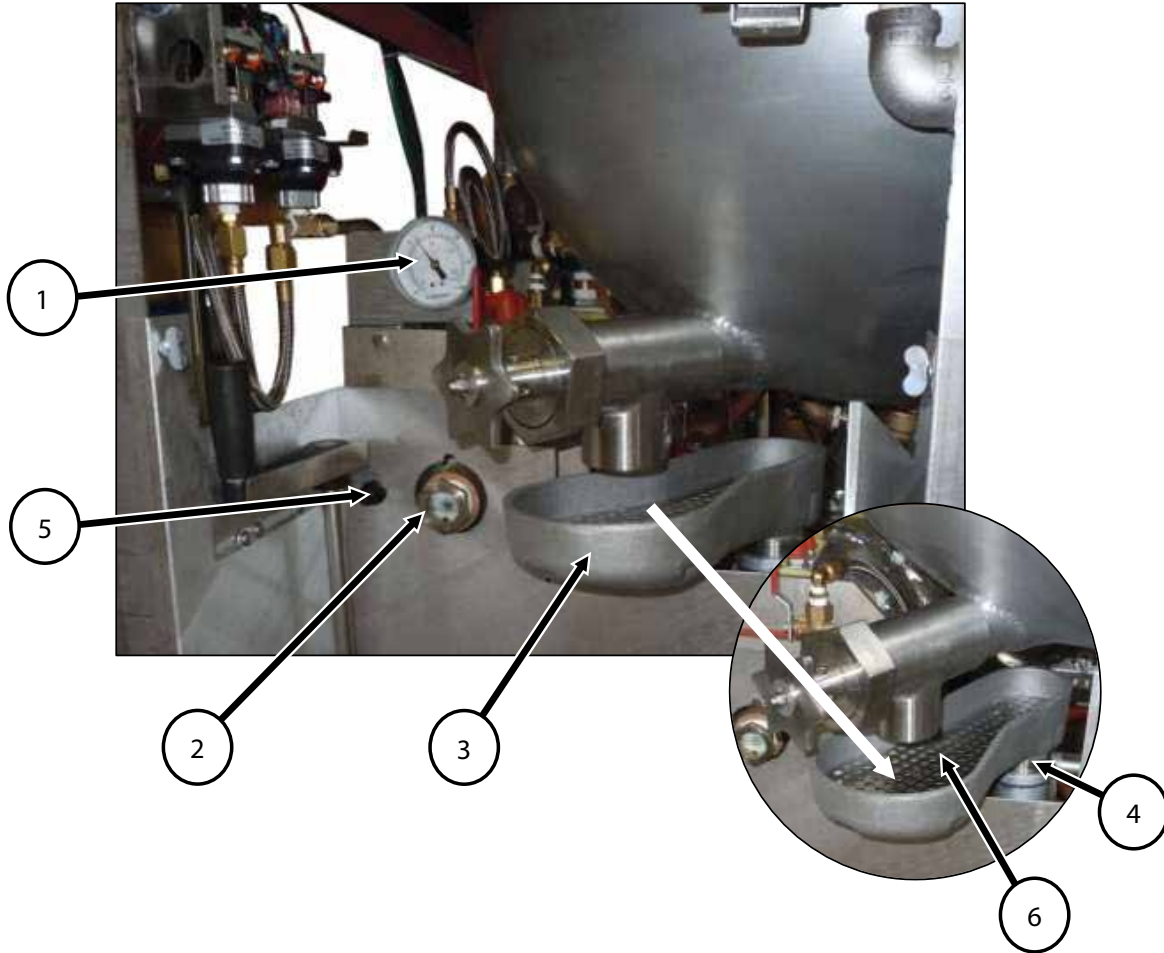
KETTLE CABINET BASE

MT60



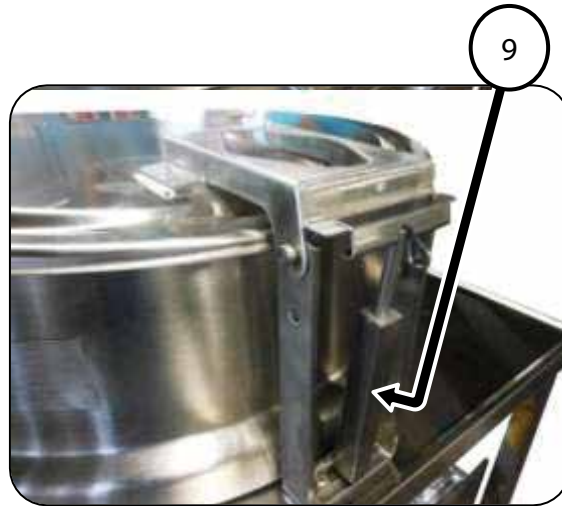
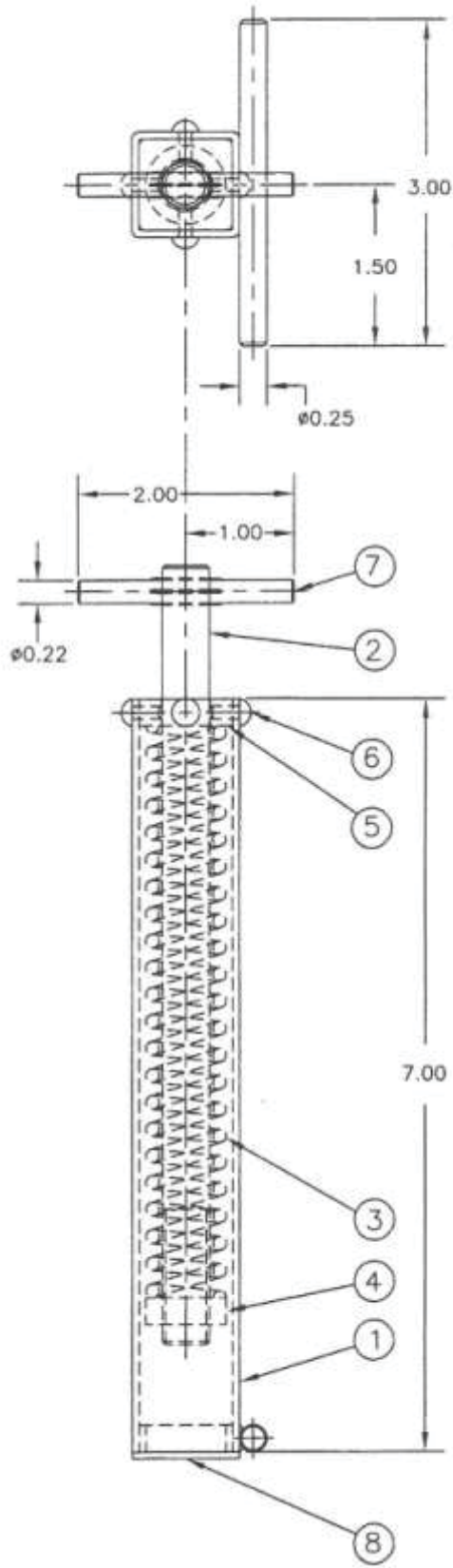
ITEM	PART NO.	DESCRIPTION
1	10-0412	SWING DRAIN
2	10-3945	CLAMP, CONDENSATE HOSE
3	08-5469	STEAM TRAP WITH HOSE FITTING
4	90-7493	CONDENSATE HOSE, 3/8" ID
5	10-4928	1-1/2" DRAW OFF VALVE
6	REF	48" CABINET
7	10-5242	1/2" ANGLE STEAM VALVE
8	10-6796	HINGE AND LID ASSEMBLY
9	10-3916	CLAMP, STEAM HOSE
10	91-1977	STEAM HOSE, 3/4" ID
11	--	FAUCET AND SPOUT ASSEMBLY (see page 10)
12	91-1839	PAN SUPPORT UPRIGHT, LEFT
13	91-1838	PAN SUPPORT UPRIGHT, RIGHT
14	10-1791	MACHINE SCREW, 1/4" x 7/8" LG.
15	10-2403	WASHER, 1/4"
16	10-6784	SPACER, SMALL
17	90-3476	SPACER, LARGE
18	91-1983	PAN SUPPORT, REMOVABLE
19	90-8725	SPLASH GUARD ASSEMBLY
20	--	TILTING MECHANISM (see page 4)

DRAIN ASSEMBLY



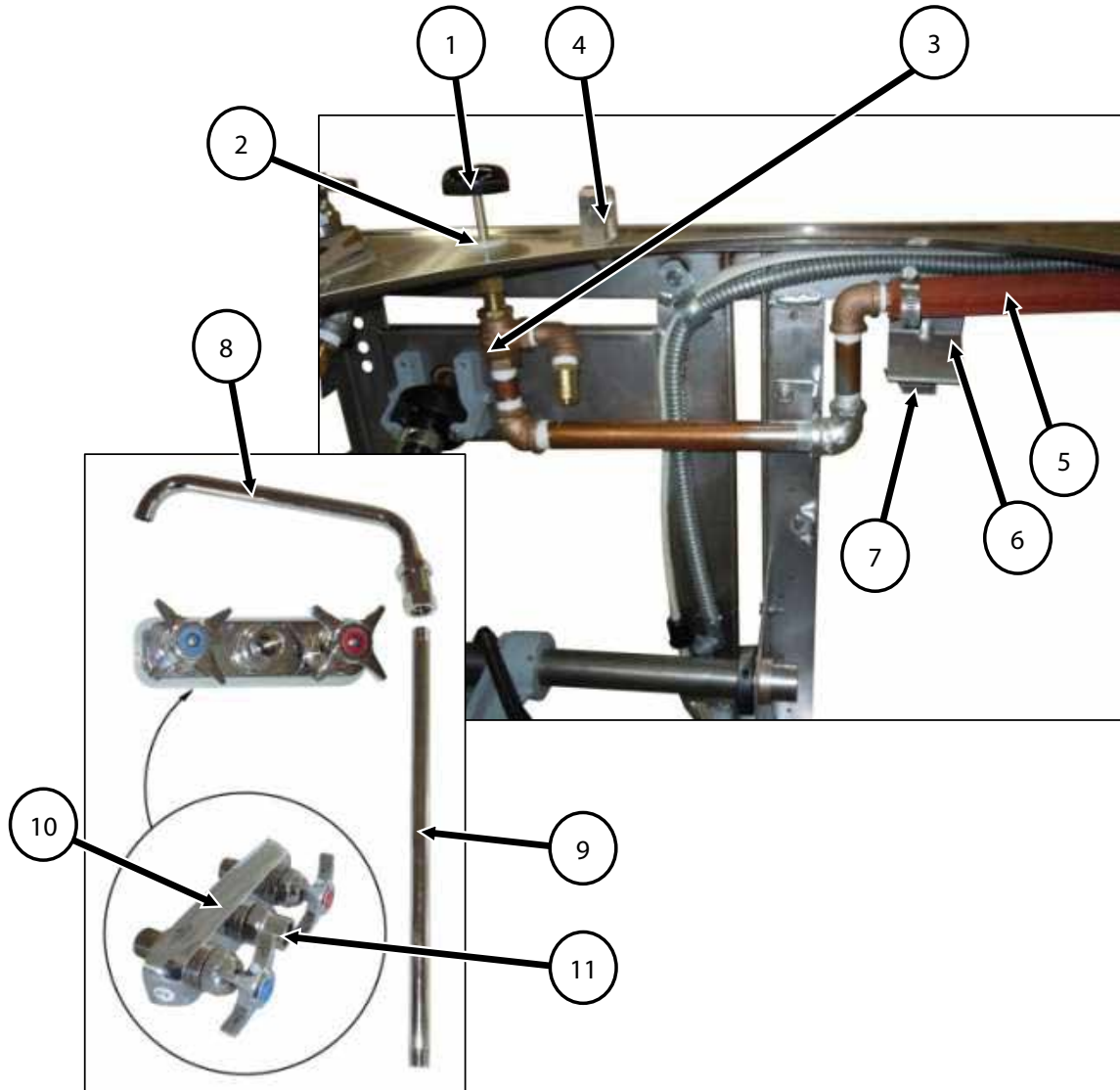
ITEM	PART NO.	DESCRIPTION
1	10-4804	PRESSURE GAUGE
2	10-7974	SIGHT WINDOW
3	10-0412	SWING DRAIN
4	90-7475	SUPPORT, NIPPLE, DRAIN
5	08-6553	LOW WATER CUT OFF
6	91-1835	STRAINER

PISTON ASSEMBLY



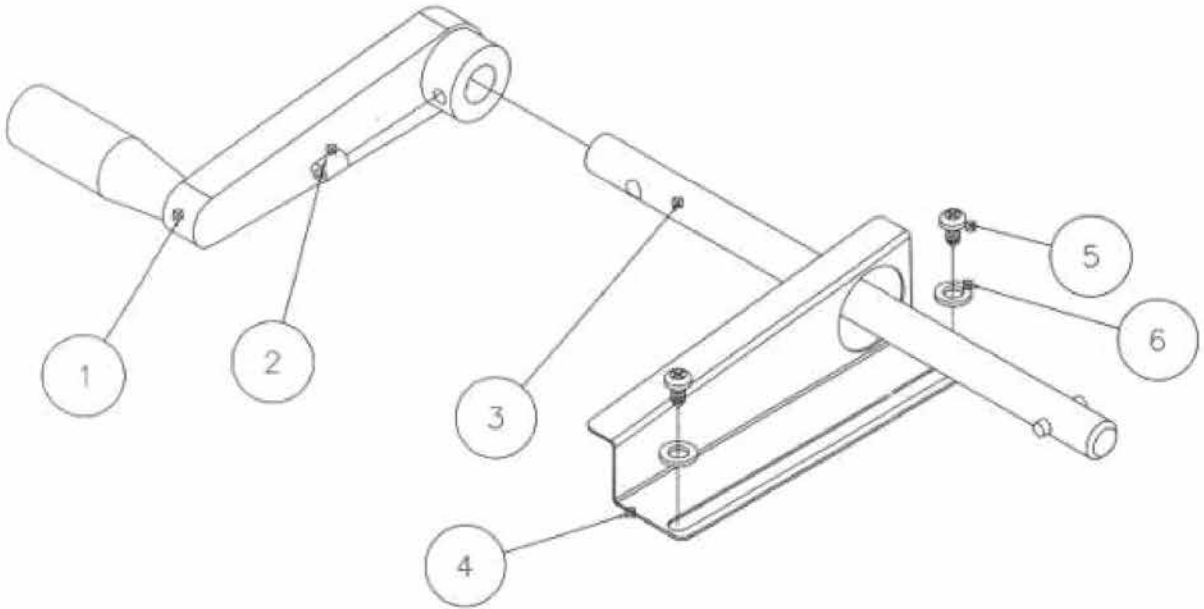
ITEM	PART NO.	DESCRIPTION
1	98-0530	Housing-Compression Rod & Spring
2	98-0535	Compression Rod
3	08-4606	Compression Spring
4	98-0537	Floating Nut
5	98-0536	End Guide
6	08-4200	Rivet, Barbed
7	08-3205	Hooking Pin, Driv Lok Type "E" 7/32 x 2
8	08-1208	Plug, Plastic
9	98-0529	COMPLETE PISTON ASSEMBLY

VALVE AND FAUCET



ITEM	PART NO.	DESCRIPTION
1	10-0105A	KNOB
2	10-6303	VALVE RETAINER COLLAR
3	10-5242	VALVE
4	90-3490	HINGE BLOCK
5	91-4795	RUBBER HOSE, 3/4" ID X 36" LONG
6	90-3210	MAGNETIC BRACKET
7	10-5561	DOOR MAGNET
8	10-5753	NOZZLE, SWIVEL SPOUT
9	91-0887	RISER, 15" LONG
10	10-7680	FAUCET SET
11	08-5467	ADAPTER

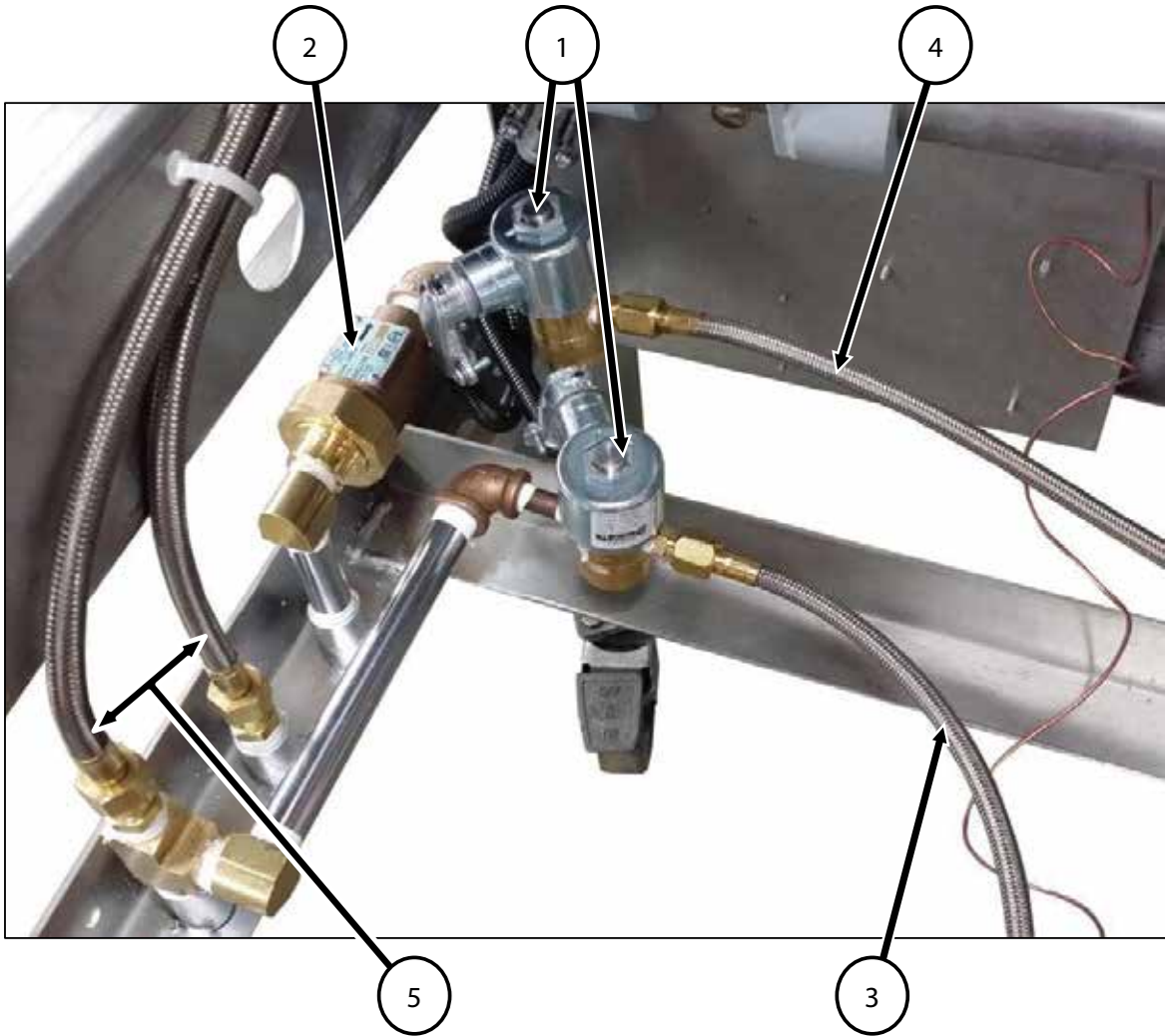
CRANK SHAFT



NOTE: 1. BRACKET (ITEM#4) TO BE POSITION AS NEEDED USING EXISTING HOLES IN ALL DOOR PANELS.
2. ITEMS 1-3 TO BE ASSEMBLED AT FACTORY.

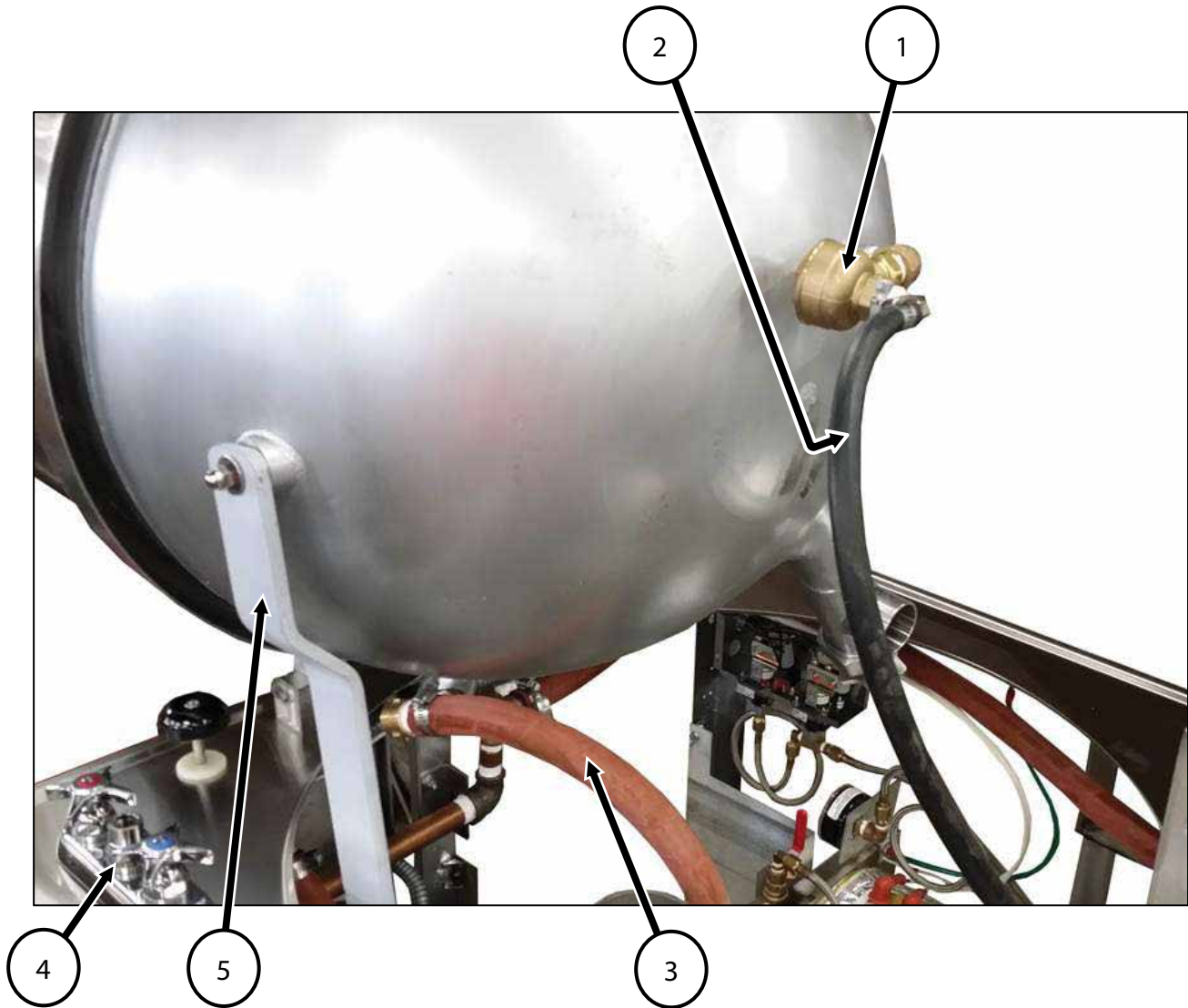
ITEM	PART NO.	DESCRIPTION
1	08-7906	Handle with Knob
2	08-7911	Screw, Set 1/4 – 20, 3/8" Long
3	98-1537	Assembly, Crank Shaft
4	90-8878	Clip, Bracket, Universal
5	10-1735	Screw, #8-32, Sheet Metal
6	10-2508	Washer, Stainless Steel

VALVE ASSEMBLY



ITEM	PART NO.	DESCRIPTION
1	08-4822	WATER VALVE
2	08-4979	CHECK VALVE
3	08-4131	CONDENSER HOSE
4	98-4030	FILL HOSE
5	98-4128	FAUCET HOSE

KETTLE JACKET ASSEMBLY

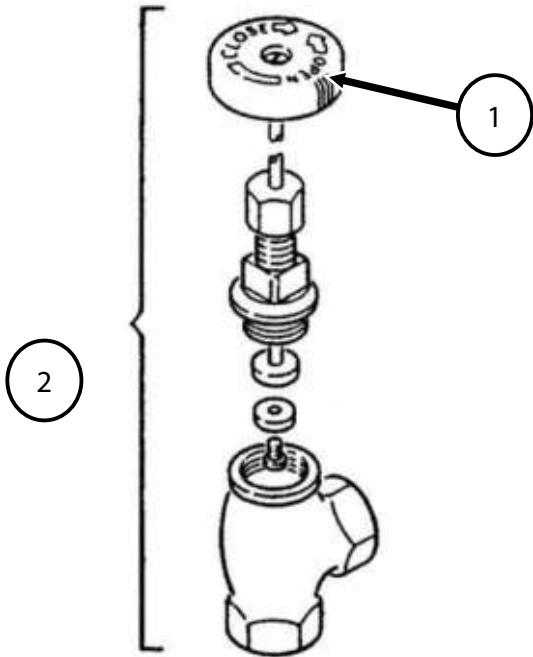


ITEM	PART NO.	DESCRIPTION
1	*	STEAM TRAP
2	90-7493	RUBBER HOSE, 3/8 ID X 40" LONG
3	91-4795	RUBBER HOSE, 3/4 ID X 36" LONG
4	10-7680	FAUCET SET
5	98-0771	LIFT ARM, FOR 40 GALLON KETTLE
5	98-0599	LIFT ARM, FOR 25 & 60 GALLON KETTLE

* Kit to change trap to current style #98=4494

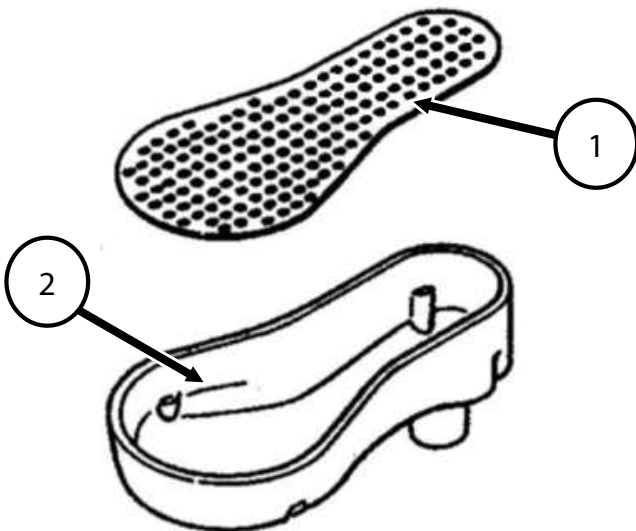
* New steam trap #08-5469

STEAM SUPPLY VALVE



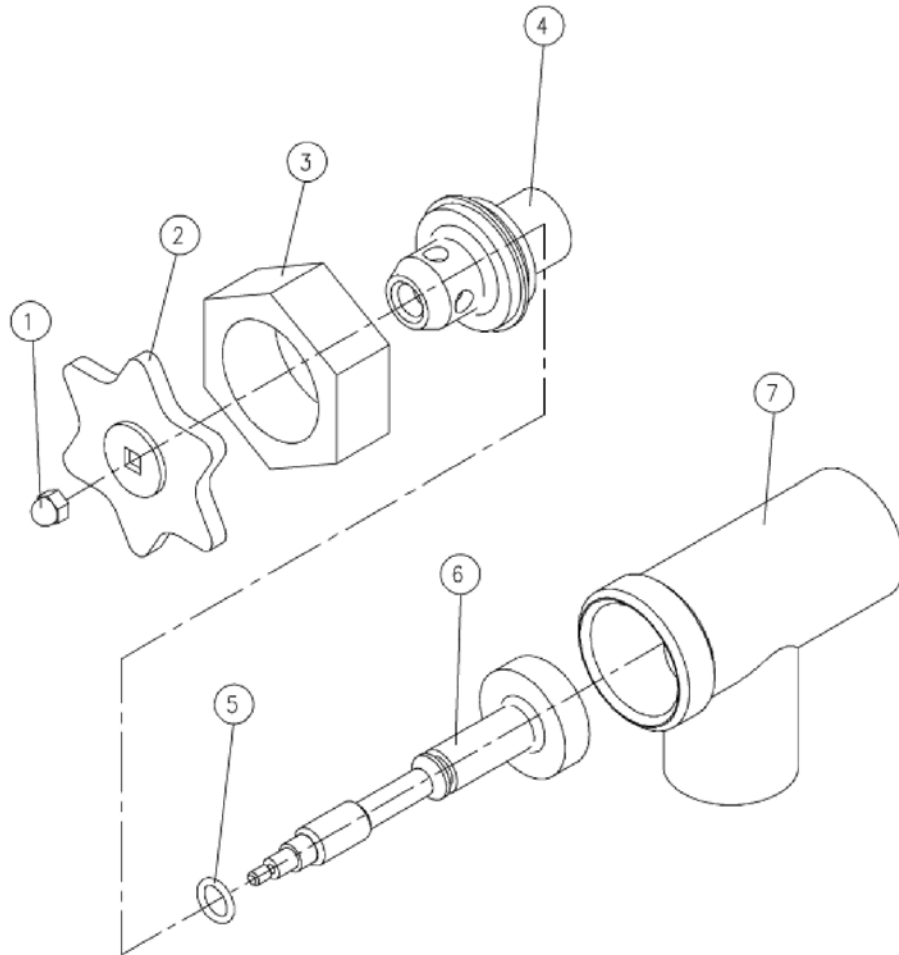
ITEM	PART NO.	DESCRIPTION
1	10-0105	STEAM VALVE HANDLE
2	10-5242	1/2" ANGLE STEAM CONTROL VALVE

SWING DRAIN



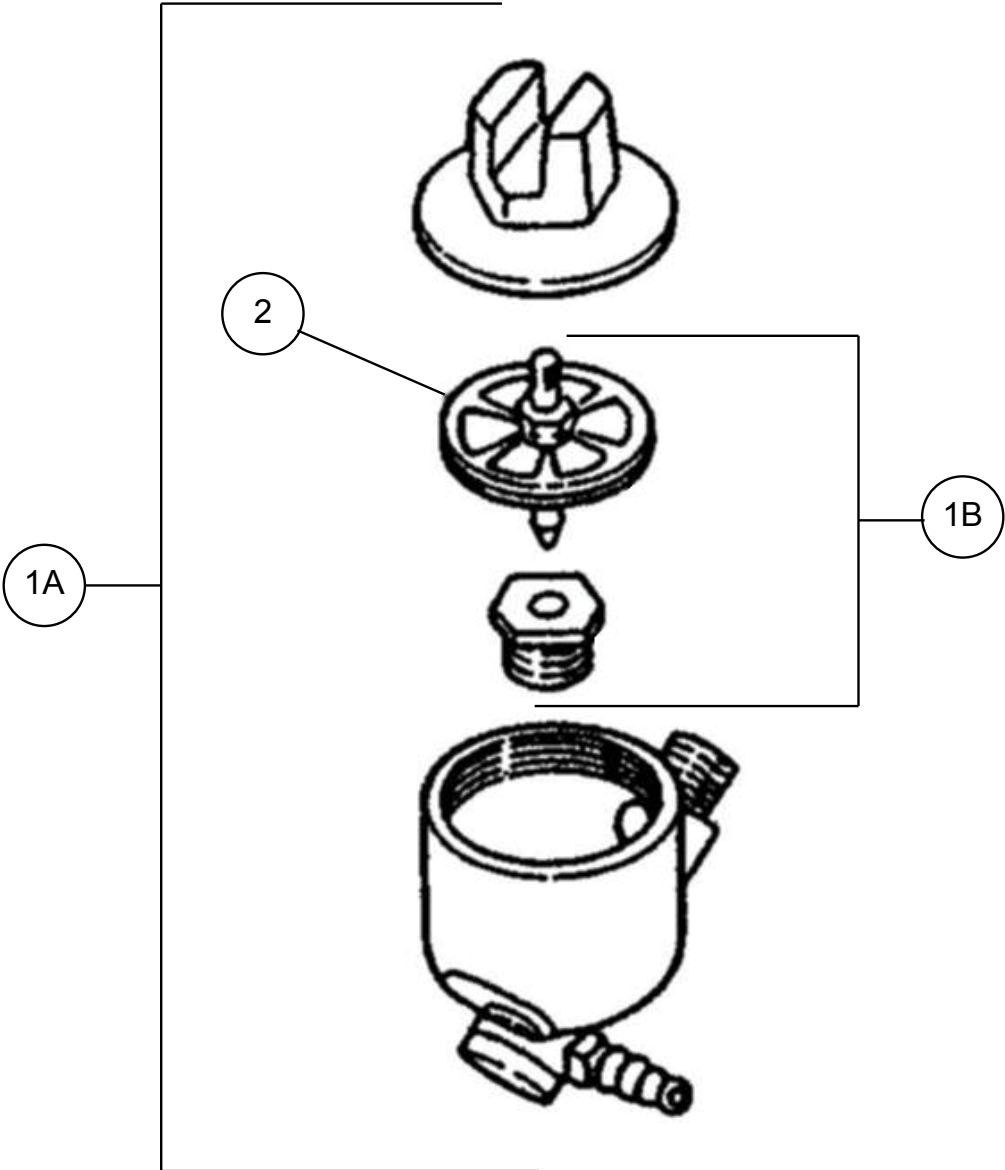
ITEM	PART NO.	DESCRIPTION
1	91-1835	STRAINER, SWING DRAIN
2	10-0412	SWING DRAIN, CASTING

DRAW OFF VALVE



ITEM	PART NO.	DESCRIPTION
	97-5063	2" DRAW OFF VALVE ASSEMBLY (STANDARD)
1	98-6155	ACORN NUT, 10-24 UNC
2	97-5566	HANDLE, STAINLESS STEEL
3	97-5069	GLAND NUT
4	97-5072	BONNET
5	97-5078	"O" RING
6	97-5075	STEAM ASSEMBLY
7	98-6156	VALVE BODY
	97-5605	3" DRAW OFF VALVE ASSEMBLY (OPTIONAL)
1	97-5066	ACORN NUT, 10-24 UNC
2	97-5067	HANDLE, STAINLESS STEEL
3	97-5068	GLAND NUT
4	97-5073	BONNET
5	97-5079	"O" RING
6	97-5076	STEAM ASSEMBLY
7	97-6497	VALVE BODY

STEAM TRAP



ITEM	PART NO.	DESCRIPTION
1A	08-5469	TRAP ONLY (NEW STYLE)
1B	98-4494	1/2" STEAM TRAP KIT (TO CHANGE OLD STYLE TO CURRENT STYLE)
2	10-4937	THERMOSTAT, STEAM TRAP