



Model U421I2
SERVICE MANUAL

Manual No. 513683

Rev.0

This manual provides basic information about the machine. Instructions and suggestions are given covering its operation and care.

The illustrations and specifications are not binding in detail. We reserve the right to make changes to the machine without notice, and without incurring any obligation to modify or provide new parts for machines built prior to date of change.

DO NOT ATTEMPT to operate the machine until instructions and safety precautions in this manual are read completely and are thoroughly understood. If problems develop or questions arise in connection with installation, operation, or servicing of the machine, contact Stoelting.



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A Few Words About Safety

Safety Information

Read and understand the entire manual before operating or maintaining Stoelting equipment.

This manual provides the operator with information for the safe operation and maintenance of Stoelting equipment. As with any machine, there are hazards associated with their operation. For this reason safety is emphasized throughout the manual. To highlight specific safety information, the following safety definitions are provided to assist the reader.

The purpose of safety symbols is to attract your attention to possible dangers. The safety symbols, and their explanations, deserve your careful attention and understanding. The safety warnings do not by themselves eliminate any danger. The instructions or warnings they give are not substitutes for proper accident prevention measures.

If you need to replace a part, use genuine Stoelting parts with the correct part number or an equivalent part. We strongly recommend that you do not use replacement parts of inferior quality.



Safety Alert Symbol:

This symbol Indicates danger, warning or caution. Attention is required in order to avoid serious personal injury. The message that follows the symbol contains important information about safety.

Signal Word:

Signal words are distinctive words used throughout this manual that alert the reader to the existence and relative degree of a hazard.



The signal word “WARNING” indicates a potentially hazardous situation, which, if not avoided, may result in death or serious injury and equipment/property damage.



The signal word “CAUTION” indicates a potentially hazardous situation, which, if not avoided, may result in minor or moderate injury and equipment/property damage.

CAUTION

The signal word “CAUTION” not preceded by the safety alert symbol indicates a potentially hazardous situation, which, if not avoided, may result in equipment/property damage.

NOTE (or NOTICE)

The signal word “NOTICE” indicates information or procedures that relate directly or indirectly to the safety of personnel or equipment/property.

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SECTION 1 DESCRIPTION AND SPECIFICATIONS

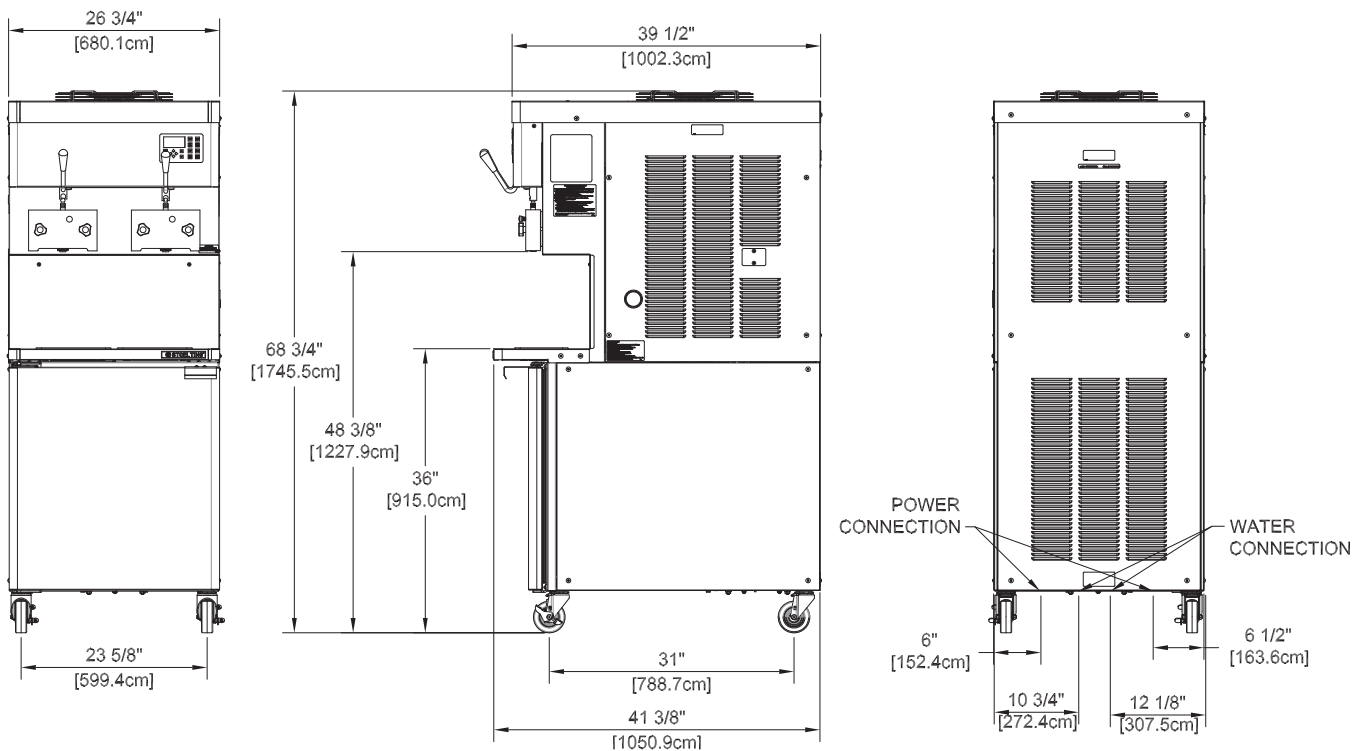
1.1 DESCRIPTION

The Stoelting U421 I2 floor model machine is pressure fed. It is equipped with fully automatic controls to provide a uniform product.

This manual is designed to assist qualified service personnel and operators with installation, operation and maintenance of the U421 I2.



Figure 1-1 Model U421 I2



1.2 SPECIFICATIONS

	U431-I2 Water Cooled				U431-I2 Air Cooled			
Dimensions	Machine		with crate		Machine		with crate	
	width	26-3/4" (67,9 cm)	34" (86,4 cm)		26-3/4" (67,9 cm)	34" (86,4 cm)		
	height	67-1/2" (171,5 cm)	78" (198,1 cm)		68-3/4" (174,6 cm)	78" (198,1 cm)		
depth	39-1/2" (100,3 cm)	48" (121,9 cm)		39-1/2" (100,3 cm)	48" (121,9 cm)			
Weight	760 lbs (344,7 kg)		908 lbs (411,8 kg)		785 lbs (356,0 kg)		935 lbs (424,1 kg)	
Electrical	1 PH		3 PH		1 PH		3 PH	
	left	right	left	right	left	right	left	right
	minimum circuit ampacity	32A	32A	20A	20A	32A	32A	20A
maximum overcurrent protection device	50A	50A	30A	30A	50A	50A	30A	30A
International Option	1 Phase, 220-240 VAC, 50Hz or 3 Phase, 380-415 VAC, 50Hz							
Compressor	Two - 19,000 Btu/hr Cabinet - 1,300 Btu/hr Compressor (R-134a)							
Drive Motor	Two - 2 hp							
Cooling	Water cooled units require 1/2" N.P.T. water and drain fittings. Maximum water pressure of 130 psi. Minimum water flow rate of 3 GPM per barrel. Ideal EWT of 50°-70°F. The machine requires 6" (15,2 cm) air space on all sides for the cabinet refrigeration system.				Air cooled units require 6" (15,2 cm) air space on all sides and open at the top.			
Hopper Volume	Two - 8 gallon (30,28 liters)							
Freezing Cylinder Volume	Two - 1.33 gallon (5,03 liters)							

	U421 I2
Refrigerant	R-404A
Charge	46 oz
Suction Pressure	22-23 psig
Discharge Pressure at 80°F Ambient	235-240 psig
	Cabinet
Refrigerant	R-134A
Charge	12 oz
Cab Suction Pressure	32-34 psig

1.3 COMPONENT SETTINGS

Following are the settings for the components in the U421 I2 machine.

A. COMPRESSOR WINDINGS

When testing the compressor windings the resistance through the windings should be as follows:

Compressor	Electrical	S to C	R to C
282082	1 PH	2.71Ω	0.91Ω
282106	1 PH	1.72Ω	0.83Ω
282107	3 PH	1.46Ω	0.00Ω
282111	1 PH	16.40Ω	10.20Ω

B. CAPACITORS

Refer to the following table for the capacitance of all the capacitors in the machine:

Capacitor	Part	Rating	
		MFD	VAC
Compressor - Start	230638	88-106 MFD	330 VAC
Compressor - Run	231047	45 MFD	370 VAC
Motor - Start	230622	200 MFD	250 VAC
Motor - Run	231075	30 MFD	370 VAC
Fan Motor	230654	5 MFD	400 VAC

C. PUMP PRESSURE SWITCH

The pump pressure switch, located in the cabinet, maintains 21-24 psig in the mix line.

D. TEMPERATURE CONTROL SENSOR

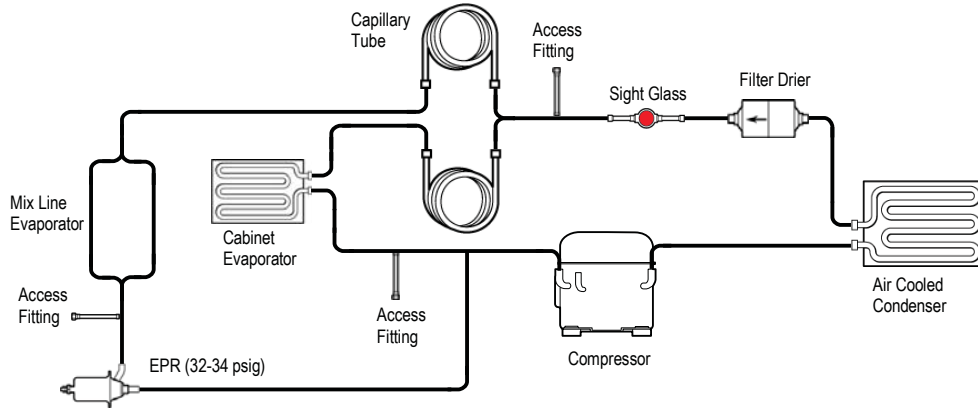
The following table shows the relationship between the thermistor resistance and the suction line temperature.

°F	Resistance	°F	Resistance
-22	176950	40	26100
-20	165200	42	24725
-18	154300	44	23400
-16	144200	46	22175
-14	134825	48	21000
-12	126125	50	19900
-10	118050	52	18875
-8	110550	54	17900
-6	103550	56	17000
-4	97075	58	16125
-2	91025	60	15325
0	85400	62	14550
2	80150	64	13825
4	75275	66	13150
6	70725	68	12500
8	66475	70	11875
10	62500	72	11300
12	58800	74	10750
14	55325	76	10250
16	52100	78	9750
18	49075	80	9300
20	46250	82	8850
22	43600	84	8450
24	41125	86	8050
26	38800	88	7675
28	36625	90	7325
30	34575	92	7000
32	32675	94	6675
34	30875	96	6375
36	29175	98	6100
38	27600	100	5825

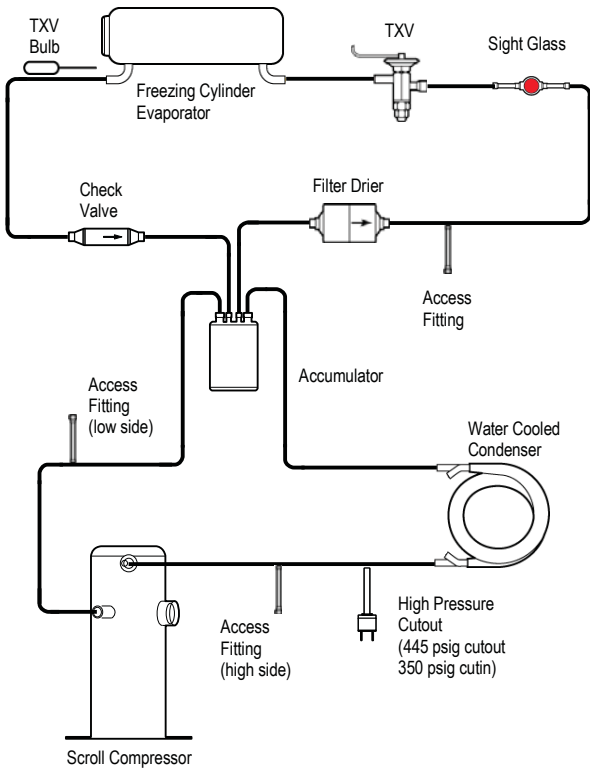
SECTION 2 REFRIGERATION DIAGRAM AND WIRING DIAGRAMS

2.1 REFRIGERATION DIAGRAMS

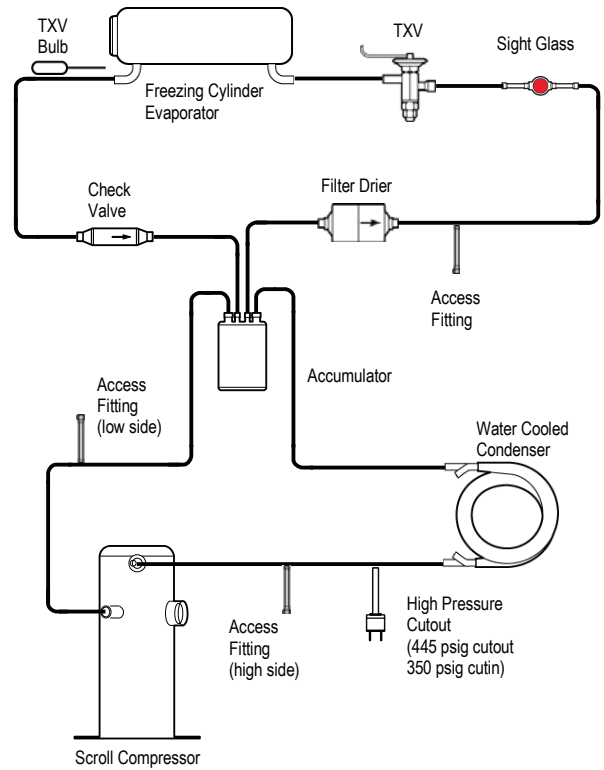
**Cabinet Refrigeration
R134A**



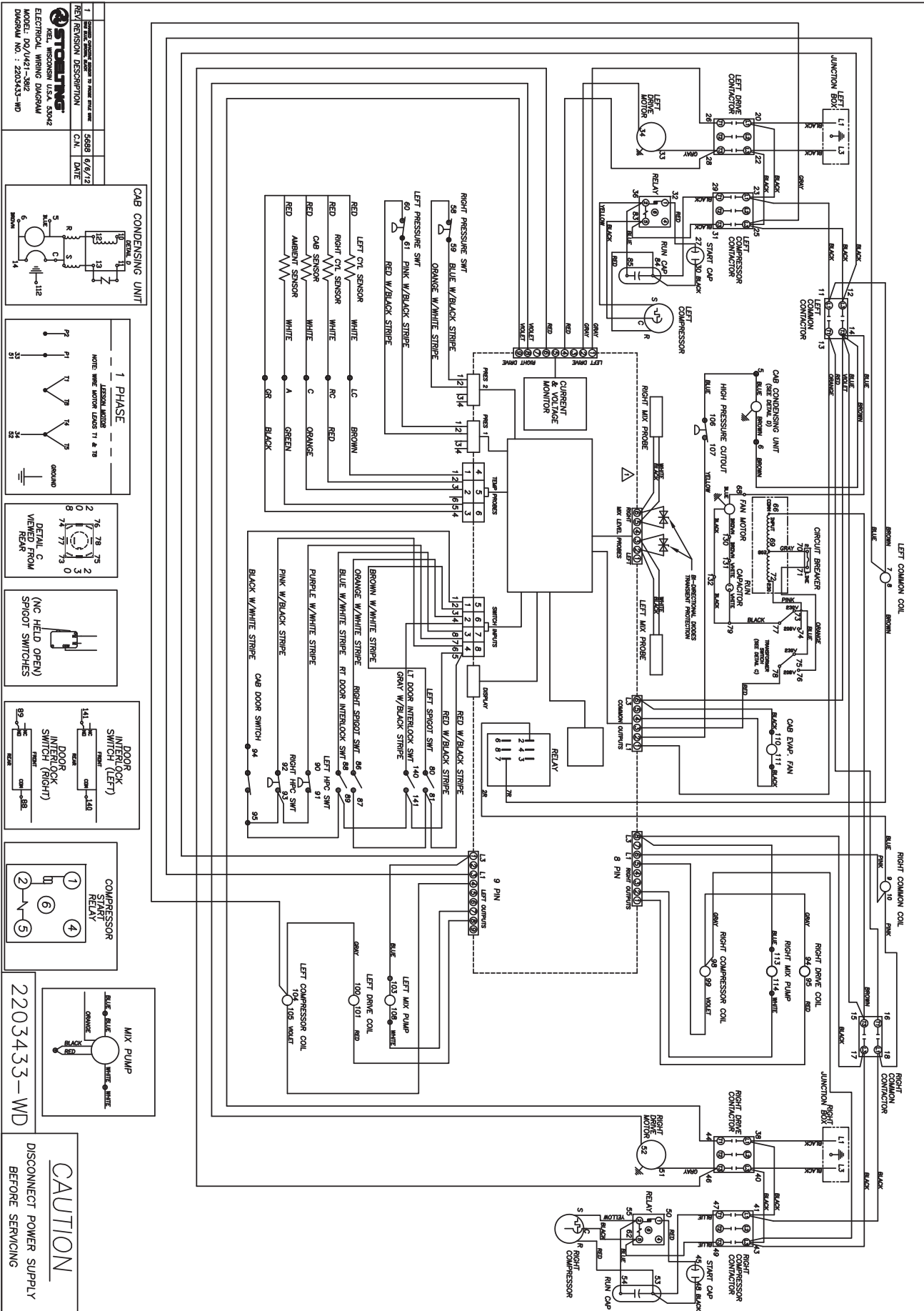
**Left Side
R404A**

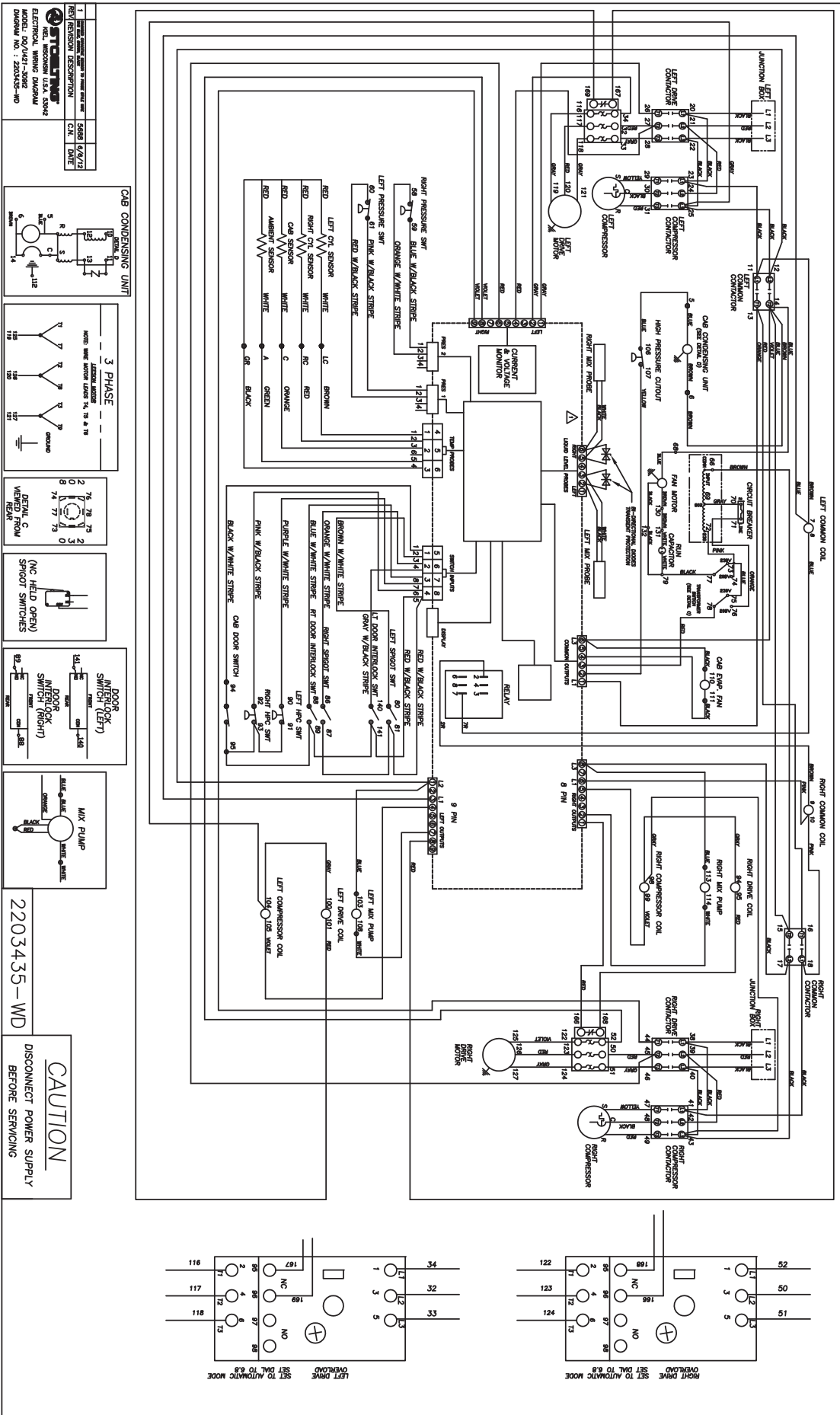


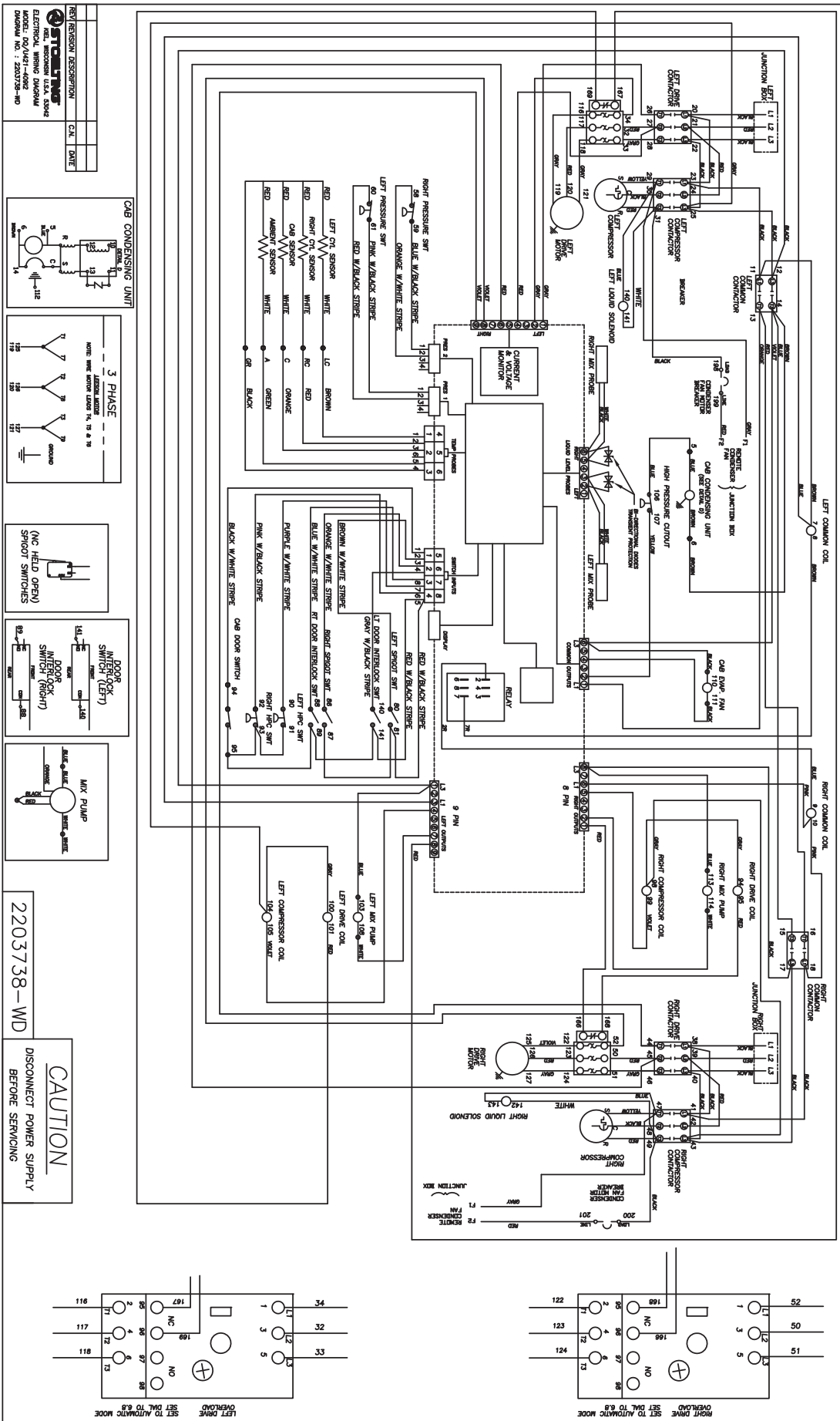
**Right Side
R404A**



2.2 WIRING DIAGRAMS





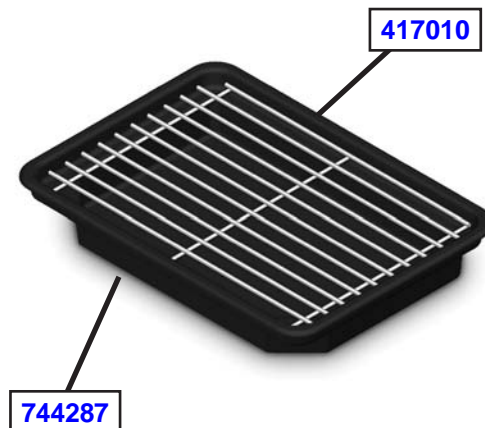


SECTION 3 REPLACEMENT PARTS

3.1 BRUSHES, DECALS AND LUBRICATION

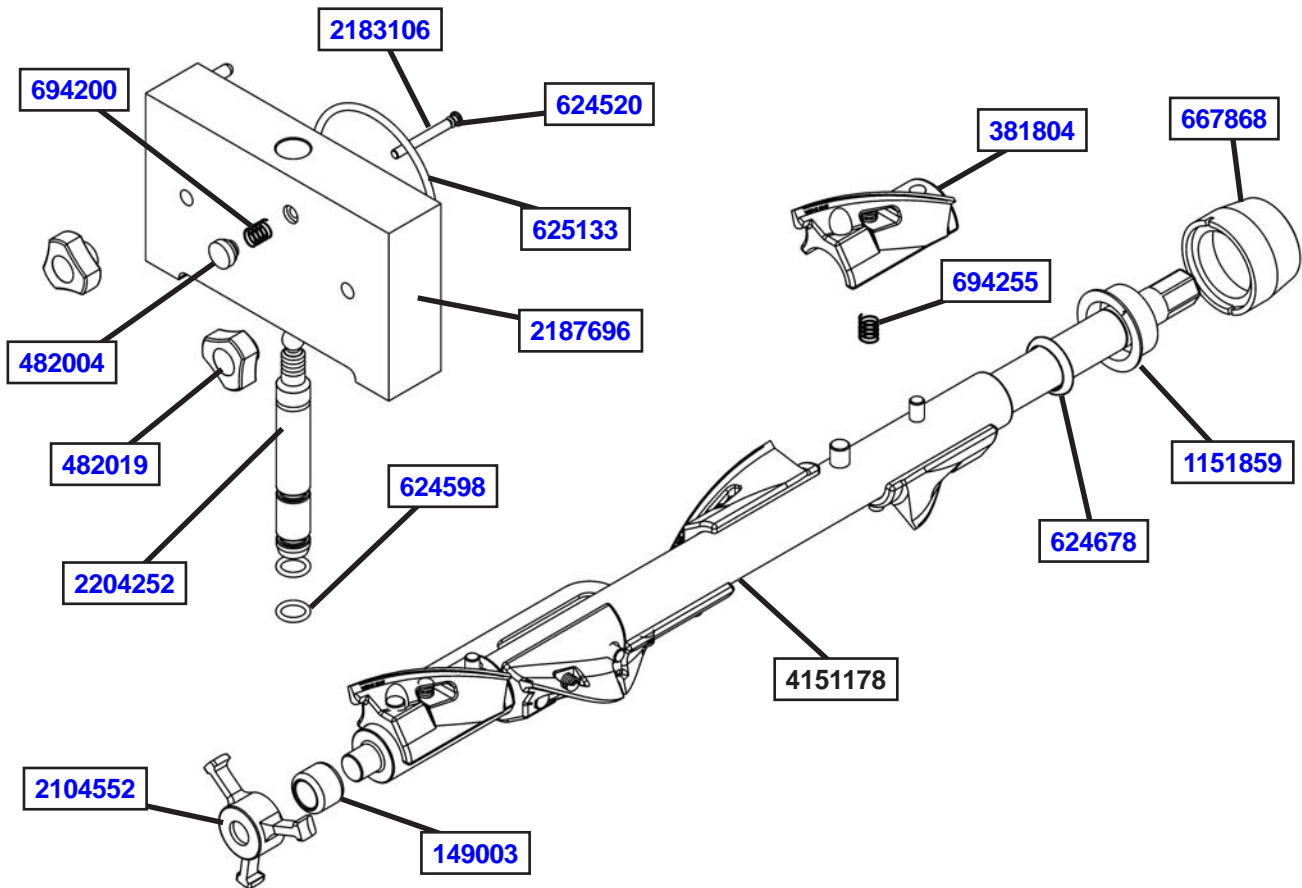
Part Number	Description	Quantity
208135	Brush - 4" X 8" X 16" (Barrel)	1
208380	Brush - 1/4" X 3" X 14"	1
208387	Brush - 1/2" X 5" X 24"	1
208465	Brush - 1" X 3-1/2" X 18"	1
208467	Brush - 3/8" X 1" X 5"	1
324065	Decal - Water Inlet	1
324105	Decal - Caution Electrical Shock	1
324107	Decal - Caution Hazardous Moving Parts	1
324125	Decal - Danger Electric Shock Hazard	1
324141	Decal - Caution Rotating Blades	1
324200	Decal - High Pressure Cut-Out	1
324208	Decal - Attention Refrigerant Leak Check	1
324393	Decal - Stoelting Swirl Logo	1
324509	Decal - Cleaning Instructions	1
324548	Decal - Adequate Ventilation 6"	1
324566	Decal - Wired According To	1
324803	Decal - Domed Stoelting Logo (Large) (Header Panel)	1
324859	Decal - Domed Dairy Queen Logo (Header Panel)	-
324888	Decal - Fan Motor Reset	1
324901	Decal - Transformer Switch	1
324909	Decal - USB Port	1
324932	Decal - Thermistor ID	1
508048	Lubricant - Spline (2 oz Squeeze Tube)	1
508135	Petrol Gel - 4 oz Tube	1
513673	Manual - Owner's	1
1998210	Card - Cleaning Instructions (DQ)	1

3.2 TRAYS



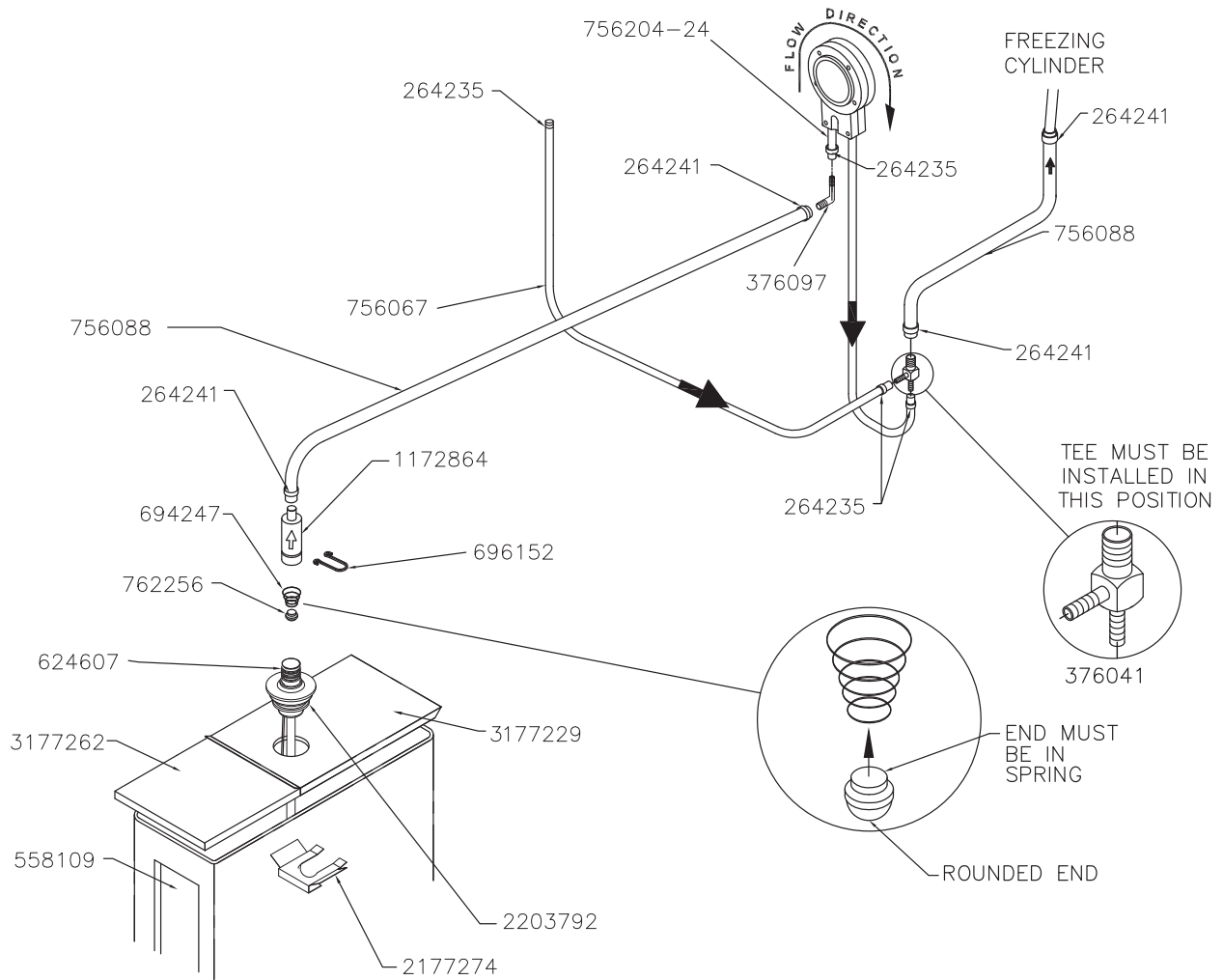
Part Number	Description	Quantity
417010	Grid - Drip Tray	1
744272	Tray - Drain (Cabinet)	1
744287	Tray - Drip	1
744610	Tray - Drain w/Magnet	1

3.3 AUGER SHAFT AND FACEPLATE PARTS



Part Number	Description	Quantity
149003	Bushing - Front Auger Support	2
381804	Auger Flight	12
482004	Knob (Air Bleed Valve)	2
482019	Knob - Front Door (Black)	4
624520	O-Ring - Air Bleed Valve - Black	2
624598	O-Ring - Outside Spigot - Black	4
624678	O-Ring - Rear Seal - Black	2
625133	O-Ring - Front Door - Black	2
667868	Seal - Rear Auger (Orange)	2
694200	Spring - Air Bleed Valve	2
694255	Spring - Auger Flight	12
1151859	Adapter - Rear Seal (Code 1)	2
2104552	Support - Front Auger	2
2183106	Valve - Air Bleed	2
2187696	Front Door	2
2204252	Spigot Body	2
4151178	Auger Shaft	2

3.4 CAB TUBING

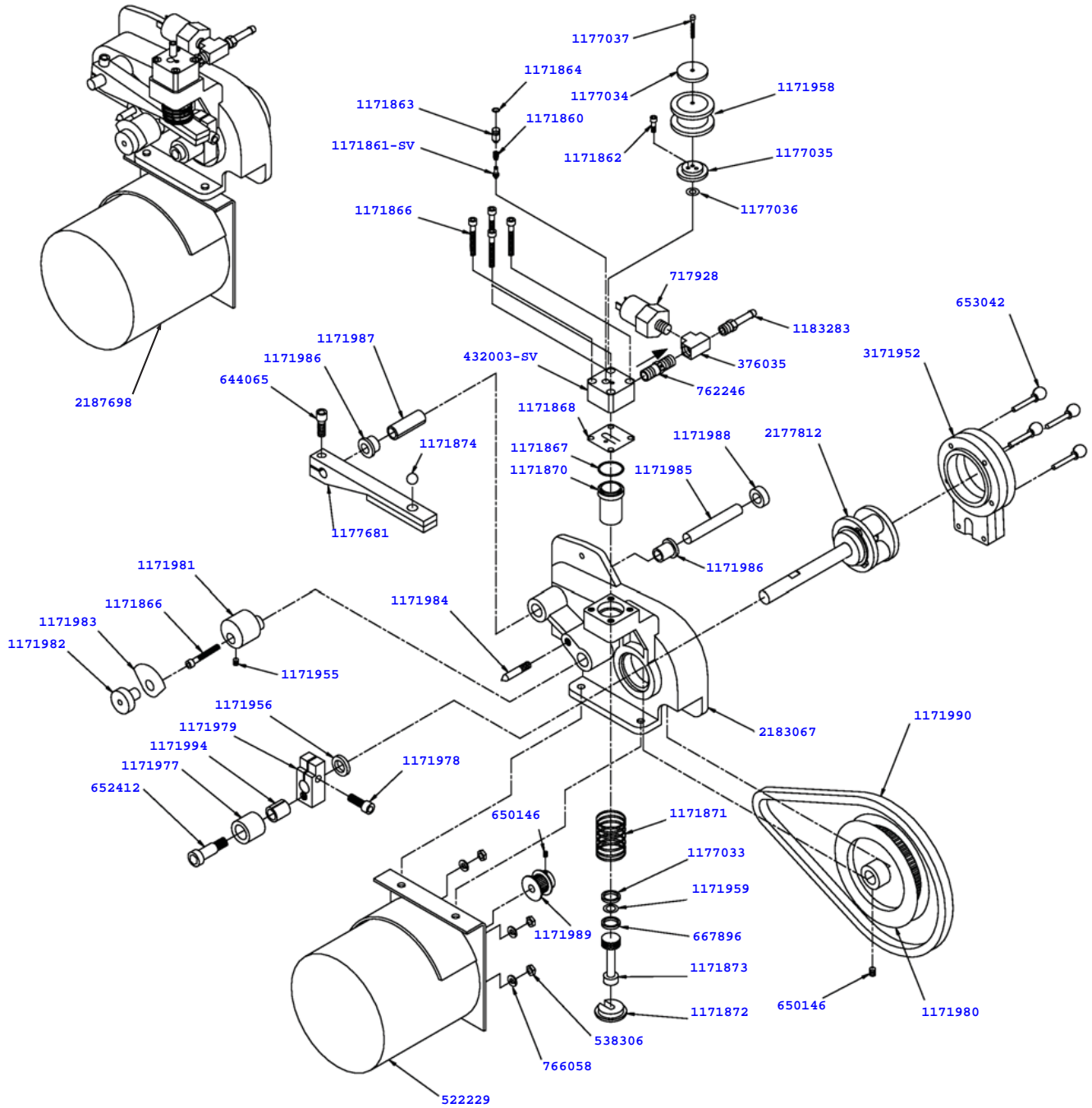


Part Number	Description	Quantity
264235	Clamp - Metal (1/4" ID Tubing)	8
264241	Clamp - Metal (1/2" ID Tubing)	8
376041	Tee Connector - 3-Way (Stainless)	2
376097	Elbow - Barbed (1/2"- 1/4")	2
558109	Mix Container Only	2
624607-5	O-Ring - Check Valve Body - Black (5 Pack)	4
694247	Spring - Check Valve	2
696152	Clip - Lock (Check Valve)	2
756067	Tubing - 1/4" ID - Clear - Air Line (25' Increments) (Per Inch)	13"(2)
756088	Tubing - 1/2" ID - Clear - Mix Line (25' Increments) (Per Inch)	21"(2) and 6"(2)
756204	Tubing - 1/4" ID - Pump (50' Box Only) (Per Inch)	-
756204-40	Tubing - 1/4" ID - Pump (Pre-Cut 40" Piece)	4
762256	Check Valve - Mix Outlet	2
1172864	Check Valve - Mix In Line (Outer)	2
2177274	Clip - Retaining (Mix Probe To Cover)	2
2203792	Pick-Up Tube - Mix	2
3177229	Cover - Rear (Mix Container)	2
3177262	Cover - Front (Mix Container)	2

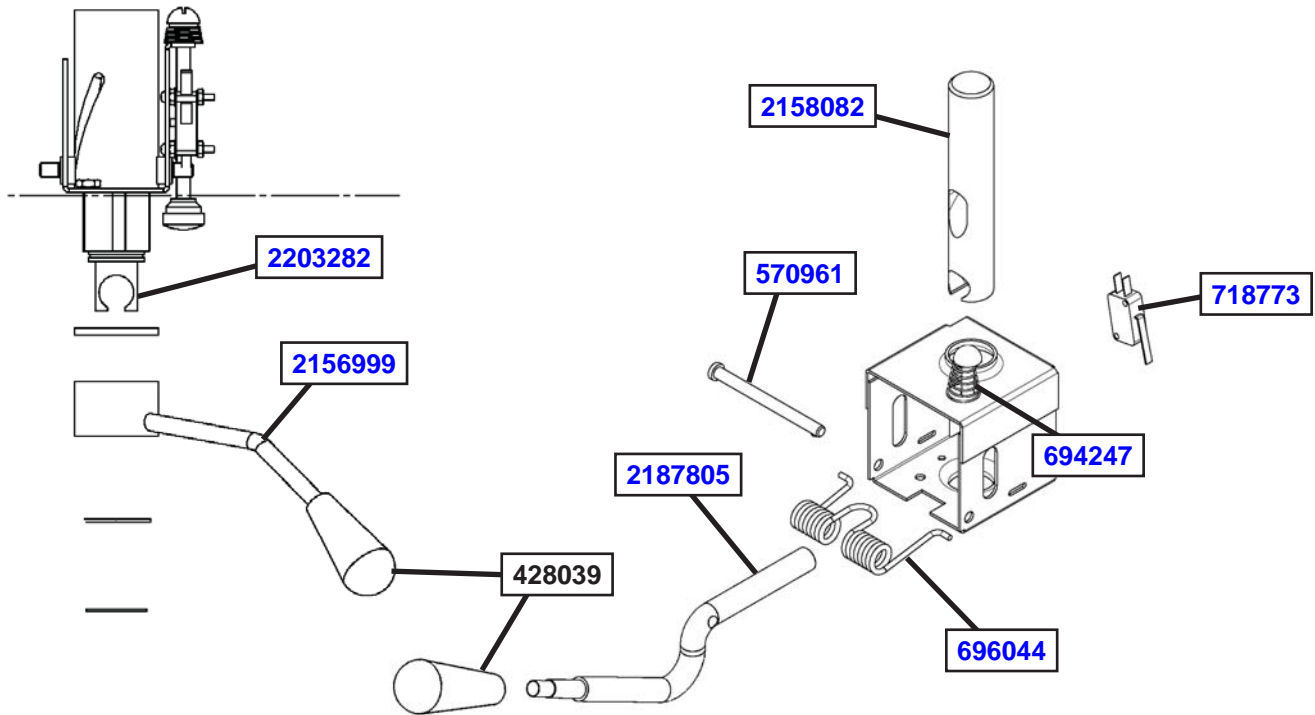
3.5 PUMP PARTS

Part Number	Description	Quantity
376035	Tee Connector - Air Pressure Switch (Cab)	2
432003-SV	Valve Head Only w/Tubes (Pump) (Cab)	2
522229	Motor - Pump (Cab)	2
538306	Nut - Motor Mounting (Cab)	8
644065	Screw - Rocker Arm (Cab)	2
650146	Set Screw - Pulley (Cab)	2
652412	Screw - Shoulder (Crank Arm Roller Assembly) (Cab)	2
653042	Screw - Thumb (Cover Clamp) (Cab)	8
667896	Seal - Bumper (Piston) (Pump) (Cab)	2
717928	Switch - Pressure (Pump) (Cab)	1
762246	Check Valve - Air Line (Stainless) (Cab)	2
766058	Washer - Lock - Motor Mounting (Cab)	8
1171860	Spring - Check Valve (Pump) (Cab)	2
1171861-SV	Needle Valve w/O-Ring (Pump) (Cab)	2
1171862	Screw - Air Filter Retainer (Cab)	2
1171863	Valve Guide (Pump) (Cab)	2
1171864	O-Ring - Needle Valve (Pump) (Cab)	2
1171866	Screw - Valve Head (Cab)	10
1171867	O-Ring (Pump Cylinder Sleeve) (Cab)	2
1171868	Reed Valve (Pump) (Cab)	2
1171870	Cylinder Sleeve (Pump) (Cab)	2
1171871	Spring - Piston (Cab)	2
1171872	Piston Spring Seat (Cab)	2
1171873	Piston (Pump) (Cab)	2
1171874	Ball Bearing - Single (Pump Rocker Arm) (Cab)	2
1171955	Set Screw - Eccentric (Cab)	2
1171956	Washer - Crank Arm - Nylon (Cab)	2
1171958	Filter - Air (Pump) (Cab)	2
1171959	O-Ring (Piston) (Pump) (Cab)	2
1171977	Roller (Crank Arm) (Cab)	2
1171978	Screw - Crank Arm (Cab)	2
1171979	Crank Arm (Cab)	2
1171980	Pulley - Large (Pump) (Cab)	1
1171981	Eccentric (Cab)	2
1171982	Knob - Crank Arm Overrun Setting (Cab)	2
1171983	Dial - Crank Arm Overrun Setting (Cab)	2
1171984	Pointer - Crank Arm Overrun Setting (Cab)	2
1171985	Dowel Pin - Rocker Arm (Cab)	2
1171986	Flange Bearing - Rocker Arm (Cab)	4
1171987	Wick - Rocker Arm (Cab)	2
1171988	Collar - Rocker Arm Dowel Pin (Cab)	2
1171989	Pulley - Small (Cab)	2
1171990	Belt (Pump) (Cab)	1
1171994	Sleeve Bearing - Crank Arm (Cab)	2
1177033	Bumper Ring (Piston) (Pump) (Cab)	2
1177034	Air Filter Retainer - Top (Cab)	2
1177035	Air Filter Retainer - Bottom (Cab)	2
1177036	Washer - Air Filter Retainer (Cab)	2
1177037	Screw - Air Filter (Cab)	2
1177681	Rocker Arm (Cab)	2
1183283	Fitting - Barbed - Air Inlet	2
2177812	Roller Carrier Assembly Kit (Cab)	-
2183067	Pump Body Casting (Cab)	2
2187698	Pump Assembly w/Motor (Cab)	
3171952	Cover - Clamp (Two Piece Black) (Cab)	2

3.5 PUMP PARTS (CONTINUED)



3.6 SPIGOT ASSEMBLY

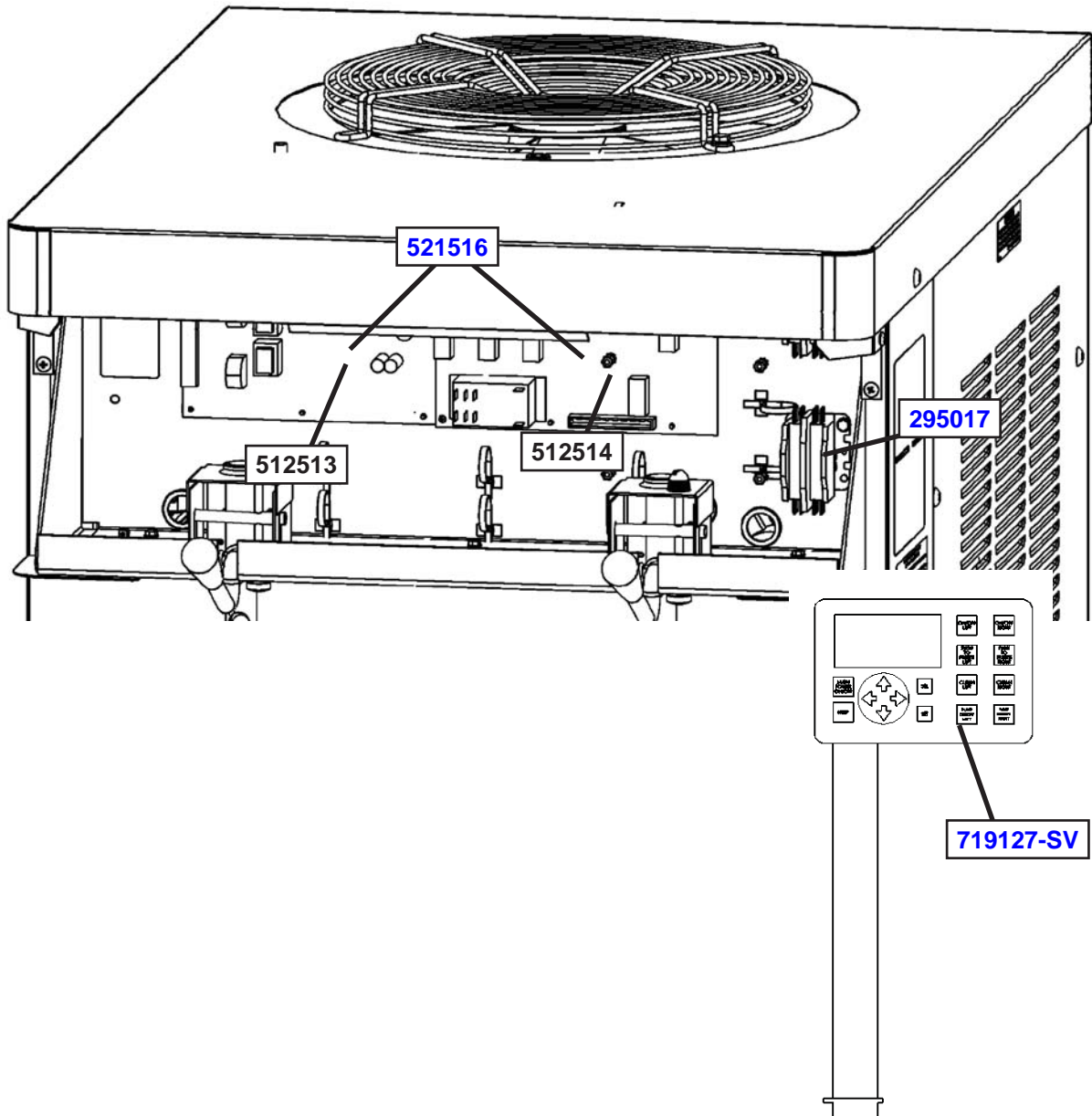


Part	Description	Quantity
428039	Knob - Spigot Handle (Black)	2
570961	Pin - Cotterless Clevis (Spigot Handle)	2
694247	Spring - Cone (Spigot Cam)	2
696044	Spring - Torsion (Spigot Handle)	2
718773	Switch - Limit (Spigot)	2
2158082	Glide - Spigot Socket	2
2156999	Handle Weldment - Spigot (Gate Style)	2
2187805	Handle - Spigot (Handle Only)	2
2203282	Glide - Spigot Adapter - Socket	2

3.7 PANELS AND SCREWS

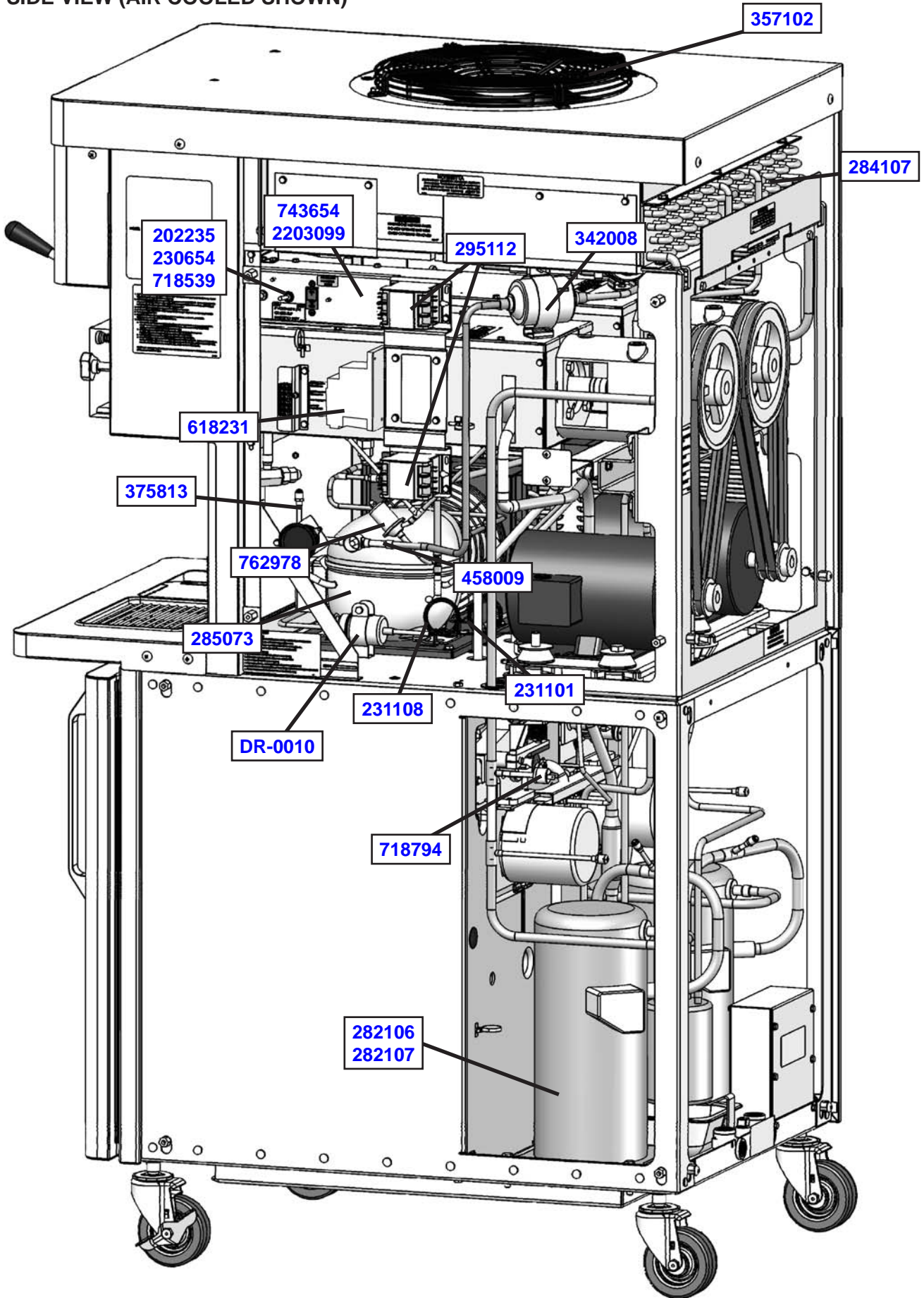
Part	Description	Quantity
232452	Plug - USB (Rubber Push-In)	
647653	Screw - Panel (Header)	-
647899	Screw - Panel (Side, Rear & Front Shroud)	-
1154886	Panel - Side Cover (Drain Tray)	1
2202935	Panel - Top (Water-Cooled)	1
2202936	Panel - Top (Air-Cooled)	1
2202939-SV	Panel - Lower Side w/Insulation	2
2203101	Panel - Header	1
2203106	Panel - Drip Tray Support	1
2203404-SV	Panel - Rear w/Insulation	1
2203405	Panel - Upper R.H. Side	1
2203406-SV	Panel - Upper L.H. Side w/Insulation	1

3.8 ELECTRICAL PANELS



Part	Description	Quantity
229148	Cable - IntelliTec2 (Control Board to Display Board)	1
229158	USB Cable Extension	1
295017	Contactor (45CG20AG) (IntelliTec2)	2
332563	Board - Display Module (Display Only)	1
521513	Board - Program / Power (IntelliTec2)	1
521514	Board - Relay (IntelliTec2)	1
521516	Board - Program / Relay (IntelliTec2)	1
718537	Switch - Limit (Door Safety)	1
719127-SV	Switch - Membrane Strip (Touchpad & Ribbon)	1

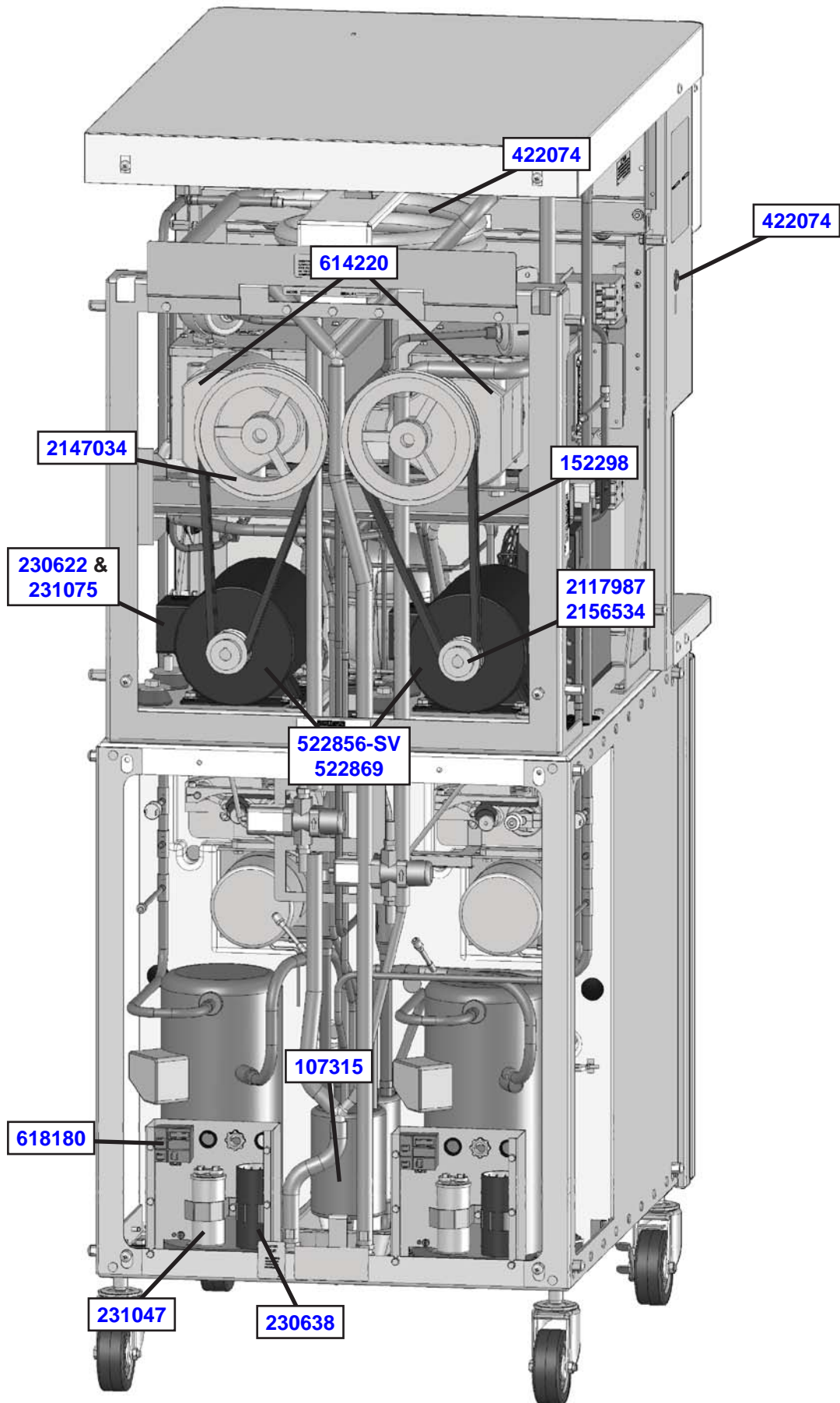
3.9 SIDE VIEW (AIR COOLED SHOWN)



3.9 SIDE VIEW (CONTINUED)

Part	Description	Quantity
DR-0010	Drier - Filter (1/4" OD) (Cab Condenser)	1
202235	Circuit Breaker	1
230654	Capacitor (Fan Motor)	1
231101	Cap Tube Only (Mix Line) (Cab)	1
231108	Cap Tube Only (Cab)	1
282106	Compressor - 1 PH - 60 Hz	2
282107	Compressor - 3 PH - 60 Hz	2
284107	Condenser (Air-Cooled)	1
285073	Condenser (Cab)	1
295112	Contactors - Compressor / Drive (42BE35AG)	4
342008	Drier (Liquid Line)	1
357102	Motor - Fan (Air-Cooled Condenser) (Includes Blade & Guard)	1
368469	Filter (Air-Cooled Condenser)	1
375813	Access Valve Fitting (Mix Line) (Cab)	1
458009	Sight Glass	1
618231	Relay - Overload (#522869 & #522853 Drive Motor)	2
718539	Switch - Toggle (Transformer Voltage Selector)	1
718686	Switch - Pressure (High Pressure Cutout) (Cab)	1
718794	Switch - High Pressure Cutout	2
743654	Transformer - Booster	1
762412	Valve - Expansion	2
762978	Valve - EPR (Cab)	1
2203098	Evaporator Assembly - L.H.	1
2203099	Evaporator Assembly - R.H.	1

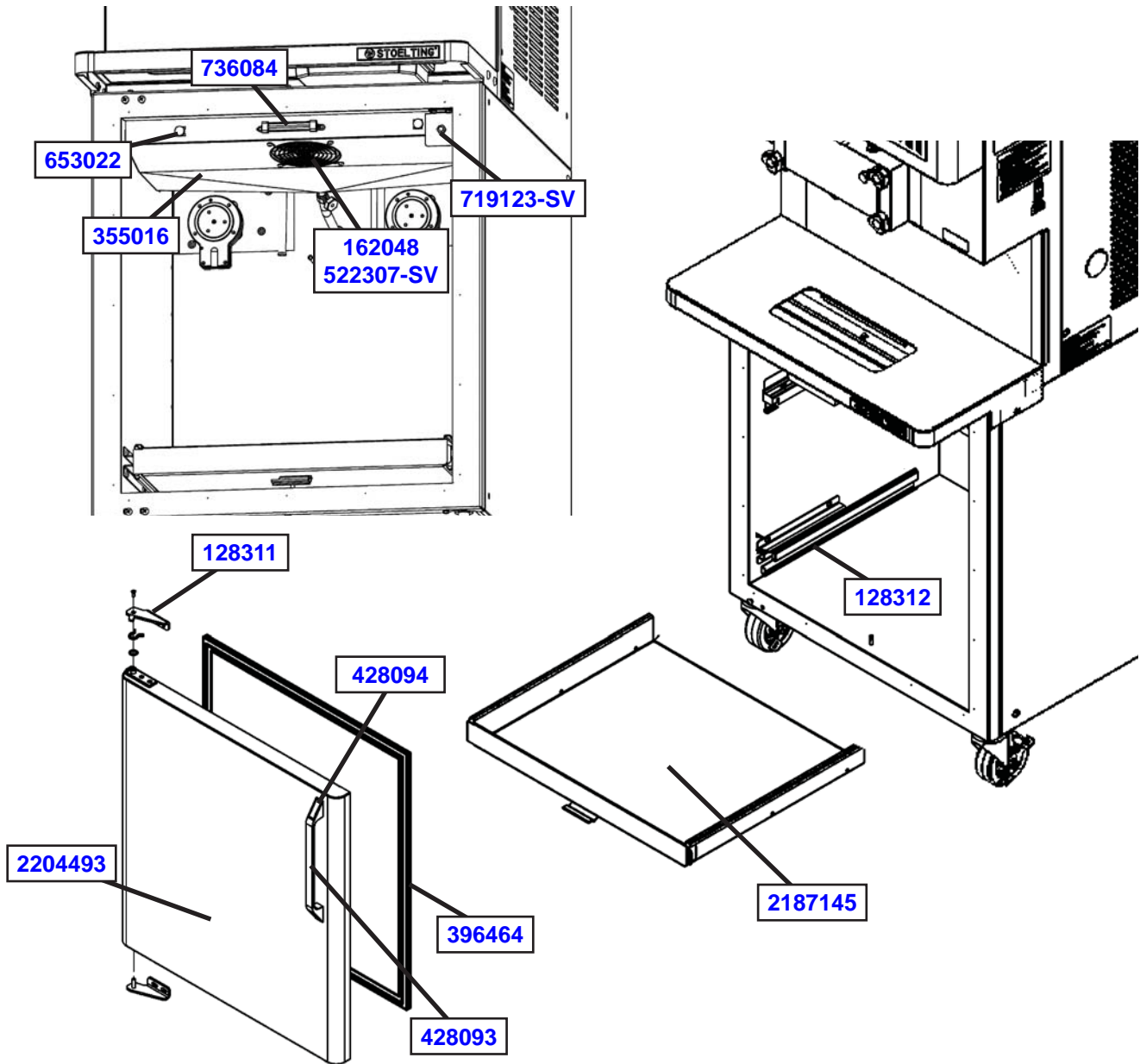
3.10 REAR VIEW (WATER COOLED SHOWN)



3.10 REAR VIEW (CONTINUED)

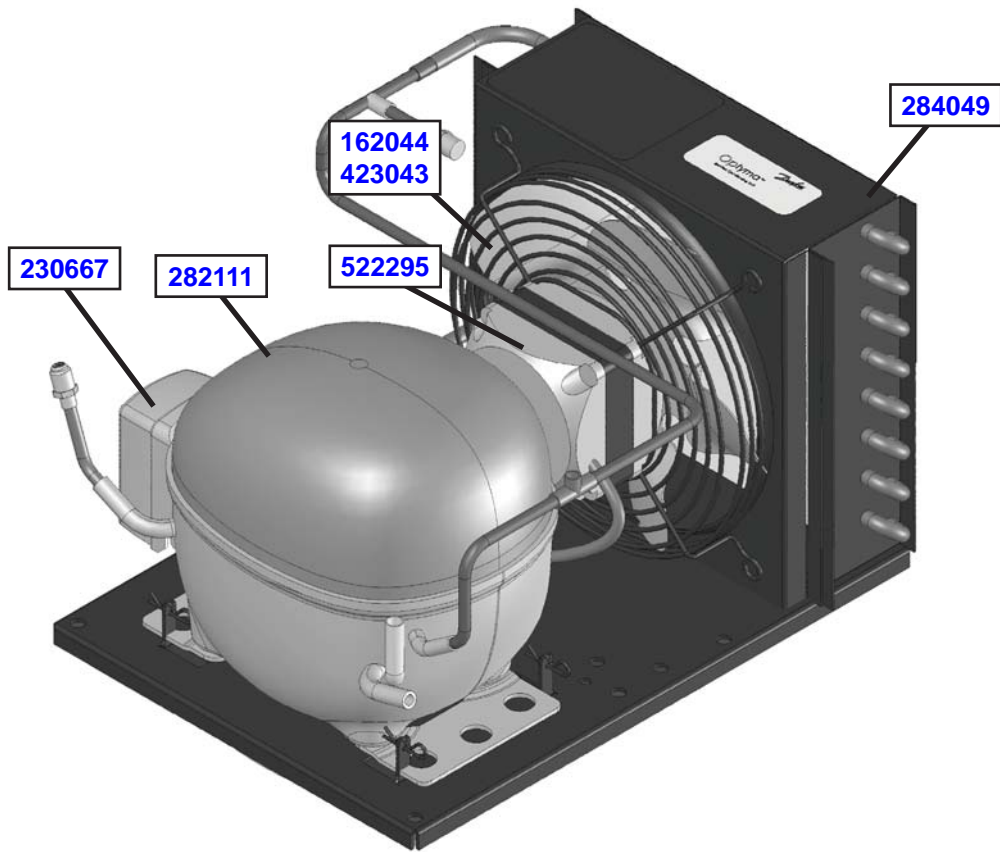
Part	Description	Quantity
107315	Accumulator	2
152298	Belt - Smooth (A38KC)	4
230622	Capacitor - Start (#522856 Motor)	2
230638	Capacitor - Start (#282082 Compressors)	2
231047	Capacitor - Run (#282082 Compressor)	2
231075	Capacitor - Run (#522856 Motor)	2
266018	Clip - "J" (Hose Holder) (Cab)	2
284104	Condenser (Water-Cooled)	1
422074	Grommet - Rubber (High Pressure Cutout)	1
522856-SV	Motor - Drive (1 PH)	2
522869	Motor - Drive (2 HP, 3 PH, 208V / 230V, 60 Hz)	2
614220	Speed Reducer	2
618180	Relay (#282082 Compressor)	2
763181	Valve - Water	2
778027	Wrench - Allen (Cab)	2
2117987	Pulley - Drive Motor (60 Hz)	2
2147034	Pulley - Speed Reducer	2
2156534	Pulley - Drive Motor (All 50 Hz)	2

3.11 CABINET



Part	Description	Quantity
128311	Hinge - Door (Top & Bottom) (Cab)	1
128312	Mix Container Holder Assembly w/Rollers (Cab)	1
162048	Blade - Fan (Evaporator) (Cab)	1
302045	Plug & Cord (Low Mix) (Cab)	2
355016	Evaporator (Cab)	1
368448	Filter - Air (Cab Condenser)	1
396464	Gasket - Door (Cab)	1
428093	Handle - Door (Cab)	1
428094	Cap - Handle (Cab)	1
522307-SV	Motor - Fan (Evaporator Assembly) (60 Hz) (Cab)	1
653022	Screw - Thumb (Cab Shroud to Evaporator)	2
719123-SV	Switch Only - Cab Door (Cab)	1
736084	Thermometer (Cab)	1
2204493	Door Assembly - Foamed (Cab)	1
2187145	Mix Container Holder (Cab)	1

3.12 CONDENSING UNIT - CAB



Part Number	Description	Quantity
162044	Blade - Fan (#285073 Condensing Unit) (Cab)	1
230667	Capacitor - Start (#285073 Condensing Unit) (Cab)	1
282111	Compressor (#285073 Condensing Unit) (Cab)	1
284049	Condenser (#285073 Condensing Unit) (Cab)	1
423043	Guard - Fan (#285073 Condensing Unit) (Cab)	1
522295	Motor - Fan (#285073 Condensing Unit) (Cab)	1
618365	Relay - Start (#285073 Condensing Unit) (Cab)	1

3.13 KITS AND MISCELLANEOUS

Part Number	Description	Quantity
232734	Cap - Rosette	4
236036	Card - Cleaning Instruction	1
244138	Caster - Non-Locking (4") (Each)	2
244139	Caster - Locking (4") (Each)	2
624677-5	O-Ring - Spigot Extension - Black (5 Pack)	-
1177436	Air Compressor Kit (Reed Valve, Piston & Cylinder Sleeve) (Cab)	-
1177606	Check Valve Kit - Air Compressor (Reed Valve, Needle Valve, Valve Guide, O-Rings & Spring) (Cab)	-
2177072	Extension - Spigot - 1.5"	-
2177073	Extension - Spigot - 2.5"	-
2177074	Extension - Spigot - 3.2"	-
2177917	Brush Kit	-
2203790	Sensor Probe Kit	-



**DOMESTIC WARRANTY
(Including Mexico)
SOFT SERVE / SHAKE EQUIPMENT**

1. **Scope:**
PW Stoelting, L.L.C. (“Stoelting”) warrants to the first user (the “Buyer”) that the freezing cylinders, hoppers, compressors, drive motors, speed reducers, and augers of Stoelting soft serve / shake equipment will be free from defects in materials and workmanship under normal use and proper maintenance appearing within five (5) years, and that all other components of such equipment manufactured by Stoelting will be free from defects in material and workmanship under normal use and proper maintenance appearing within twelve (12) months after the date that such equipment is originally installed.

2. **Disclaimer of Other Warranties:**

THIS WARRANTY IS EXCLUSIVE; AND STOELTING HEREBY DISCLAIMS ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR PARTICULAR PURPOSE.

3. **Remedies:**
Stoelting’s sole obligations, and Buyer’s sole remedies, for any breach of this warranty shall be the repair or (at Stoelting’s option) replacement of the affected component at Stoelting’s plant in Kiel, Wisconsin, or (again, at Stoelting’s option) refund of the purchase price of the affected equipment, and, during the first twelve (12) months of the warranty period, deinstallation/reinstallation of the affected component from/into the equipment. Those obligations/remedies are subject to the conditions that Buyer (a) signs and returns to Stoelting, upon installation, the Start-Up and Training Checklist for the affected equipment, (b) gives Stoelting prompt written notice of any claimed breach of warranty within the applicable warranty period, and (c) delivers the affected equipment to Stoelting or its designated service location, in its original packaging/crating, also within that period. Buyer shall bear the cost and risk of shipping to and from Stoelting’s plant or designated service location.

4. **Exclusions and Limitations:**
This warranty does not extend to parts, sometimes called “wear parts”, which are generally expected to deteriorate and to require replacement as equipment is used, including as examples but not intended to be limited to o-rings, auger flights, auger seals, auger support bushings, and drive belts. All such parts are sold

AS IS.

Further, Stoelting shall not be responsible to provide any remedy under this warranty with respect to any component that fails by reason of negligence, abnormal use, misuse or abuse, use with parts or equipment not manufactured or supplied by Stoelting, or damage in transit.

THE REMEDIES SET FORTH IN THIS WARRANTY SHALL BE THE SOLE LIABILITY STOELTING AND THE EXCLUSIVE REMEDY OF BUYER WITH RESPECT TO EQUIPMENT SUPPLIED BY STOELTING; AND IN NO EVENT SHALL STOELTING BE LIABLE FOR ANY INCIDENTAL OR CONSEQUENTIAL DAMAGES, WHETHER FOR BREACH OF WARRANTY OR OTHER CONTRACT BREACH, NEGLIGENCE OR OTHER TORT, OR ON ANY STRICT LIABILITY THEORY.