



**LVO Manufacturing, Inc.**



**CT24 Conveyor Table**  
**Owner's Manual**



\* Sanitation Listing on 9ft Table Only



# LVO Manufacturing, Inc.

808 N. 2<sup>nd</sup> Avenue E., P.O. Box 188

Rock Rapids, IA 51246

www.lvomfg.com

(712) 472-3734

1-800-346-5749 Fax (712) 472-2203

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## Warranty

LVO Manufacturing Inc. warrants equipment manufactured by it to be free from defects in material and workmanship for a period of one (1) year from date of delivery except as noted below.

LVO will **not** be held responsible for damage or unsatisfactory performance due to negligence, accident, alteration, unauthorized repair, improper installation or startup (see owner's manual), improper application, or improper maintenance (see owner's manual).

Parts found, on factory inspection, to be defective in workmanship or materials during the warranty period will be replaced (parts and labor, not overtime), provided the Buyer returns the defective parts to LVO Manufacturing Inc. within 30 days, transportation prepaid. LVO Manufacturing Inc. will pay UPS 2nd Day Air shipping charges for parts (with the exception of excessively large or heavy items) covered on warranty if the machine is not operational.

LVO Manufacturing Inc. reserves the right to make changes in design and construction of its products without imposing any obligation upon itself toward products previously manufactured.

This warranty is in lieu of any other warranties, expressed or implied, made on the part of LVO Manufacturing Inc. who does not accept responsibility to any purchaser of its products for any representation or warranty made by dealers or salespersons beyond those herein expressed including any implied warranties of merchantability or fitness for a particular purpose.

## Warranty Procedure

- 1) Locate and record the 12 digit serial number located on the side of the Production Table.
- 2) Gather as much information about the problem as possible.
- 3) Call LVO Manufacturing Inc. at 1-800-346-5749 and request technical service. Prior to performing any warranty work, you must call the factory for a warranty authorization number (WA-\_\_\_\_). This warranty authorization number must be on every invoice we receive for services rendered on the machine. Without this authorization number the invoice will not be paid. The warranty number must also be included with the defective part returned.**



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## CT24 Specifications

### Overall Dimensions

Width – 34 ½”

Height – 29 ¼”-41 ¼” Adjustable

Depth (Standard 9’ Table) – 110 ½”

### Electrical Information

115 Volt

230 Volt

Full Load Amps

7.5

3.8


## Warnings & Cautions

### General Warnings and Cautions:

1. Service work on the machine should be done by either a factory representative or qualified local service company. **Contact the factory if the machine is under warranty.**
2. Failure to follow the cleaning guidelines described in this manual will damage the machine and will void the warranty.

## Safety Features

This machine is equipped with several safety features.

 **Warning:** Do not operate this machine without all of these safety features installed and operational.

All of the features listed here are shown on the General View in the drawings section.

- |                                   |   |
|-----------------------------------|---|
| 1. Front Belt Roller Finger Guard | Prevents unintentional insertion of fingers into the gap between the front roller and the conveyor belt.  |
| 2. Chain Guard Cover              | When cover is opened, power is disconnected, shutting off the machine. The machine is designed not to restart until the cover is closed and the Start Button is pushed. |

 **CAUTION:** Before doing any service work on this machine, be sure it is unplugged.



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## **Introduction**

This manual should be read and understood by everyone involved with the installation and operation of the Conveyor Table. Keep this manual in a safe place for future reference. Extra copies or replacement copies can be purchased from the manufacturer.

Service work on the machine should be done by either a factory representative or qualified local service company. **Contact the factory if the machine is under warranty.**

The LVO Conveyor Table is designed for use in bakeries and restaurants for moulding or cutting dough for bread loaves, doughnuts, long johns, cookies, etc. LVO Conveyor Tables are constructed from stainless steel. The control system is assembled with UL approved components housed in the rear of the machine.

In addition, the LVO Conveyor Table is equipped with a variable speed drive. This lets the operator change the speed of the machine up or down depending on their own level of experience or type of dough being used. This increases the machines versatility, allowing it to be used for a wide range of products and operators.



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## Operation of Machine

### General Operation

1. Position cutter or moulding carriage onto the conveyor table carriage pins, making sure adjustment handle is on the same side as the roller adjustment handle. There are two sets of carriage notches; one to lock the carriage in place while in use, and a second smaller set to raise the carriage off the belt.
2. Select the proper cutter or pressure plate. For moulding position the pressure plate on the moulding carriage linkage with the approach/rise toward the machine sheeting rollers. Adjust plastic moulding carriage dough guides next to pressure plate.
3. Position carriage adjustment handle to desired setting; lower for lighter weight, higher for heavier weight products.
4. Select desired belt speed. Speed will vary with product type and user experience. It is recommended to start at a slower speed until machine experience and product knowledge is gained.
5. A catch tray may be provided to catch product as it leaves the carriage.



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## Scheduled Maintenance



**Always disconnect the power before servicing the machine.**

### Daily:

#### Conveyor Belt Tension and Location:

Inspect the belt for condition and location. Belt should be centered on the table. If the belt is closer to one side, tighten the adjustment nut on that side ¼ turn. Run the belt and observe for correct centering and adjust as required. Several adjustments may be required.

Belt Tightness – The conveyor belt needs to be tight enough to not slip when held by hand.

**DO NOT OVER TIGHTEN THE BELT!!**

The belt tension is adjusted by turning the adjustment nuts on both sides an equal amount.



**CAUTION: BE SURE TO REINSTALL BOTH ROLLER FINGER GUARDS AFTER ALL ADJUSTMENTS HAVE BEEN MADE.**

### Monthly:

#### Drive Chain:

1. Lightly oil the drive chain
2. Inspect for loose or worn components
3. Repair or replace as needed



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## Cleaning Instructions

 **Always disconnect the power before cleaning the machine.**

At the end of each day's use, the operator of the machine must clean the machine according to the following procedure:

1. Remove carriage (if attached).
2. Clean all food contact surfaces of machine.
  - a. Remove all excess flour and dough crumbs with dry cloth or brush.
  - b. Thoroughly clean all surfaces with hot water and soap/detergent and a clean cloth.
  - c. Rinse all surfaces with fresh warm water and a clean cloth. Do NOT reuse cloth from washing.
  - d. Mix a sanitizing solution of fresh warm water and chlorine bleach to a mixture of 1 teaspoon of bleach per gallon of water.
  - e. Wipe all food surfaces with sanitizing solution and a clean cloth. Do NOT reuse cloth from rinse. Keep cloth in the sanitizing solution when not in use.
  - f. Let all surfaces air dry.
  - g. In order to clean the entire surface of the rollers and belt, it may be necessary to run the machine for a short period of time to turn the roller/advance the belt. To do this, first replace all covers and reconnect power. Next start the machine until a new area is accessible for cleaning. Then re-disconnect the power, remove covers and continue cleaning.

 **CAUTION: DO NOT ATTEMPT TO CLEAN MACHINE WHILE RUNNING OR RUN WITHOUT ALL COVERS/SAFETY DEVICES IN PLACE.**

3. Clean food contact surfaces on the carriages using same method as the machine.
4. Wipe down all other exposed surfaces of the machine with a clean cloth. This should be done before replacing scrapers and cover.





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## Replacement Parts List

### CT24

#### Rollers

| <u>Part Number</u> | <u>Description</u>        |
|--------------------|---------------------------|
| 200-2044           | Rear Belt Roller Assembly |
| 200-6123           | Front Belt Roller Tube    |
| 200-6124           | Front Belt Roller Shaft   |

#### Pressure Plates

| <u>Part Number</u> | <u>Description</u> |
|--------------------|--------------------|
| 200-2001           | 6" Plate           |
| 200-2002           | 9" Plate           |
| 200-2003           | 12" Plate          |
| 200-2032           | 14" Plate          |
| 200-2004           | 16" Plate          |
| 200-2034           | 18" Plate          |
| 200-2031           | 20" Plate          |
| 200-2039           | 22" Plate          |
| 200-2009           | Bolillo Plate      |



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## Miscellaneous Parts

### Part Number

200-6114

200-6009

200-6010

200-2010

201-2027

200-6064

200-6177

200-6176

200-6178

201-2024

523-5003

519-5020

517-5010

517-5043

### Description

Catch Tray

Moulding Carriage Dough Guide – L/H

Moulding Carriage Dough Guide – R/H

Moulding Carriage

Cutter Carriage

Front Belt Roller Finger Guard

Moulding Carriage Adjustment Handle

Carriage Handle Hub

Moulding Carriage Adjustment Rack

Cutter Carriage Handle

Carriage Handle Spring

Adjustment Handle Pin

Caster – Plate Mount

Caster – Stem Mount



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## Electrical Parts

### Part Number

512-5013  
512-5018  
511-5246  
511-5247  
511-5205  
511-5107L  
511-5107R  
511-5105

### Description

¾ HP DC Motor – 90 VDC  
Motor w/Gearbox – 90 VDC  
DC Speed Control  
Speed Potentiometer  
NO Contact Block  
On/Off Station – Left Side  
On/Off Station – Right Side  
Miniature Limit Switch

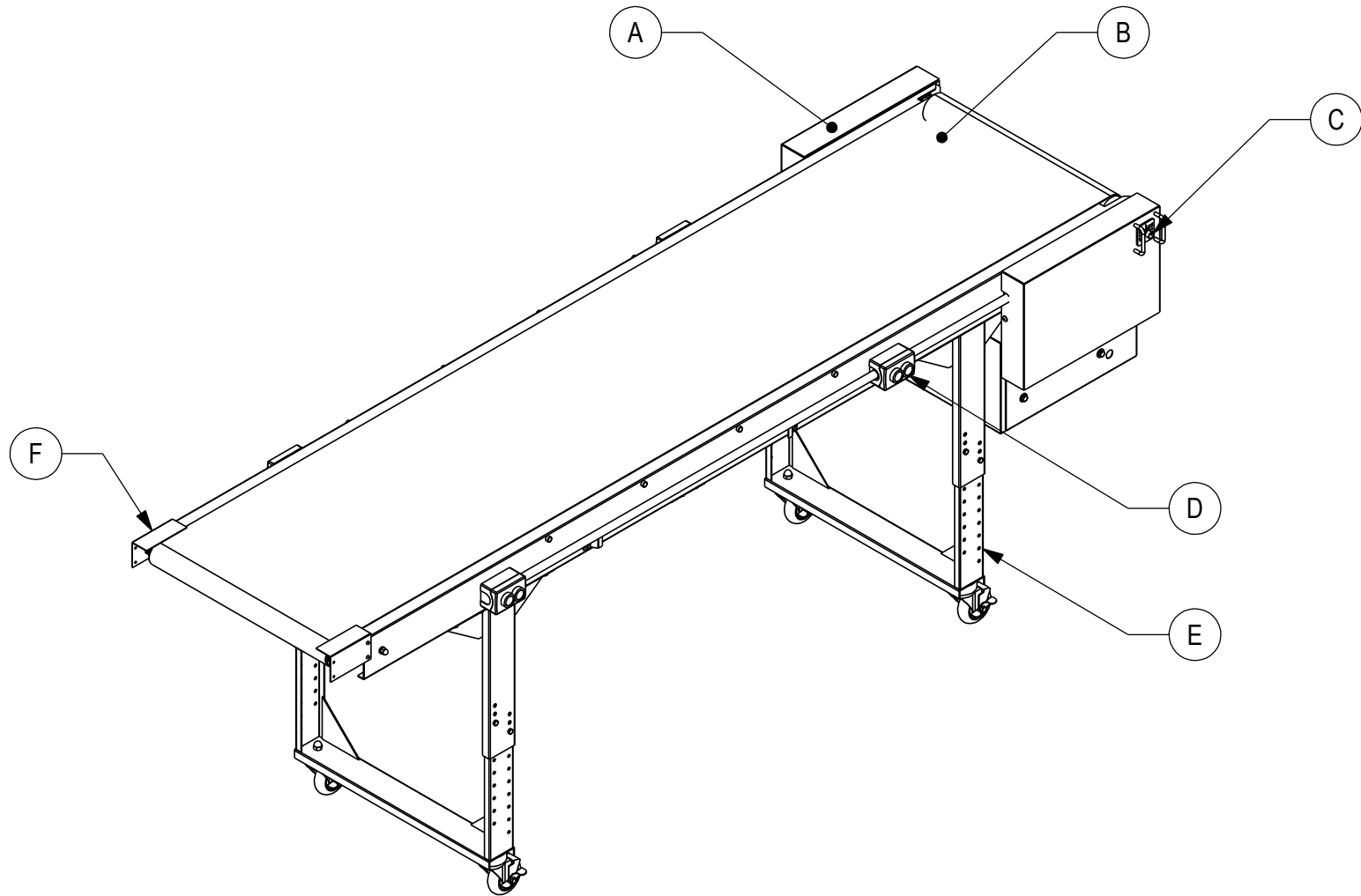
## Drive Parts

### Part Number

525-5003  
525-5004  
525-5012  
525-5013  
525-5036  
204-6045

### Description

¾" Cam-Lock Bearing – Rear Belt Roller  
Stamped Bearing Flangette – Rear Belt Roller  
12 Tooth Sprocket – Motor  
13 Tooth Sprocket –Belt Drive Roller  
Front Belt Roller Bearing (no Flange)  
Drive Chain



- A. Chain Guard Cover
- B. Conveyor Belt
- C. Speed Control Knob
- D. Start/Stop Station
- E. Adjustable Leg
- F. Front Belt Roller Guard

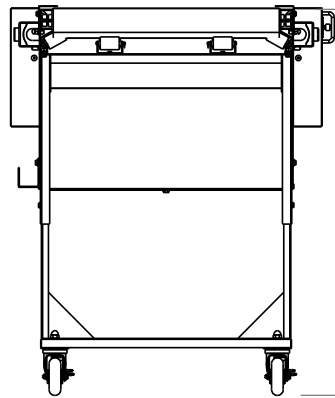


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Name: General View CT24-9

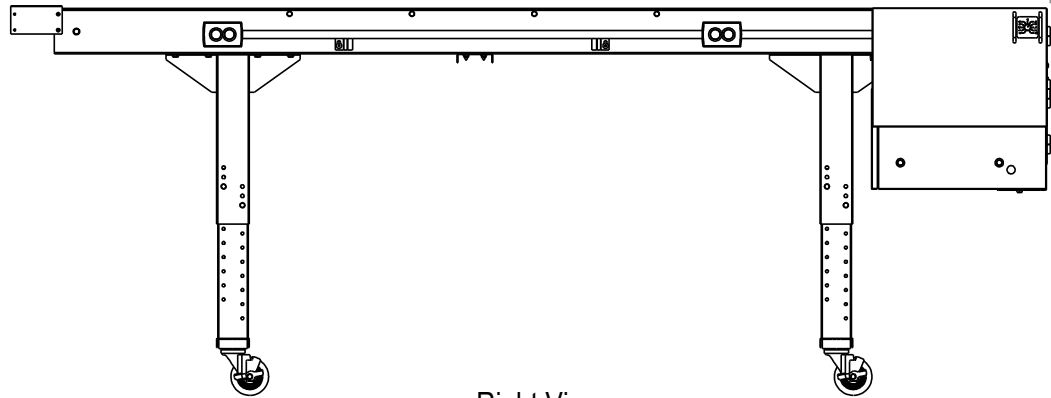
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|------------|------------|----------------|----------|--------|
| 3/23/2015  | Scale 1:16 | Ga. -          | Finish - | Mat. - |
| C. Woiwood | Rev. -     | No. 204-1009-7 |          |        |

34 1/2"



Front View

110 1/2"



Right View

Adjustable  
Table Height  
29 1/4" to 41"



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Name: CT24-9

3/23/2015

Scale 1:20

Ga. -

Finish -

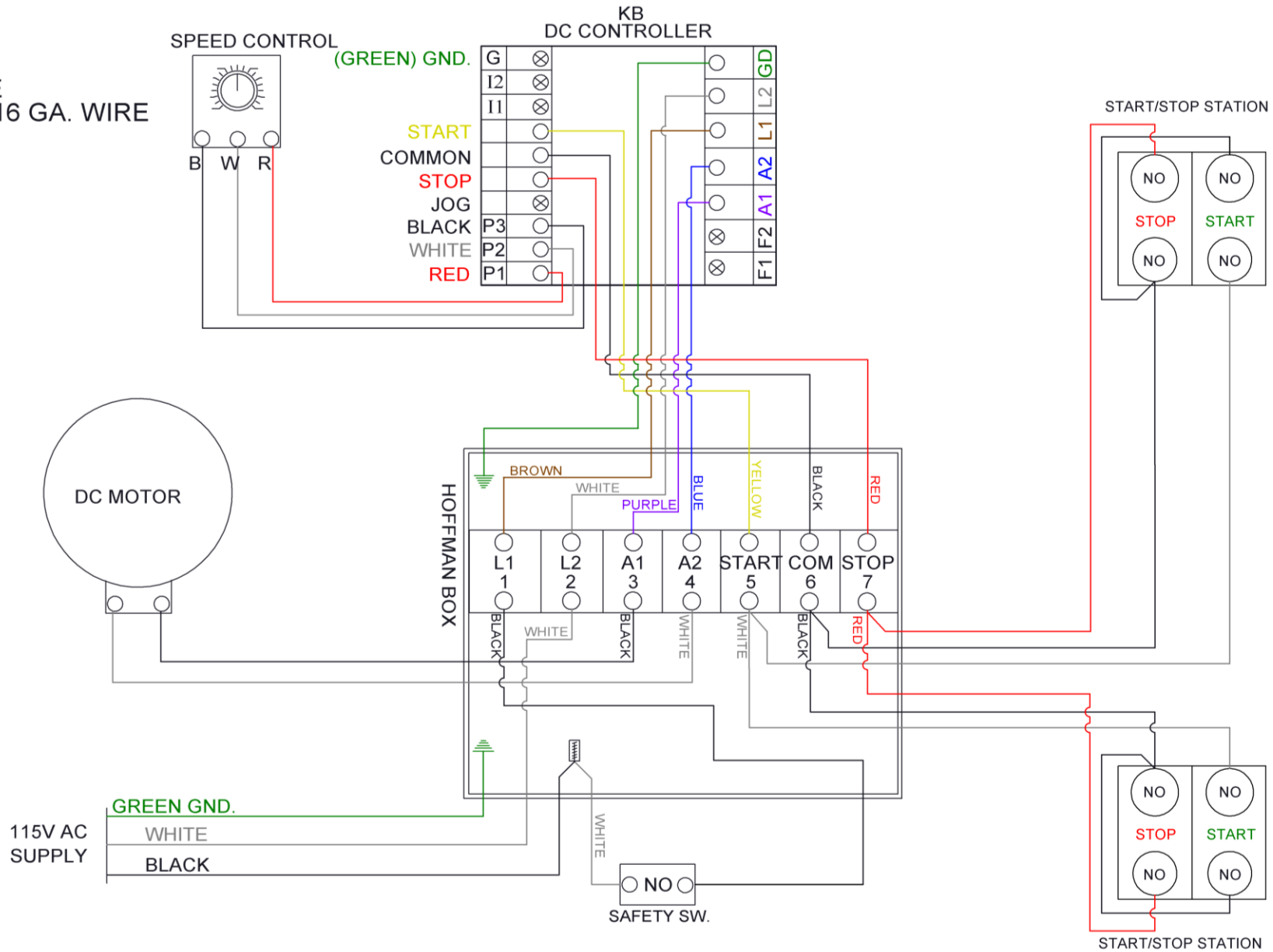
Mat. -

C. Woiwood

Rev. -

No. 204-1009-1

NOTE  
USE 16 GA. WIRE



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|        |          |
|--------|----------|
| Mat. - |          |
| Ga. -  | Finish - |
| Rev. - |          |

Scale 1:1  
12/13/2011  
C. Woivood

Name: S/M Schematic  
-  
No. 122-1030KB1-CT