DUKERS®

Gas Energy-Saving Steamer Cabinet

Model: DCSC24/DCSC30/DCSC36/DCSC48/DCSC54

Thank you for purchasing and using the **Gas Energy-Saving Steamer Cabinet**. To fully understand the features, installation requirements, and operating procedures of this product, please read this manual carefully. Retain this manual for future reference.

When installed, this appliance must be electrically grounded in accordance with local codes. In the absence of local codes, grounding must comply with the **National Electrical Code (NFPA 70)** or the **Canadian Electrical Code (CSA C22.2)**, as applicable.

Installation must comply with all local codes. Where local codes do not exist, installation must conform to the **National Fuel Gas Code (ANSI Z223.1/NFPA 54)** or the **Natural Gas and Propane Installation Code (CSA B149.1)**, as applicable, including the following requirements:

i) The appliance and its individual shutoff valve must be disconnected from the gas supply piping system during any pressure testing of the system at test pressures exceeding **1/2 psi (3.5 kPa)**.

ii) The appliance must be isolated from the gas supply piping system by closing its individual manual shutoff valve during any pressure testing of the gas supply piping system at test pressures equal to or less than **1/2 psi (3.5 kPa)**.

The vent line from the gas appliance pressure regulator must be installed outdoors in accordance with local codes or, in the absence of local codes, in compliance with the **National Fuel Gas Code (ANSI Z223.1/NFPA 54)** or the **Natural Gas and Propane Installation Code (CSA B149.1)**.

FOR YOUR SAFETY

Do not store or use gasoline or other flammable vapors and liquids in the vicinity of this or any other appliance.

⚠ **WARNING:** Improper installation, adjustment, alteration, service or maintenance can cause property damage, injury or death. Read the installation, operating and maintenance instructions thoroughly before installing or servicing this equipment.

Catalogue

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Operating Instructions

This operating manual is an integral part of the equipment and provides essential information for safe operation, cleaning, maintenance, and troubleshooting. It must be made available to all personnel responsible for operating or servicing the equipment.

- Before operating the equipment, all authorized personnel must read and understand this manual, with particular attention to the **Safety Tips** section.
- This operating manual must be retained for the entire service life of the equipment.
- Ensure that the manual is readily accessible to personnel at the equipment's installation site at all times.
- This manual must be transferred to any subsequent owner or user of the equipment.
- Incorporate any additional information or updates provided by the manufacturer into this manual.
- Include operating guidance covering monitoring and reporting responsibilities for abnormal conditions, such as instructions related to labor organization, work procedures, or assigned personnel.

Target Groups

- This operating manual is intended for operators who are trained and experienced in equipment operation, cleaning, maintenance, and fault response.
- Servicing, repair, and technical maintenance of the equipment must be performed only by specially trained and authorized professionals.
- This manual is not intended for use by persons (including children) with reduced physical, sensory, or mental capabilities, or by individuals lacking the necessary experience and knowledge.
- If you are unable to fully understand the contents of this manual, do not operate the equipment. Contact your supervisor for assistance before use.

Safety Tips

Safety Instructions

This product complies with applicable safety standards. However, compliance with these standards does not eliminate all potential hazards, particularly those arising from improper installation, operation, or maintenance.

The operator is responsible for understanding and complying with all applicable local regulations when installing and operating the equipment. In addition, observe the following safety instructions:

Burn and Scalding Hazards : Excessively hot surfaces, steam, and hot liquids may cause serious burns.

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. Wear heat-resistant protective gloves during operation.
. Allow surfaces to cool before cleaning.
. Do not touch baking pans or internal components immediately after operation.
. Hot grease presents a significant scalding hazard.

Fire Hazard here: Accumulated grease, dirt, and improper operation may result in a fire hazard.

. Clean the equipment after each use.
. Follow all cleaning instructions provided in this manual.
. Do not leave the equipment unattended during operation.
. When operating the equipment without food, run it only for a short duration.
. Use only original manufacturer-approved replacement parts.
. Use proper cooking utensils suitable for high-temperature operation.

Ventilation Warning:

. Do not block air vents. Ensure all vents always remain unobstructed.
. Blocking ventilation openings may cause equipment damage and increase the risk of fire.

Transportation and Storage

During transportation, the equipment must be handled with care and must not be inverted or tilted excessively, as this may cause damage to the exterior casing or

internal components.
When temporary storage is needed, rainproof measures shall be taken.

Packaged equipment should be stored in a well-ventilated area free from corrosive gases or substances.
If temporary outdoor storage is required, appropriate rainproof and moisture-protection measures must be taken to prevent damage.

Warranty and Responsibility

Unauthorized modifications or technical changes to the equipment are strictly prohibited. Any such modifications will immediately void all warranty and liability claims and may compromise the safe operation of the equipment.

The manufacturer assumes no responsibility or liability for personal injury or property damage resulting from one or more of the following conditions:

- Improper or unintended use of the equipment
- Incorrect installation, commissioning, operation, or maintenance
- Unauthorized technical modifications made without prior approval from the manufacturer
- Use of replacement parts or accessories not approved by the manufacturer
- Failure to comply with the instructions and warnings contained in this operating manual

Product Specifications

Product Introduction

Producing nutritious, safe, and hygienic food while reducing customer waiting time, reliable and efficient cooking equipment is essential. Drawing on decades of manufacturing and research experience and supported by advanced production testing equipment and strict quality control systems, the company has developed the **Dukers® series Gas Energy-Saving Steamer Cabinets** to meet professional commercial kitchen requirements.

This eco-friendly gas steamer series is designed to be **energy-efficient, safe, reliable, clean, and hygienic**, making it an ideal cooking solution for professional chefs and foodservice operations.

Product Features

1. The steamer cabinet water tank is constructed of stainless steel. All components in contact with water and steam are made of food-grade stainless steel for durability and hygiene.
2. The optimized water tank structure provides a large heating surface area and high thermal efficiency. While ensuring sufficient steam output, gas consumption is reduced by approximately **20%**.
3. A specially designed burner is matched to the water and fire tube structure to ensure complete combustion. Harmful emissions such as carbon monoxide and nitrogen oxides are minimized, heat distribution is uniform, and overall service life is extended.
4. Two main gas control valves regulate multiple burners. Steam output can be adjusted as needed, offering three operating modes: **rapid steaming, slow steaming, and heat preservation**.
5. Each steaming compartment operates independently with no steam leakage. The optimized steam flow design ensures uniform heating from top to bottom and improves overall steam utilization.
6. A specially designed silicone door gasket combined with a reinforced locking mechanism ensures a tight seal and prevents steam leakage.
7. Fan-free combustion design eliminates the need for electrical power during combustion and reduces operating noise to below **65 dB(A)**.
8. A pressure-balanced automatic water supply tank ensures stable and reliable water levels within the system.
9. Water shortage protection is built in to prevent dry firing and damage to the water tank.
10. The unit is equipped with a continuous pilot flame for reliable ignition.
11. A step-by-step safety control system ensures that gas flow is only enabled after successful ignition, preventing excessive gas accumulation and improving operational safety.
12. Thermocouple flame-failure protection provides fast response in the event of

flame extinguishment, ensuring safe and reliable operation.

13. Steam control switches and steam safety discharge ports are installed on each layer of the steamer cabinet, ensuring safe, convenient, and independent operation for multi-layer use.
14. Each steam layer features a U-shaped drainage structure that prevents steam from escaping from the lower sections of the cabinet, improving safety and efficiency.
15. The water tank is equipped with a **Φ1-1/2″ ball valve drain**, with the handle positioned at the front for easy access and water discharge. Daily draining significantly reduces scale buildup and effectively extends the service life of the water tank.
16. The detachable steam inlet and exhaust passage design complies with sanitation and hygiene requirements, allowing for easy disassembly and thorough cleaning.
17. The layer racks are designed for easy assembly, disassembly, and pull-out operation, providing a user-friendly experience for loading and unloading food.
18. All spare and serviceable components are accessible from the front of the unit. No side maintenance clearance is required, improving space utilization and simplifying installation and servicing.

Product Specifications

Technical Parameters

Model	Size			Fuel connection	Water entry	Drain	Calorific value		Rated pressure Pa
	L	D	H				KW	B.T.U/h	
DCSC24	24.02	34.65	74.80	DN20	DN15	DN40	26	90000	1000
DCSC30	30	34.65	74.80	DN20	DN15	DN40	39	135000	1000
DCSC36	36	34.65	74.80	DN20	DN15	DN40	39	135000	1000
DCSC48	48	34.65	74.80	DN20	DN15	DN40	52	180000	1000
DCSC54	54.02	34.65	74.80	DN20	DN15	DN40	52	180000	1000

Remarks: The specifications and standard configuration of each product model are subject to the information shown on the product rating label.
Model Selection: Models **DCSC24/DCSC30/DCSC36/DCSC48/DCSC54** are subject to change without prior notice as part of ongoing product improvement.

Product Specifications

Structure

The **Dukers Eco-Friendly Steamer Cabinet** is a commercial Chinese-style steamer designed as an **open-pressure steaming appliance** with an open heating structure. The unit is divided into upper and lower sections.

The **lower section** is responsible for steam generation and consists of a stainless steel water tank, water inlet control tank, combustion system, and drainage system.

The **upper section** utilizes the generated steam for cooking and includes a stainless steel inner liner, outer cabinet body, and insulated cabinet door.

The stainless steel water tank features a fire-tube heating design with an internal **S-shaped fire tube**. Water level is automatically controlled by a float valve located in the water supply tank. The steamer cabinet is equipped with a **Φ1/2″ (DN15) water inlet** and a **Φ1-1/2″ (DN40) drain outlet**.

The combustion system is governed by a multi-level safety control system. When ignition is not established, the main gas valve remains closed to prevent excessive gas flow. The system includes thermocouple flame-failure protection for enhanced safety. The burners and corresponding fire tubes use self-inducting atmospheric structures, ensuring stable and efficient combustion.

The main burners are regulated by two primary gas control valves, allowing the operator to select different heat output levels as required.

The Eco-Friendly Steamer Cabinet is equipped with **three independent steaming chambers**, each featuring **four removable rack levels** for flexible cooking capacity.

Installation Instructions

Installation Notices

1. Product Selection

1.1 The **Eco-Friendly Steamer Cabinet** must be installed with appropriate exhaust and ventilation equipment.

1.2 Users shall select the appropriate model of the Eco-Friendly Steamer Cabinet based on gas type, installation conditions, and intended use.

1.3 The gas type specified for the selected steamer cabinet must match the gas supply available at the installation site.

1.4 The installation location must comply with all general installation requirements for commercial cooking equipment.

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2. Installation Requirements

2.1 Installation must be carried out in accordance with all applicable local regulations and codes at the installation site.

2.2 At the time of installation, the equipment must be inspected by the supplier or an authorized service organization.

2.3 The Eco-Friendly Steamer Cabinet is intended for installation in a commercial kitchen environment and must be placed on a level, stable surface.

2.4 The installation site must meet the following conditions:

A. The required exhaust airflow must be greater than **30.7 m³/h per kW** of heat input.

B. Fire protection, heat insulation, and other safety measures must comply with applicable local fire safety regulations.

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3. Water Supply Requirements

The steamer cabinet requires a suitable water supply for proper operation. Soft water is recommended. The concentration of oxides and nitrates in the water should not exceed **100 mg/L**.

Recommended Water Quality Parameters:

- pH value: **6.5 – 9.5**

- Water hardness: **≤ 8° dH** (1° dH = 10 mg CaO/L)
- Minimum water pressure: **0.2 MPa (2 bar)**
- Maximum water pressure: **0.4 MPa (4 bar)**

If the water hardness exceeds **8° dH**, a water softener must be installed to prevent scale formation caused by calcium deposits within the steamer. When using a water softening system, follow the manufacturer's installation and operating instructions.

Important: Damage to the equipment caused by scale buildup or improper water quality is **not covered under warranty**.

Installation Approval and Location Restrictions
Installation of the **three-door steamer cabinet** must be approved by both the local gas authority and the equipment supplier, in accordance with the gas supply conditions at the installation site and applicable commercial kitchen installation requirements.
The steamer cabinet **must not** be installed in the following locations:
A. Basements of residential buildings
B. Areas used for storing flammable or explosive materials
C. Rooms containing corrosive gases or substances
D. Locations in close proximity to exposed wiring or electrical equipment

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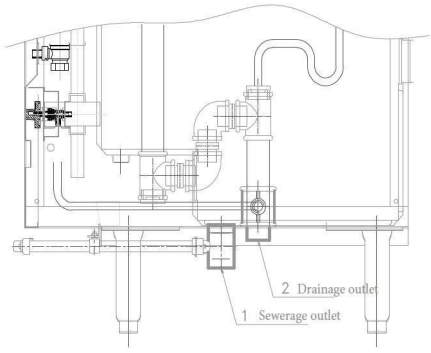
Clearance Requirements
The minimum safety clearance for the steamer cabinet is **150 mm**. The distance between the steamer and any combustible materials on both sides must be **greater than 150 mm** to ensure safe operation and proper ventilation.

Installation Instructions

Installation Instructions

1. **Site Verification**
   Before installation, confirm that the installation site meets all required conditions. Fire prevention, heat insulation, ventilation, and other safety measures must comply with applicable fire safety regulations. Verify that the gas type, gas pressure, gas supply capacity, and gas connection location meet the equipment's installation requirements.
2. **Equipment Positioning**
   Place the equipment in its designated location and confirm that the installation position matches the design layout. Adjust the leveling feet and use a spirit level to ensure the unit is properly leveled.
3. **Pipeline Installation**
   Install piping according to the principle of **"from inside to outside, and from larger diameter to smaller diameter."**
4. **Water Supply Connection Requirements**
   - Install a dedicated, easily accessible shutoff valve on the water supply branch line.
   - A stainless steel corrugated hose connection is recommended.
   - Due to potential inlet pressure fluctuations, installation of a water pressure regulator is recommended.
   - Check valves are recommended to prevent backflow.
   - The water softener and steamer must not be connected using galvanized steel or other corrosion-prone materials, as this may cause corrosion and rust.
5. **Drainage Connection Requirements**
   The drainage system is located at the bottom of the steamer cabinet and includes the following outlets:
   - **Sewage outlet:** Water must be drained daily to reduce scale buildup.
   - **Condensate outlet:** Collects condensate from the steamer and water from the front water tank and discharges it into the drain system.
   - The drain pipe diameter must be **Φ1-1/2"**.
   - Water may be discharged directly to a floor drain or



kitchen drainage trench.
    - If a drain pipe is connected, a backflow prevention device must be installed to prevent reverse flow in the event of blockage.
    - The drain pipe must not be tapered or reduced in diameter.
6. **Gas Connection Requirements**
    - The gas supply pipe connected to the steamer cabinet must be equipped with an independent, easily accessible manual shutoff valve.
    - Installation must comply with all applicable local gas regulations and codes.
    - Because the equipment may move or vibrate during operation, the use of a stainless steel flexible gas connector is recommended.

Important: Gas connections and installation must be performed only by properly licensed and authorized personnel.

Operation Instructions

Commissioning (Debugging)

1. **Gas Pipeline Leak Testing**
   - Use a pressure gauge to check the gas pipeline for leaks.
   - Set the test pressure to a **1 m water column**, then connect the pipeline.
   - If the water column remains stable with no pressure drop for **1 minute**, the system is considered leak-free.
   - To locate potential leak points, apply soapy water to all joints and connections and observe for bubble formation.
2. **Gas Venting**
   - Gas venting may only be performed after the gas pipeline connections have been verified as leak-free.
   - Venting must be carried out by properly licensed personnel.
   - Observe all safety precautions during venting operations.
3. **Burner Setup and Adjustment**

A. **Initial Adjustment**
   - Burner adjustment must be performed by trained professionals after the gas supply pressure has stabilized.
   - Ignition adjustments must follow the procedures outlined in the **Operating Instructions** section.
   - For safety verification, a visible ignition flame should be present at the burner outlet to confirm proper ignition.

B. **Ignition Requirements**
   - No gas accumulation should occur before ignition.
   - Main burner ignition must occur smoothly without flashback or deflagration.
   - Flames must remain stable during operation and must not extinguish unexpectedly.
   - The ignition flame must not impinge on the edges of the main burner head.

C. **Main Burner Adjustment**
   - Adjust the air inlet and air shutter to achieve the correct primary air volume.
   - Operate the main gas control valve to verify ignition quality and combustion performance.

D. **Flame Observation**
   - In the presence of moisture, dust, or soot, the flame may appear slightly yellow while remaining clear and strong. This is considered a

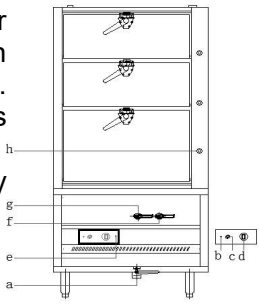
normal operating condition and does not indicate incomplete combustion.

Final Leak Check: After burner adjustment, perform a final leak test using soapy water or a gas leak detection device while the unit is operating. Confirm that no gas leakage is present before placing the equipment into service.

Operation Instructions

Operating Procedures

1. Before starting the equipment, ensure that the kitchen exhaust system is operating and ventilation is unobstructed. Confirm that the main gas supply valve is open and that gas supply is normal.
2. Verify that all surface control valves **(f, g)** are in the closed position. Then open the gas shutoff valve located in front of the unit.
3. Confirm that the water and gas supplies are functioning properly. Observe the water level through the sight window and ensure it reaches the designated level.
4. For ignition, lift the small round handle **(e)** on the waterproof cover plate and open the cover, as shown in Figure 5.
5. Open the ignition valve **(d)** and press the safety valve to activate it. Ignite the burner using an electronic igniter with a **3-second delay**. Once ignition is established, the main burner safety valve will open. After ignition, close the waterproof cover; the handle will automatically lock in place. Close the ignition valve and inspect the flame. If operation is normal, proceed with the next steps.
6. Hold the safety valve for approximately **5 seconds** to ensure stable combustion. Slowly open the main burner valves **(f, g)**. Do not open the valves too quickly, and do not operate the main burner valves in a partially open position.
   Note: If the water-shortage protection thermostat **(b)** has been activated, it must be reset before re-ignition.
7. When loading or unloading food during operation, pull out the steam shutoff rod **(h)** to close the steam outlet, or close the main burner valves **(f, g)**. Allow steam to dissipate before opening the cabinet to prevent steam burns.
8. When the unit is unattended or temporarily not in use, do not leave the main burner operating. Close the main burner valves **(f, g)** and keep only the pilot flame ignited.
9. To shut down the unit, close the ignition valve **(d)** to extinguish the pilot flame, then close the main burner valves **(f, g)**.
10. At the end of each workday, open the drain valve **(a)** for approximately **2 minutes** to drain the water tank. Then close the valve and allow the tank to refill automatically. This procedure helps reduce scale buildup and extends the service life of the water tank.
11. Under normal operating conditions, the water supply valve in front of the unit should remain open.



Operation Instructions

Operating Instructions

Caution

A. The steamer must be operated strictly in accordance with the procedures and precautions outlined in this manual.

B. During handling and operation, avoid impact or collision with hard objects to prevent damage to the unit.

C. Always operate the steamer with the kitchen ventilation and exhaust system turned on to ensure proper air circulation.

D. Do not ignite or operate the main burner if the pilot flame is not lit, is unstable, or if combustion is abnormal.

E. If flame failure occurs, wait at least **5 minutes** before attempting to relight the burner.

F. Avoid loading or unloading food while the steamer is operating to prevent steam burns. If necessary, pull out the steam shutoff rod to close the steam inlet or close the main burner valves before opening the cabinet.

G. During operation, ensure that the steam outlet, safety discharge port, drain outlet, and exhaust port are functioning properly and are not blocked or obstructed.

H. Do not leave the equipment unattended while the main burner is operating.

I. Long-term operation may cause dust and carbon buildup in the heat exchanger, which can affect combustion efficiency and increase carbon monoxide levels. To ensure safe operation, qualified service personnel must clean the water tank and burner assembly **at least every six months**.

J. Three burners are controlled by two main burner valves **(f, g)**. Different steam output levels can be selected based on operational needs, including **rapid steaming, slow steaming, and heat preservation** modes.

K. After use, always close the gas shutoff valve located in front of the steamer.

Abnormal Operation Warning

If gas leakage or abnormal combustion conditions occur (such as flame lifting, flashback, yellow flames, or deflagration), immediately discontinue use of the steamer and notify qualified service personnel from the manufacturer or an authorized service agent. Unauthorized disassembly or repair is strictly prohibited.

Maintenance

Cleaning and Maintenance

A. When cleaning the exterior of the steamer or surrounding kitchen areas, do **not** rinse or spray the unit with water hoses or high-pressure water. Water intrusion may damage internal components and affect normal operation.
B. B. Inspect and replace burners as required. When reinstalling a burner, ensure that the nozzle orifice is properly aligned with the centerline of the burner ejector tube and that the flame position remains correctly aligned with the main burner.
C. C. Gas valve maintenance includes inspection of valve tightness in both open and closed positions, sealing performance, obstruction or contamination, and proper switch orientation.
D. D. Burner inspection shall include checks for gas tightness, combustion condition (including flame stability, flashback, yellow flame, deflagration, or flame lift), and blockage of the nozzle orifice.
E. E. Perform maintenance in accordance with a regular preventive maintenance schedule to ensure safe and reliable operation.

Name	Item	Daily	Weekly	Every 3 Months	Every 6 Months
Steam Layer and Outer Body	Cleaning	O			
Water Thank (Water Bladder)	Drain water	O			
Drain Valve	Inspection			O	
Pull Rod Valve	Inspection & Clean			O	
Chimney	Inspection & Clean				*
Gas Valve	Tighten control components		O		
	Inspection				*
Main Pilot Burner	Inspection				*
Safety Valve	Leak detection				*

Permanent Pilot Burner	Inspection & Cleaning				*
Float Valve	Inspection				*
Water Shortage Protection Thermostat	Inspection				*
Steam Outlet	Inspection				*
Steamer Door Lock	Inspection & Repair				O
Steamer Door Hinge	Inspection & Repair				O
Note: * Indicates maintenance tasks that must be performed by qualified service professionals authorized by the contractor or manufacturer.					

Maintenance

Maintenance Requiring Equipment Movement

A. Turn off the steamer and close the independent **water supply shutoff valve**.

B. Turn off the steamer and close the independent **gas supply shutoff valve**.

C. Disconnect the piping connections between the shutoff valves and the equipment before moving the unit.

Replacement of Components

A. Before replacing any components, ensure that both the **water supply valve** and **gas supply valve** are fully closed.

B. Remove the equipment access panel and replace the required parts in accordance with manufacturer instructions.

Maintenance

Corrosion Prevention

1. Keep all equipment surfaces clean, dry, and properly ventilated at all times.
2. Regularly remove scale buildup, grease, starch, and protein residues to prevent corrosion and maintain hygiene.
3. Periodically remove salt deposits from stainless steel surfaces.
4. Stainless steel components should only be exposed to concentrated acids, seasonings, salt, or similar substances for short periods of time.
5. Do not use metal tools or abrasive cleaning materials (such as steel wool pads or wire brushes) that may damage stainless steel surfaces.
6. Avoid contact between stainless steel and iron or carbon steel materials, including steel wool, iron-based cleaning tools, pipe debris, or iron-contaminated water.
7. The use of bleaching agents or chlorine-containing cleaning products is strictly prohibited.
8. After cleaning, rinse all contact surfaces thoroughly with clean, fresh water.

Fault diagnosis

Common Fault Detection and Troubleshooting

Malfunction	Possible Cause	Corrective Action
Pilot flame is weak or will not ignite	● Gas supply valve not open ● Gas supply system shut down ● Burner port blocked ● Pilot nozzle blocked	● Check and open the gas supply valve ● Contact the gas supplier for emergency service ● Clean burner ports ● Have the nozzle inspected and serviced by qualified personnel
Pilot flame ignites but will not remain lit	● Thermocouple damage ● Safety valve damage	● Replace thermocouple ● Inspect and service safety valve
Flashback or flame extinguishes when main burner is operating	● Improper pilot flame combustion	● Contact qualified service personnel for adjustment
Flame out during use	● Water shortage protection thermostat activated ● Thermostat failure ● Gas supply interruption ● Safety valve damage	● Check water supply and refill if necessary inspection & handling ● Replace thermostat ● Contact gas supplier for emergency service ● Repair or replace safety valve
Water tank overflow	● Float valve malfunction ● Water level set too high ● Steam outlet from water tank blocked	● Replace float valve or seal ● Adjust float valve to maintain water level **65–70 mm** below the top of the tank ● Clean and service steam outlet
Steam leakage at cabinet door	● Door gasket damaged ● Door misalignment or deformation ● Door lock damaged	● Replace door gasket ● Adjust door alignment ● Replace door lock
Water accumulation in steam chamber or water flowing back into tank	● Drain pipe blockage	● Clean and clear drain pipe

★ **Note:** Equipment failures should be analyzed based on specific conditions. Troubleshooting and repairs must be performed by qualified service personnel using appropriate professional tools and experience to ensure safe and effective resolution.

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