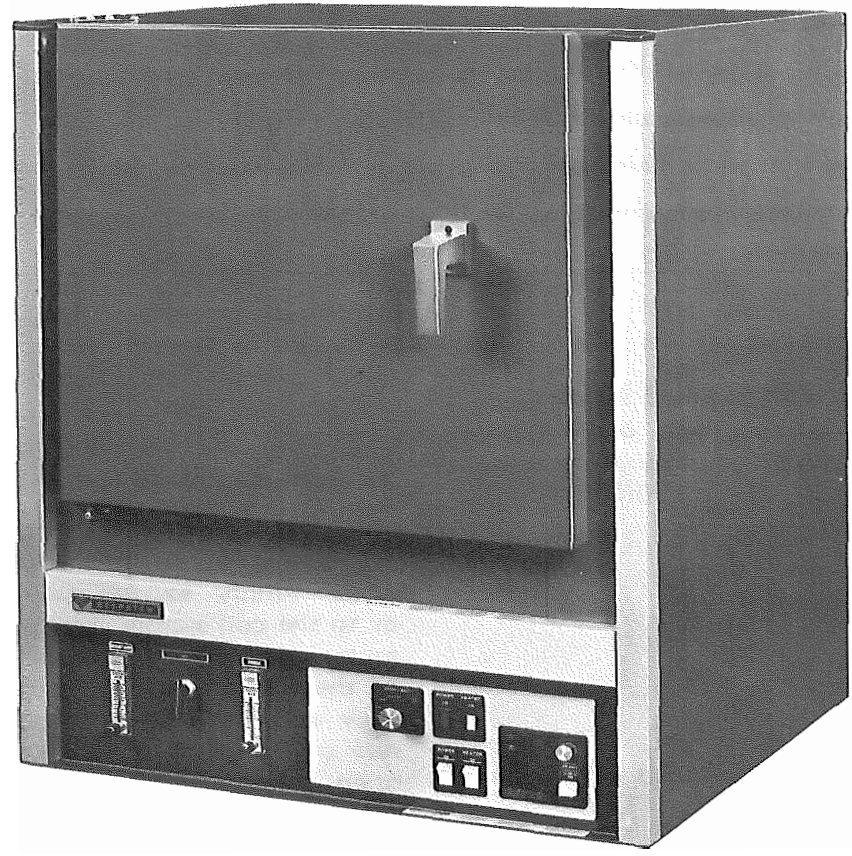


**NOTE: Manual For Reference Only - Actual Oven May Vary Depending on Model Year, Options, Controllers, and Individual Configuration**

For Information And To Order  
Contact Us At:  
323-770-0634 800-574-2748  
sales@LRE.com [www.LRE.com](http://www.LRE.com)



# Operator's Manual for LND 1 42 oven



Despatch LND 1-42 oven is a nitrogen gas atmosphere bench oven with a maximum operating temperature of 316°C (600°F) and with forced convected airflow.

MODEL	VOLTS	PHASE	HZ	HEATER WATTS	TOTAL AMPS
LND 1-42	240	1	60	3,000	14.6

## INTRODUCTION

The Despatch LND 1-42 is a precise high quality, high volume inert atmosphere oven featuring a horizontal airflow system for rapid, uniform distribution of heat throughout the chamber.

To obtain optimal results from your Despatch oven thoroughly familiarize yourself with this manual and the various procedures outlined.

**WARNING:** Failure to heed these restrictions can result in property damage, serious bodily injury or death.

DO NOT use oven in wet, corrosive, or explosive atmosphere.

DO NOT attempt any service on this equipment without disconnecting the main power switch.

DO NOT exceed maximum operating temperature of 316°C (600°F).

DO NOT use any flammable solvent or other flammable materials or enclosed containers in the oven.

DO NOT attempt any service on this equipment without shutting off the nitrogen gas supply.

DO NOT use with other than inert gases.

### Unpacking, Inspection and Packing List

Remove all packing materials and inspect the oven for damage. If damaged, and damage is due to shipment, contact the shipper immediately. If oven parts are damaged, or if parts are missing, contact Despatch Customer Service at 800/328-5476. (In MN 800-462-5396)

You should have in this box:

- One oven
- Two shelves
- One package containing four rubber feet
- One operators manual
- Warranty card

Any optional accessories ordered will be shipped separately.

### Installation

Remove the adhesive backing sheet from the rubber feet and attach the rubber feet to the bottom corners of the oven.

Place the oven on a bench top or an optional cabinet base. The oven must have a minimum of 2" clearance in the rear to provide proper ventilation but may be placed next to another cabinet or oven (the doors will still open).

Make sure oven is level and plumb, this will assure proper heat distribution and operation of all mechanical components.

Check the oven power requirements for amperage and voltage (this is listed on the cover of the manual). Connect the electric supply directly to your oven (see electrical schematic in back of manual) with all required grounding and safety equipment, in compliance with applicable codes, ordinances and accepted safe practices.

A note on line voltage: Line voltages may vary according to your geographical location. If line voltage is significantly lower than oven voltage rating, heat up times will be extended, and motor may overheat. If line voltage varies  $\pm 10\%$  from the oven voltage rating, temperature control will operate erratically.

Ovens designed for 240 volts (see name plate on oven) will operate satisfactorily on a minimum of 208 volts, but with a

reduction in heater power. If your power characteristics are lower, contact Despatch Industries, Inc.

Connect the nitrogen supply line (from a tank) to the inlet located on the oven rear panel and marked nitrogen supply. The nitrogen supply to the oven must not exceed 80 PSI.

Mount the cooling water flowmeter (optional) as desired and run tubing from flowmeter to coil supply. Connect a clean water supply to the flowmeter connection marked inlet or to the coil supply direct from a valve if the optional flowmeter was not purchased. The brass needle valve on the face of the water flowmeter can be used for adjusting the water flow or shutting off the water flow. The other pipe on the rear of the oven marked water drain should be piped to an open drain and never allowed to be plugged as a hot oven will generate a small amount of steam when the water is first turned on.

#### A. PRE-START-UP

##### 1. KNOW THE SYSTEM:

Read this manual carefully. Make use of its instructions and explanations. The "Know How" of safe, continuous, satisfactory, trouble free operation depends primarily on the degree of your understanding of the system and of your willingness to keep all parts in proper operating condition.

##### 2. CHECK LINE VOLTAGE

This must correspond to nameplate requirements of motors and controls. A wrong voltage can result in serious damage.

#### B. START-UP

##### 1. START FAN AND CHECK ROTATION

Rotation MUST correspond to the directional arrow provided.

##### 2. ADJUST HI-LIMIT TO OPERATING POSITIONS

The hi-limit thermostat can be used for the protection of the equipment or the product against excessive temperatures when set properly.

Hi-limit thermostats of the non-indicating type (ones which do not show the temperature) can be properly set only after oven is in operation. Until then, such thermostats should be set at their maximum positions so all preliminary testing and adjusting can be done. Before putting oven into production, adjust this type of thermostat as follows: Set the temperature control at 14°C (25°F) above the desired operating temperature. Operate oven until the control setpoint is reached. Carefully adjust the hi-limit downward until it trips. Reset the temperature control at the desired operating temperature. The two instruments are now set in their correct positions.

NOTE: Never operate oven at a temperature in excess of the maximum operating temperature which is 316°C (600°F).

### 3. NITROGEN SUPPLY CHECK

Turn the three way valve on the control panel to the "off" position and screw the adjusting knob clockwise on both PURGE and MAINTAIN flowmeters all the way in to the "off" position. Then open the tank valve on the nitrogen supply and set the pressure regulator to about 40 psi. Check the nitrogen plumbing for leaks using a soapy water solution. As nitrogen gas is odorless, all leaks should be stopped to prevent the possibility of suffocation in a small work area in which a nitrogen leak might displace much of the oxygen in the atmosphere.

NOTE: All ovens are tested at the factory; however, shipping may cause damage or deviation. Therefore, before oven is put into regular service, the following items should be inspected and adjusted if necessary: control and hi-limit calibration, doors, hinges, latches and other miscellaneous parts.

### C. OPERATION

#### 1. KEEP EQUIPMENT CLEAN

Gradual dirt accumulation retards air flow. A dirty oven can result in unsatisfactory operation such as unbalanced temperatures in the work chamber, reduced heating capacity, reduced production, overheated components, etc.

Keep the walls, floor and ceiling of the oven work chamber free of dirt and dust. Floating dust or accumulated dirt may produce unsatisfactory results.

Keep all equipment accessible. Do not permit other materials to be stored or piled against it.

#### 2. PROTECT CONTROLS AGAINST EXCESSIVE HEAT

This is particularly true of controls, motors or other equipment containing electronic components. Temperatures in excess of 51.5°C (125°F) should be avoided.

#### 3. ESTABLISH MAINTENANCE AND CHECK-UP SCHEDULES

Do this promptly and follow them faithfully. Careful operation and maintenance will be more than paid for in continuous, safe and economical operation.

#### 4. MAINTAIN EQUIPMENT IN GOOD REPAIR

Make repairs immediately. Delays may be costly in added expense for labor and materials and in prolonged shut down.

#### 5. LUBRICATION

Fan motor bearings are permanently lubricated.

All door latches, hinges, door operating mechanisms, bearing or wear surfaces should be lubricated to ensure easy operation.

#### 6. CHECK SAFETY CONTROLS

This should be done as indicated in a and b below.

Make these tests carefully and do them regularly. The safety of personnel as well as the equipment may depend upon the proper operation of any one of these controls at any time.

##### a. TEMPERATURE CONTROL (Every 40 hours)

Observe heater indicator light flashes every 1 to 2 seconds when the control is operating at set point temperature.

##### b. HI-LIMIT (Every 40 hours)

With the oven operating at a given temperature, gradually turn the hi-limit control knob down to the set point operating temperature. The hi-limit is in control when the heater indicator light is on for 3 or more seconds at a time rather than a fraction of a second.

#### 7. PRACTICE SAFETY

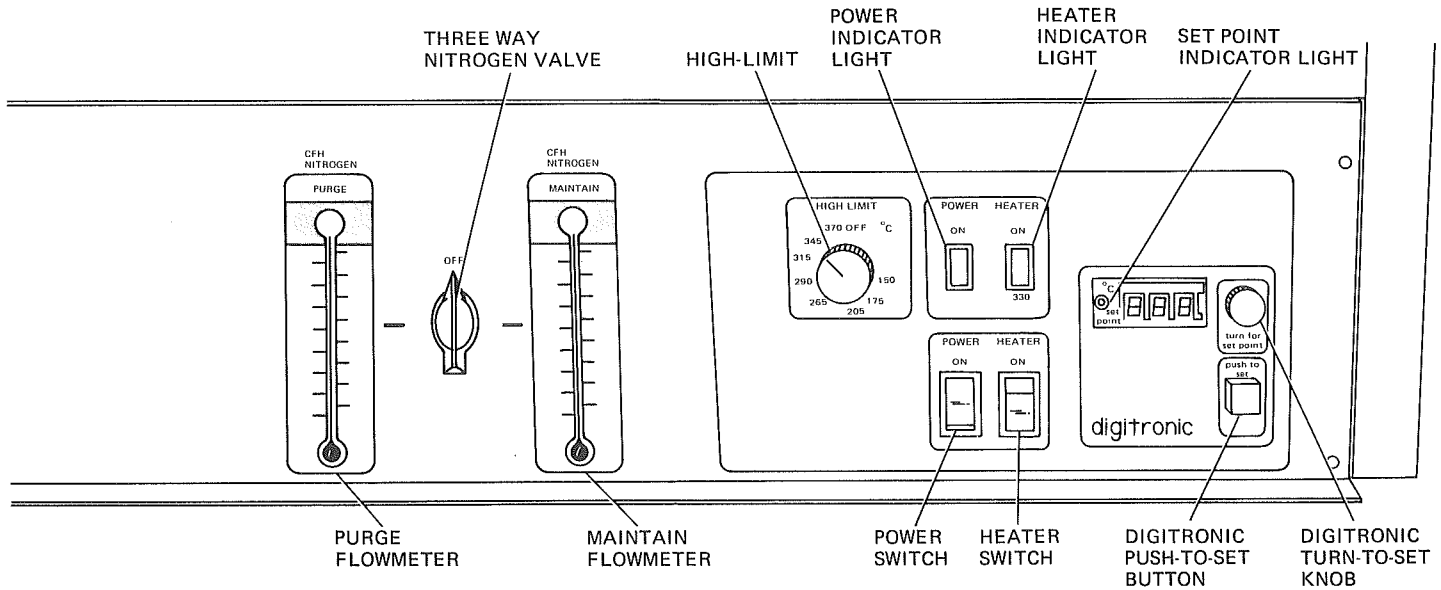
Make it a prime policy to "know what you are doing before you do it." Make CAREFULNESS, PATIENCE and GOOD JUDGEMENT the safety watchwords for the operation of your oven.

### IMPORTANT

**WARNING:** Failure to heed these restrictions can result in property damage, serious bodily injury or death.

THE USER(S) OF THIS EQUIPMENT MUST COMPLY WITH OPERATING PROCEDURES AND TRAINING OF OPERATING PERSONNEL AS STATED IN THE OCCUPATIONAL SAFETY AND HEALTH ACT (OSHA) of 1970, SECTION 5, AND THE NATIONAL FIRE PROTECTION ASSOCIATION (NFPA) 86A of 1973 (ARTICLE 100, SECTION 2d, 5 AND APPENDIX 1).

## Operation



### Starting the Oven

1. Push power switch to "ON" (indicator light should light). This activates the fans and control circuit.
2. Press and hold "push-to-set" button on the Digitronic™ temperature control. The display will be in the set point mode and the set point indicator light is on as long as the button is depressed.
3. Rotate "turn-to-set" knob until the desired chamber temperature is displayed. Release the "push-to-set" button. Note that the set point will be changed if knob is turned when button is not depressed.
4. Set hi-limit device by rotating hi-limit control knob to 10-15°C (18-27°F) above process temperature. Set point should be low enough to prevent damage to the workload but high enough to allow the Digitronic to control at set point. Hi-limit will assume control of heater if chamber temperature exceeds high limit set point.
5. Push heater switch to "ON". Heater indicator light should light. When the desired temperature is reached, the Digitronic will proportion power to the heater as needed and the heater indicator light will flash on and off.
6. The readout area will alternately display set point and actual chamber temperature. Set point is on display when the small light shows above the "set point" label.
7. Oven set point can be displayed at any time by manually depressing and holding the "push-to-set" button. This will not disengage the control function.
8. The nitrogen portion of this oven consists of a manual three way valve and two flowmeters connected by piping between these components and to the inlet connection on the lower back panel marked nitrogen supply. The three positions of the valve are PURGE to the left, OFF in the center, and MAINTAIN to the right. The flow rates of the PURGE and MAINTAIN can be set by the needle valve at the bottom of each flowmeter. Refer to Figures 1-3 for times and flow rates to achieve the listed conditions.

9. When operating this oven without the water cooling coil, the minimum operating temperature is 75 degrees centigrade over the ambient room temperature. This is the result of the heat generated by the recirculating fan and since this is a nitrogen atmosphere oven, air vents are not possible. The water cooling coil must be used when operating below approximately 100 degrees centigrade or when cooling a load that has been processed at a higher temperature in a relatively short period of time. The water flow is controlled by the optional cooling water flowmeter and can be adjusted or shut off by the brass needle valve on its face. See Figure 4 for approximate cooling coil performance for various water flow rates in an empty oven.

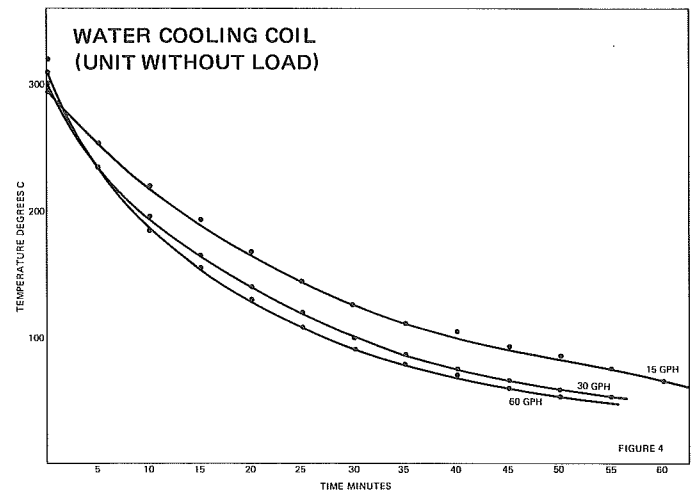
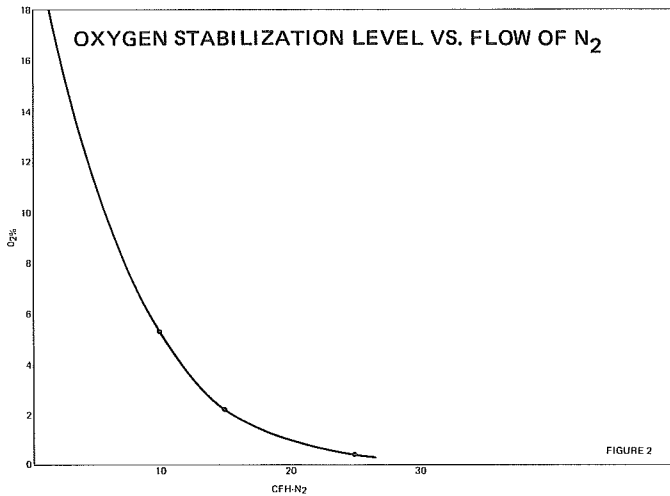
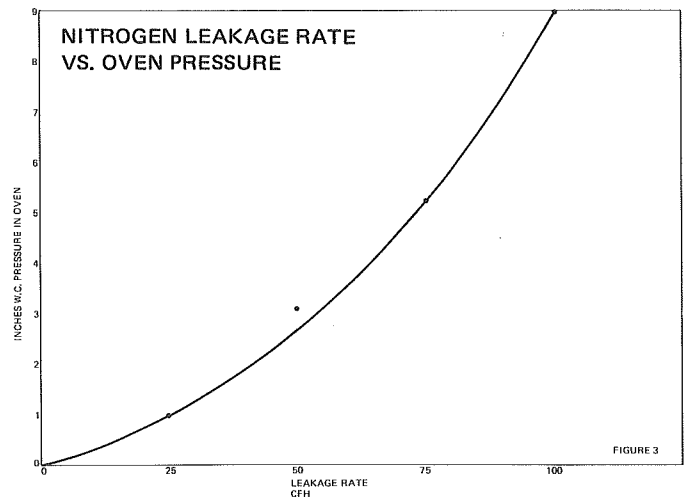
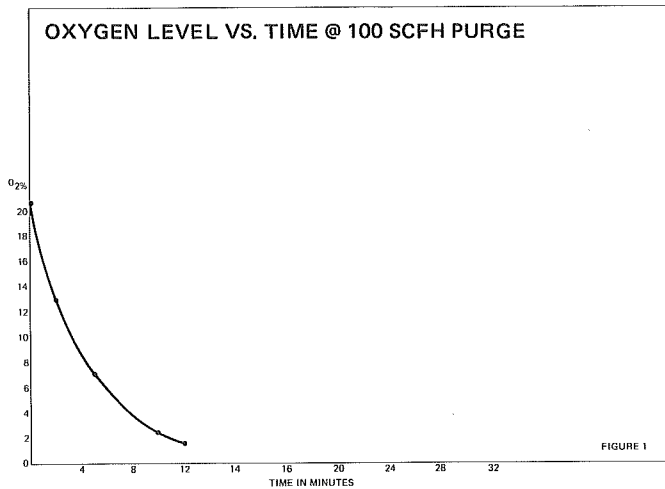
### Loading the Oven

1. Avoid spills of anything onto the heater elements or floor of oven.
2. The two shelves are designed to be pulled out about half-way without tipping.
3. The support capacity of the shelves is 25 pounds. Do not overload the shelves.
4. Do not place the load on the oven floor plate. Placing the load on the oven floor plate may cause the load to heat unevenly. Use the shelves provided.
5. Distribute workload evenly so that airflow is not restricted.
6. Do not overfill your oven. The workload should not take up more than two-thirds of any dimension of the inside cavity.

### Shutting down the oven

1. Push the heater switch to "OFF" after the heating cycle is complete.
2. Do not turn the power off until the oven temperature is below 150°C (302°F). If the oven is turned off before it is properly cooled, the fan shaft and motor bearings may become overheated, shortening the life of the motor.
3. Turn the nitrogen control valve to OFF.
4. Turn off the water supply to the cooling coil or the valve on the face of the optional cooling water flowmeter.

## Typical Performance Data



### How to replace parts

**WARNING — Disconnect main power switch or power cord before attempting any repairs or adjustments.**

**Replacing control unit (Tools needed: screwdriver, either an adjustable wrench or a nut driver, pliers)**

1. Disconnect power. Remove screws from the face of the control panel and slide it forward.
2. Locate the Digitrone printed circuit (PC) board.
3. Remove wires from terminal strip, noting which numbered wires connect to which terminals. Refer to wiring diagram in this manual.
4. Remove the screws holding the terminal board onto sub-panel. Replace old PC board with new PC board. Attach board to sub-panel.
5. Reattach wires to terminal strip making sure the correct ones are connected.
6. Replace control panel.

**Replacing heater unit (Tools needed: crescent wrench, screwdriver)**

1. Disconnect power. Remove floor plate by removing screws and lifting it out.

2. Disconnect heater leads from heater element with wrench. Note which wires go on which terminals.
3. Unscrew the screws holding the frame to the oven body. Remove the heater and discard.
4. Screw down new heater frame.
5. Attach heater leads to appropriate terminals.
6. Replace interior floor.

**Replacing fan motor (Tools needed: screwdriver, 5/32" Allen wrench, and crescent wrench)**

1. Disconnect power. Remove chamber floor by removing screws and lifting it out.
2. Remove the screws from heater frame then tip up and to the right.
3. Loosen set screws on fan wheel inside fan housing.
4. Remove the screws from the face of the control panel and slide it forward to uncover motor.
5. Tip oven on its back.
6. Unbolt the four bolts holding the motor to the motor mount.
7. Remove motor (NOTE: After fan wheel has run at temperature for a while, it will stick to the shaft. Some force may be required to separate the two). Suggest holding the fanwheel against the insulated wall while using a mallet and center punch to loosen the shaft from the fan.

8. Disconnect motor leads from terminal block.
9. Hold new motor in place while you remount fan wheel to motor shaft. Reattach motor to motor mount.
10. Attach motor lead wires to terminal block (see wiring diagram).
11. Replace oven control panel and bottom, then tip oven upright again.
12. Adjust fan wheel for 3/16" clearance between wheel and inlet ring.
13. Tighten set screws making sure set screws hit the flats machined into the motor shaft.
14. Bolt heater back in place.
15. Replace interior floor.

#### Replacing the hi-limit (Tools needed: small screwdriver)

1. Disconnect power. Remove the screws from the face of the control panel and slide it forward.
2. Locate control thermocouple and hi-limit bulb along the left side of the control chamber.
3. Loosen the nut on the brass fitting holding the hi-limit capillary in place.
4. Pull hi-limit capillary out of the fitting. NOTE: Avoid rough handling.
5. Carefully uncoil the new capillary tube, taking care not to kink it.
6. Feed the new hi-limit capillary through the nut and ferrule and place back into the fitting.
7. Retighten the fitting nut.
8. Remove the "hi-limit" label on the outside of the control panel.
9. Detach the old hi-limit body by unscrewing the screws that were underneath the label.
10. Remove the hi-limit and discard.
11. Attach the new hi-limit. Put on the new label. Reattach the knob.
12. Replace control panel of oven.

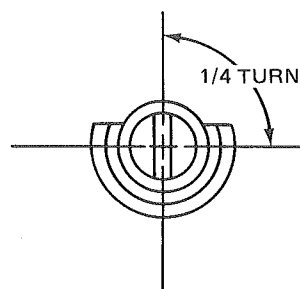
#### Recalibrating the hi-limit

(Tools needed: small screwdriver)

The hi-limit device was calibrated at our factory; however it may need periodic checking and recalibration. If the hi-limit overrides the Digitronic when the hi-limit is set above Digitronic set point, the hi-limit needs recalibration. The hi-limit is in control when heater indicator light is lit for 2-3 seconds at a time rather than for a fraction of a second. Recalibrate using the following procedures:

1. Turn oven on and set controller at 260°C (500°F). It should be stabilized at temperature for about one hour before adjustments are made.
2. Set hi-limit to 260°C (500°F). Pull hi-limit control knob off. Calibration screw is located in the center of the thermostat shaft.
3. 1/4 turn of the screw equals approximately 20°C (68°F).
4. If hi-limit set point is HIGHER than actual oven temperature, (Digitronic readout) turn calibration screw counter-clockwise.
5. Turn the screw until the heater shuts off.
6. If set point is LOWER than actual temperature, turn screw clockwise.

7. Turn the screw until the heater turns on.
8. If readings do not coincide within 30 minutes, repeat operation.
9. Replace knob on shaft.



#### Thermocouple break protection

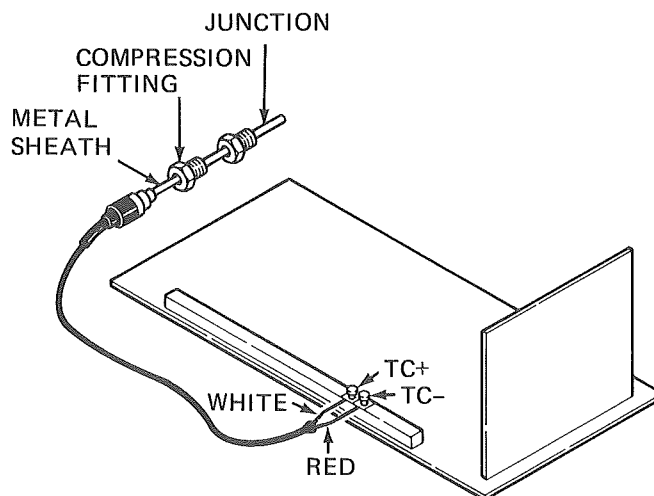
If the thermocouple breaks, the Digitronic will shut off power to the heater, preventing excessive temperature in the chamber. This condition will be indicated on the Digitronic digital display area by decimal points between the numerals.

#### Replacing the thermocouple

(Tools needed: small screwdriver and small crescent wrench)

The Controller thermocouple is type "J" (iron/constantan) and is replaceable using the following procedure:

1. Disconnect power and remove screws from the face of the control panel and slide it forward.
2. Locate thermocouple and hi-limit bulb along the left side of the control chamber.
3. Loosen the nut on the fitting holding the thermocouple in place.
4. Pull thermocouple out of brass fitting.
5. Feed new thermocouple through the nut and ferrule and place back into the fitting.
6. Retighten the fitting nut.
7. Remove old thermocouple from terminals marked "TC+" and "TC-" on PC board.
8. Attach new thermocouple to "TC+" and "TC-" making sure that white lead is attached to the "+" terminal and the red lead is attached to the "-".
9. Replace oven control panel.
10. If decimal points still appear between numerals, repeat procedure.



## Digitronic trouble shooting

DIFFICULTY	PROBABLE CAUSE	SUGGESTED REMEDY
Erratic Sensor Readout	Broken T/C	See Thermocouple Test
	Control Malfunction	See Control Output Test
Erratic Setpoint Readout	Bad Slide Wire on 5K Potentiometer	See Potentiometer Test
	Control Malfunction	See Potentiometer Test
Inaccurate Temperatures	Control Miscalibration	See Calibration Procedure
Decimal Points Between the Numerals		
Sensor Readout	Thermocouple is Open or Broken	See Thermocouple Break Protection
Setpoint Readout	Overrange	Lower Setpoint Potentiometer or Input Signal Voltage

### Tests

**WARNING – HIGH VOLTAGE IS PRESENT ON TERMINALS. VOLTAGE CHECKS TO BE MADE ONLY BY QUALIFIED ELECTRICAL MAINTENANCE PERSONNEL: E.G., ELECTRICIAN OR TECHNICIAN. FAILURE TO HEED THIS WARNING CAN RESULT IN SERIOUS BODILY INJURY, PROPERTY DAMAGE, OR DEATH.**

#### Thermocouple Test:

1. Place a jumper or short the terminals "TC+" and "TC-" on the control. The display should read ambient temperature and be very stable.
2. Replace the control if the unit is not stable

#### Control Output Test:

1. Disconnect line power from the control.
2. Remove the jumper or leads attached to terminals + and - on the control.
3. Attach a multimeter with internal impedance greater than 10,000 OHMS/volt DC across these terminals.
4. Set meter to 30 VDC range.
5. Reconnect line power to the control.
6. The meter should read approximately 10 VDC when the sensor readout is 10°C below setpoint and 0 VDC when the readout is 10°C above setpoint. The voltage should be fluctuating when both the sensor and setpoint readouts are the same.
7. Replace control if the unit does not respond as above

#### Potentiometer Test:

##### Control:

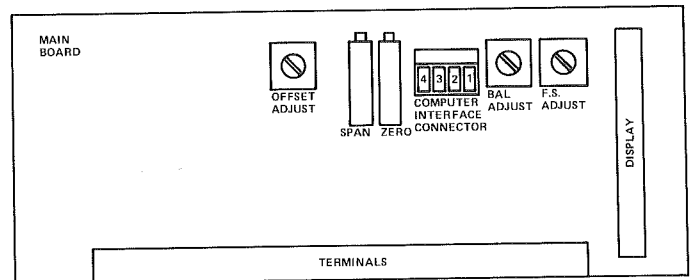
1. Most controls have a bypass resistor across terminals P<sub>1</sub> and P<sub>2</sub> to limit the maximum operating setpoint temperature.
2. Remove one potentiometer lead leaving the bypass resistor across P<sub>1</sub> and P<sub>2</sub>. The setpoint display will increase to

approximately 200° to 400°, but the readout should be stable.

3. Replace control if the readout still is not stable

#### Setpoint Potentiometer:

1. Turn the pot all the way clockwise and then all the way counter clockwise several times. This should remove any dust or dirt from the slidewire. The setpoint should be stable.
2. Replace pot if the readout is still not stable.



#### Calibration procedure

1. Disconnect line power to the control.
2. Attach an accurate potentiometer with a millivolt of Type "J" thermocouple output to the "TC+" and "TC-" terminals on the control
3. Attach a multimeter with internal impedance greater than 10,000 OHMS/volt DC across terminal + and - on the control. Remove jumper, if one was installed.
4. Set meter to 30 VDC range.
5. Turn the line voltage on.
6. Set offset, bal. adjust, and FS adjust to mid range.
7. Turn millivolt source to 0.0°C or °F. Adjust zero pot on control when necessary, if the readout is not the same.
8. Turn millivolt source to 538°C (1000°F). Adjust span pot on control when necessary if readout is not the same.



9. Turn millivolt source to 150°C (302°F).
10. Adjust the FS adjust pot if the readout is not 150°C (302°F). Turn the FS adjust clockwise to turn the readout down.
11. Turn the control setpoint pot (5K) until the meter is fluctuating at about 50% on and 50% off.
12. If the setpoint readout is not 150°C (302°F) adjust the bal. adjust until the setpoint is 150°C (302°F). Turn the bal. adjust pot clockwise to turn the setpoint up.
13. Repeat steps 11 and 12 until the setpoint and sensor temperature both read 150°C and the meter is fluctuating at 50%.
14. Disconnect all power, leads and re-install jumper if necessary.
15. Place nail polish on the zero, span, FS adjust, and bal. adjust pots.

### Trouble shooting.

Any equipment operating for as many hours a day as lab ovens often do is likely to have problems now and then. Below are possible problems and suggested solutions. If you have a problem not listed and don't know what to do, contact Despatch at our toll free "Help Line" 800-328-5476 (In MN 800-462-5396).

DIFFICULTY	PROBABLE CAUSE	SUGGESTED REMEDY
Failure to heat	No power	Check power source and/or oven and wall fuses
	Burned out heating element	Replace element (see warranty statement)
	Control malfunction	See trouble shooting information on Digitronic
	Loose wire connections	Disconnect power and check connections behind control panel
Slow heat up	Improperly loaded	Reduce load or redistribute load in chamber
	Low line voltage	Supply sufficient power and proper connections. Check to see if circuit is overloaded
	1 or 2 heating elements burned out	Replace burned out element (see warranty statement)
	240 volt oven is connected to a 208 volt line	Reconnect heater for 208V (See wiring diagram)
	Fan motor failure	Replace fan motor
	Water flow in cooling coil	Shut water off
Frequent heater element burn out	Harmful fumes generated by load	Increase vent opening or discontinue process
	Overheating Oven	Do not operate over 316°C (600°F)
Erratic temperatures	Control malfunction	See trouble shooting information on Digitronic
Inaccurate temperatures	Control miscalibration	Recalibrate control (see section on control recalibration)
Excess surface temperature around door	Door seal deterioration	Replace door seal



## DIFFICULTY

## PROBABLE CAUSE

## SUGGESTED REMEDY

Improper airflow

Fan motor failure

Replace fan motor

Unbalanced fan wheel

Replace fan wheel

Excessive Vibration

Dirty fan wheel

Clean Fan

Unbalanced fan wheel

Replace fan wheel

Oven will not control at set point

Hi-limit set too low

Set the hi-limit higher

Hi-limit is out of calibration

Recalibrate the hi-limit (see directions on recalibrating the hi-limit)

Triac malfunction

Replace Triac

Control malfunction

See trouble shooting information on Digitronic

Air friction of recirculation fan

The minimum operating temperature is approximately 75°C above ambient room temperature. Use water cooling coil.

Heater does not shut off until the temperature reaches the hi-limit setting

Triac shorted

Replace Triac

Excessive O<sub>2</sub> levels

Door seal deterioration

Replace door seal

Pressure relief valve leaking

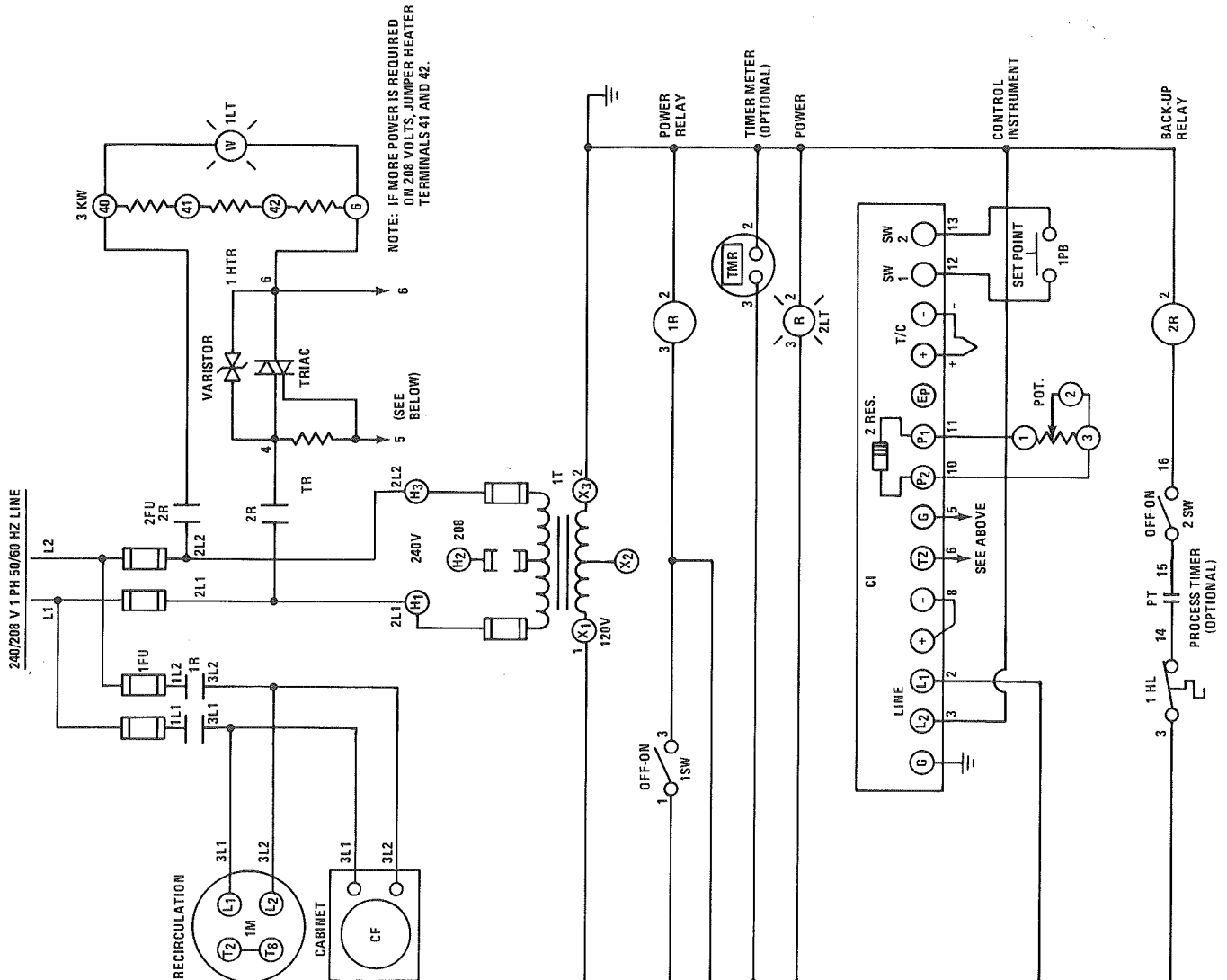
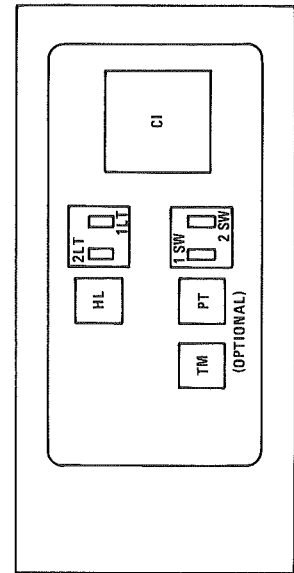
Replace valve

Fan shaft seal leaking

Replace shaft seal (remove fan motor first)

MATERIAL LIST			
ITEM	PART NO.	QTY.	DESCRIPTION
CI	031332	1	61-06-AL DIGITRONIC CONTROL
TR	015405	1	W/240 VOLT TRIAC
1 PB	030525	1	T6420M TRIAC
POT	030526	1	UP-101M SWITCH
CF	015229	1	3253 POTENTIOMETER
		1	MU 3A1 ROTRON FAN 240 V
1FU	007471	1	F30A2 FUSE BLOCK
2FU	007532	2	FRN 5.0 FUSETRON
	007471	1	F30A2 FUSEBLOCK
1M	007456	2	A25 X 15 AMP - TRAP FUSE
1T	008335	1	1/4 HP MOTOR 48FR 1750RPM
	013315	1	BX200MP1215 - 3PK TRANSFORMER
1HL	007502	2	FNM 2 FUSETRON
VAR	030489	1	150 - 370°C HI-LIMIT KIT
	012748	1	V275LA1SA VARIATOR
1-2SW	012173	2	TIGK-51-65-WH-NBL SWITCH
1LT	008670	1	LT-C2-NW-N2-MF WHITE PILOT LIGHT
2LT	008662	1	LT-C2-NR-N1-MF RED PILOT LIGHT
1-2R	010434	2	PRD07AYO RELAY 25 AMP 120 V
2 RES	010495	1	7.5 OHM RESISTOR ±5%
1-HTR	007777	1	3KW WAGNER

INCLUDED  
IN ITEM  
C1



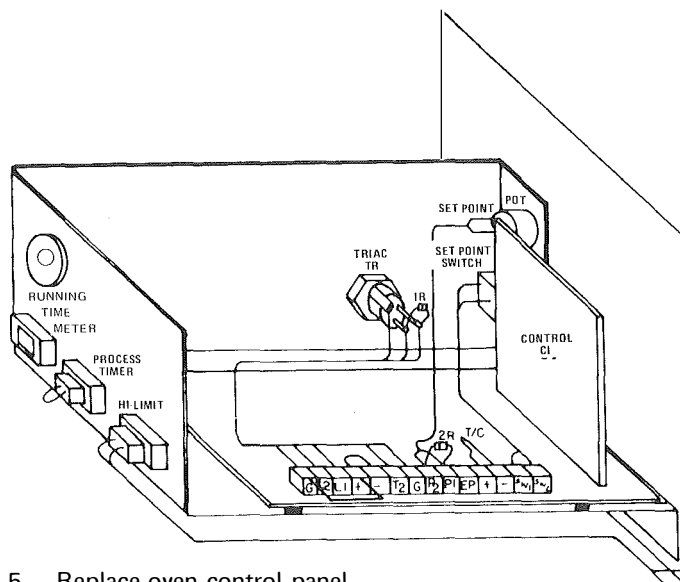
## How to install LND optional accessories:

Three optional accessories are available for LND series ovens. They are available at any time from Despatch Industries' Customer Service Department, 800/328-5476 which is our no toll "Help Line". (MN 800-462-5396)

When you order accessories, full instructions for mounting them in the control panel will be enclosed; however, in case they are misplaced, instructions are repeated here.

**Process timers.** Available for 60 minutes or 6 hour cycles, these timers are electrically connected into oven control and will shut off the heater at end of cycle. (Tools needed: screwdriver, utility knife.)

1. Disconnect power, remove screws from the face of the control panel and slide it forward.
2. From back of panel, locate pre-punched holes. Process timer can be mounted in either of the two far left sets of holes. From the front of panel, use utility knife to cut holes in the silver overlay.
3. Put shaft and mounting screws through holes and screw timer into place.
4. Locate connector marked "Process Timers" on the back of the digitronic bracket. Remove jumper. Replace it with connector supplied with the timer.



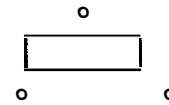
5. Replace oven control panel.
6. Peel top part of backing off black "Process Timer" sticker and apply it to front of control panel, using the two locating marks and shaft holes as location guides. Peel remaining backing off and smooth sticker down.
7. Push knob onto shaft.

**Signal Timer.** This timer sounds an audible bell at the end of the cycle, up to 60 minutes. It is not electrically connected to oven and does not shut off heater. (Tools needed: screwdriver, utility knife.)

1. Disconnect power, remove screws from the face of the control panel and slide it forward.
2. From back of panel, locate pre-punched holes. Signal timer can be mounted in either of the two far left sets of holes. From the front of panel, use utility knife to cut holes in the silver overlay.
3. Put shaft and mounting screws through the holes and screw timer into place.
4. Replace control panel.
5. Peel top part of backing off black "Signal Timer" sticker and apply it to front of control panel, using the two locating marks and shaft holes as location guides. Peel remaining backing and smooth sticker down.
6. Push knob onto shaft.

**Running Time Meter.** Digital meter counts up to 99,999.9 hours of process time. Runs continuously when oven is on. Not resettable. (Tools needed: screwdriver, utility knife.)

1. Disconnect power, remove screws from the face of the oven control panel and slide it forward.
2. From back of panel, locate pre-punched holes. The running time meter can be positioned only in the lower left set of holes. Use the utility knife to cut four holes in the silver overlay.



3. Attach meter to panel with screws.
4. Locate connector marked time meter on the back of the Digitronic bracket and connect the wired connector from the meter to it.
5. Replace control panel.
6. Peel top part of backing off black "Running Time" sticker and apply it to the front of the control panel using locating marks and meter hole as location guides. Peel remaining backing off and smooth sticker down.
7. Meter will operate when oven is on.

## Cooling Coil Flowmeter

1. Mount flowmeter as desired on wall or adjacent to the oven.
2. Connect tubing from the flowmeter outlet to the coil supply on rear of oven.
3. Run tubing from coil drain connection to an open drain.
4. Connect a clean water supply to the flowmeter inlet connection.
5. Open valve and check for leaks.